MAGNA T 225

MILACRON®

Technical Specifications

	970 Frame								1540 Frame							
INJECTION UNIT	**Metric**	**A**	**B**	**C**	**English**	**A**	**B**	**C**	**Metric**	**A**	**B**	**C**	**English**	**A**	**B**	**C**
Injection Capacity, Maximum GPPS	gms	363	448	646	oz	12.8	15.8	22.8	gms	523	753	1025	oz	18.4	26.6	36.2
Theoretical Displacement	cm^3	382	471	679	in^3	23.3	28.7	41.4	cm^3	550	792	1078	in^3	33.6	48.3	65.8
Maximum Injection Pressure	bar	2249	2057	1428	psi	32600	29800	20700	bar	2236	1941	1426	psi	32400	28100	20600
Max Injection Rate	cm^3/sec	164	202	291	in^3/sec	10.0	12.3	17.8	cm^3/sec	149	214	291	in^3/sec	9.1	13.1	17.8
Screw Stroke	mm	240	240	240	in	9.4	9.4	9.4	mm	280	280	280	in	11.0	11.0	11.0
Screw Diameter	mm	45	50	60	in	1.77	1.97	2.36	mm	50	60	70	in	1.97	2.36	2.76
Screw L/D Ratio	L/D	26.7	24	20	L/D	26.7	24	20	L/D	28	23.3	20	L/D	28	23.3	20
Screw Speed	rpm	293	293	293	rpm	293	293	293	rpm	180	180	180	rpm	180	180	180
Screw Torque @172 bar	Nm	1305	1305	1305	in-lb	11800	11800	11800	Nm	2126	2126	2126	in-lb	19300	19300	19300
Plasticizing Rate GPPS	gm/sec	27	44	68	oz/sec	0.9	1.5	2.3	gm/sec	27	42	66	oz/sec	0.9	1.4	2.2
Number of Pyrometers (Barrel/Nozzle)	qty		4/1		qty		4/1		qty		4/1		qty		4/1	
Total Heat Capacity	kW		16.9		kW		16.9		kW		24.9		kW		24.9	
CLAMP																
Clamping Force	kN		2000		ton		224		kN		2000		ton		224	
Opening Force	kN		200		ton		22		kN		200		ton		22	
Clamp Stroke	mm		510		in		20.1		mm		510		in		20.1	
Maximum Daylight	mm		1220		in		48.0		mm		1220		in		48.0	
Minimum Mold Height	mm		200		in		7.9		mm		200		in		7.9	
Maximum Mold Height	mm		710		in		28.0		mm		710		in		28.0	
Platen Size (H × V)	mm		810 × 810		in		31.9 × 31.9		mm		810 × 810		in		31.9 × 31.9	
Distance Between Tie Rods	mm		570 × 570		in		22.4 × 22.4		mm		570 × 570		in		22.4 × 22.4	
Minimum Mold Area	mm		380 × 380		in		15.0 × 15.0		mm		380 × 380		in		15.0 × 15.0	
Tie Rod Diameter	mm		100		in		3.9		mm		100		in		3.9	
Ejector Stroke	mm		150		in		5.9		mm		150		in		5.9	
Ejector Force	kN		44		ton		4.9		kN		44		ton		4.9	
Maximum Mold Weight	kg		1,906		lbs		4,202		kg		1,906		lbs		4,202	
Dry Cycle Time (Euromap 6)	sec-mm		2.5 - 399		sec - in		2.5 - 15.7		sec-mm		2.5 - 399		sec - in		2.5 - 15.7	
GENERAL																
Electrical Motor	kW		13.6		hp		18.2		kW		13.6		hp		18.2	
Total Oil Capacity	L		525		gal		139		L		525		gal		139	
Water Supply (29°C Inlet Temp)	L/min		75		gal/min		19.8		L/min		75		gal/min		19.8	
Connected Load	kW		30.5		kW		30.5		kW		38.5		kW		38.5	
Overall Dimensions (L × W × H)	m		6.3 × 1.7 × 2.6		ft		20.7 × 5.6 × 8.5		m		6.3 × 1.7 × 2.6		ft		20.7 × 5.6 × 8.5	
Machine Weight	kg		8,650		lbs		19,070		kg		9,500		lbs		20,944	

