



MILACRON®

THE Q-PET SERVO



110-450 TON

THE Q-PET SERVO

CLAMP - FAST & PRECISE

The all new clamp system on the Q-series has been mounted on the LM guideways which provide precise movement with minimal frictional losses. The clamp system has higher mold carrying capacity, enhanced parallelism and squareness.

INJECTION

- 6 Stage Configurable Injection Velocity Profile
- Closed Loop Pressure Control through Servo
- 5 Fill Pressure Steps
- 10 Configurable Pack/Hold pressure steps
- Linear position transducer
- Sliding Hopper
- Insulated Ceramic Heaters
- Digital Setting of Extruder RPM & Digital Read Out of Actual RPM
- Proportional Extruder RPM control
- Heater Failure Detection & Monitoring on screen



2

MACHINE BASE - RUGGED

The Reduced Machine Base Height Provides Better Toggle Kinematics during High Speed Molding. The 3 Way Part Drop Provides Better Access to the Molded Parts.

MOLD SAFETY SYSTEM

The Mold is one of the most critical parts of the Injection Molding Process. The all new Q-Series machines takes care of your Mold with Mold Safety as a standard feature. It's a closed loop control process which senses presence of left over article from the last process cycle or any foreign article in between the core & the cavity. It's a continuous monitoring system. The control records & analyses the data after every process cycle.

3

SERVO POWER PACK

- For Energy Saving

Injection Unit Specifications

IU	630	970	1540	2290	3470
Q-PET SERVO 110					
Q-PET SERVO 150					
Q-PET SERVO 180					
Q-PET SERVO 230					
Q-PET SERVO 280					
Q-PET SERVO 350					
Q-PET SERVO 450					

Clamp Specifications

MODEL	TONNAGE	PLATEN SIZE (H X V)	TIE BAR SPACING (H X V)	MAX DAYLIGHT	MIN/MAX MOLD THICKNESS
	tons	mm	mm	mm	mm
Q-PET SERVO 110	110	690 x 645	480 x 435	900	150 / 520
Q-PET SERVO 150	150	780 x 740	550 x 510	1060	200 / 600
Q-PET SERVO 180	180	810 x 770	575 x 525	1100	200 / 600
Q-PET SERVO 230	230	920 x 820	660 x 560	1260	200 / 710
Q-PET SERVO 280	280	990 x 940	710 x 660	1400	250 / 750
Q-PET SERVO 350	350	1120 x 1035	810 x 725	1520	300 / 800
Q-PET SERVO 450	450	1245 x 1200	875 x 830	1670	350 / 820

NOTES

[illegible]

STANDARD FEATURES

CLAMP	
Moving Platen on LM Guides	●
Auto Lubrication	●
Grease Collection Trays below Toggle Area and Moving Platen	●
Part Drop Chute with Rubber Cladding	●
Auto Mold Height Adjustment	●
Mold Guard Safety Feature	●
Contactless Transducer for Clamp Position	●
Rear Door Handle	●
Clamp try again	●
Position Based Ramping for Accurate Position Switching, Precise Speed & Pressure Control	●
Proportional Speed Control with Operator Adjustable 5 Opening & 5 Closing Speeds	●
Jam Bar	○
T-Slot Platens	○
Part Drop Detect	○
Extended Daylight	○
Electric Power Gate - Front	○

INJECTION	
Plain Barrier Screw	●
Auto Screw Protection	●
Nozzle Contact Force by Pressure Switch for main IU	●
Layin Hopper Magnet	●
Cold Slug Removal by Extruder / Injection	●
Extra Heating Zone	○

EJECTOR	
Knock-Out Bar - Special Pattern (upto 350 T)	●
Eject Retract Verification by Limit Switch	●
Proportional Speed control through Pump (operator adjustable at control)	●
Pulsating Ejector Strokes upto 9 Pulses	●
Pilot Operated Check Valve for Ejector	●
Knock-Out Bar for Multipoint Ejection	●
2 Stage Programmable Forward & Retract Speeds	●
Intermediate Retract Set Point	●
Digital Readout Ejector Position	●
Pause Time between Ejector Forward Profile	●
Air Eject - Single & Double	○
Parallel Ejection - Ejector on Fly	○
Hydraulic Core Pull - Single & Double Sequence	○
Pneumatic Core Pull - Single or Double Sequence	○

TEMPERATURE CONTROL	
Feed Throat Temperature Control with Indication	●
PID Control Nozzle & Barrel	●
High / Low Temperature Alarms	●
Oil Temperature Control for Heat Exchanger	●

● - Standard Feature ○ - Optional Feature

CONTROLLER	
15.6" FHD Multi-Touch Capacitive Display	●
20 function keys with LEDs	●
Actual Injection Speed & Pressure Graph Display	●
30 Parameter monitoring for last 3000 cycles	●
500 Mold data storage	●
High / Low Limit Display for Each Adjustable Parameter	●
I/O diagnosis - Analog & Digital	●
Manual in PDF format for help	●
Overview Menu for Easy access of all axis parameters	●
Choice of Multiple Languages	●
Unit Selection (Metric or English)	●
Data Protection with four level of access	●
Graphical Representation of last 48 Hours Production	●
Daily Production Data of last 1 Year	●
Graphical Representation of Cycle Analysis	●
Energy Consumption analysis for each axis	●
Automatic Reporting of Process Data, Alarms, Change log (USB or Network location)	●
Change Log Menu:logs last 3000 Set Points Changes with Time/Date & User	●
3000 Alarms History with Date & Time Log	●
Process Mode:Functions with its Co-functions on a Single Key Press	●
Note Pad	●
Freely Programmable Smart Outputs & Inputs (total 3 inputs and outputs)	●
Freely Configurable Cores, Ejector & Air	●
4 User Configurable actual parameters for ease of monitoring for operator	●
Soft Keys for selection of Cores, Air & Mold Gates to operate in Set/Manual Mode	●
Favorite Page - Select 4 frequently used pages & operate from single page	●
Graphical display of Actual Zone Temperature of last 30 mins.	●
Favourite Page - Select 5 frequently used pages & operate from single page	●
Filtering of Alarm - Helps in quick analysis of specific alarm	●
Filtering & sort of Changelog - Helps in quick review / analysis of parameter changes	●
Configurable FlyOut area for viewing frequently used Monitoring Pages	●
No Page more than two click away	●
Auto shut down	●
Visual & Audible Alarm	●
Set point and actual values shown as absolute values	●
Pausibility check on values entered	●
Data saving in USB-Mold Data, Change log, Trend Data, Log book, Alarm History, Screen Shot	●
Shift wise Production Counter	●
Servo Motor / Drive diagnostic screen	●
Semi Auto Purge	●
Cold slug removal by extruder/ Injection	●
Intrusion Molding	●
Insert Molding	●
Freely Programmable Core pull Sequence	●
Energy meter on screen	●

STANDARD FEATURES

ADDITIONAL FEATURES	
Levelling Pads	●
Y Strainer in Heat Exchanger Inlet	●
Butter Fly Valve at Pump Suction Line	●
UV/OV Monitoring Relay-Voltage Monitor Relay	●
Filter Element IFR-2-06B-20-10B for Oil Filling	●
Hour Meter on Electrical Panel	●
Visual ON/OFF Indication with Z4 LED	●
Power On Push Button	●
Gauge Port for all Major Functions	●
Servo Motor Operated Gear Pump	●
Hydraulic Solenoid Valve Connector with ON/OFF LED Indicator	●
Water Manifold	○
Electrical Unscrewing	○
Hydraulic Unscrewing	○
Electric UPS for Control	○
Tubelight in Clamp Area	○
Dome Lamp 3-Tier, 4-Tier	○
Pneumatic Mold Gate Valve	○
Good / Defective Part Signal	○
Gas Assist Injection Interface	○
Latch & Blender Unit Interface	○
Integrated Hot Runner Controller	○
Stand Alone Hot Runner Controller	○
Water Battery with Temperature Indicator	○
Robot Interface (SPI & Euromap -12 & -67)	○
Water Saver Valve for Mold / Pulse Cooling	○
Fully Enclosed Clamp Unit for Mold Dehumidifier	○
Extra Power Supply Outlets with Available Combination	○
Safety Interlock Between Hot Runner Controller & Mold Water Cooling	○

