



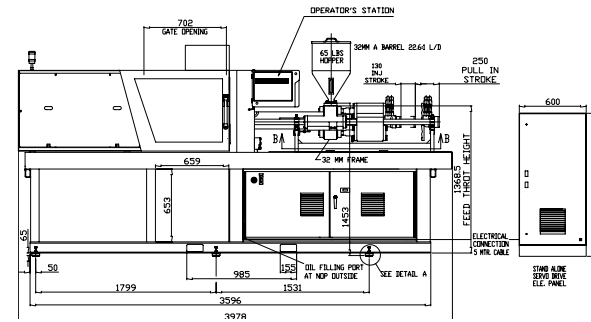
# MAGNA

## TOGGLE SERIES

Tonnage: 90

Frame Sizes:  
32mm, 40mm

## TECHNICAL SPECIFICATIONS



		32mm Frame			40mm Frame		
	ENGLISH METRIC	A	B	C	A	B	C
<b>General</b>							
Electrical Motor	hp kW		15 11.5			15 11.5	
Total Oil Capacity	gal L		58 220			58 220	
Water Supply (29°C Inlet Temp)	gal/min L/min		10.6 40			10.6 40	
Connected Load	kW		18.8			24.6	
Overall Dimensions (L x W x H)	ft m		13.0 x 4.9 x 6.8 [2] 3.98 x 1.5 x 2.1			13.0 x 4.9 x 6.8 [2] 4.48 x 1.5 x 2.1	
Machine Weight	lbs kg		8,904 4,039			9,868 4,476	
<b>Injection Unit Specifications</b>							
Injection Capacity, Maximum GPPS	oz gms	3.5 99	4.4 125	6.0 171	7.6 215	9.6 272	11.9 336
Theoretical Displacement	in <sup>3</sup> cm <sup>3</sup>	6.3 104	8.1 132	11.0 180	13.8 226	17.4 286	21.5 353
Maximum Injection Pressure	psi bar	30,000 2,074	23,700 1,639	17,400 1,204	27,500 1,901	21,700 1,502	17,600 1,217
Injection Rate	in <sup>3</sup> /sec cm <sup>3</sup> /sec	6.0 99	7.7 126	10.4 171	7.1 117	9.0 148	11.2 183
Injection Velocity	in/sec mm/sec		4.9 125			3.7 94	
Screw Stroke	in mm		5.1 130			7.1 180	
Back Pressure Limits	psi bar		500 34.4			500 34.4	
Screw Diameter	in mm	1.26 32	1.42 36	1.65 42	1.57 40	1.77 45	1.97 50
Screw L/D Ratio	L/D	22.6	20	17	22.5	20	18
Screw Speed	rpm		298			237	
Screw Torque	in-lb Nm	6,000 665	6,100 671	6,100 671	7,600 846	7,600 846	7,600 846
	at psi at bar	2,466 170	2,495 172	2,495 172		2,495 172	
Plasticizing Rate (GPPS)	oz/sec gm/sec	0.4 11	0.5 15	0.8 23	0.6 16	0.8 22	1.1 30
Number of Pyrometers (Barrel/Nozzle)	qty		3/1			3/1	
Total Heat Capacity	kW		7.3			13.1	

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		32mm Frame			40mm Frame		
	ENGLISH METRIC	A	B	C	A	B	C
<b>Clamp</b>							
Clamping Force	ton kN		89 800			89 800	
Opening Force	ton kN		240 26			240 26	
Clamp Stroke	in mm		12.2 310			12.2 310	
Clamp Close Velocity	in/sec cm/sec		15.7 400			15.7 400	
Clamp Open Velocity	in/sec cm/sec		15.7 400			15.7 400	
Eject Force (forward)	tons kN		3.7 36			3.7 36	
Eject Velocity (forward)	in/sec cm/sec		13.5 343			13.5 343	
Eject Velocity (retract)	in/sec cm/sec		13.5 343			13.5 343	
Ejector Stroke	in mm		4.7 120			4.7 120	
Mold Protect Pressure	psi bar		493 34			493 34	
Maximum Daylight	in mm		28 710			28 710	
Minimum Mold Height	in mm		5.9 150			5.9 150	
Maximum Mold Height	in mm		15.7 400			15.7 400	
Maximum Mold Weight	lbs kg		1,528 693			1,528 693	
Platen Size (H x V)	in mm		24.0 x 22.2 610 x 565			24.0 x 22.2 610 x 565	
Distance Between Tie Rods	in mm		15.9 x 14.1 405 x 360			15.9 x 14.1 405 x 360	
Tie Rod Diameter	in mm		2.8 70			2.8 70	
Dry Cycle Time (Euromap 6)	sec		2.65			2.65	

#### 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.
- 2) Additional cabinet dimensions: 1.96 ft x 1.4 ft x 4.2 ft with 16 ft cable



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