***Note: All machine dimensions and specifications are subject to change. Values are for reference only.

MAGNA T 225 970 GENERAL ASSEMBLY DRAWINGS

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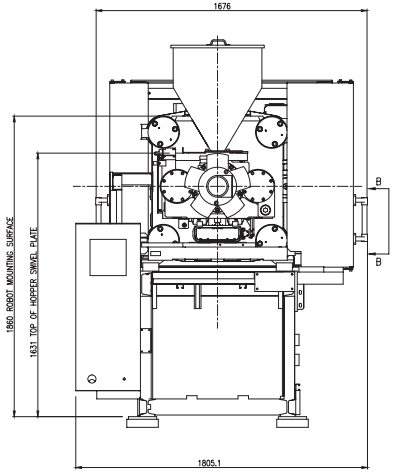
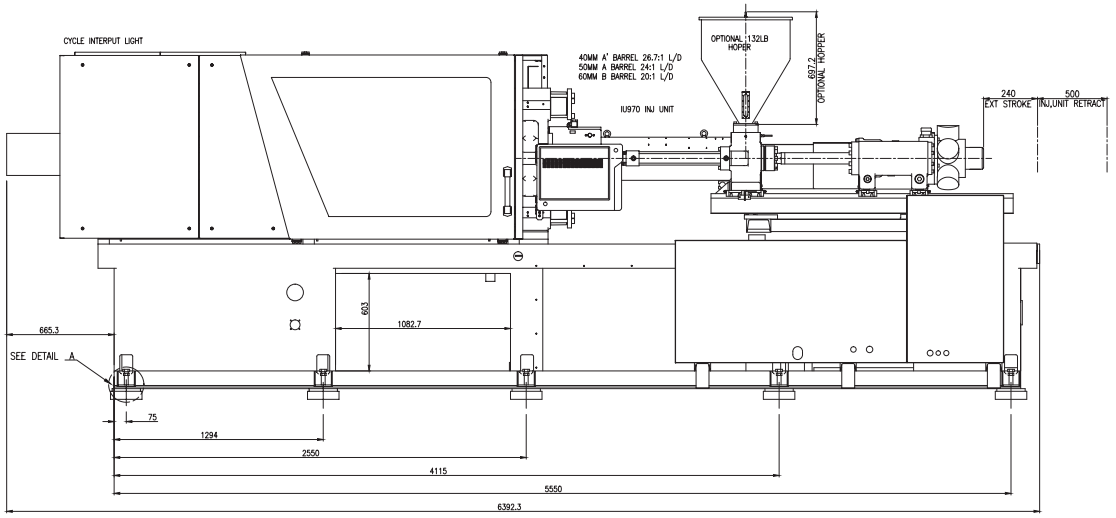
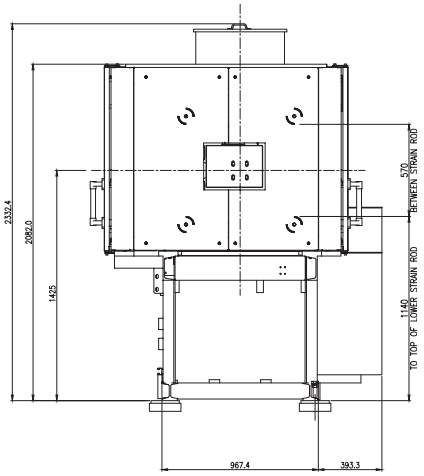
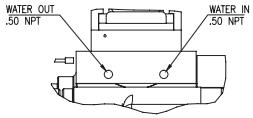
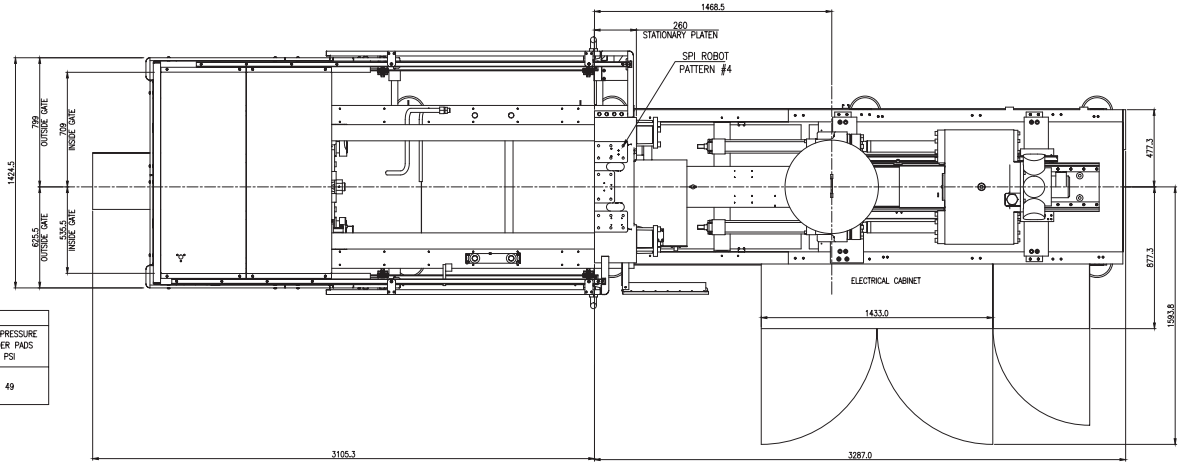