● - Standard Feature ○ - Optional Feature

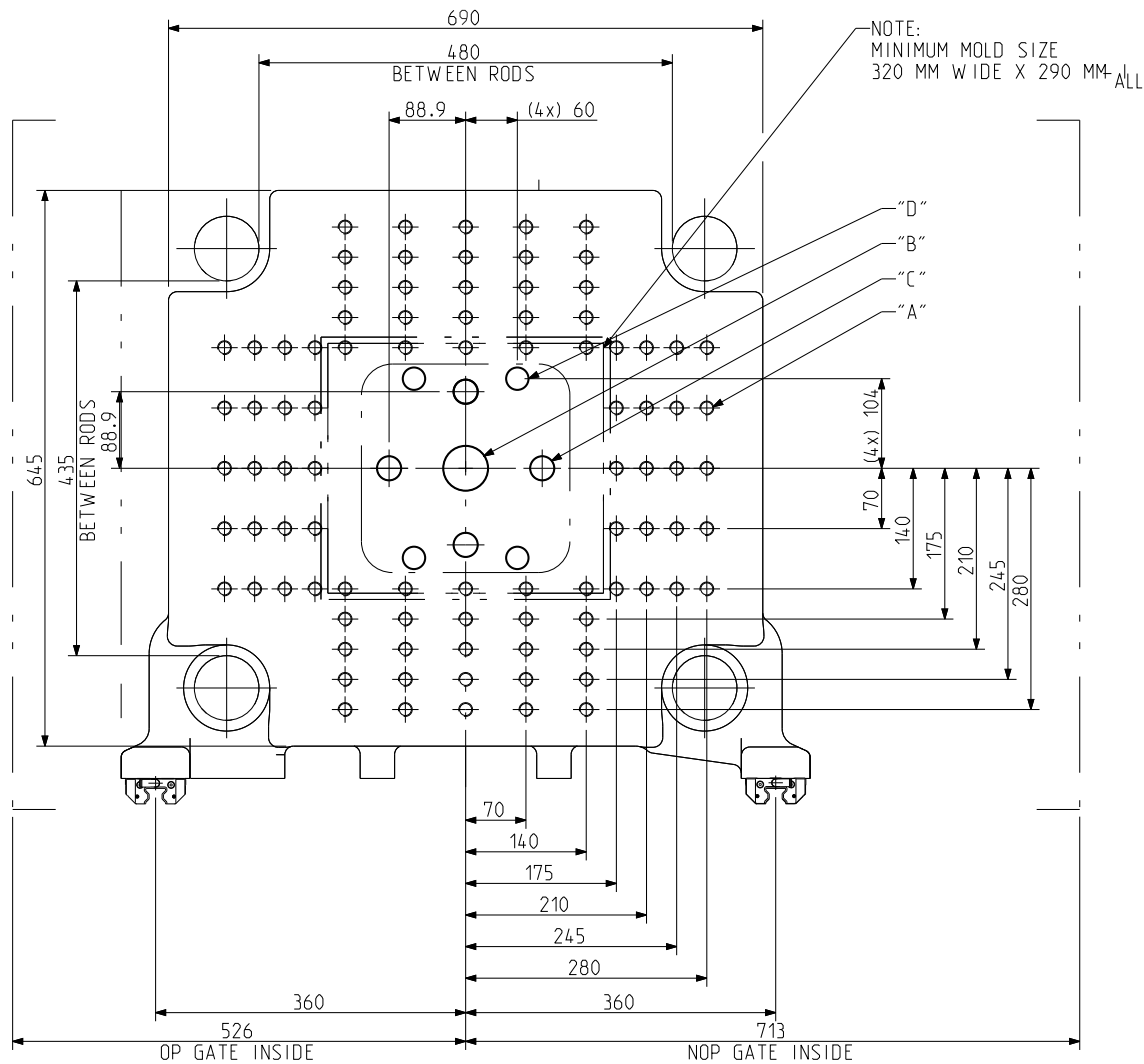
APPLICATIONS



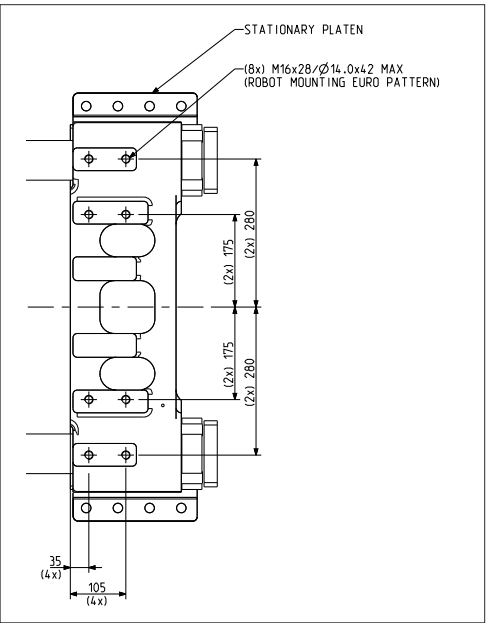
THE Q-PET SERVO
TONNAGE: 110

Injection Unit 630

TECHNICAL SPECIFICATIONS

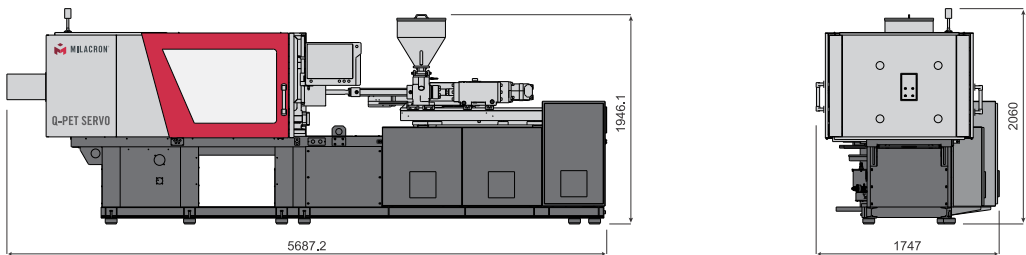


MOVING PLATEN
VIEW A-A



ALL DIMENSIONS ARE IN MM

- A M16x32 (90) PLACES ON BOTH PLATEN
- B MOVING PLATEN: Ø50(+0.025/-0.0) THRU BORE, K/O BAR CENTER HOLE M16 THRU.
STATIONARY PLATEN:
Ø100(+0.035/-0.0) WITH LOCATING RING,
Ø125(+0.04/-0.0) x 10(+0.15/-0.0) DEEP, WITHOUT LOCATING RING.
- C Ø27 THRU, (4) HOLES IN MOVING PLATEN
K/O BAR M16 THRU (4) HOLES
- D Ø25 THRU, (4) HOLES IN MOVING PLATEN
K/O BAR M12 THRU (4) HOLES



Q-PET SERVO 110	UNIT	630
	METRIC	
INJECTION UNIT SPECIFICATIONS		
INJECTION CAPACITY MAX. (PET)	gm	463
THEORETICAL DISPLACEMENT	cc	393
INJECTION PRESSURE MAX.	bar	1276
INJECTION RATE *	cc/sec	208
INJECTION SCREW STROKE	mm	200
SCREW DIAMETER	mm	50
SCREW L/D RATIO		24
SCREW SPEED	rpm	190
SCREW TORQUE @ 172 BAR	NM	1341
PLASTICIZING RATE (PET) *	gm/sec	55
NO.OF PYROMETERS (BARREL+NOZZLE)		4+1
TOTAL HEAT CAPACITY	KW	16.7
CLAMP UNIT SPECIFICATIONS		
CLAMP FORCE	Ton	110
OPENING FORCE	Ton	11
CLAMP STROKE	mm	380
MAXIMUM DAYIGHT	mm	900
MINIMUM MOULD HEIGHT	mm	150
MAXIMUM MOULD HEIGHT	mm	520
PLATEN SIZE (H X V)	mm	690 X 645
DISTANCE BETWEEN TIE ROD	mm	480 X 435
TIE ROD DIAMETER	mm	75
EJECTOR STROKE	mm	150
EJECTOR FORCE	Ton	5
MOULD WEIGHT CAPACITY (STAT. / MOVING)	kg	1540 (770 / 770)
DRY CYCLE TIME (EUROMAP 6) ***	sec-mm	1.65 - 336
GENERAL		
SERVO DRIVE **	kW	13.6
TOTAL OIL CAPACITY	L	375
WATER REQUIREMENT (INLET TEMP. 29°C)	lpm	80
CONNECTED LOAD	kW	30.3
MACHINE DIMENSION (L X W X H)	m	5.9 X 1.8 X 2.3
MACHINE WEIGHT	kg	5500

