



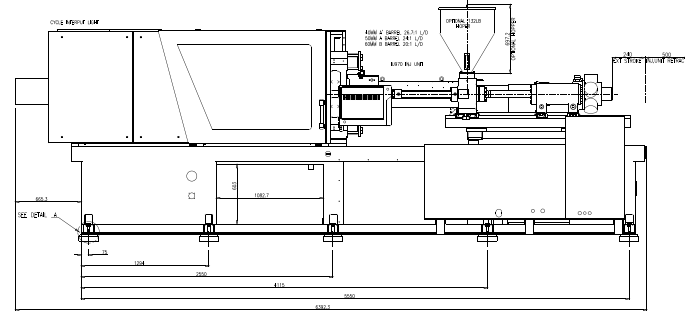
MAGNA

TOGGLE SERIES

Tonnage: 225

Frame Sizes:
970, 1540

TECHNICAL SPECIFICATIONS



		970 Frame			1540 Frame		
	ENGLISH METRIC	A	B	C	A	B	C
General							
Electrical Motor	hp kW	18 13.6			18 13.6		
Total Oil Capacity	gal L	139 525			139 525		
Water Supply (29°C Inlet Temp)	gal/min L/min	19.8 75			19.8 75		
Connected Load	kW	30.5			38.5		
FLI / FLA (Full Load Amps) ²	Amps	63			73		
Main Circuit Breaker ²	Amps	125			125		
Overall Dimensions (L x W x H)	ft m	20.1 x 5.9 x 7.5 6.4 x 2.1 x 2.4			21.7 x 5.9 x 7.5 6.6 x 2.1 x 2.4		
Machine Weight	lbs kg	21,098 9,570			22,046 10,000		
Injection Unit Specifications							
Injection Capacity, Maximum GPPS	oz gms	12.8 363	15.8 448	22.8 646	18.4 523	26.6 753	36.2 1,025
Theoretical Displacement	in ³ cm ³	23.3 382	28.7 471	41.4 679	33.6 550	48.3 792	65.8 1,078
Maximum Injection Pressure	psi bar	32,600 2,249	29,800 2,057	20,700 1,428	32,400 2,236	28,100 1,941	20,600 1,426
Injection Rate	in ³ /sec cm ³ /sec	10 164	12.3 202	17.7 291	9.0 149	13.0 214	17.7 291
Injection Velocity	in/sec mm/sec	4.0 103			3.0 76		
Screw Stroke	in mm	9.4 240			11 280		
Back Pressure Limits	psi bar	500 34.4			500 34.4		
Screw Diameter	in mm	1.77 45	1.97 50	2.36 60	1.97 50	2.36 60	2.76 70
Screw L/D Ratio	L/D	26.7	24	20	28	23.3	20
Screw Speed	rpm	293			180		
Screw Torque @172 bar	in-lb Nm	11,800 1,305			19,300 2,126		
Plasticizing Rate (GPPS)	oz/sec gm/sec	0.9 27	1.5 44	2.4 68	0.9 27	1.4 41	2.3 66

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Pub Number: T4.1006.A.02.18

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		970 Frame			1540 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	16.9			24.9		
Clamp							
Clamping Force	ton kN	224 2,000			224 2,000		
Opening Force	ton kN	22 200			22 200		
Clamp Stroke	in mm	20.1 510			20.1 510		
Clamp Close Velocity	in/sec cm/sec	33.4 850			33.4 850		
Clamp Open Velocity	in/sec cm/sec	29.5 750			29.5 750		
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	5.9 150			5.9 150		
Mold Protect Pressure	psi bar	986 68			986 68		
Maximum Daylight	in mm	48 1,220			48 1,220		
Minimum Mold Height	in mm	7.9 200			7.9 200		
Maximum Mold Height	in mm	28 710			28 710		
Maximum Mold Weight	lbs kg	4,202 1,906			4,202 1,906		
Platen Size (H x V)	in mm	31.9 x 31.9 810 x 810			31.9 x 31.9 810 x 810		
Distance Between Tie Rods	in mm	22.4 x 22.4 570 x 570			22.4 x 22.4 570 x 570		
Tie Rod Diameter	in mm	3.9 100			3.9 100		
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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