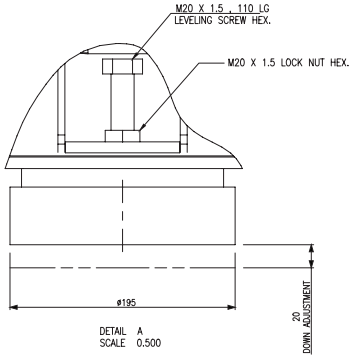






VIEW B–B
SCALE 0.200
FEED THROAT COOLING





DETAIL A
SCALE 0.500

TOTAL MACHINE WEIGHT (NO MOLD):

DRY 9,570 KG/ 21,098 LBS/ 10.54 US TONS

WITH OIL 10,022 KG/ 22,094 LBS/ 11.047 US TONS

WEIGHT WITH OIL (NO MOLD)				
WEIGHTS		# OF LEVELING PADS	AVG PRESSURE UNDER PADS N/cm2	AVG PRESSURE UNDER PADS PSI
KG	LB			
10,022	22,094	10	34	49

FMIL PART NO. 5311370–3 (10) PLACES
MAXINUM LEVELING MOUNT LOAD:
3500 KG

GENERAL ASSEMBLY MTs–225 WITH 970 INJ UNIT

MAGNA T 225 1540 GENERAL ASSEMBLY DRAWINGS

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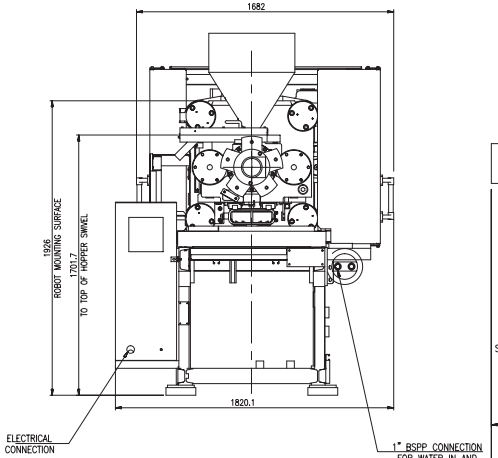
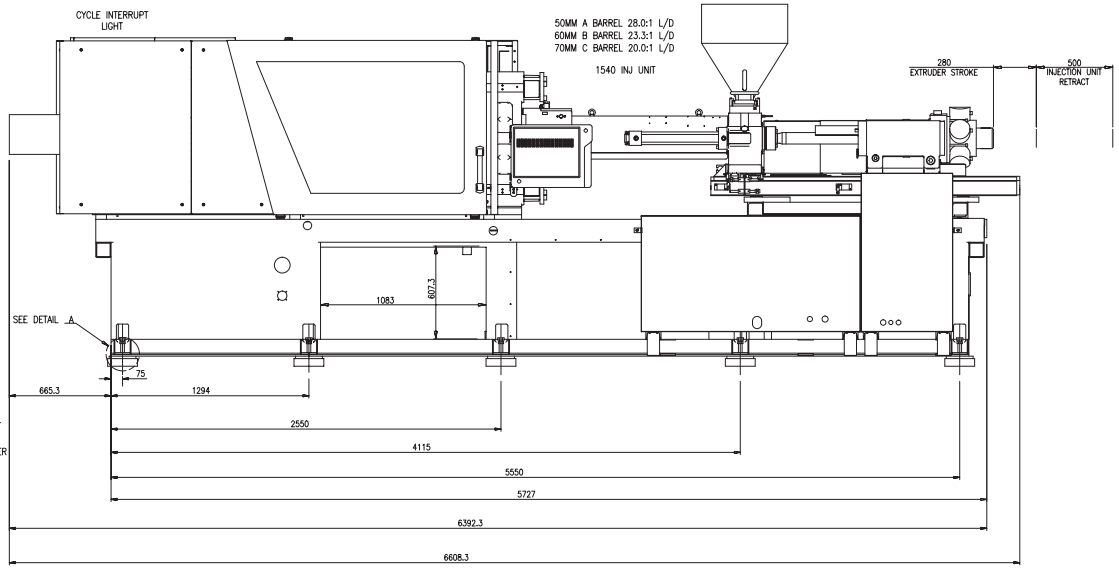
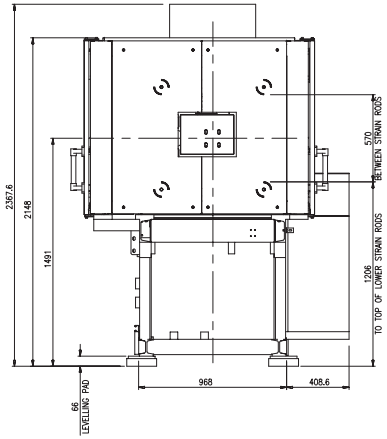
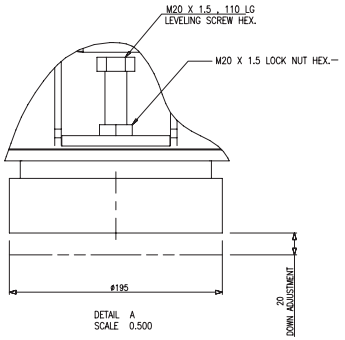
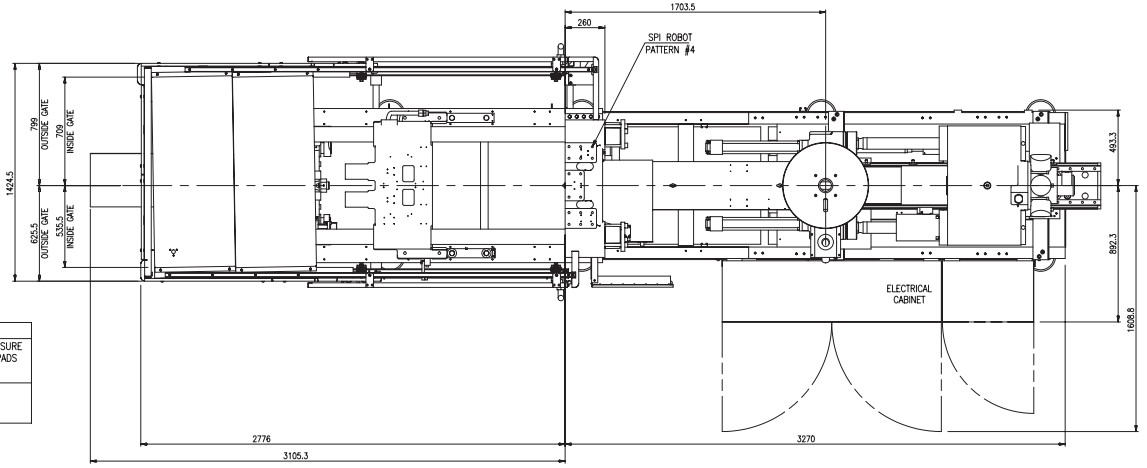


