

## Technical Specifications

INJECTION UNIT	1540 Frame								2290 Frame							
	Metric	A	B	C	English	A	B	C	Metric	A	B	C	English	A	B	C
Injection Capacity, Maximum GPPS	gms	523	753	1025	oz	18.4	26.6	36.2	gms	861	1172	1530	oz	30.4	41.3	54.0
Theoretical Displacement	cm <sup>3</sup>	550	792	1078	in <sup>3</sup>	33.6	48.3	65.8	cm <sup>3</sup>	905	1232	1608	in <sup>3</sup>	55.2	75.2	98.1
Maximum Injection Pressure	bar	2236	1941	1426	psi	32400	28100	20600	bar	2238	1856	1421	psi	32400	26900	20600
Injection Rate	cm <sup>3</sup> /sec	246	351	478	in <sup>3</sup> /sec	15	21.4	29.2	cm <sup>3</sup> /sec	270	367	480	in <sup>3</sup> /sec	16.5	22.4	29.3
Screw Stroke	mm	280	280	280	in	11.0	11.0	11.0	mm	320	320	320	in	12.6	12.6	12.6
Screw Diameter	mm	50	60	70	in	1.97	2.36	2.76	mm	60	70	80	in	2.36	2.76	3.15
Screw L/D Ratio	L/D	28	23.3	20	L/D	28	23.3	20	L/D	26.7	22.9	20	L/D	26.7	22.9	20
Screw Speed	rpm	251	251	251	rpm	251	251	251	rpm	159	159	159	rpm	159	159	159
Screw Torque @172 bar	Nm	2126	2126	2126	in-lb	19300	19300	19300	Nm	3347	3347	3347	in-lb	30400	30400	30400
Plasticizing Rate GPPS	gm/sec	44	68	100	oz/sec	1.6	2.4	3.5	gm/sec	43	69	93	oz/sec	1.5	2.4	3.3
Number of Pyrometers (Barrel/Nozzle)	qty	4/1		qty	4/1		qty	4/1		qty	4/1		qty	4/1		
Total Heat Capacity	kW	24.9		kW	24.9		kW	39.6		kW	39.6					

### CLAMP

Clamping Force	kN	2750		ton	309		kN	2750		ton	309	
Opening Force	kN	275		ton	30		kN	275		ton	30	
Clamp Stroke	mm	610		in	24.0		mm	610		in	24.0	
Maximum Daylight	mm	1360		in	53.5		mm	1360		in	53.5	
Minimum Mold Height	mm	200		in	7.9		mm	200		in	7.9	
Maximum Mold Height	mm	750		in	29.5		mm	750		in	29.5	
Platen Size (H × V)	mm	940 × 940		in	37.0 × 37.0		mm	940 × 940		in	37.0 × 37.0	
Distance Between Tie Rods	mm	660 × 660		in	26.0 × 26.0		mm	660 × 660		in	26.0 × 26.0	
Minimum Mold Area	mm	440 × 440		in	17.3 × 17.3		mm	440 × 440		in	17.3 × 17.3	
Tie Rod Diameter	mm	115		in	4.5		mm	115		in	4.5	
Ejector Stroke	mm	160		in	6.3		mm	160		in	6.3	
Ejector Force	kN	74		ton	8.3		kN	74		ton	8.3	
Maximum Mold Weight	kg	2,831		lbs	6,241		kg	2,831		lbs	6,241	
Dry Cycle Time (Euromap 6)	sec-mm	2.6 - 462		sec - in	2.6 - 18.2		sec-mm	2.6 - 462		sec - in	2.6 - 18.2	

### GENERAL

Electrical Motor	kW	25.1		hp	33.6		kW	25.1		hp	33.6	
Total Oil Capacity	L	615		gal	162.7		L	615		gal	V	
Water Supply (29°C Inlet Temp)	L/min	75		gal/min	19.8		L/min	75		gal/min	19.8	
Connected Load	kW	61.9		kW	61.9		kW	76.6		kW	76.6	
Overall Dimensions (L × W × H)	m	7.2 × 1.9 × 2.8		ft	23.6 × 6.2 × 9.2		m	7.2 × 1.9 × 2.8		ft	23.6 × 6.2 × 9.2	
Machine Weight	kg	13,150		lbs	28,990		kg	14,100		lbs	31,085	

