



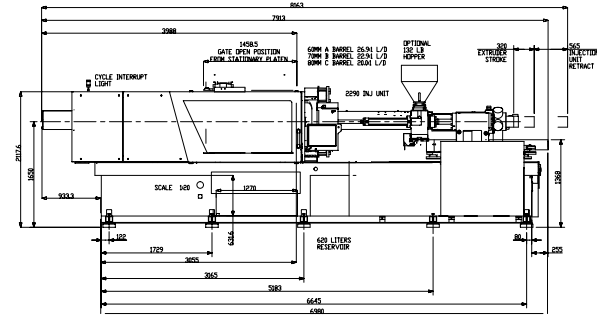
MAGNA

TOGGLE SERIES

Tonnage: 400

Frame Sizes:
2290, 3470

TECHNICAL SPECIFICATIONS



		2290 Frame			3470 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
General							
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	26.5 100			26.5 100		
Connected Load	kW	64.7			83		
Overall Dimensions (L x W x H)	ft m	25.9 x 7.08 x 8.62 7.9 x 2.2 x 2.7			28.1 x 7.08 x 8.62 8.6 x 2.2 x 2.7		
Machine Weight	lbs kg	39,683 18,000			40,785 18,500		
Injection Unit Specifications							
Injection Capacity, Maximum GPPS	oz gms	30.4 861	41.3 1,172	54.0 1,530	46.5 1,318	60.7 1,722	76.9 2,179
Theoretical Displacement	in ³ cm ³	55.2 905	75.2 1,232	98.1 1,608	84.5 1,385	110.4 1,810	139.7 2,290
Maximum Injection Pressure	psi bar	32,459 2,238	26,900 1,856	20,600 1,421	33,100 2,289	27,700 1,917	21,900 1,515
Injection Rate	in ³ /sec cm ³ /sec	16.5 270	22.4 367	29.3 480	16.6 272	21.7 356	27.5 450
Injection Velocity	in/sec mm/sec	3.7 96			2.7 71		
Screw Stroke	in mm	12.6 320			14.2 360		
Back Pressure Limits	psi bar	500 34.4			500 34.4		
Screw Diameter	in mm	2.36 60	2.76 70	3.15 80	2.76 70	3.15 80	3.54 90
Screw L/D Ratio	L/D	26.7	22.9	20	25.7	22.5	20
Screw Speed	rpm	187			146		
Screw Torque @172 bar	in-lb Nm	30,400 3,347			39,000 4,291		
Plasticizing Rate (GPPS)	oz/sec gm/sec	1.5 43	2.4 69	3.3 93	1.9 53	2.5 72	3.4 97
Number of Pyrometers (Barrel/Nozzle)	qty	4/1			4/1		
Total Heat Capacity	kW	39.6			57.9		

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Pub Number: T4.1008.A.03.17

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		2290 Frame			3470 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
Clamp							
Clamping Force	ton kN		393 3,500			393 3,500	
Opening Force	ton kN		39 350			39 350	
Clamp Stroke	in mm		26.6 675			26.6 675	
Clamp Close Velocity	in/sec cm/sec		23.6 600			23.6 600	
Clamp Open Velocity	in/sec cm/sec		20.2 515			20.2 515	
Eject Force (forward)	tons kN		7.9 70			7.9 70	
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		7.9 200			7.9 200	
Mold Protect Pressure	psi bar		986 68			986 68	
Maximum Daylight	in mm		58.1 1,475			58.1 1,475	
Minimum Mold Height	in mm		11.8 300			11.8 300	
Maximum Mold Height	in mm		31.5 800			31.5 800	
Maximum Mold Weight	lbs kg		8,708 3,950			8,708 3,950	
Platen Size (H x V)	in mm		40.6 x 40.6 1,030 x 1,030			40.6 x 40.6 1,030 x 1,030	
Distance Between Tie Rods	in mm		28.3 x 28.3 720 x 720			28.3 x 28.3 720 x 720	
Tie Rod Diameter	in mm		5.1 130			5.1 130	
Dry Cycle Time (Euromap 6)	sec		4.3			4.3	

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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