



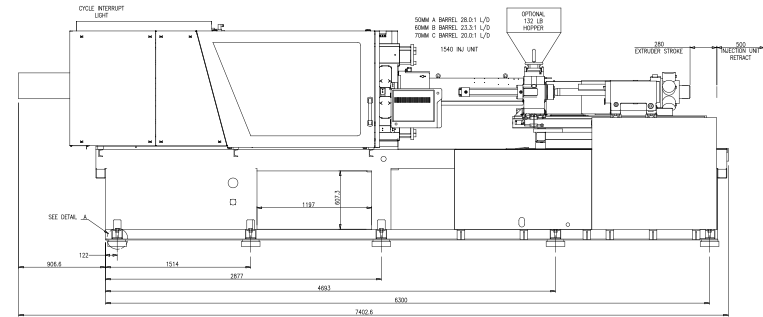
MAGNA

TOGGLE SERIES

Tonnage: 310

Frame Sizes:
1540, 2290

TECHNICAL SPECIFICATIONS



	ENGLISH METRIC	1540 Frame			2290 Frame		
		A	B	C	A	B	C
General							
Electrical Motor	hp kW		34 25.1			34 25.1	
Total Oil Capacity	gal L		162.7 615			162.7 615	
Water Supply (29°C Inlet Temp)	gal/min L/min		19.8 75			19.8 75	
Connected Load	kW		50			64.7	
FLI / FLA (Full Load Amps) ²	Amps		108			126	
Main Circuit Breaker ²	Amps		200			225	
Overall Dimensions (L x W x H)	ft m		24.3 x 6.6 x 8.2 7.45 x 2.22 x 2.5			25 x 6.6 x 8.2 7.65 x 2.22 x 2.5	
Machine Weight	lbs kg		29,034 13,170			30,820 13,980	
Injection Unit Specifications							
Injection Capacity, Maximum GPPS	oz gms	18.4 363	26.6 753	36.2 1,025	30.4 861	41.3 1,172	54.0 1,530
Theoretical Displacement	in ³ cm ³	33.6 550	48.3 792	65.8 1,078	55.2 905	75.2 1,232	98.1 1,608
Maximum Injection Pressure	psi bar	32,459 2,238	28,100 1,941	20,600 1,426	32,400 2,238	26,900 1,856	20,600 1,421
Injection Rate	in ³ /sec cm ³ /sec	15 246	21.4 351	29.2 478	16.5 270	22.4 367	29.3 480
Injection Velocity	in/sec mm/sec		4.8 124			3.7 96	
Screw Stroke	in mm		11 280			12.6 320	
Back Pressure Limits	psi bar		500 34.4			500 34.4	
Screw Diameter	in mm	1.97 50	2.36 60	2.76 70	2.36 60	2.76 70	3.15 80
Screw L/D Ratio	L/D	28	23.3	20	26.7	22.9	20
Screw Speed	rpm	295	295	273		187	
Screw Torque @172 bar	in-lb Nm		19,300 2,126			30,400 3,347	
Plasticizing Rate (GPPS)	oz/sec gm/sec	1.6 44	2.4 68	3.5 100	1.5 43	2.4 69	3.3 93

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		1540 Frame			2290 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	24.9			39.6		
Clamp							
Clamping Force	ton kN	309 2,750			309 2,750		
Opening Force	ton kN	30 275			30 275		
Clamp Stroke	in mm	24 610			24 610		
Clamp Close Velocity	in/sec cm/sec	27.5 700			27.5 700		
Clamp Open Velocity	in/sec cm/sec	23.6 600			23.6 600		
Eject Force (forward)	tons kN	8.3 74			8.3 74		
Eject Velocity (forward)	in/sec cm/sec	7.87 200			7.87 200		
Eject Velocity (retract)	in/sec cm/sec	11.8 300			11.8 300		
Ejector Stroke	in mm	6.3 160			6.3 160		
Mold Protect Pressure	psi bar	986 68			986 68		
Maximum Daylight	in mm	53.5 1,360			53.5 1,360		
Minimum Mold Height	in mm	7.9 200			7.9 200		
Maximum Mold Height	in mm	29.5 750			29.5 750		
Maximum Mold Weight	lbs kg	6,241 2,831			6,241 2,831		
Platen Size (H x V)	in mm	37 x 37 940 x 940			37 x 37 940 x 940		
Distance Between Tie Rods	in mm	26 x 26 660 x 660			26 x 26 660 x 660		
Tie Rod Diameter	in mm	4.5 115			4.5 115		
Dry Cycle Time (Euromap 6)	sec	2.8			2.8		

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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