

ATTENFELD INJECTION MOLDING MACHINE SPECIFICATIONS - BA 50-4
INTERNATIONAL DESIGNATION BA 460/170)

JULY 1987

LAMPING UNIT

	U.S.	METRIC
type	HORIZONTAL, FULLY HYDR.	
Lamp force (tons, kN)	51	460
Lamp opening force (tons, kN)	4.4	40
Lamp stroke max. (in.,mm)	14.77	375
open daylight max. (in.,mm)	20.67	525
closed daylight min. (in., mm)	5.90	150
Laten dimensions	Horizontal (in.,mm)	18.9
	Vertical (in.,mm)	18.9
Laten bolting pattern	SPI	
Distance between tie rods	Horizontal (in.,mm)	11.98
	Vertical (in.,mm)	11.98
Tie rod diameter (in.,mm)	1.97	50
Ejector knock-out, type and pattern	HYDR, CENTER EJECTOR	
Force (tons, kN)	1.9	17.5
Stroke (in.,mm)	6.3	160
Nozzle penetration (in.,mm)	1.18	30

INJECTION UNIT

type	RECIPROCATING SCREW					
Injection capacity-calculated (cu.in.,cu.cm)	5.3	6.9	8.7	86.6	113	143
Injection capacity-cal. G.P. polystyrene (oz.,gm)	2.8	3.7	4.6	78.8	103	130
Elasticizing capacity G.P. (lb./hr.,kg./hr.)	100	130	165	46	60	75
Injection pressure-max. (psi,kg./sq.cm)	28478	21750	17236	1964	1500	1188
Inj. rate-max. at max. press. (cu.in./sec.,cu.cm./sec.)	6.5	8.5	10.8	106.7	139.5	176.4
Injection stroke (in.,mm)	3.54			90		
Screw diameter (in.,mm)	1.38	1.58	1.77	35	40	45
Screw L/D ratio	19.5	17	15	19.5	17	15
Screw speed range (rpm)	0-280					
Torque (in.-lbs.,Nm)	3900			420		
Injection carriage travel (in.,mm)	7.87			200		
Max. nozzle contact force (tons,kN)	6.3			59		

HYDRAULICS

Pump capacity - per stage (GPM,liters/min.)	1.32/2.64/5.29/10.59	5/10/20/40
	total (GPM,liters/min.)	75
Oil reservoir capacity (gal.,liters)	48	180

ELECTRICS

Voltage motor	230/3/60
Voltage heating	230/1/60
Number of electric motors	1
Total rated h.p.	20
Total heating wattage (kW)	6.28
Number of heat control zones	4
Number of pyrometers	4

MACHINE DIMENSIONS - OVERALL

Length (in.,mm)	137	3465
Width (in.,mm)	48	1215
Height (in.,mm)	76	1920
Weight (lbs.,kg.)	5512	2500

SUBJECT TO CHANGE

Battenfeld