



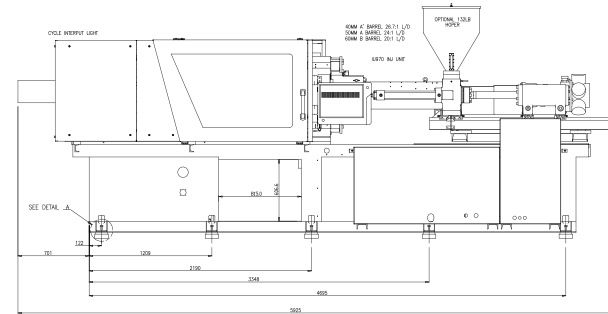
# MAGNA

## TOGGLE SERIES

Tonnage: 170

Frame Sizes:  
630, 970

## TECHNICAL SPECIFICATIONS



		630 Frame			970 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	110 415			110 415		
Water Supply (29°C Inlet Temp)	gal/min L/min	13.2 50			13.2 50		
Connected Load	kW	27.2			28.4		
FLI / FLA (Full Load Amps) <sup>2</sup>	Amps	58			60		
Main Circuit Breaker <sup>2</sup>	Amps	100			100		
Overall Dimensions (L x W x H)	ft m	19.4 x 6.5 x 7.5 5.6 x 1.95 x 2.3			19.4 x 6.5 x 7.5 6 x 1.97 x 2.3		
Machine Weight	lbs kg	15,696 7,120			16,755 7,600		
<b>Injection Unit Specifications</b>							
Injection Capacity, Maximum GPPS	oz gms	8.4 239	10.7 303	13.2 374	12.8 363	15.8 448	22.8 646
Theoretical Displacement	in <sup>3</sup> cm <sup>3</sup>	15.3 251	19.4 318	24 393	23.3 382	28.7 471	41.4 679
Maximum Injection Pressure	psi bar	36,100 2,492	28,500 1,969	23,100 1,595	32,600 2,249	29,800 2,057	20,700 1,428
Injection Rate	in <sup>3</sup> /sec cm <sup>3</sup> /sec	6.5 107	8.2 135	10.2 167	6.4 105	7.8 129	11.3 186
Injection Velocity	in/sec mm/sec	3.3 85			2.6 66		
Screw Stroke	in mm	7.9 200			9.4 240		
Back Pressure Limits	psi bar	500 34.4			500 34.4		
Screw Diameter	in mm	1.57 40	1.77 45	1.97 50	1.77 45	1.97 50	2.36 60
Screw L/D Ratio	L/D	25	22.2	20	26.7	24	20
Screw Speed	rpm	222			188		
Screw Torque @172 bar	in-lb Nm	9,800 1,080			11,800 1,305		
Plasticizing Rate (GPPS)	oz/sec gm/sec	0.53 15	0.71 20	1.16 33	0.60 17	0.99 28	1.52 43

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		630 Frame			970 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
<b>Injection Unit Specifications (continued)</b>							
Number of Pyrometers (Barrel/Nozzle)	qty	4/1			4/1		
Total Heat Capacity	kW	15.7			16.9		
<b>Clamp</b>							
Clamping Force	ton kN	168 1,500			168 1,500		
Opening Force	ton kN	16 150			16 150		
Clamp Stroke	in mm	17.3 440			17.3 440		
Clamp Close Velocity	in/sec cm/sec	25.5 650			25.5 650		
Clamp Open Velocity	in/sec cm/sec	21.6 550			21.6 550		
Eject Force (forward)	tons kN	4.9 44			4.9 44		
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	5.1 130			5.1 130		
Mold Protect Pressure	psi bar	986 68			986 68		
Maximum Daylight	in mm	37.4 950			37.4 950		
Minimum Mold Height	in mm	5.9 150			5.9 150		
Maximum Mold Height	in mm	20.1 510			20.1 510		
Maximum Mold Weight	lbs kg	3,307 1,500			3,307 1,500		
Platen Size (H x V)	in mm	29.1 x 29.1 740 x 740			29.1 x 29.1 740 x 740		
Distance Between Tie Rods	in mm	20.1 x 20.1 510 x 510			20.1 x 20.1 510 x 510		
Tie Rod Diameter	in mm	3.3 85			3.3 85		
Dry Cycle Time (Euromap 6)	sec	2.5			2.5		

**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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