



VERTICAL INSERT INJECTION MOLDING MACHINES

22 mm SPECIFICATIONS

MAGNA V30

Injection Unit Specifications

Injection Capacity Max.	English	a	b	c	d	Metric	a	b	c	d
Screw diameter	in	0.71	0.86	0.94	1.10	mm	18	22	24	28
GP Styrene	ozs	0.73	1.08	1.29	1.76	g.	20.7	30.6	36.6	49.9
Displacement	in ³	1.32	1.97	2.35	3.19	cm ³	21.63	32.28	38.51	52.27
Injection Hyd. Pressure, Max	psi	1,800	2,200	2,200	2,200	bar	124	152	152	152
Injection Melt Pressure, Max	psi	37,000	30,000	25,125	18,528	bar	2,551	2,068	1,732	1,277
Injection Rate	in ³ /sec	2.26	3.39	4.03	5.48	cm ³ /sec	37.03	55.55	66.04	89.8
Screw Stroke	in	3.35	3.35	3.35	3.35	mm	85.1	85.1	85.1	85.1
Screw L/D (xx:1)		27:1	22:1	20:1	17:1		27:1	22:1	20:1	17:1

Screw Performance

At screw pressure	@psi	1,100	1,380	2,000	2,000	@bar	76	95	138	138
Torque at Screw	in-lb	720	950	1,375	1,375	Nm	81.4	107.4	155.4	155.4
Screw speed	rpm	390	380	360	360	rpm	390	380	360	360

Barrel Heat Control

Number of Pyrometers (Barrel/Nozzle)		3/1	3/1	3/1	3/1		3/1	3/1	3/1	3/1
Total Heat Capacity	kW	5.5	5.5	5.5	5.5	kW	5.5	5.5	5.5	5.5

28 AND 32 mm SPECIFICATIONS

Injection Unit Specifications	English	28 mm			32 mm			Metric	28 mm			32 mm		
		a	b	c	a	b	c		a	b	c	a	b	c
Injection Capacity Max.														
Screw diameter	in	1.10	1.26	1.42	1.26	1.42	1.65	mm	28	32	36	32	36	42
GP Styrene	ozs	2.27	2.97	3.76	3.51	4.44	6.04	g.	64.44	84.16	106.5	99.47	125.89	171.4
Displacement	in ³	4.13	5.40	6.83	6.38	8.07	10.99	cm ³	67.73	88.46	112	104.6	132.32	180.1
Injection Hyd. Pressure, Max	psi	1,800	2,450	2,450	2,400	2,400	2,400	bar	124	169	169	166	166	166
Injection Melt Pressure, Max	psi	30,000	22,980	18,156	30,000	23,688	17,424	bar	2,068	1,584	1,252	2,068	1,634	1,201
Injection Rate	in ³ /sec	3.77	4.92	6.23	3.69	4.67	6.36	cm ³ /sec	61.78	80.62	102.09	60.47	76.53	104.22
Screw Stroke	in	4.33	4.33	4.33	5.12	5.12	5.12	mm	110	110	110	130	130	130
Screw L/D (xx:1)		23:1	20:1	17:1	23:1	20:1	17:1		23:1	20:1	17:1	23:1	20:1	17:1
Screw Performance														
At screw pressure	psi	2,475	2,475	2,475	2,475	2,500	2,500	bar	171	171	171	171	172	172
Torque at Screw	in-lb	2,100	3,775	3,775	3,775	4,600	4,600	Nm	237.3	426.6	426.6	426.6	519.8	519.8
Screw speed	rpm	350	170	170	170	130	130	rpm	350	170	170	170	130	130
Barrel Heat Control														
Number of Pyrometers (Barrel/Nozzle)		3/1	3/1	3/1	3/1	3/1	3/1		3/1	3/1	3/1	3/1	3/1	3/1
Total Heat Capacity	kW	6.4	6.4	6.4	7.0	7.0	7.0	kW	6.4	6.4	6.4	7.0	7.0	7.0

Clamping Unit Specifications

	English	22 - 28 - 32 mm	Metric	22 - 28 - 32 mm
Maximum mold size	in	8 x 12	mm	203.2 x 304.8
Clamp force	ton	30	kN	27.22
Maximum ejector stroke	in	0.75	mm	19
Maximum clamp stroke	in	7.5	mm	190.5
Minimum mold height	in	6.5	mm	165
Maximum daylight	in	14.0	mm	355.6

