

Technical Data

International size ¹⁾		50-25
Clamp Unit	Tons	25
Clamping Pressure	Tons	28
Locking Pressure	mm (in.)	60-200 (2.35-7.875)
Mould opening stroke (adjustable)	mm (in.)	600 (19.685)
Max. distance between platen	mm (in.)	150-300 (5.9-11.82)
Mould height	mm (in.)	342 x 260 (13.472 x 9.875)
Platen size	mm (in.)	221 (8.707)
Space between pillars	mm (in.)	220 x 250 (8.665 x 9.875)
Platen area		see next page
Mould space	Tons	2
Hydraulic ejector force	mm (in.)	60 (2.35)
Max. stroke of hydraulic ejector		

Injection Unit		10	22 ²⁾	25
Screw diameter (choice)	mm	90	90	90
Max. Screw stroke ³⁾	cm ³ (cu. in.)	23 (1.40)	34 (2.07)	44 (2.68)
Max. swept volume	cm ³ (cu. in.)	18 (1.10)	27 (1.65)	35 (2.14)
Max. injection volume ⁴⁾	g	see below		
Max. shot capacity	Tons	5.7		
Max. injection force	kg/cm ² (psi.)	2230 (31.700)	1500 (21.300)	1160 (16.500)
Max. injection pressure	rpm	10-300		
Infinitely variable screw speed	rpm	10,5		
Screw torque	Watts	2 x 1400 - 2800		
Cylinder heater	Watts	200		
Nozzle heater	l	10,5		
Material hopper capacity				

Drive and Hydraulics		4
Pump motor	kW	120
Required hydraulic oil	l/h	1980
Dry cycles ⁵⁾	kW	7
Total connected load		
380/220 V, 3-phase 50 cycles		

General		2,6 x 0,9
Length x width of machine	m	1,45 / 2,25
Height of horizontal/vertical injection Unit	m	700
Machine weight without oil	kg.	3/4
Water supply and drain	in.	hammer tone green similar PAL 6011
Colour		

Max. Shot Capacity (in gramme)		18 mm	22 mm	25 mm
Screw diameter	PS	19	29	37
Polystyrene	SB	19	29	37
Polystyrene Co-Polymers	SAN, ABS ⁶⁾	20	30	38
	CA ⁸⁾	23	35	45
Cellulose Acetate	CAB ⁹⁾	22	33	42
Cellulose Acetate Butyrate	PMMA	22	32	42
Polymethylmethacrylate	PPO	19	29	38
Polyphenylene oxide	PC	22	33	42
Polycarbonate		23	34	44
Polysulfone	PA 6.6, PA 6 ¹⁰⁾	21	31	40
Polyamide	PA 6.10, PA 11 ¹¹⁾	19	29	37
	POM	26	38	50
Acetal Resin	PETP	25	38	49
Polyethylene Terephthalate	PE soft	17	25	33
Polyethylene	PE hard	18	26	34
	PP	17	25	32
Polypropylene	FEP, PCTFE ¹²⁾	39	59	78
Polyolefins (Teflon, FEP, Hostallon)	ETFE	31	47	60
(Tetzel)	PVC hard / soft ¹³⁾	25 / 23	38 / 35	49 / 45
Polyvinylchloride				

1) 1 bar = 1 kg/cm² = 1 at
 2) 1 N = 1 Newton = 0.1 kg; 1 kN = 0.1 Mp = 100 kp
 3) Max. swept volume (cm³) x max. spec. injection pressure (bar)
 x 10 = 3 Lock force (Mpa)
 4) with standard cylinder

5) middle values
 6) effective screw stroke, allowing for 4 mm
 return stroke for die compression
 7) calculated with H factor = 0.8
 8) according to Euromap

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