



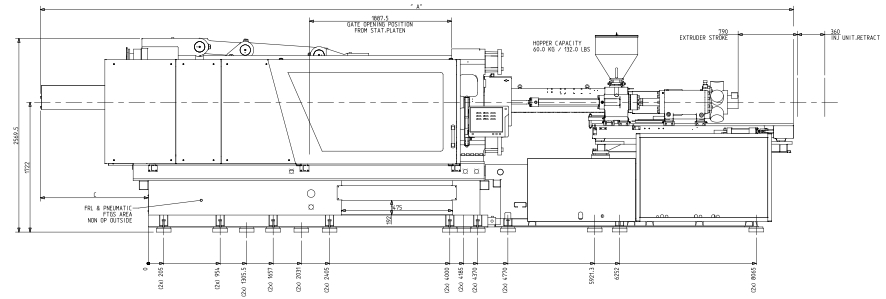
MAGNA

TOGGLE SERIES

Tonnage: 610

Frame Sizes:
3470, 4880

TECHNICAL SPECIFICATIONS



		3470 Frame			4880 Frame	
	ENGLISH METRIC	A	B	C	A	B
General						
Electrical Motor	hp kW		51.8 38.7			67.3 50.2
Total Oil Capacity	gal L		198.4 750			359.8 1,360
Water Supply (29°C Inlet Temp)	gal/min L/min		26.5 100			39.7 150
Connected Load	kW		96.6			104.1
Overall Dimensions (L x W x H)	ft m		32.1 x 8.6 x 8.7 9.8 x 2.6 x 2.6			33.5 x 8.7 x 9.7 10.2 x 2.7 x 3.0
Machine Weight	lbs kg		67,792 30,750			73,083 33,150
Injection Unit Specifications						
Injection Capacity, Maximum GPPS	oz gms	46.5 1,318	60.7 1,722	76.9 2,179	85.4 2,421	105.4 2,989
Theoretical Displacement	in ³ cm ³	84.5 1,385	110.4 1,810	139.7 2,290	155.3 2,545	191.7 3,142
Maximum Injection Pressure	psi bar	33,100 2,289	27,700 1,917	21,900 1,515	27,400 1,896	22,300 1,538
Injection Rate	in ³ /sec cm ³ /sec	26.7 438	34.9 572	44.2 724	43.9 720	54.2 889
Injection Velocity	in/sec mm/sec		3.8 97			*
Screw Stroke	in mm		14.2 360			15.7 400
Back Pressure Limits	psi bar		500 34.4			500 34.4
Screw Diameter	in mm	2.76 70	3.15 80	3.54 90	3.54 90	3.93 100
Screw L/D Ratio	L/D	25.7	22.5	20	22.2	20
Screw Speed	rpm	235	235	214	212	191
Screw Torque @172 bar	in-lb Nm		39,000 4,291			51,000 5,613
Plasticizing Rate (GPPS)	oz/sec gm/sec	3.0 86	4.1 116	4.7 134	4.9 140	5.6 160
Number of Pyrometers (Barrel/Nozzle)	qty		4/1			4/1
Total Heat Capacity	kW		57.9			53.9

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		3470 Frame			4880 Frame	
	ENGLISH METRIC	A	B	C	A	B
Clamp						
Clamping Force	ton kN		617 5,500		617 5,500	
Opening Force	ton kN		61 550		61 550	
Clamp Stroke	in mm		36.2 920		36.2 920	
Clamp Close Velocity	in/sec cm/sec		27.5 700		27.5 700	
Clamp Open Velocity	in/sec cm/sec		21.6 550		21.6 550	
Eject Force (forward)	tons kN		13.5 120		13.5 120	
Eject Velocity (forward)	in/sec cm/sec		4.92 125		4.92 125	
Eject Velocity (retract)	in/sec cm/sec		8.27 210		8.27 210	
Ejector Stroke	in mm		7.9 200		7.9 200	
Mold Protect Pressure	psi bar		986 68		986 68	
Maximum Daylight	in mm		71.7 1,820		71.7 1,820	
Minimum Mold Height	in mm		15.7 400		15.7 400	
Maximum Mold Height	in mm		35.4 900		35.4 900	
Maximum Mold Weight	lbs kg		18,298 8,300		18,298 8,300	
Platen Size (H x V)	in mm		52.36 x 51.18 1,330 x 1,300		52.36 x 51.18 1,330 x 1,300	
Distance Between Tie Rods	in mm		39.37 x 35.43 1,000 x 900		39.37 x 35.43 1,000 x 900	
Tie Rod Diameter	in mm		6.7 170		6.7 170	
Dry Cycle Time (Euromap 6)	sec		4.15		4.15	

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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