

Clamping unit		HM 45/ ...											
Clamping force	kN	450											
Distance between tier-bars	mm x mm	320 x 270											
Mold height (min.)	mm	195											
Opening stroke/opening force	mm/kN	375/26											
Maximum daylight	mm	570											
Ejector stroke/ejector force	mm/kN	100/26,4											
Dry cycle time ¹⁾	s-mm	1,6 - 224											
Injection unit		... /60			... /130				... /210				
Screw diameter	mm	14	18	22	18	22	25	30	25	30	35		
Screw stroke	mm	90			110				125				
Screw L/D ratio		20			20				22				
Theoretical shot volume	cm ³	13,9	22,9	34,2	28	41,8	61,4	88,4	73,6	106	144		
Specific injection pressure	bar	3000	2593	1736	3000	2864	2218	1540	2940	2042	1500		
Max. screw speed	min ⁻¹	498			318				310				
Max. plasticizing rate (PS) ²⁾	g/s	1,7	5	7,2	3,2	4,6	8,5	12,3	8,2	12	18,6		
Max. screw torque	Nm	90	231		238			357		490			
Nozzle stroke/nozzle contact force	mm/kN	250/47			250/47				250/86				
Injection rate into air	cm ³ /s	32,7	54,1	80,7	32,7	48,9	63,1	90,9	59,5	85,7	117		
Injection rate into air with twin-pump (option)	cm ³ /s	49	81,1	121	49,1	73,4	94,7	136	71,4	103	140		
Injection rate into air with hydraulic accumulator (option)	cm ³ /s	65	108	161	77,7	116	150	216	143	206	280		
Drive													
Drive power	kW	11			11				11				
Oil tank volume	l	150			150				150				
Electrical power supply without/with Europackage	kVA	20/49			24/53				27/56				
Weights, Dimensions													
Netweight (exclusive oil)	kg	2500			2500				2600				
Length x width x weight ³⁾	m	3,0x1,3x1,9			3,3x1,3x1,9				3,4x1,3x1,9				
Max. mold weight/min. mold diameter ⁴⁾	kg/mm	400/250			400/250				400/250				

1) according to Euromap 6 2) according to Battenfeld norm, higher plasticizing rates possible with twin-pump (option)

3) max. length with middle screw diameter in back position 4) max. 2/3 on clamping platen