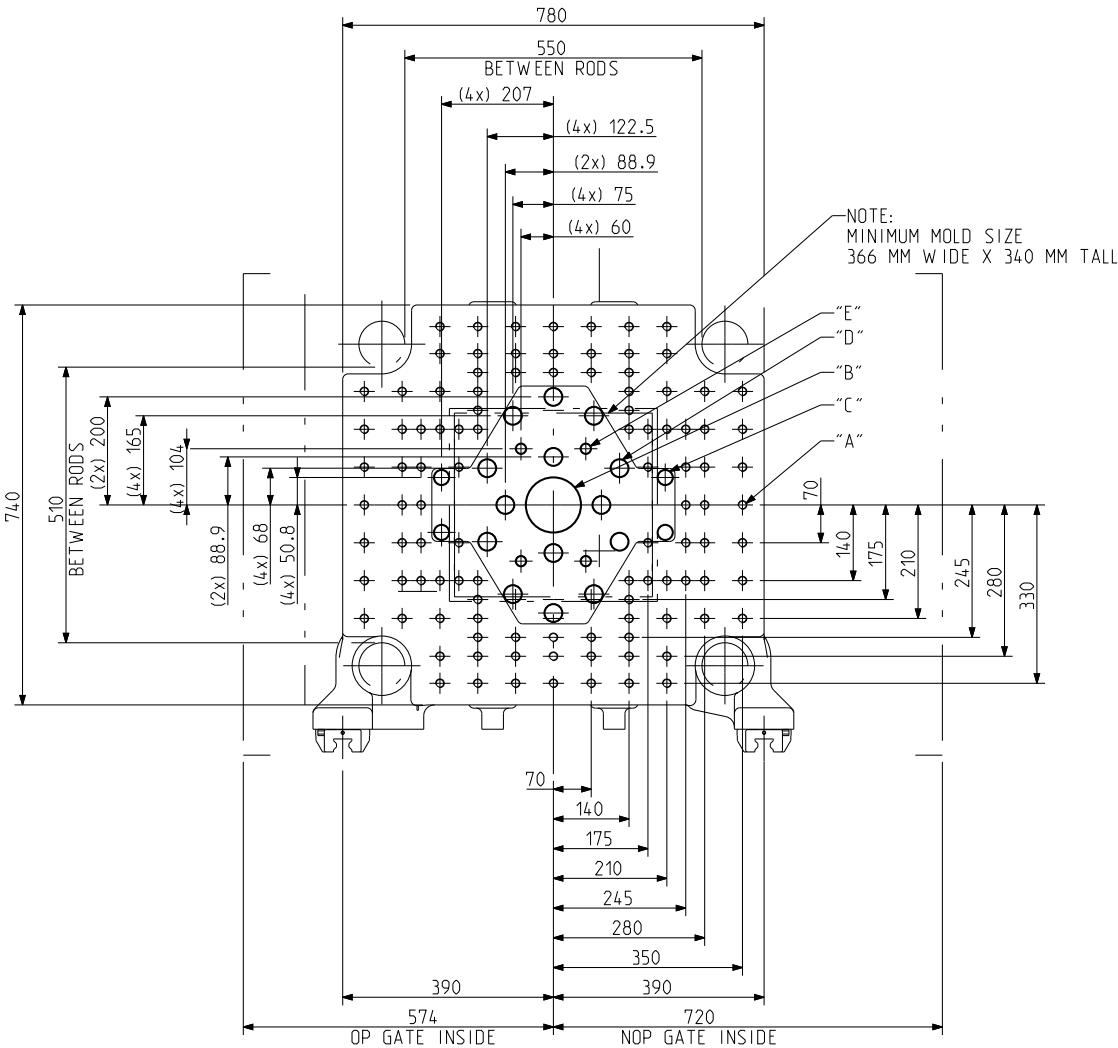
* WITH OPEN NOZZLE
** UNDER SPECIFIED CONDITION
***BREAKAWAY AND TONNAGE DECOMPRESSION TIMES ARE NOT INCLUDED IN DRY CYCLE TIME

All machine dimensions and specifications are subject to change. Values are for reference only. These values are for standard machine power.

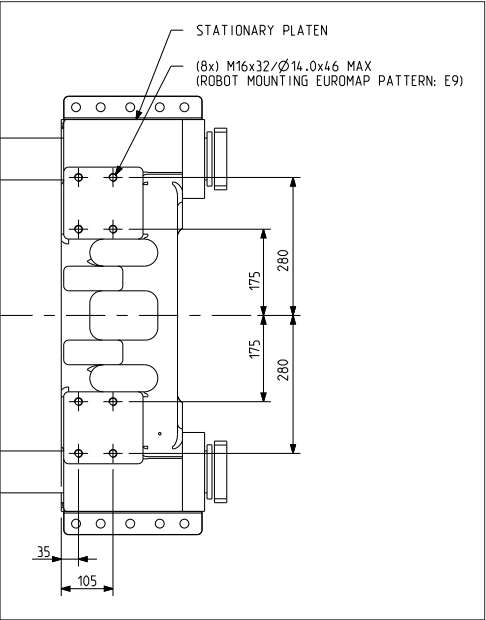
THE Q-PET SERVO
TONNAGE: 150

Injection Unit 630, 970, 1540

TECHNICAL SPECIFICATIONS

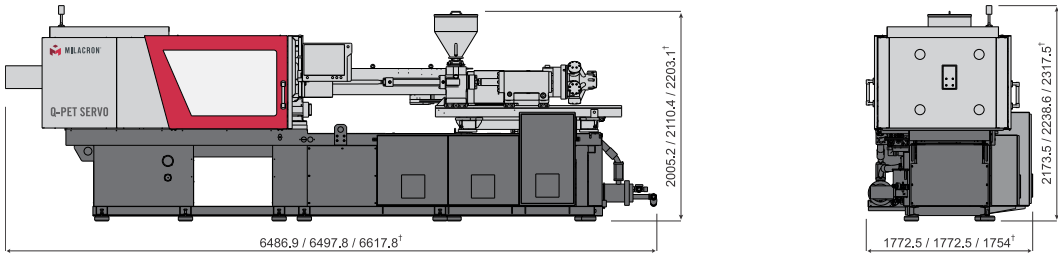


MOVING PLATEN
VIEW A-A



ALL DIMENSIONS ARE IN MM

- A MOVING PLATEN: M16x32 DEEP (104) PLACES,
STATIONARY PLATEN: M16x32 DEEP (116) PLACES.
- B MOVING PLATEN: Ø100(+0.035/-0.0) THRU BORE,
K/O BAR CENTER HOLE M16x40 DEEP.
- STATIONARY PLATEN: Ø125(+0.04/-0.0) WITH LOCATING RING,
Ø160(+0.04/-0.0) x 10(+0.15/-0.0) DEEP, WITHOUT LOCATING RING.
- C Ø27 THRU, (4) HOLES IN MOVING PLATEN
K/O BAR M16x40 DEEP
- D Ø32 THRU, (14) HOLES IN MOVING PLATEN
K/O BAR M16x40 DEEP
- E Ø18 THRU, (4) HOLES IN MOVING PLATEN
K/O BAR M12x40 DEEP



