

**Machine Specification Form
Engineering Standard**



Date: 4/8/99

Sheet: 1 of 2

By: JLB

MSF No: 200-0001

Rev.: 0

ECN No:

Specification Name:

Horizontal Toggle Clamp Machine, 85HT with Inline Ram, Standard Speed

English Specifications

85HT Inline Ram

		2.3	3	3.7	5
INJECTION UNIT	UNITS				
Injection Capacity-Calculated	cu. in.	4.17	5.82	6.85	9.32
Injection Capacity-GPPS	oz.	2.27	3.17	3.73	5.08
Std. Recovery Rate	oz./sec.	0.24	0.36	0.49	0.73
Std. Screw Speed -Maximum	RPM	320	320	435	409
Opt. Recovery Rate	oz./sec.	NA	NA	NA	0.76
Opt. Screw Speed -Maximum	RPM	NA	NA	NA	435
Injection Pressure-Maximum	psi	28125	20161	27505	20208
Injection Velocity-at 10,000psi	in/sec	7.7	7.7	5.6	5.8
Injection Rate-at 10,000psi	cu.in./sec.	6.0	8.4	6.1	8.4
Injection Stroke	in.	5.31	5.31	6.25	6.25
Screw Diameter	mm	25.4	30	30	35
Screw Diameter	in.	1.00	1.18	1.18	1.36
Barrel L/D Ratio		20:1			
Back Press. Adjust (screw rotating)	psi	50-300			
Nozzle Sealing Force	US tons	2.8			
Max. Nozzle Retraction	in.	12			
CLAMP UNIT					
Clamp Force	US tons	85			
Clamp Stroke-Maximum	in.	12			
Open Daylight-Maximum	in.	28			
Mold Thickness-Minimum	in.	4			
Platen Size:					
-Horizontal	in.	22.8			
-Vertical	in.	20.4			
Distance Between Bars:					
-Horizontal	in.	16			
-Vertical	in.	13.6			
Tie Bar Diameter	in.	2.40			
Clamp Speeds:					
-Close	in./sec.	29			
-Open	in./sec.	45			
Ejector Force	US tons	4.9			
Ejector Stroke	in.	3.0			
Ejector Speed:					
-Forward	in./sec.	17			
-Retract	in./sec.	24			
POWER					
Pump Motor(s)	Hp	15			
Barrel Heating	Kw	5.8	5.6	5.6	8.1
GENERAL					
System Pressure-Inject	psi	2000	2000	2000	2000
Pump Capacity (@ 100psi)	GPM	23	23	23	23
Eject Function	GPM	23	23	23	23
Injection Unit Calibration		333	333	463	463
Oil Capacity	gal.	80			
Hopper Capacity	lb.	40	40	40	40
Machine Weight	lb.	9500			
Machine Dimensions -L	ft.	14.7			
-W	ft.	4.3			
-H	ft.	5.6			