



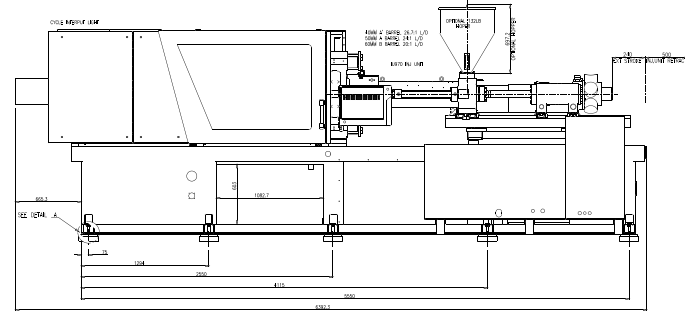
# MAGNA

## TOGGLE SERIES

Tonnage: 225

Frame Sizes:  
970, 1540

## TECHNICAL SPECIFICATIONS



		970 Frame			1540 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
<b>General</b>							
Electrical Motor	hp kW		18 13.6			18 13.6	
Total Oil Capacity	gal L		139 525			139 525	
Water Supply (29°C Inlet Temp)	gal/min L/min		19.8 75			19.8 75	
Connected Load	kW		30.5			38.5	
Overall Dimensions (L x W x H)	ft m		20.1 x 5.9 x 7.5 6.4 x 2.1 x 2.4			21.7 x 5.9 x 7.5 6.6 x 2.1 x 2.4	
Machine Weight	lbs kg		21,098 9,570			22,046 10,000	
<b>Injection Unit Specifications</b>							
Injection Capacity, Maximum GPPS	oz gms	12.8 363	15.8 448	22.8 646	18.4 523	26.6 753	36.2 1,025
Theoretical Displacement	in <sup>3</sup> cm <sup>3</sup>	23.3 382	28.7 471	41.4 679	33.6 550	48.3 792	65.8 1,078
Maximum Injection Pressure	psi bar	32,600 2,249	29,800 2,057	20,700 1,428	32,400 2,236	28,100 1,941	20,600 1,426
Injection Rate	in <sup>3</sup> /sec cm <sup>3</sup> /sec	10 164	12.3 202	17.7 291	9.0 149	13.0 214	17.7 291
Injection Velocity	in/sec mm/sec		4.0 103			3.0 76	
Screw Stroke	in mm		9.4 240			11 280	
Back Pressure Limits	psi bar		500 34.4			500 34.4	
Screw Diameter	in mm	1.77 45	1.97 50	2.36 60	1.97 50	2.36 60	2.76 70
Screw L/D Ratio	L/D	26.7	24	20	28	23.3	20
Screw Speed	rpm		293			180	
Screw Torque @172 bar	in-lb Nm		11,800 1,305			19,300 2,126	
Plasticizing Rate (GPPS)	oz/sec gm/sec	0.9 27	1.5 44	2.4 68	0.9 27	1.4 41	2.3 66
Number of Pyrometers (Barrel/Nozzle)	qty		4/1			4/1	
Total Heat Capacity	kW		16.9			24.9	

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

		970 Frame			1540 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
<b>Clamp</b>							
Clamping Force	ton kN		224 2,000			224 2,000	
Opening Force	ton kN		22 200			22 200	
Clamp Stroke	in mm		20.1 510			20.1 510	
Clamp Close Velocity	in/sec cm/sec		33.4 850			33.4 850	
Clamp Open Velocity	in/sec cm/sec		29.5 750			29.5 750	
Eject Force (forward)	tons kN		4.9 44			4.9 44	
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		5.9 150			5.9 150	
Mold Protect Pressure	psi bar		986 68			986 68	
Maximum Daylight	in mm		48 1,220			48 1,220	
Minimum Mold Height	in mm		7.9 200			7.9 200	
Maximum Mold Height	in mm		28 710			28 710	
Maximum Mold Weight	lbs kg		4,202 1,906			4,202 1,906	
Platen Size (H x V)	in mm		31.9 x 31.9 810 x 810			31.9 x 31.9 810 x 810	
Distance Between Tie Rods	in mm		22.4 x 22.4 570 x 570			22.4 x 22.4 570 x 570	
Tie Rod Diameter	in mm		3.9 100			3.9 100	
Dry Cycle Time (Euromap 6)	sec		2.5			2.5	

#### 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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