'IU 630 / 970 / 1540

Q-PET SERVO 150	UNIT	630	970	1540
	METRIC			
INJECTION UNIT SPECIFICATIONS				
INJECTION CAPACITY MAX. (PET)	gm	463	801	1272
THEORETICAL DISPLACEMENT	cc	393	679	1078
INJECTION PRESSURE MAX.	bar	1276	1224	1222
INJECTION RATE *	cc/sec	208	378	466
INJECTION SCREW STROKE	mm	200	240	280
SCREW DIAMETER	mm	50	60	70
SCREW L/D RATIO		24	24	24
SCREW SPEED	rpm	190	160	135
SCREW TORQUE @ 172 BAR	NM	1341	2159	3676
PLASTICIZING RATE (PET) *	gm/sec	55	85	100
NO.OF PYROMETERS (BARREL+NOZZLE)		4+1	4+1	4+1
TOTAL HEAT CAPACITY	KW	16.7	18.7	28
CLAMP UNIT SPECIFICATIONS				
CLAMP FORCE	Ton		150	
OPENING FORCE	Ton		15	
CLAMP STROKE	mm		460	
MAXIMUM DAYLIGHT	mm		1060	
MINIMUM MOULD HEIGHT	mm		200	
MAXIMUM MOULD HEIGHT	mm		600	
PLATEN SIZE (H X V)	mm		780 X 740	
DISTANCE BETWEEN TIE ROD	mm		550 X 510	
TIE ROD DIAMETER	mm		85	
EJECTOR STROKE	mm		175	
EJECTOR FORCE	Ton		8	
MOULD WEIGHT CAPACITY (STAT. / MOVING)	kg		2300 (1100 / 1200)	
DRY CYCLE TIME (EUROMAP 6) ***	sec-mm		1.70 - 385	
GENERAL				
SERVO DRIVE **	kW	13.6	25.1	27.2
TOTAL OIL CAPACITY	L	535	535	535
WATER REQUIREMENT (INLET TEMP. 29°C)	lpm	80	130	180
CONNECTED LOAD	kW	30.3	43.8	55.2
MACHINE DIMENSION (L X W X H)	m	6.5 X 1.8 X 2.5	6.6 X 1.8 X 2.5	7 X 1.8 X 2.5
MACHINE WEIGHT	kg	7600	7800	8200

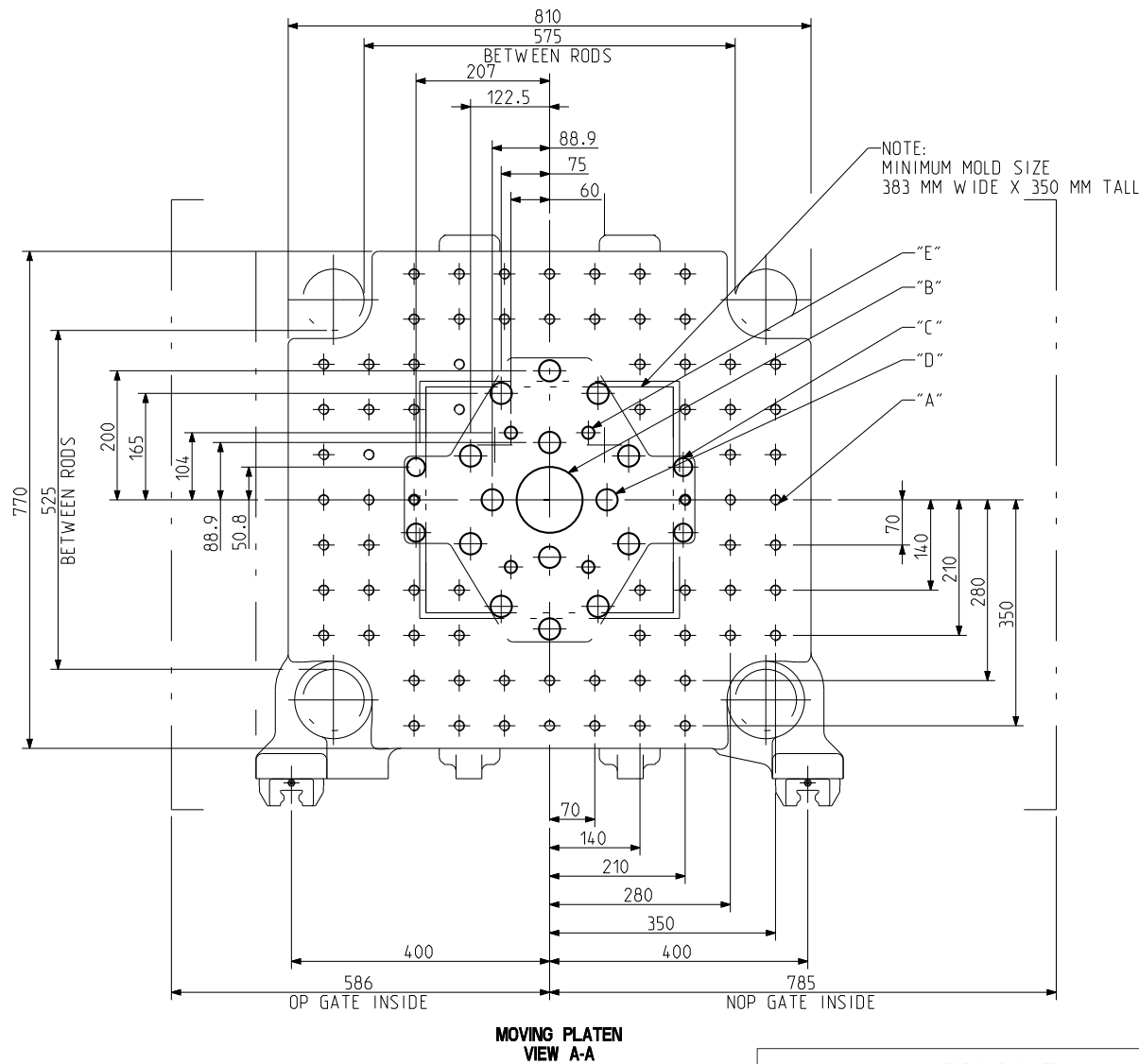
* WITH OPEN NOZZLE
** UNDER SPECIFIED CONDITION
***BREAKAWAY AND TONNAGE DECOMPRESSION TIMES ARE NOT INCLUDED IN DRY CYCLE TIME

All machine dimensions and specifications are subject to change. Values are for reference only. These values are for standard machine power.

THE Q-PET SERVO
TONNAGE: 180

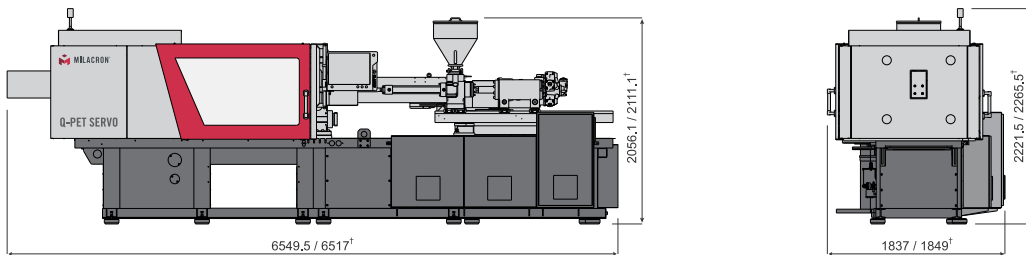
Injection Unit 630, 970, 1540

TECHNICAL SPECIFICATIONS



ALL DIMENSIONS ARE IN MM

- A MOVING PLATEN: M16x32 (74) PLACES,
STATIONARY PLATEN: M16x32 DEEP (84) PLACES.
- B MOVING PLATEN: Ø100(+0.035/-0.0) THRU BORE,
K/O BAR CENTER HOLE M16x40 DEEP.
- STATIONARY PLATEN: Ø125(+0.04/-0.0) WITH LOCATING RING,
Ø160(+0.04/-0.0) x 10(+0.15/-0.0) DEEP, WITHOUT LOCATING RING.
- C Ø27 THRU, (4) HOLES IN MOVING PLATEN
K/O BAR M16x40 DEEP
- D Ø32 THRU, (14) HOLES IN MOVING PLATEN
K/O BAR M16x40 DEEP
- E Ø18 THRU, (4) HOLES IN MOVING PLATEN
K/O BAR M12x40 DEEP