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

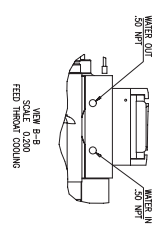
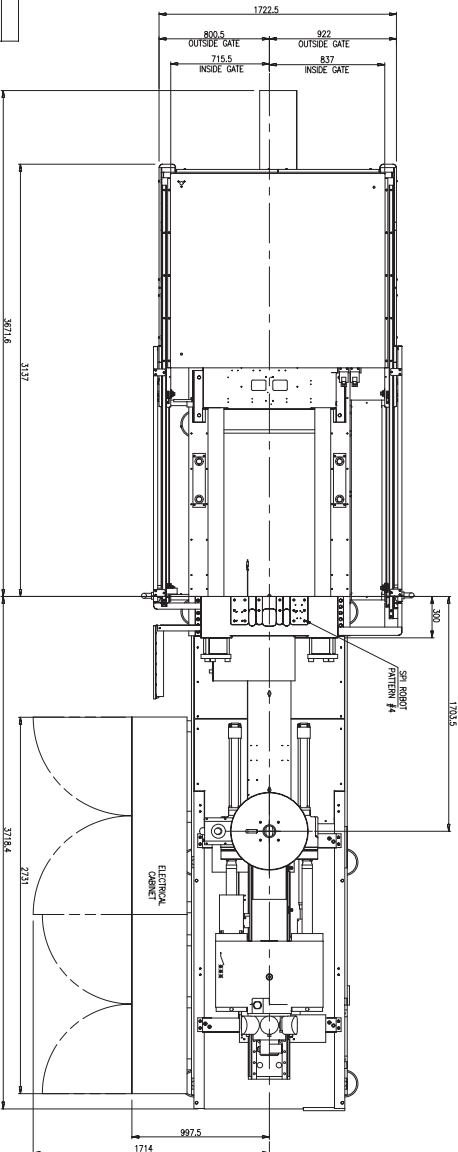
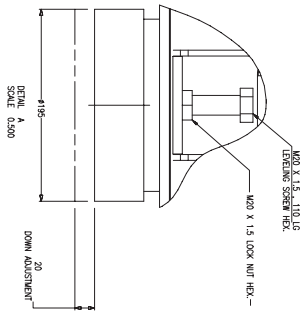
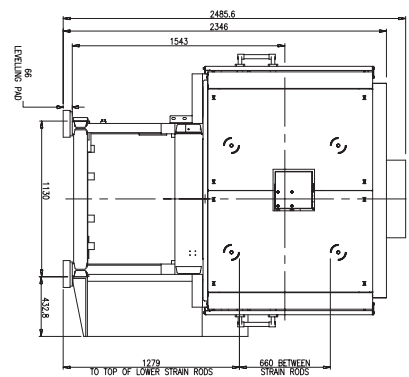
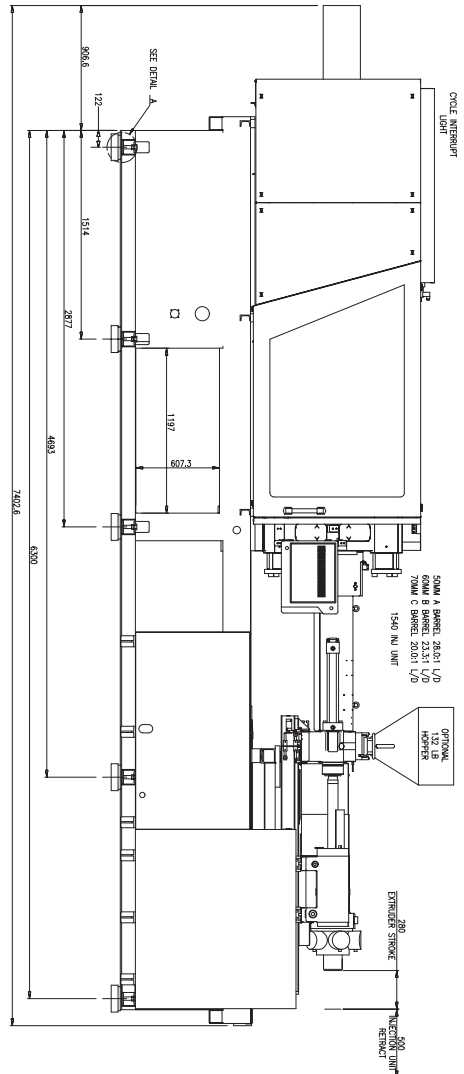
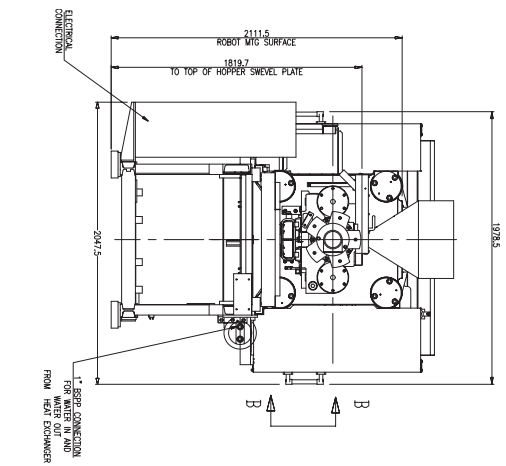
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## 310 1540

