



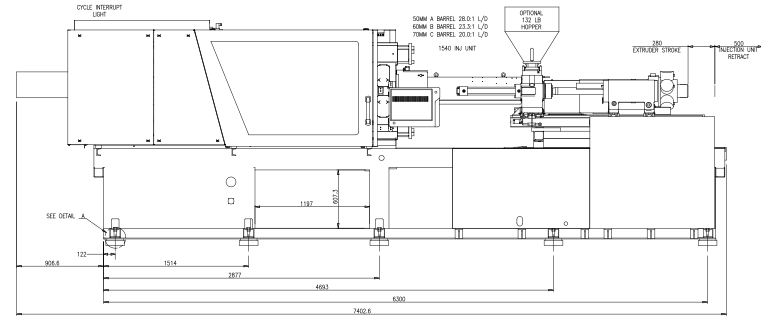
# MAGNA

## TOGGLE SERIES

Tonnage: 310

Frame Sizes:  
1540, 2290

## TECHNICAL SPECIFICATIONS



		1540 Frame			2290 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
<b>General</b>							
Electrical Motor	hp kW		34 25.1			34 25.1	
Total Oil Capacity	gal L		162.7 615			162.7 615	
Water Supply (29°C Inlet Temp)	gal/min L/min		19.8 75			19.8 75	
Connected Load	kW		50			64.7	
Overall Dimensions (L x W x H)	ft m		24.3 x 6.6 x 8.2 7.45 x 2.22 x 2.5			25 x 6.6 x 8.2 7.65 x 2.22 x 2.5	
Machine Weight	lbs kg		29,034 13,170			30,820 13,980	
<b>Injection Unit Specifications</b>							
Injection Capacity, Maximum GPPS	oz gms	18.4 363	26.6 753	36.2 1,025	30.4 861	41.3 1,172	54.0 1,530
Theoretical Displacement	in <sup>3</sup> cm <sup>3</sup>	33.6 550	48.3 792	65.8 1,078	55.2 905	75.2 1,232	98.1 1,608
Maximum Injection Pressure	psi bar	32,459 2,238	28,100 1,941	20,600 1,426	32,400 2,238	26,900 1,856	20,600 1,421
Injection Rate	in <sup>3</sup> /sec cm <sup>3</sup> /sec	15 246	21.4 351	29.2 478	16.5 270	22.4 367	29.3 480
Injection Velocity	in/sec mm/sec		4.8 124			3.7 96	
Screw Stroke	in mm		11 280			12.6 320	
Back Pressure Limits	psi bar		500 34.4			500 34.4	
Screw Diameter	in mm	1.97 50	2.36 60	2.76 70	2.36 60	2.76 70	3.15 80
Screw L/D Ratio	L/D	28	23.3	20	26.7	22.9	20
Screw Speed	rpm	295	295	273		187	
Screw Torque @172 bar	in-lb Nm		19,300 2,126			30,400 3,347	
Plasticizing Rate (GPPS)	oz/sec gm/sec	1.6 44	2.4 68	3.5 100	1.5 43	2.4 69	3.3 93
Number of Pyrometers (Barrel/Nozzle)	qty		4/1			4/1	
Total Heat Capacity	kW		24.9			39.6	

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

		1540 Frame			2290 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
<b>Clamp</b>							
Clamping Force	ton kN		309 2,750			309 2,750	
Opening Force	ton kN		30 275			30 275	
Clamp Stroke	in mm		24 610			24 610	
Clamp Close Velocity	in/sec cm/sec		27.5 700			27.5 700	
Clamp Open Velocity	in/sec cm/sec		23.6 600			23.6 600	
Eject Force (forward)	tons kN		8.3 74			8.3 74	
Eject Velocity (forward)	in/sec cm/sec		7.87 200			7.87 200	
Eject Velocity (retract)	in/sec cm/sec		11.8 300			11.8 300	
Ejector Stroke	in mm		6.3 160			6.3 160	
Mold Protect Pressure	psi bar		986 68			986 68	
Maximum Daylight	in mm		53.5 1,360			53.5 1,360	
Minimum Mold Height	in mm		7.9 200			7.9 200	
Maximum Mold Height	in mm		29.5 750			29.5 750	
Maximum Mold Weight	lbs kg		6,241 2,831			6,241 2,831	
Platen Size (H x V)	in mm		37 x 37 940 x 940			37 x 37 940 x 940	
Distance Between Tie Rods	in mm		26 x 26 660 x 660			26 x 26 660 x 660	
Tie Rod Diameter	in mm		4.5 115			4.5 115	
Dry Cycle Time (Euromap 6)	sec		2.8			2.8	

#### 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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