Sumitomo SHI DEMAG

The all-electric.

IntElect.

Sustainable - Precise - Efficient

act SUSTAINABLY

WORLD-LEADER IN ALL-ELECTRIC MACHINES

The IntElect

Technology, expertise, experience and sustainability.

Sumitomo (SHI) Demag, the market leader in all-electric injection moulding machines, sets the highest benchmark in electrical machine engineering. Our targets are clear; maximum dynamics resulting in the highest level of efficiency and 100% production quality.

As a specialist manufacturer of injection moulding machines, we design and produce all of the core components for our electrical drive technology in-house. Because of this, our IntElect series delivers maximum dynamics and processing precision, resulting in optimal efficiency. Experience and test our technology, competence and experience for yourself.

The IntElect

Features and benefits at a glance.

Proprietary drive technology

We have our own research and development centre where our direct drives, converter technology and control system components are developed, tested and produced specifically for use in injection moulding machines. The result is the highest level of dynamics resulting in maximum processing precision, repeatability and production efficiency.

Comprehensive mould safety

The IntElect's new mould platens have been redesigned using finite element analysis. This provides up to 20% greater platen rigidity. Combined with the linear guides, this all helps to protect the longevity of the mould and protect against wear and tear.

Intuitive control

The IntElect control is intuitive to use and offers a variety of options for process monitoring and control. The logical and simple programming with pre-defined flexible machine sequences enables users to fully utilise the IntElect's numerous features to optimise productivity.

Investing in a sustainable future

The electrical energy consumed by injection moulding machines is converted into heat. Part of it directly, the other part indirectly via kinetic energy, deformation and friction. All of the heat generated must be dispersed and cooled. Naturally, less heat generated through powering the IntElect machine equals less cooling and consequently lowers the energy consumption. All of which naturally reduces the CO_2 footprint.

Efficiency

Application-based motor design.

Average 60% less energy consumption

The combination of in-house developed drive motors, frequency inverters, as well as the entire servomotor control system, has resulted in building one of the most energy-efficient injection moulding machines on the market. When compared to other injection moulding machines, the IntElect is proven to consume up to 80% less energy than hydraulic machines and 20% less energy than conventional all-electric machines.

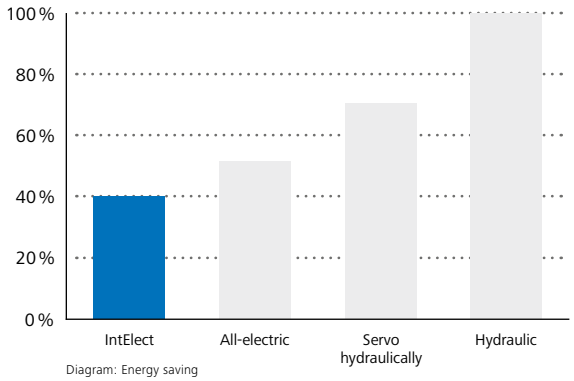


Diagram: Energy saving

LESS CONSUMPTION. MORE POWER.

CO_2 footprint

The basis for higher production output is higher machine availability, combined with dynamic, precise and parallel movements. Additionally, the high precision of the machine prevents the production of reject parts. The material savings are significant. Running at the optimum speed equals faster cycles, fewer process interruptions, increased productivity, and optimised production costs.

In-house drive technology

This level of dynamics, precision and efficiency cannot be accomplished using standard drive motors. Because the direct drives and controls on the IntElect series are precisely coordinated to match the machine, the IntElect achieves a response time of 0.1 ms. This is 20 times faster than conventional injection moulding machines and 1.000 times faster than the blink of a human eye.

Part quality

Delivering the highest quality standards.

Tightest tolerance process window

The use of direct drives means that mechanical losses are minimised. Compared to other drive technologies on the market, there are significantly fewer components to affect the transmission of forces. This combination of sophisticated control technology and additional efficiency modules are the basis for achieving the highest precision.

