

# HM 650 t

Clamping unit		HM 650/ ...								
Clamping force	kN	6500								
Distance between tier-bars	mm x mm	1100 x 800								
Mold height (min.)	mm	500								
Opening stroke/opening force	mm/kN	1250/247								
Maximum daylight	mm	1750								
Ejector stroke/ejector force	mm/kN	250/81								
Dry cycle time <sup>1)</sup>	s-mm	4,5 - 560								
Injection unit		... /3400			... /5100			... /8800		
Screw diameter	mm	65	75	85	75	85	95	95	105	120
Screw stroke	mm	375			425			525		
Screw L/D ratio		22			22			22		
Theoretical shot volume	cm <sup>3</sup>	1244	1657	2128	1878	2412	3012	3721	4545	5937
Specific injection pressure	bar	2500	2022	1574	2500	2110	1689	2359	1931	1479
Max. screw speed	min <sup>-1</sup>	330			207			188		
Max. plasticizing rate (PS) <sup>2)</sup>	g/s	92	140	195	88	124	160	145	170	210
Max. screw torque	Nm	3759			6048			8000		
Nozzle stroke/nozzle contact	mm/kN	600/129			600/129			600/129		
Injection rate into air	cm <sup>3</sup> /s	488	649	834	484	622	777	668	815	1065
Injection rate into air with twin-pump (option)	cm <sup>3</sup> /s	605	805	1034	600	771	963	801	979	1278
Injection rate into air with hydraulic accumulator (option)	cm <sup>3</sup> /s	1040	1385	1779	1291	1659	2072	1483	1812	2367
Drive										
Drive power	kW	90			90			110		
Oil tank volume	l	1650			1650			1650		
Electrical power supply without/with Europackage	kVA	148/177			153/182			215/244		
Weights, Dimensions										
Netweight (exclusive oil)	kg	31000			32000			34000		
Length x width x weight <sup>3)</sup>	m	8,3x2,7x2,6			8,3x2,7x2,6			8,8x2,7x2,6		
Max. mold weight/min. mold diameter <sup>4)</sup>	kg/mm	8000/800			8000/800			8000/800		

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