1U 630 / 970

Q-PET SERVO 180	UNIT	630	970	1540	1540/850 (Special Option)
	METRIC				
INJECTION UNIT SPECIFICATIONS					
INJECTION CAPACITY MAX. (PET)	gm	463	801	1272	1272
THEORETICAL DISPLACEMENT	cc	393	679	1078	1078
INJECTION PRESSURE MAX.	bar	1276	1224	1222	1222
INJECTION RATE *	cc/sec	208	378	466	466
INJECTION SCREW STROKE	mm	200	240	280	280
SCREW DIAMETER	mm	50	60	70	70
SCREW L/D RATIO		24	24	24	24
SCREW SPEED	rpm	190	160	135	135
SCREW TORQUE @ 172 BAR	NM	1341	2159	3676	3676
PLASTICIZING RATE (PET) *	gm/sec	55	85	100	100
NO.OF PYROMETERS (BARREL+NOZZLE)		4+1	4+1	5+1	5+1
TOTAL HEAT CAPACITY	KW	16.7	18.7	28	28
CLAMP UNIT SPECIFICATIONS					
CLAMP FORCE	Ton		180		180
OPENING FORCE	Ton		18		18
CLAMP STROKE	mm		500		500
MAXIMUM DAYLIGHT	mm		1100		1100
MINIMUM MOULD HEIGHT	mm		200		200
MAXIMUM MOULD HEIGHT	mm		600		600
PLATEN SIZE (H X V)	mm		810 X 770		810 X 850
DISTANCE BETWEEN TIE ROD	mm		575 X 525		575 X 525
TIE ROD DIAMETER	mm		95		95
EJECTOR STROKE	mm		175		200
EJECTOR FORCE	Ton		8		11
MOULD WEIGHT CAPACITY (STAT. / MOVING)	kg		2500 (1200 / 1300)		2500 (1200 / 1300)
DRY CYCLE TIME (EUROMAP 6) ***	sec-mm		1.85 - 402		1.85 - 402
GENERAL					
SERVO DRIVE **	kW	13.6	25.1	27.2	27.2
TOTAL OIL CAPACITY	L	535	535	535	650
WATER REQUIREMENT (INLET TEMP. 29°C)	lpm	80	130	180	220
CONNECTED LOAD	kW	30.3	43.8	55.2	55.2
MACHINE DIMENSION (L X W X H)	m	6.5 X 1.8 X 2.5	6.7 X 1.8 X 2.5	7.3 X 1.8 X 2.5	7.3 X 1.8 X 2.5
MACHINE WEIGHT	kg	8200	8500	9000	9500

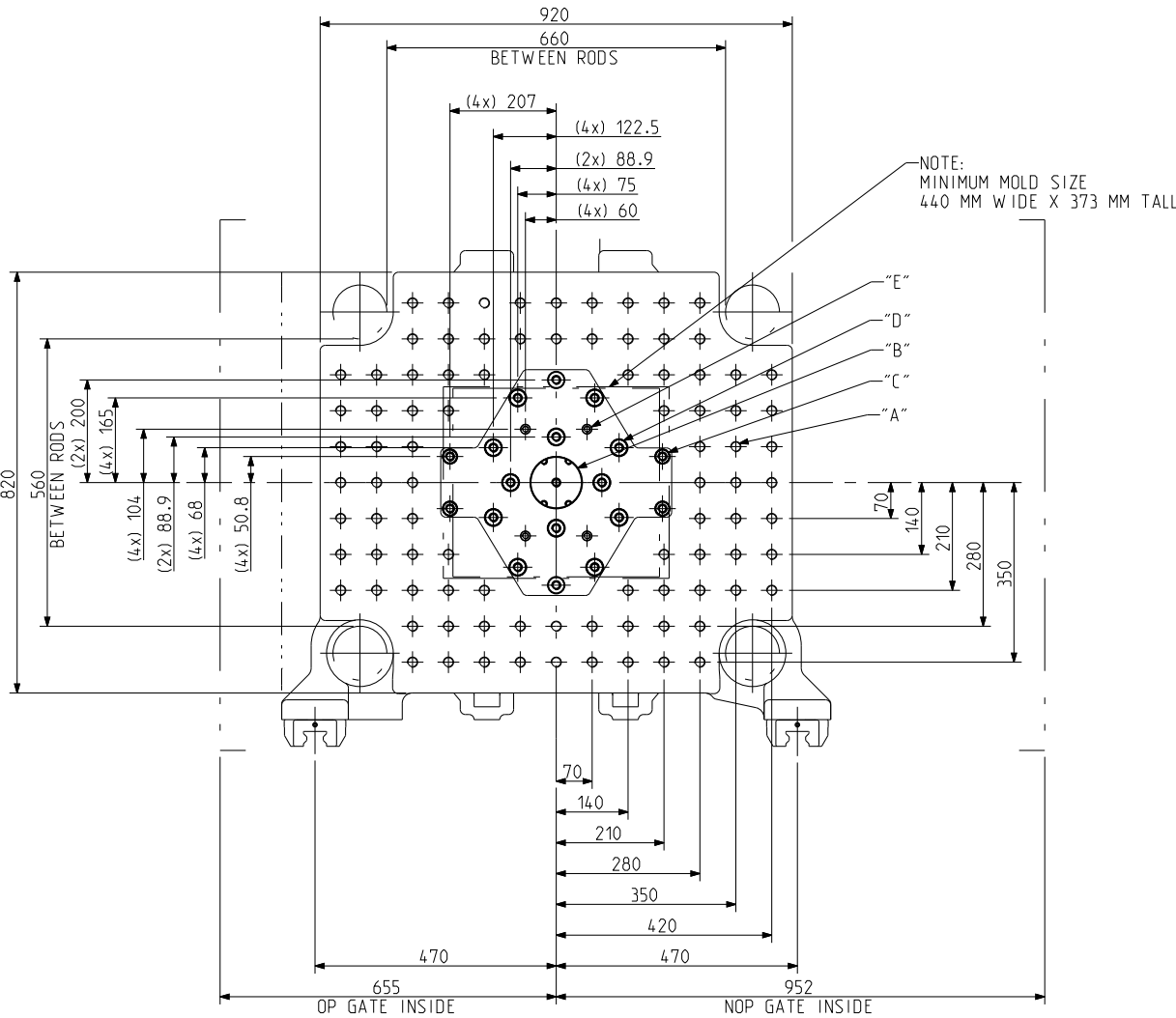
* WITH OPEN NOZZLE
** UNDER SPECIFIED CONDITION
***BREAKAWAY AND TONNAGE DECOMPRESSION TIMES ARE NOT INCLUDED IN DRY CYCLE TIME

All machine dimensions and specifications are subject to change. Values are for reference only. These values are for standard machine power.

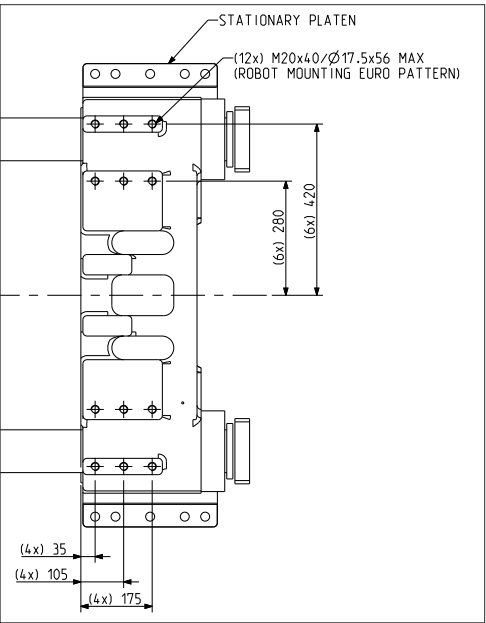
THE Q-PET SERVO
TONNAGE: 230

Injection Unit 970, 1540, 2290

TECHNICAL SPECIFICATIONS

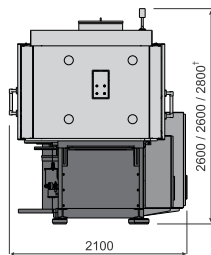
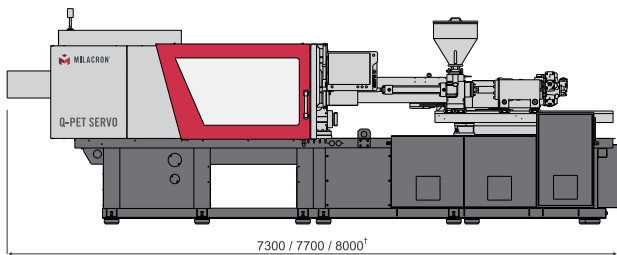