### GENERAL ASSEMBLY DRAWINGS



# MILACRON®



TOTAL MACHINE WEIGHT (NO MOLD):  
 DRY.....1,3170 KG/29,034 LBS/14.51 US TONS  
 WITH OIL.....13,699 KG/30,138 LBS/15.1 US TONS

WEIGHT WITH OIL (NO MOLD)

WEIGHTS		# OF LEVELING PADS	AVG PRESSURE UNDER PADS N/cm2	AVG PRESSURE UNDER PADS PSI
KG	LB			
16,699	30,138	10	46	67

FAIL PART NO. S311370-3 (10) PLACES  
 MAXIMUM LEVELING MOUNT LOAD:  
 3500 KG

GENERAL ASSEMBLY MT-S-310 SERV'D 1540 INJ UNIT

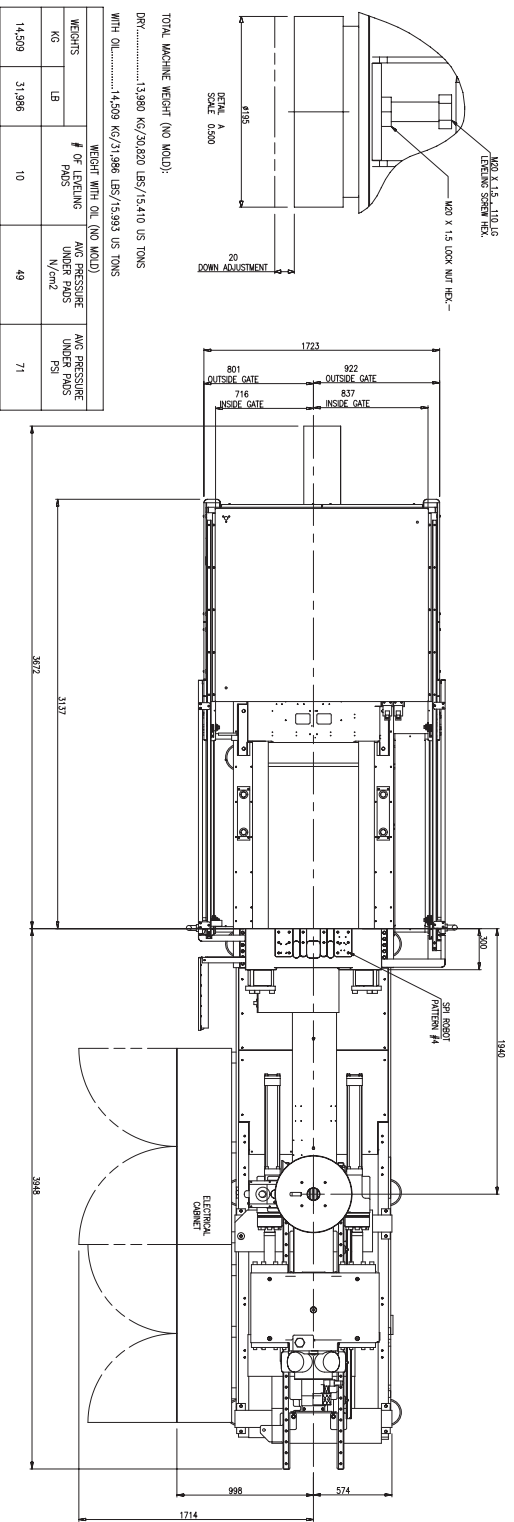
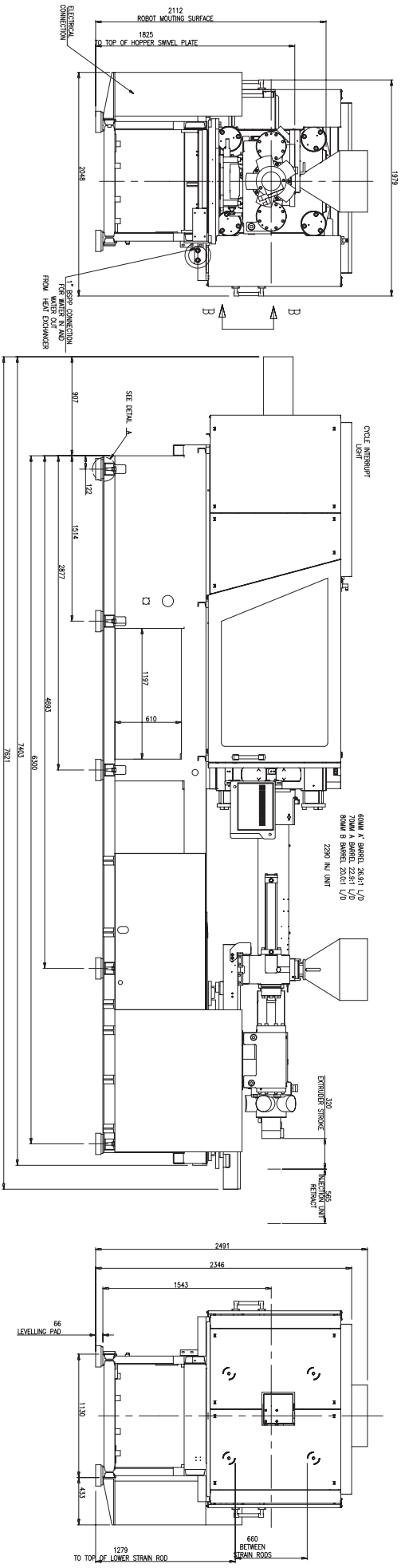
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# 310 2290

## GENERAL ASSEMBLY DRAWINGS



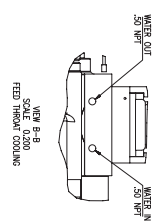
# MILACRON®



TOTAL MACHINE WEIGHT (NO MOLD):  
 DRY.....13,980 KG/30,820 LBS/15,410 US TONS  
 WITH OIL.....14,509 KG/31,986 LBS/15,993 US TONS

WEIGHT WITH OIL (NO MOLD)

WEIGHTS	# OF LIFTING PADS	AVG PRESSURE UNDER PADS N/cm <sup>2</sup>	AVG PRESSURE UNDER PADS PSI
KG	LB	10	49
14,509	31,986		71



GENERAL ASSEMBLY MTS-310 SERV0 2290 INU UNIT

TOTAL PART NO. S311370-3 (00) PLACES  
 PART NO. S311370-3 (00) PLACES  
 3500 KG