Long-term production stability

Due to our longstanding experience in manufacturing electric injection moulding machines, combined with the IntElect's own-brand drive concept, we are able to retain this constant process control throughout the service life of the machine. This advantage is especially important for maintaining compliance with validated process parameters.

MAXIMUM DYNAMICS.
100% QUALITY.

Dynamic injection movements

Combining high dynamics and speed means that the IntElect is able to process tight-tolerance engineering applications that many other full-electric injection moulding machines struggle to achieve.
Due to its unprecedented precision and repeatability, the IntElect can accommodate the widest selection of the most demanding moulding applications. Its highly dynamic acceleration and deceleration is critical to process stability, ensuring consistent production of higher quality parts. The rapid switch from injection to holding pressure also helps to eliminate burrs, resulting in minimal component defects.

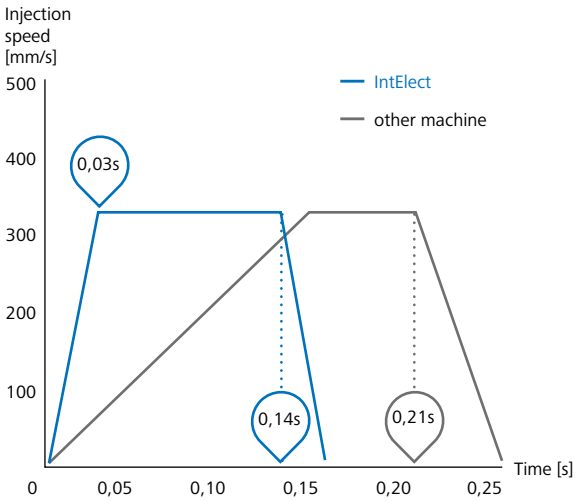


Diagram: Dynamics of the machine during injection

Part quality

Extra efficiency modules.

activeLock
Quality assurance

Our activeLock technology module makes it possible to reduce shot weight fluctuations by up to 60%. The switchable non-return valve prevents melt from flowing back into the plasticising cylinder at the beginning of the injection phase. Ensuring that your injection moulded parts are manufactured to the highest quality.