MOVING PLATEN
VIEW A-A



ALL DIMENSIONS ARE IN MM

- A MOVING PLATEN: M20x45 (90) PLACES,
STATIONARY PLATEN: M20x45 DEEP (96) PLACES.
- B MOVING PLATEN: Ø100(+0.035/-0.0) THRU BORE,
K/O BAR CENTER HOLE M16x40 DEEP.
- STATIONARY PLATEN: Ø125(+0.04/-0.0) WITH LOCATING RING,
Ø160(+0.04/-0.0) x 10(+0.15/-0.0) DEEP, WITHOUT LOCATING RING.
- C Ø27 THRU, (4) HOLES IN MOVING PLATEN
K/O BAR M16x40 DEEP
- D Ø32 THRU, (14) HOLES IN MOVING PLATEN
K/O BAR M16x40 DEEP
- E Ø18 THRU, (4) HOLES IN MOVING PLATEN
K/O BAR M12x40 DEEP



1U 970 / 1540 / 2290

Q-PET SERVO 230	UNIT	970	1540	2290
	METRIC			
INJECTION UNIT SPECIFICATIONS				
INJECTION CAPACITY MAX. (PET)	gm	801	1272	1898
THEORETICAL DISPLACEMENT	cc	679	1078	1608
INJECTION PRESSURE MAX.	bar	1224	1222	1218
INJECTION RATE *	cc/sec	524	525	526
INJECTION SCREW STROKE	mm	240	280	320
SCREW DIAMETER	mm	60	70	80
SCREW L/D RATIO		24	24	24
SCREW SPEED	rpm	160	135	120
SCREW TORQUE @ 172 BAR	NM	2159	3676	4858
PLASTICIZING RATE (PET) *	gm/sec	85	100	110
NO.OF PYROMETERS (BARREL+NOZZLE)		4+1	5+1	5+1
TOTAL HEAT CAPACITY	KW	18.7	28	44.5
CLAMP UNIT SPECIFICATIONS				
CLAMP FORCE	Ton		230	
OPENING FORCE	Ton		23	
CLAMP STROKE	mm		550	
MAXIMUM DAYLIGHT	mm		1260	
MINIMUM MOULD HEIGHT	mm		200	
MAXIMUM MOULD HEIGHT	mm		710	
PLATEN SIZE (H X V)	mm		920 X 820	
DISTANCE BETWEEN TIE ROD	mm		660 X 560	
TIE ROD DIAMETER	mm		105	
EJECTOR STROKE	mm		160	
EJECTOR FORCE	Ton		11	
MOULD WEIGHT CAPACITY (STAT. / MOVING)	kg		3200 (1500 / 1700)	
DRY CYCLE TIME (EUROMAP 6) ***	sec-mm		1.95 - 462	
GENERAL				
SERVO DRIVE **	kW	32.2	32.2	32.2
TOTAL OIL CAPACITY	L	650	650	650
WATER REQUIREMENT (INLET TEMP. 29°C)	lpm	180	220	220
CONNECTED LOAD	kW	50.9	60.2	76.7
MACHINE DIMENSION (L X W X H)	m	7.4 X 2.1 X 2.6	7.8 X 2.1 X 2.6	8.3 X 2.1 X 2.8
MACHINE WEIGHT	kg	10200	10700	12200

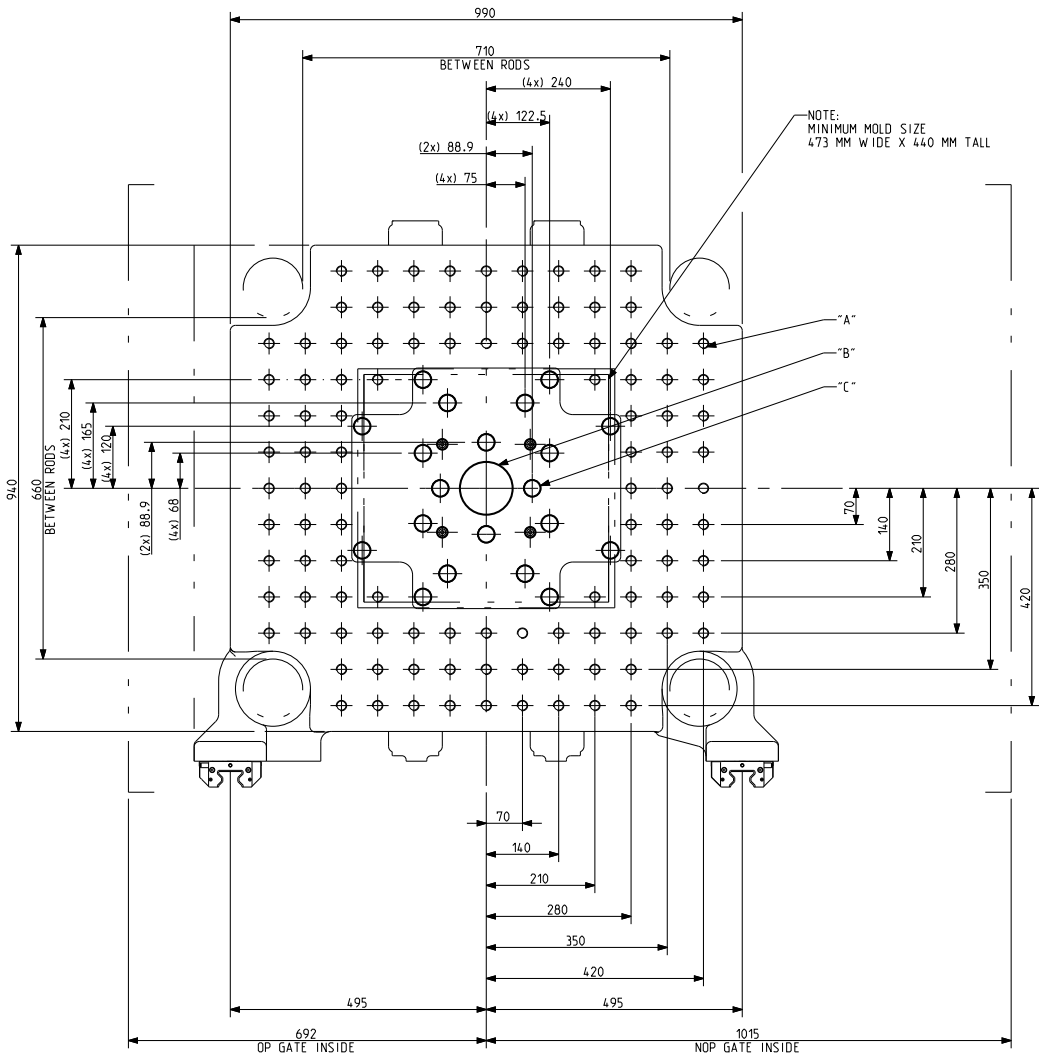
* WITH OPEN NOZZLE
** UNDER SPECIFIED CONDITION
***BREAKAWAY AND TONNAGE DECOMPRESSION TIMES ARE NOT INCLUDED IN DRY CYCLE TIME

All machine dimensions and specifications are subject to change. Values are for reference only. These values are for standard machine power.

