

Clamping unit		HM 90/ ...													
Clamping force	kN	900													
Distance between tier-bars	mm x mm	420 x 370													
Mold height (min.)	mm	250													
Opening stroke/opening force	mm/kN	475/43													
Maximum daylight	mm	725													
Ejector stroke/ejector force	mm/kN	150/41,2													
Dry cycle time ¹⁾	s-mm	2,0 - 294													
Injection unit		... /130				... /210			... /350			... /525			
Screw diameter	mm	18	22	25	30	25	30	35	30	35	40	35	40	45	
Screw stroke	mm	110				125			150			175		200	
Screw L/D ratio		20				22			22			22		22	
Theoretical shot volume	cm ³	28	41,8	61,4	88,4	73,6	106	144	123	169	220	193	251	318	
Specific injection pressure	bar	3000	2864	2218	1540	2940	2042	1500	2835	2083	1595	2743	2100	1659	
Max. screw speed	min ⁻¹	477				372			298			318			
Max. plasticizing rate (PS) ²⁾	g/s	4,8	6,9	12,6	18,5	9,9	14,4	22,3	11,6	17,9	28,5	19,1	30,4	39,7	
Max. screw torque	Nm	238				357			490			621		770	
Nozzle stroke/nozzle contact force	mm/kN	250/47				250/86			250/86			350/86			
Injection rate into air	cm ³ /s	49,1	73,4	94,7	136	71,4	103	140	74,1	101	132	102	133	169	
Injection rate into air with twin-pump (option)	cm ³ /s	77,7	116	150	216	119	171	233	124	168	220	153	200	253	
Injection rate into air with hydraulic accumulator (option)	cm ³ /s	77,7	116	150	216	155	223	303	216	294	384	287	375	475	
Drive															
Drive power	kW	15				15			15			18,5			
Oil tank volume	l	250				250			250			250			
Electrical power supply without/with Europackage	kVA	30/59				32/61			34/63			39/68			
Weights, Dimensions															
Netweight (exclusive oil)	kg	4000				4100			4100			4200			
Length x width x weight ³⁾	m	3,7x1,5x2,1				3,7x1,5x2,1			3,9x1,5x2,1			4,2x1,5x2,1			
Max. mold weight/min. mold diameter ⁴⁾	kg/mm	800/350				800/350			800/350			800/350			

1) according to Euromap 6 2) according to Battenfeld norm, higher plasticizing rates possible with twin-pump (option)

3) max. length with middle screw diameter in back position 4) max. 2/3 on clamping platen