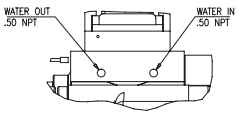






DETAIL A
SCALE 0.500





VIEW B-B
SCALE 0.200
FEED THROAT COOLING

TOTAL MACHINE WEIGHT (NO MOLD):

DRY.....10,000 KG/22,046 LBS/11.023 US TONS

WITH OIL.....10,452 KG/23,042 LBS/11.521 US TONS

WEIGHT WITH OIL (NO MOLD)				
WEIGHTS		# OF LEVELING PADS	AVG PRESSURE UNDER PADS N/cm2	AVG PRESSURE UNDER PADS PSI
KG	LB			
10,542	23,042	10	35	51

FMIL PART NO. 5311370-3 (10) PLACES
MAXINUM LEVELING MOUNT LOAD:

GENERAL ASSEMBLY MTs-225 SERVO 1540 INJ UNIT

MAGNA T 225

DIE SPACE DRAWINGS

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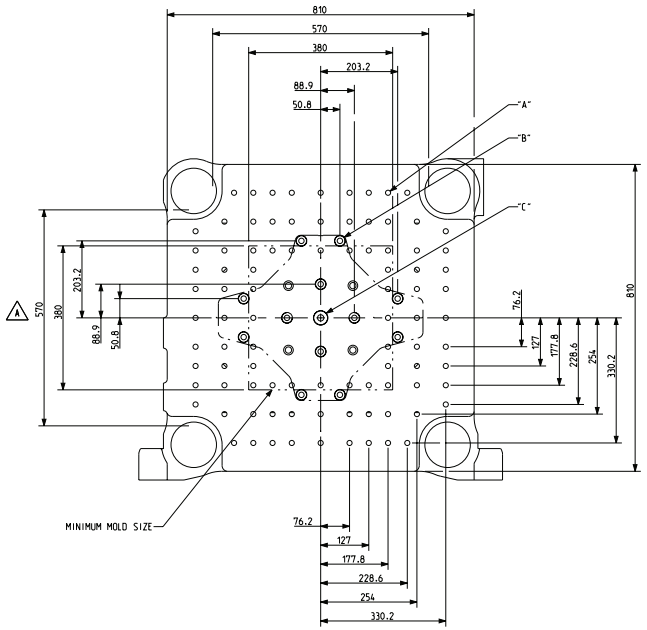
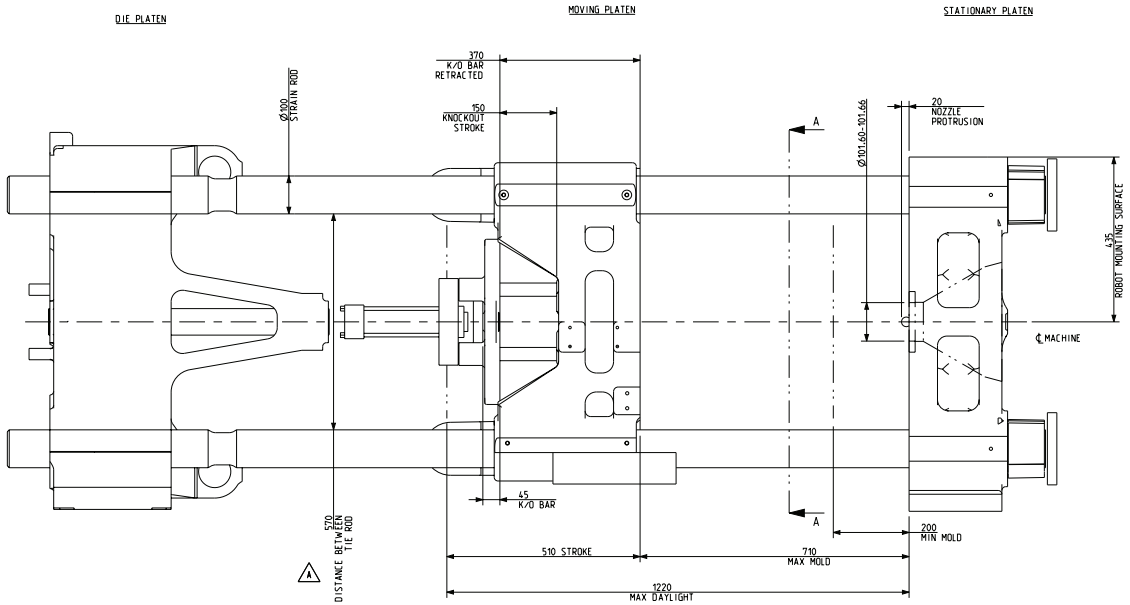
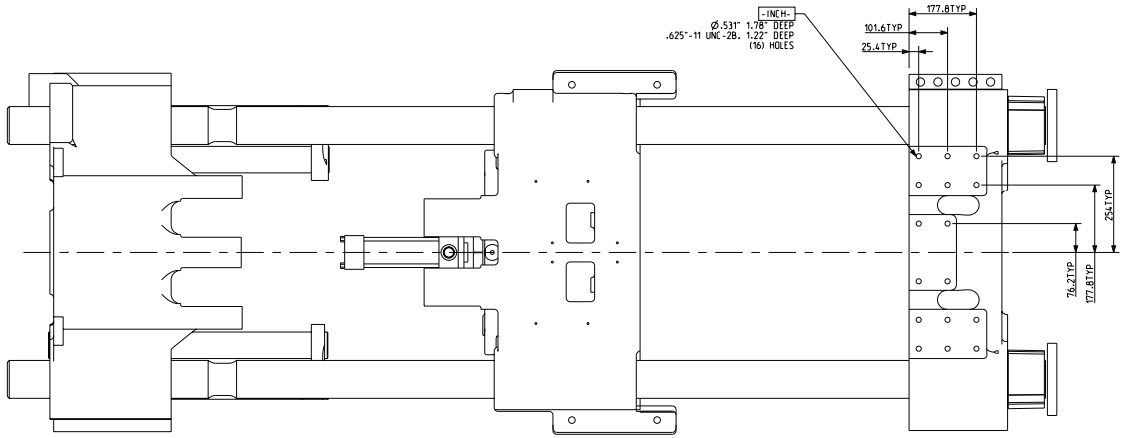


MOVING PLATEN VIEW
SECTION A-A





HOLE DESCRIPTION:

"A" - Ø.531", 1.78" DEEP, .625-11UNC-2B, 1.22" DEEP
(92) HOLES MOVING PLATEN, (92) HOLES STATIONARY PLATEN
"B" - Ø27.0 (1.063") THRU, (12) HOLES
"B" - CORRESPONDING HOLES IN K/O M 16 THRU (12) HOLES
"C" - Ø36.53 (1.438") THRU
"C" - CORRESPONDING HOLE IN K/O M 16 THRU, .750"-10 UNC-2B THRU

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