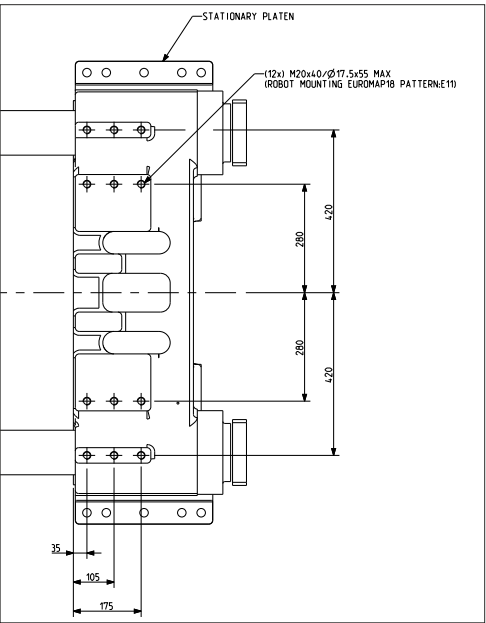
THE Q-PET SERVO
TONNAGE: 280

Injection Unit 1540, 2290,

TECHNICAL SPECIFICATIONS

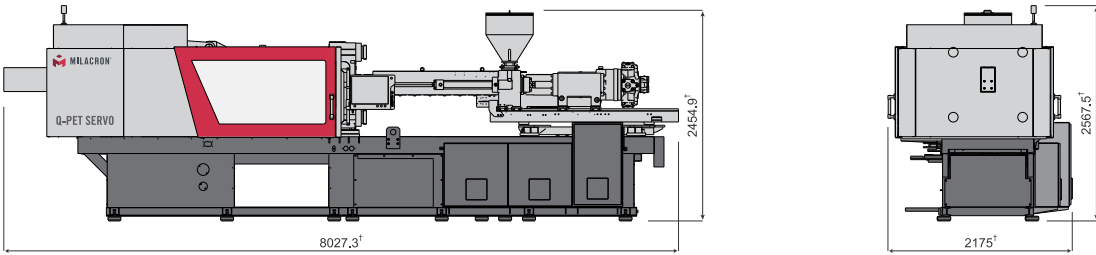


MOVING PLATEN
VIEW A-A



ALL DIMENSIONS ARE IN MM

- A M20x45/Ø17.5x61 MAX (108) HOLES ON BOTH PLATEN.
- B MOVING PLATEN: Ø100(+0.035/-0.0) THRU BORE, K/O BAR CENTER HOLE M16x40 DEEP.
- STATIONARY PLATEN: Ø125(+0.04/-0.0) WITH LOCATING RING, Ø160(+0.04/-0.0) x 10(+0.15/-0.0) DEEP, WITHOUT LOCATING RING.
- C Ø32 THRU, (20) HOLES IN MOVING PLATEN K/O BAR M16x40 DEEP (20) HOLES, Ø14 THRU, (1) AT CENTER



1U 2290

Q-PET SERVO 280	UNIT	1540	2290
	METRIC		
INJECTION UNIT SPECIFICATIONS			
INJECTION CAPACITY MAX. (PET)	gm	1272	1898
THEORETICAL DISPLACEMENT	cc	1078	1608
INJECTION PRESSURE MAX.	bar	1222	1218
INJECTION RATE *	cc/sec	525	526
INJECTION SCREW STROKE	mm	280	320
SCREW DIAMETER	mm	70	80
SCREW L/D RATIO		24	24
SCREW SPEED	rpm	135	120
SCREW TORQUE @ 172 BAR	NM	3676	4858
PLASTICIZING RATE (PET) *	gm/sec	100	110
NO.OF PYROMETERS (BARREL+NOZZLE)		5+1	5+1
TOTAL HEAT CAPACITY	KW	28	44.5
CLAMP UNIT SPECIFICATIONS			
CLAMP FORCE	Ton	280	
OPENING FORCE	Ton	28	
CLAMP STROKE	mm	650	
MAXIMUM DAYLIGHT	mm	1400	
MINIMUM MOULD HEIGHT	mm	250	
MAXIMUM MOULD HEIGHT	mm	750	
PLATEN SIZE (H X V)	mm	990 X 940	
DISTANCE BETWEEN TIE ROD	mm	710 X 660	
TIE ROD DIAMETER	mm	115	
EJECTOR STROKE	mm	200	
EJECTOR FORCE	Ton	11	
MOULD WEIGHT CAPACITY (STAT. / MOVING)	kg	4400 (1900 / 2500)	
DRY CYCLE TIME (EUROMAP 6) ***	sec-mm	2.15 - 497	
GENERAL			
SERVO DRIVE **	kW	32.2	32.2
TOTAL OIL CAPACITY	L	650	650
WATER REQUIREMENT (INLET TEMP. 29°C)	lpm	220	220
CONNECTED LOAD	kW	60.2	76.7
MACHINE DIMENSION (L X W X H)	m	8.0 X 2.2 X 2.7	8.6 X 2.2 X 2.6
MACHINE WEIGHT	kg	13500	14700

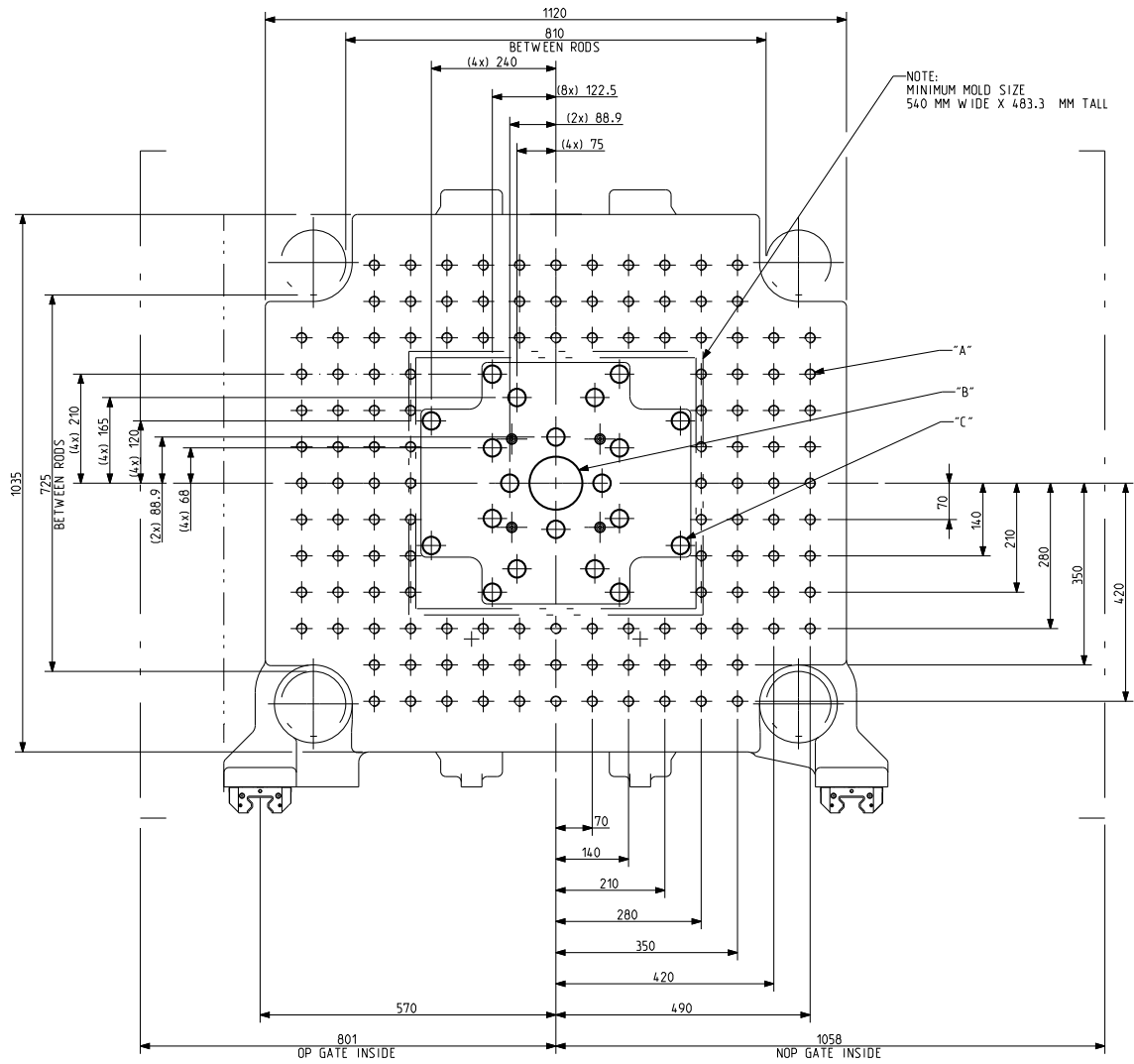
* WITH OPEN NOZZLE
** UNDER SPECIFIED CONDITION
***BREAKAWAY AND TONNAGE DECOMPRESSION TIMES ARE NOT INCLUDED IN DRY CYCLE TIME

All machine dimensions and specifications are subject to change. Values are for reference only. These values are for standard machine power.