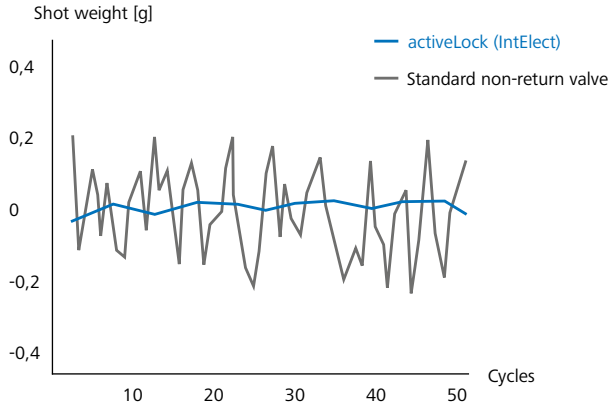
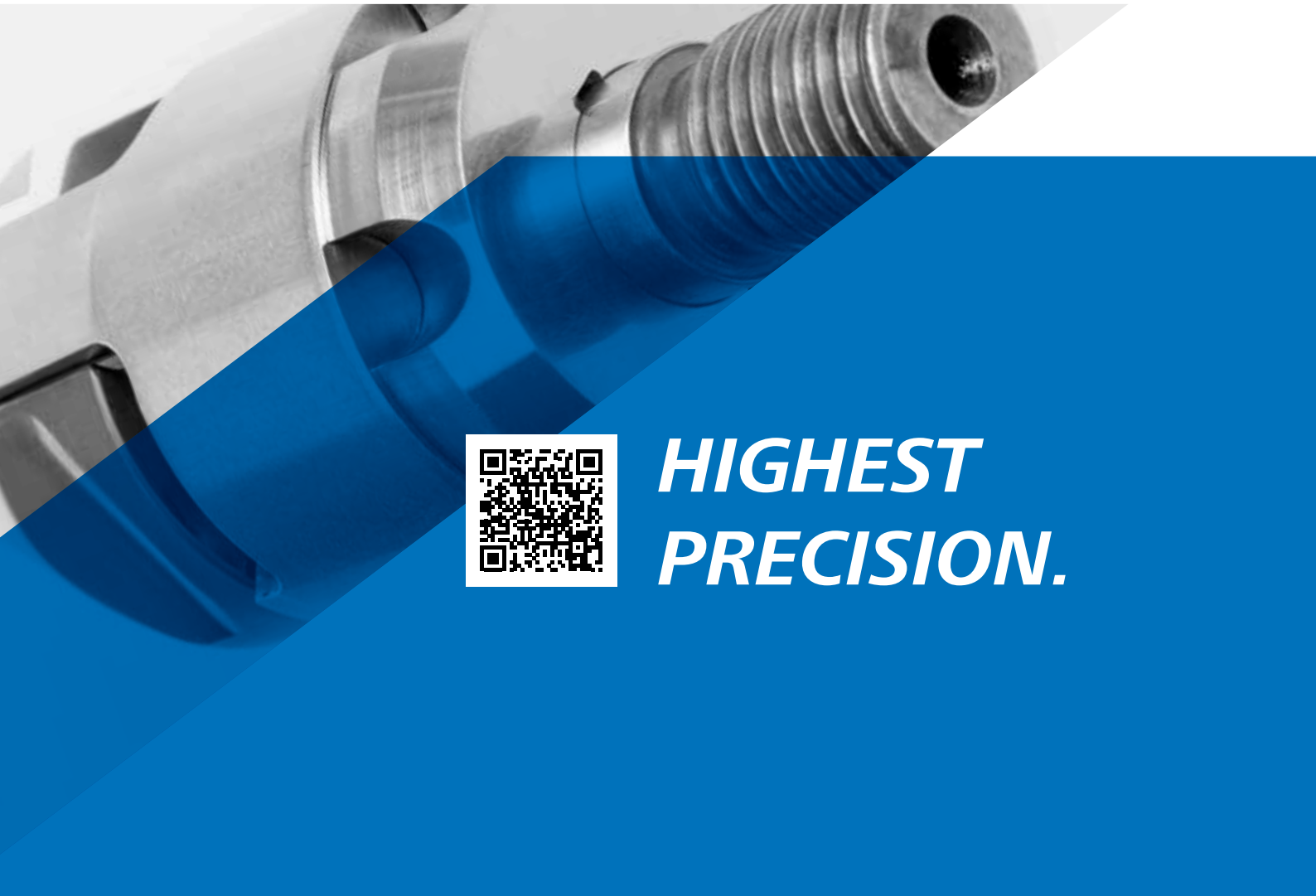


Diagram: Shot weight distribution per cycle



HIGHEST PRECISION.

activeFlowBalance

Quality assurance

With activeFlowBalance, the negative effects of uneven mould filling are resolved, resulting in constant part quality when using multi-cavity moulds. Reducing reject rates and increasing the quality of your parts.

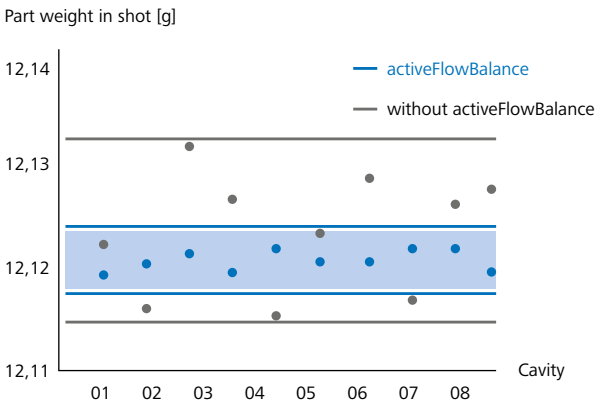


Diagram: Weight distribution in the individual cavities for an injection process

Example: without activeFlowBalance

Example: with activeFlowBalance

Mould protection

Maximum space with full safeguards.

