



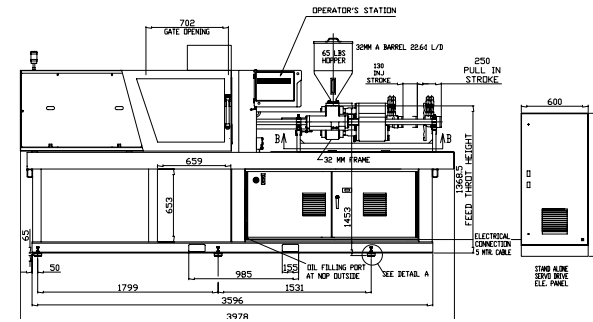
MAGNA

TOGGLE SERIES

Tonnage: 90

Frame Sizes:
32mm, 40mm

TECHNICAL SPECIFICATIONS



	ENGLISH METRIC	32mm Frame			40mm Frame		
		A	B	C	A	B	C
General							
Electrical Motor	hp kW		15 11.5			15 11.5	
Total Oil Capacity	gal L		58 220			58 220	
Water Supply (29°C Inlet Temp)	gal/min L/min		10.6 40			10.6 40	
Connected Load	kW		18.8			24.6	
FLI / FLA (Full Load Amps) ³	Amps		48			55	
Main Circuit Breaker ³	Amps		80			80	
Overall Dimensions (L x W x H)	ft m		13.0 x 4.9 x 6.8 [2] 3.98 x 1.5 x 2.1			13.0 x 4.9 x 6.8 [2] 4.48 x 1.5 x 2.1	
Machine Weight	lbs kg		8,904 4,039			9,868 4,476	
Injection Unit Specifications							
Injection Capacity, Maximum GPPS	oz gms	3.5 99	4.4 125	6.0 171	7.6 215	9.6 272	11.9 336
Theoretical Displacement	in ³ cm ³	6.3 104	8.1 132	11.0 180	13.8 226	17.4 286	21.5 353
Maximum Injection Pressure	psi bar	30,000 2,074	23,700 1,639	17,400 1,204	27,500 1,901	21,700 1,502	17,600 1,217
Injection Rate	in ³ /sec cm ³ /sec	6.0 99	7.7 126	10.4 171	7.1 117	9.0 148	11.2 183
Injection Velocity	in/sec mm/sec		4.9 125			3.7 94	
Screw Stroke	in mm		5.1 130			7.1 180	
Back Pressure Limits	psi bar		500 34.4			500 34.4	
Screw Diameter	in mm	1.26 32	1.42 36	1.65 42	1.57 40	1.77 45	1.97 50
Screw L/D Ratio	L/D	22.6	20	17	22.5	20	18
Screw Speed	rpm		298			237	
Screw Torque	in-lb Nm	6,000 665	6,100 671	6,100 671	7,600 846	7,600 846	7,600 846
	at psi at bar	2,466 170	2,495 172	2,495 172		2,495 172	
Plasticizing Rate (GPPS)	oz/sec gm/sec	0.4 11	0.5 15	0.8 23	0.6 16	0.8 22	1.1 30

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

		32mm Frame			40mm Frame		
	ENGLISH METRIC	A	B	C	A	B	C
Injection Specifications (continued)							
Number of Pyrometers (Barrel/Nozzle)	qty	3/1			3/1		
Total Heat Capacity	kW	7.3			13.1		
Clamp							
Clamping Force	ton kN	89 800			89 800		
Opening Force	ton kN	240 26			240 26		
Clamp Stroke	in mm	12.2 310			12.2 310		
Clamp Close Velocity	in/sec cm/sec	15.7 400			15.7 400		
Clamp Open Velocity	in/sec cm/sec	15.7 400			15.7 400		
Eject Force (forward)	tons kN	3.7 36			3.7 36		
Eject Velocity (forward)	in/sec cm/sec	13.5 343			13.5 343		
Eject Velocity (retract)	in/sec cm/sec	13.5 343			13.5 343		
Ejector Stroke	in mm	4.7 120			4.7 120		
Mold Protect Pressure	psi bar	493 34			493 34		
Maximum Daylight	in mm	28 710			28 710		
Minimum Mold Height	in mm	5.9 150			5.9 150		
Maximum Mold Height	in mm	15.7 400			15.7 400		
Maximum Mold Weight	lbs kg	1,528 693			1,528 693		
Platen Size (H x V)	in mm	24.0 x 22.2 610 x 565			24.0 x 22.2 610 x 565		
Distance Between Tie Rods	in mm	15.9 x 14.1 405 x 360			15.9 x 14.1 405 x 360		
Tie Rod Diameter	in mm	2.8 70			2.8 70		
Dry Cycle Time (Euromap 6)	sec	2.65			2.65		

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) Additional cabinet dimensions: 1.96 ft x 1.4 ft x 4.2 ft with 16 ft cable
- 3) These values are for standard machine horsepower and voltage (460v/3ph/60Hz) with no additional options.



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