



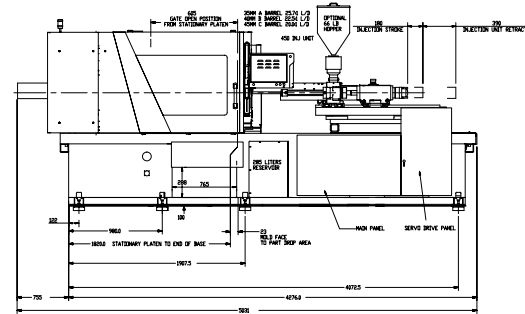
MAGNA

TOGGLE SERIES

Tonnage: 140

Frame Sizes:
450, 630

TECHNICAL SPECIFICATIONS



		450 Frame			630 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
General							
Electrical Motor	hp kW		15 11.5			15 11.5	
Total Oil Capacity	gal L		70 265			70 265	
Water Supply (29°C Inlet Temp)	gal/min L/min		13.2 50			13.2 50	
Connected Load	kW		22.8			27.2	
Overall Dimensions (L x W x H)	ft m		16.7 x 5.9 x 6.5 5.1 x 1.8 x 2.1			16.7 x 5.9 x 6.5 5.1 x 1.8 x 2.1	
Machine Weight	lbs kg		11,561 5,255			12,874 5,840	
Injection Unit Specifications							
Injection Capacity, Maximum GPPS	oz gms	5.8 165	7.6 215	9.6 272	8.4 239	10.7 303	13.2 374
Theoretical Displacement	in ³ cm ³	10.6 173	13.8 226	17.5 286	15.3 251	19.4 318	24.0 393
Maximum Injection Pressure	psi bar	35,400 2,443	28,700 1,984	22,700 1,588	36,100 2,492	28,500 1,969	23,100 1,595
Injection Rate	in ³ /sec cm ³ /sec	6.3 103	8.2 134	10.4 170	6.5 107	8.2 135	10.2 167
Injection Velocity	in/sec mm/sec		4.2 107			3.3 85	
Screw Stroke	in mm		7.1 180			7.9 200	
Back Pressure Limits	psi bar		500 34.4			500 34.4	
Screw Diameter	in mm	1.38 35	1.57 40	1.77 45	1.57 40	1.77 45	1.97 50
Screw L/D Ratio	L/D	25.7	22.5	20	25	22.2	20
Screw Speed	rpm		279			222	
Screw Torque @172 bar	in-lb Nm		7,900 876			9,800 1,080	
Plasticizing Rate (GPPS)	oz/sec gm/sec	0.5 13	0.7 19	0.9 26	0.5 15	0.7 20	1.2 33
Number of Pyrometers (Barrel/Nozzle)	qty		4/1			4/1	
Total Heat Capacity	kW		11.3			15.7	

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4165 Half Acre Rd.,
Batavia OH 45103
513.536.2000
info@milacron.com
www.milacron.com

		450 Frame			630 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
Clamp							
Clamping Force	ton kN		140 1,250			140 1,250	
Opening Force	ton kN		14 125			14 125	
Clamp Stroke	in mm		13.8 350			13.8 350	
Clamp Close Velocity	in/sec cm/sec		16.5 420			16.5 420	
Clamp Open Velocity	in/sec cm/sec		22.6 575			22.6 575	
Eject Force (forward)	tons kN		3.9 35			3.9 35	
Eject Velocity (forward)	in/sec cm/sec		11.8 300			11.8 300	
Eject Velocity (retract)	in/sec cm/sec		11.8 300			11.8 300	
Ejector Stroke	in mm		4.7 120			4.7 120	
Mold Protect Pressure	psi bar		986 68			986 68	
Maximum Daylight	in mm		32.7 830			32.7 830	
Minimum Mold Height	in mm		5.9 150			5.9 150	
Maximum Mold Height	in mm		18.9 480			18.9 480	
Maximum Mold Weight	lbs kg		2,271 1,030			2,271 1,030	
Platen Size (H x V)	in mm		25.7 x 25.7 655 x 655			25.7 x 25.7 655 x 655	
Distance Between Tie Rods	in mm		17.1 x 17.1 435 x 435			17.1 x 17.1 435 x 435	
Tie Rod Diameter	in mm		3.1 80			3.1 80	
Dry Cycle Time (Euromap 6)	sec		2.3			2.3	

Notes

1) All machine dimensions and specifications are subject to change. Values are for reference only. All general assembly drawings or visuals included herein are for reference only. Please consult the general assembly drawing from a Milacron representative.



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