Monitoring with profile

Our active mould protection solution, activeProtect, closely monitors the clamp force transmission during the mould closing sequence. Sensors are used to detect and transmit any changes to the force signature. Ensuring the safety of the mould isn't compromised. The smallest of objects can be detected. Additionally, the machine can graphically monitor the ejector force, as well as the injection pressure. All helping to mitigate damage to mould tools when operating machines at the fastest speed.

20% more space for moulds

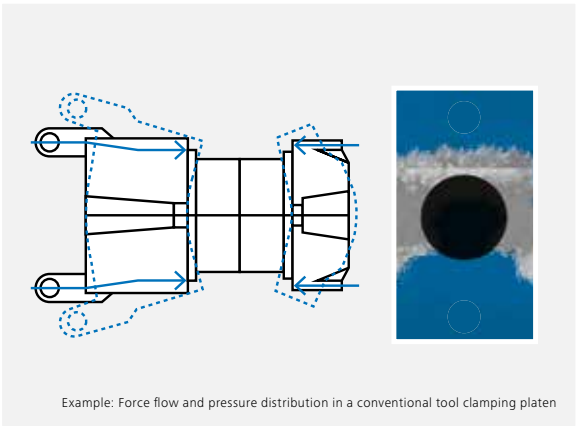
Generously dimensioned linear guides combined with increased rigidity in the machine bed help to maintain maximum parallelism of the platens. This helps to minimise mould wear. Additionally, to accommodate larger injection moulds, the IntElect series from 200t upwards features a larger tie bar spacing; wider than comparable machines on the market. Boosting production capacity even further.

IntElect	220	280	350	450/500
Tie bar distance (h x v)	660x660	730x730	830x830	920x920

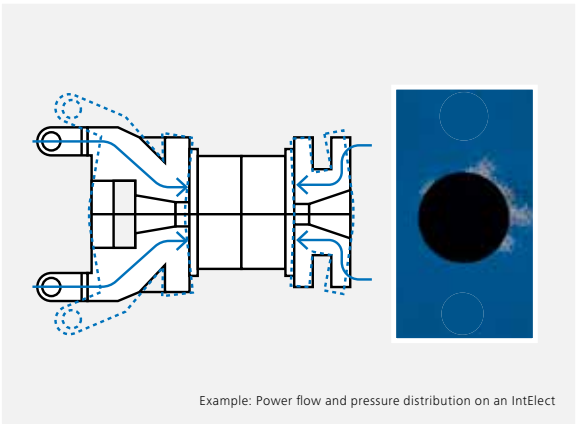
MAXIMUM TOOL PROTECTI
MAXIMUM TIE BAR WIDTH.

20% more clamp platen rigidity

Applying finite element analysis, the IntElect series platens are optimised to the application to deliver more even distribution of the clamp force and as a result a more balanced distribution of pressure. Unlike conventional platens which can deform during locking (depending on the type and shape of the mould), our platens intelligently distribute the force flow in the platen. Resulting in up to 20% higher rigidity when compared to conventional platens.



Example: Force flow and pressure distribution in a conventional tool clamping platen



Example: Power flow and pressure distribution on an IntElect

The IntElect S

More power for high speed applications.

Faster mould movements

Our direct drives are specifically optimised to support fast movement in high-speed applications and deliver minimum dry cycle times. The result of the increased performance on the IntElect S is a significant improvement in efficiency and production output rates.
Furthermore, the high performance drive spindles featured on the IntElect S are designed to extend the machine's service life, offering maximum reliability and machine availability.

Increased injection performance

Optimal injection speeds combined with advanced dynamics enables manufacturers to process a more expansive range of thin-walled applications. Further increasing your production flexibility while maintaining the highest quality of components.

Quicker ejector movements

Faster and stronger ejectors combined with quicker injection and metering speeds all help to optimise the motion sequences. Resulting in the fastest possible cycle times.

Minimum energy consumption

The highly optimised and low inertia direct drives on the IntElect S are designed specifically for fast cycle and extremely narrow tolerance applications. Featuring shorter high-performance spindles and encapsulated windings to improve heat transmission helps to ensure that the energy used to melt the polymer is minimal. Leading to higher output at the lowest ecological impact.

