



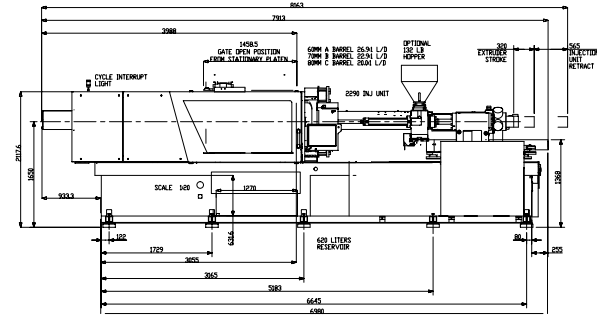
MAGNA

TOGGLE SERIES

Tonnage: 400

Frame Sizes:
2290, 3470

TECHNICAL SPECIFICATIONS



	ENGLISH METRIC	2290 Frame			3470 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	26.5 100			26.5 100		
Connected Load	kW	64.7			83		
FLI / FLA (Full Load Amps) ²	Amps	126			149		
Main Circuit Breaker ²	Amps	225			250		
Overall Dimensions (L x W x H)	ft m	25.9 x 7.08 x 8.62 7.9 x 2.2 x 2.7			28.1 x 7.08 x 8.62 8.6 x 2.2 x 2.7		
Machine Weight	lbs kg	39,683 18,000			40,785 18,500		
Injection Unit Specifications							
Injection Capacity, Maximum GPPS	oz gms	30.4 861	41.3 1,172	54.0 1,530	46.5 1,318	60.7 1,722	76.9 2,179
Theoretical Displacement	in ³ cm ³	55.2 905	75.2 1,232	98.1 1,608	84.5 1,385	110.4 1,810	139.7 2,290
Maximum Injection Pressure	psi bar	32,459 2,238	26,900 1,856	20,600 1,421	33,100 2,289	27,700 1,917	21,900 1,515
Injection Rate	in ³ /sec cm ³ /sec	16.5 270	22.4 367	29.3 480	22.6 272	21.7 356	27.5 450
Injection Velocity	in/sec mm/sec	3.7 96			2.7 71		
Screw Stroke	in mm	12.6 320			14.2 360		
Back Pressure Limits	psi bar	500 34.4			500 34.4		
Screw Diameter	in mm	2.36 60	2.76 70	3.15 80	2.76 70	3.15 80	3.54 90
Screw L/D Ratio	L/D	26.7	22.9	20	25.7	22.5	20
Screw Speed	rpm	187			146		
Screw Torque @172 bar	in-lb Nm	30,400 3,347			39,000 4,291		
Plasticizing Rate (GPPS)	oz/sec gm/sec	1.5 43	2.4 69	3.3 93	1.9 53	2.5 72	3.4 97

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4165 Half Acre Rd.,
Batavia OH 45103
513.536.2000
info@milacron.com
www.milacron.com

		2290 Frame			3470 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	39.6			57.9		
Clamp							
Clamping Force	ton kN	393 3,500			393 3,500		
Opening Force	ton kN	39 350			39 350		
Clamp Stroke	in mm	26.6 675			26.6 675		
Clamp Close Velocity	in/sec cm/sec	23.6 600			23.6 600		
Clamp Open Velocity	in/sec cm/sec	20.2 515			20.2 515		
Eject Force (forward)	tons kN	7.9 70			7.9 70		
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	7.9 200			7.9 200		
Mold Protect Pressure	psi bar	986 68			986 68		
Maximum Daylight	in mm	58.1 1,475			58.1 1,475		
Minimum Mold Height	in mm	11.8 300			11.8 300		
Maximum Mold Height	in mm	31.5 800			31.5 800		
Maximum Mold Weight	lbs kg	8,708 3,950			8,708 3,950		
Platen Size (H x V)	in mm	40.6 x 40.6 1,030 x 1,030			40.6 x 40.6 1,030 x 1,030		
Distance Between Tie Rods	in mm	28.3 x 28.3 720 x 720			28.3 x 28.3 720 x 720		
Tie Rod Diameter	in mm	5.1 130			5.1 130		
Dry Cycle Time (Euromap 6)	sec	4.3			4.3		

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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