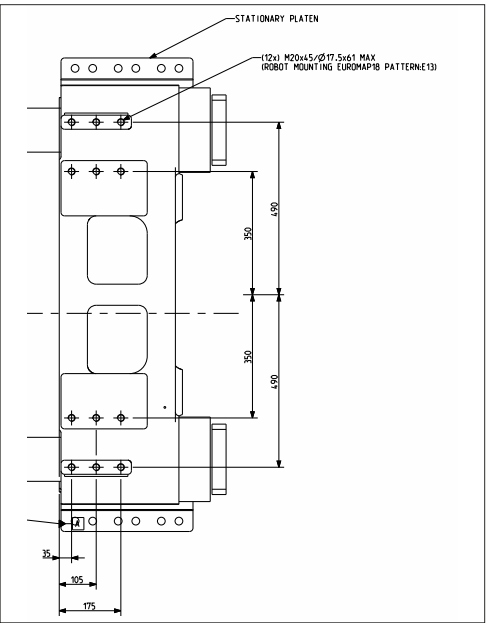
THE Q-PET SERVO
TONNAGE: 350

Injection Unit 2290, 3470

TECHNICAL SPECIFICATIONS



MOVING PLATEN
VIEW A-A



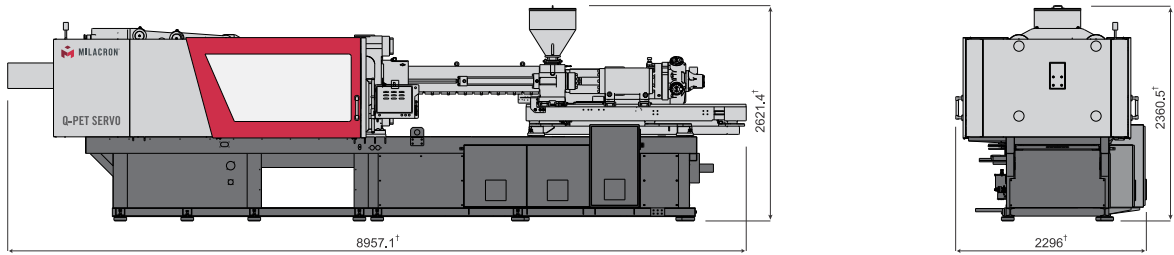
ALL DIMENSIONS ARE IN MM

A MOVING PLATEN: M20x45 (130) PLACES,
STATIONARY PLATEN: M20x45 (130) PLACES.

B MOVING PLATEN: Ø100(+0.035/-0.0) THRU BORE,
K/O BAR CENTER HOLE M16x40 DEEP.

STATIONARY PLATEN: Ø160(+0.040/-0.0) WITH LOCATING RING,
Ø200(+0.046/-0.0) x 10(+0.15/-0.0) DEEP, WITHOUT LOCATING RING.

C Ø32 THRU, (20) HOLES IN MOVING PLATEN
K/O BAR M16x40 DEEP (20) HOLES, Ø14 THRU, (1) AT CENTER



11U 3470

Q-PET SERVO 350	UNIT	2290	3470
	METRIC		
INJECTION UNIT SPECIFICATIONS			
INJECTION CAPACITY MAX. (PET)	gm	1898	2702
THEORETICAL DISPLACEMENT	cc	1608	2290
INJECTION PRESSURE MAX.	bar	1218	1212
INJECTION RATE *	cc/sec	526	549
INJECTION SCREW STROKE	mm	320	360
SCREW DIAMETER	mm	80	90
SCREW L/D RATIO		24	24
SCREW SPEED	rpm	120	93
SCREW TORQUE @ 172 BAR	NM	4858	7470
PLASTICIZING RATE (PET) *	gm/sec	110	130
NO.OF PYROMETERS (BARREL+NOZZLE)		5+1	5+1
TOTAL HEAT CAPACITY	KW	44.5	63.1
CLAMP UNIT SPECIFICATIONS			
CLAMP FORCE	Ton	350	
OPENING FORCE	Ton	35	
CLAMP STROKE	mm	720	
MAXIMUM DAYIGHT	mm	1520	
MINIMUM MOULD HEIGHT	mm	300	
MAXIMUM MOULD HEIGHT	mm	800	
PLATEN SIZE (H X V)	mm	1120 X 1035	
DISTANCE BETWEEN TIE ROD	mm	810 X 725	
TIE ROD DIAMETER	mm	125	
EJECTOR STROKE	mm	250	
EJECTOR FORCE	Ton	15	
MOULD WEIGHT CAPACITY (STAT. / MOVING)	kg	6000 (2700 / 3300)	
DRY CYCLE TIME (EUROMAP 6) ***	sec-mm	2.40 - 567	
GENERAL			
SERVO DRIVE **	kW	32.2	37.2
TOTAL OIL CAPACITY	L	650	730
WATER REQUIREMENT (INLET TEMP. 29°C)	lpm	220	220
CONNECTED LOAD	kW	76.7	100.3
MACHINE DIMENSION (L X W X H)	m	8.9 X 2.3 X 3.1	9.6 X 2.3 X 3.1
MACHINE WEIGHT	kg	18200	18700

* WITH OPEN NOZZLE

** UNDER SPECIFIED CONDITION

***BREAKAWAY AND TONNAGE DECOMPRESSION TIMES ARE NOT INCLUDED IN DRY CYCLE TIME

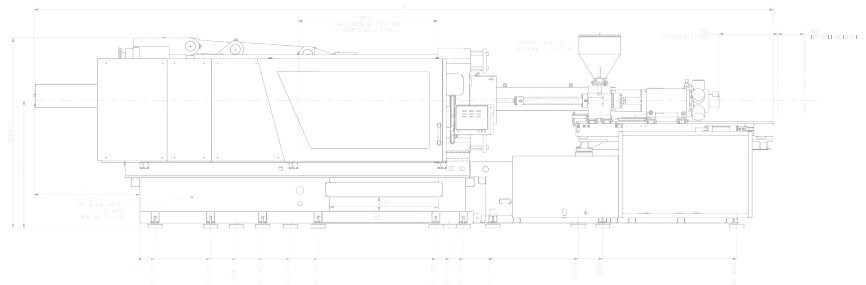
All machine dimensions and specifications are subject to change. Values are for reference only. These values are for standard machine power.

TECHNICAL SPECIFICATIONS

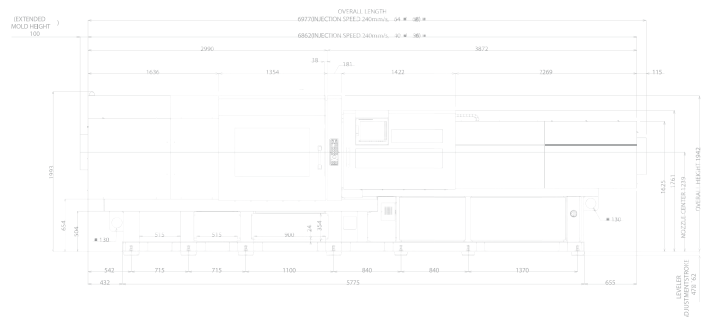
- D Ø25.4 THRU, (8) HOLES

***BREAKAWAY AND TONNAGE DECOMPRESSION TIMES ARE NOT INCLUDED IN DRY CYCLE TIME

21



All specifications reflect average values based on typical machine layouts. Actual figures will vary depending on final machine configuration. Performance specifications are based on theoretical data. Photograph may show attachments or accessories, which may not be part of the standard scope of supply. Due to continual improvements, specifications & some components are subject to change without notice.



OFFICE	PHONE NUMBER
BENGALURU	+91 99169 51333
PANCHKULA	+91-172-415 5955
CHENNAI	+91-44-2378 3648/0456/3318
HYDERABAD	+91-40-4539 2595
KOLKATA	+91-33-4601 7768
MUMBAI	+91-22-4005 5459/65
NEW DELHI	+91-11-4630 1114/5/6
PUNE	+91-20-4861 5001/02
VAPI	+91-75674 11133



Milacron India Pvt. Ltd.
93/2 & 94/1, Phase-I, G.I.D.C. Vatva,
Ahmedabad - 382445, Gujarat, India.

+91-79-61341700
enquiry@milacron.com
www.milacron.com