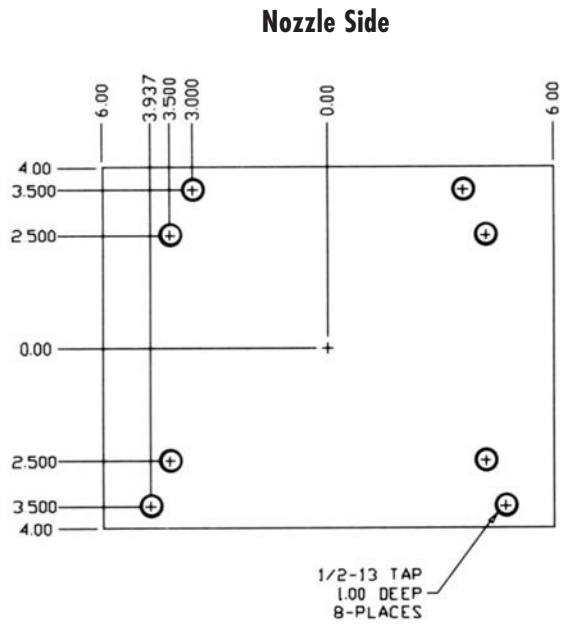
Machine Specifications

	English	22 - 28 - 32 mm	Metric	22 - 28 - 32 mm
Hopper capacity	in ³	990	cm ³	16,226
Hydraulic reservoir capacity	gal	36	ltr	135
Primary pump capacity	gpm	12	lpm	45.42
Secondary pump capacity	gpm	5	lpm	18.93
Motor (1750 rpm)	hp	20	kW	14.91
Machine voltage	V, Hz, Ph	460, 60, 3	V, Hz, Ph	460, 60, 3
Parting line range	in	3.5 - 9.5	mm	88.9 - 241.3

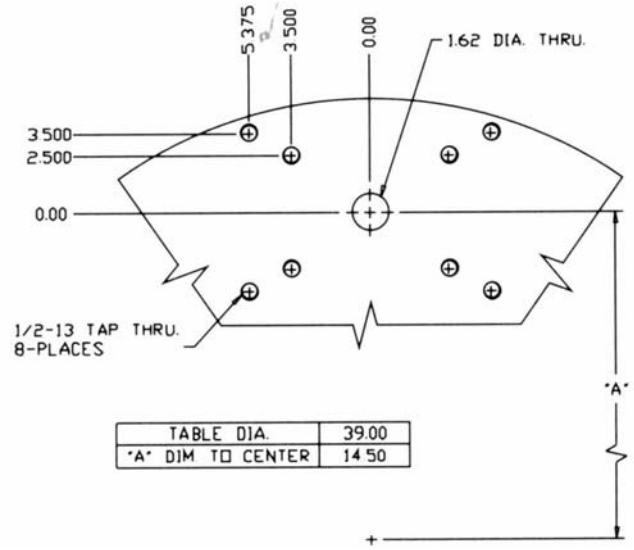
General Specifications

	English	Shuttle	Rotary	Metric	Shuttle	Rotary
Table	in	19.25 Stroke	39 (D)	mm	489 Stroke	991 (D)
Overall dimensions (L x W x H) (est)	in	103 x 67 x 78	127 x 51 x 78	mm	2,616 x 1,702 x 1,981	3,226 x 1,295 x 1,981
Shipping weight (est)	lb	6,500	7,000	kg	2,948	3,175

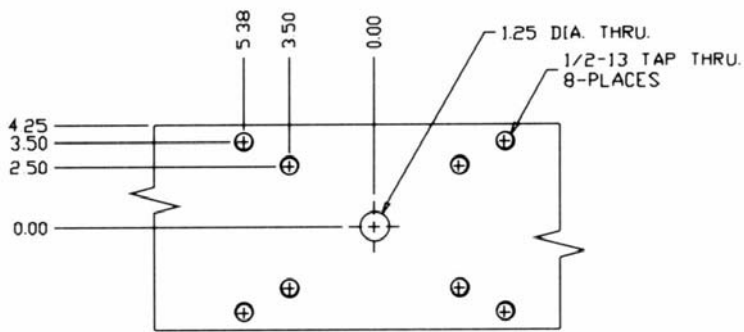
MAGNA V30



Upper Platen



Rotary



Shuttle Table Stroke 19.25"

Shuttle, Stationary

All specifications reflect average values based on typical machine layouts. Actual figures will vary depending on final machine configuration. If you require more specific data, consult a certified installation print for your particular machine. Performance specifications are based on theoretical data. Due to continual improvements, specifications are subject to change without notice.