



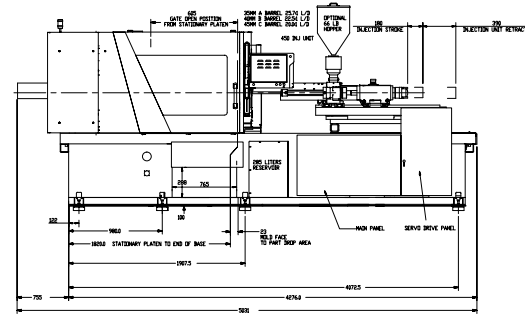
MAGNA

TOGGLE SERIES

Tonnage: 140

Frame Sizes:
450, 630

TECHNICAL SPECIFICATIONS



		450 Frame			630 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
General							
Electrical Motor	hp kW	15 11.5			15 11.5		
Total Oil Capacity	gal L	70 265			70 265		
Water Supply (29°C Inlet Temp)	gal/min L/min	13.2 50			13.2 50		
Connected Load	kW	22.8			27.2		
FLI / FLA (Full Load Amps) ²	Amps	53			58		
Main Circuit Breaker ²	Amps	90			90		
Overall Dimensions (L x W x H)	ft m	16.7 x 5.9 x 6.5 5.1 x 1.8 x 2.1			16.7 x 5.9 x 6.5 5.1 x 1.8 x 2.1		
Machine Weight	lbs kg	11,561 5,255			12,874 5,840		
Injection Unit Specifications							
Injection Capacity, Maximum GPPS	oz gms	5.8 165	7.6 215	9.6 272	8.4 239	10.7 303	13.2 374
Theoretical Displacement	in ³ cm ³	10.6 173	13.8 226	17.5 286	15.3 251	19.4 318	24.0 393
Maximum Injection Pressure	psi bar	35,400 2,443	28,700 1,984	22,700 1,568	36,100 2,492	28,500 1,969	23,100 1,595
Injection Rate	in ³ /sec cm ³ /sec	6.3 103	8.2 134	10.4 170	6.5 107	8.2 135	10.2 167
Injection Velocity	in/sec mm/sec	4.2 107			3.3 85		
Screw Stroke	in mm	7.1 180			7.9 200		
Back Pressure Limits	psi bar	500 34.4			500 34.4		
Screw Diameter	in mm	1.38 35	1.57 40	1.77 45	1.57 40	1.77 45	1.97 50
Screw L/D Ratio	L/D	25.7	22.5	20	25	22.2	20
Screw Speed	rpm	279			222		
Screw Torque @172 bar	in-lb Nm	7,900 876			9,800 1,080		
Plasticizing Rate (GPPS)	oz/sec gm/sec	0.5 13	0.7 19	0.9 26	0.5 15	0.7 20	1.2 33

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		450 Frame			630 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
Injection Unit Specifications (continued)							
Number of Pyrometers (Barrel/Nozzle)	qty	4/1			4/1		
Total Heat Capacity	kW	11.3			15.7		
Clamp							
Clamping Force	ton kN	140 1,250			140 1,250		
Opening Force	ton kN	14 125			14 125		
Clamp Stroke	in mm	13.8 350			13.8 350		
Clamp Close Velocity	in/sec cm/sec	16.5 420			16.5 420		
Clamp Open Velocity	in/sec cm/sec	22.6 575			22.6 575		
Eject Force (forward)	tons kN	3.9 35			3.9 35		
Eject Velocity (forward)	in/sec cm/sec	11.8 300			11.8 300		
Eject Velocity (retract)	in/sec cm/sec	11.8 300			11.8 300		
Ejector Stroke	in mm	4.7 120			4.7 120		
Mold Protect Pressure	psi bar	986 68			986 68		
Maximum Daylight	in mm	32.7 830			32.7 830		
Minimum Mold Height	in mm	5.9 150			5.9 150		
Maximum Mold Height	in mm	18.9 480			18.9 480		
Maximum Mold Weight	lbs kg	2,271 1,030			2,271 1,030		
Platen Size (H x V)	in mm	25.7 x 25.7 655 x 655			25.7 x 25.7 655 x 655		
Distance Between Tie Rods	in mm	17.1 x 17.1 435 x 435			17.1 x 17.1 435 x 435		
Tie Rod Diameter	in mm	3.1 80			3.1 80		
Dry Cycle Time (Euromap 6)	sec	2.3			2.3		

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) These values are for standard machine horsepower and voltage (460v/3ph/60Hz) with no additional options.



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