The IntElect multi

Flexing to your applications.

Additional injection unit

Expand your reach and range of global multi-component aesthetic applications, with our compact, energy efficient IntElect multi series. Offering double the moulding precision, from small to big shot weights, simultaneous to sequenced multi-component moulding.
Integrate multiple colours, resins and sensory/haptic features into products, while also benefiting from our long-standing processing, mould safety and direct drive experience. Sandwich moulding, foaming and fibre glass multi-component moulding are all feasible options.

Turntable integration

Reliant once again on our in-house developed drive technology geared towards top dynamics, precision and repeatability, our IntElect multi can be supplied with an integrated turntable. This option ensures the smoothest and fastest rotation of the mould between the injection of the first and second shot. Ensuring that cavities are perfectly positioned within 1 s of the turning time. Enabling production to continue immediately and without delay.

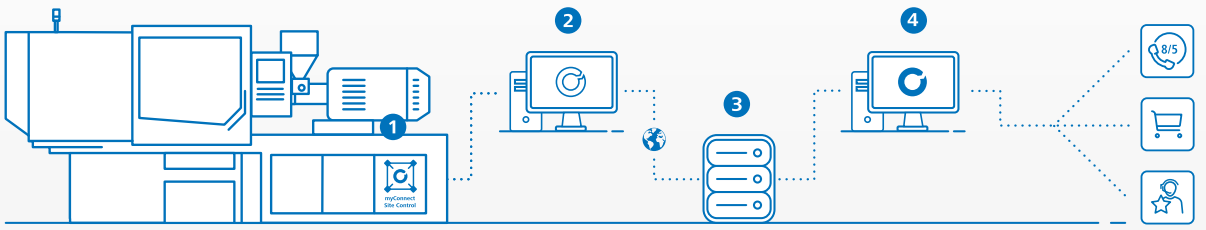
Improved mould space

Rather than opt for a larger machine to accommodate large moulds and a rotating turntable, the IntElect multi maintains its compactness by increasing the height, tie bar clearance and mould space. Delivering maximum flexibility and multi-component moulding precision, in the minimum footprint.

myConnect

Structure and construction. Modular Smart Factory platform.

myConnect is our answer to the digital age. The modular platform gives you access to a wide range of functions that enables you to react immediately in the event of a disruption to your production process. Additionally, you can easily access data in real-time, as well as access an extensive range of machine parameters. For example, you can view your production data at anytime, and from anywhere. On this technological basis, you can fall back on various parameters of the machine and, for example, visualize your production data anytime and anywhere.



1 – Full connectivity

If several machines are in use, they are combined in one system. The network thus created can be accessed via both stationary and mobile devices. The queried data can also be aggregated across an entire location. So you always have your entire production in view.

2 – Secure connection

If a fault occurs, you can immediately Open Service Request myConnect provides a secure VPN tunnel a connection to the central Server and places a request in our Service message system. The TÜV IT certification for the Connection ensures maximum safety during Exchange of your data.

3 – Maximum data protection

The central server, which acts as an intermediary between the customer and Sumitomo (SHI) Demag, is operated exclusively in Germany and is subject to the strict data protection guidelines of the GDPR. An active connection is only established with the consent of both parties.

4 – Next level support

Once the connection is established, the complete digital service world of Sumitomo (SHI) Demag opens up to you. In addition to access to our extended live support functionalities, such as direct exchange with one of our service employees, - these also include access to our database for spare parts.

myConnect BASIC

myConnect Site Control

Hardware
(One-off investment)

+

myConnectApp
Always informed

myDocumentation
All digital

myLiveCycleLog
Full overview

mySpareParts
Original parts with one click

mySupport
Live support worldwide

Software
(Monthly charge)

+

myConnect PREMIUM

mySmartVision
Expert oversight for any given situation

\+ One-off investment

myApplicationExpert
Know-how at the touch of a button

\+ Monthly charge

myMaintenance
Cleverly planned

\+ Monthly charge

myProduction
Complete control

\+ Monthly charge

mySupport Premium
Always and everywhere

\+ Monthly charge

Save up to **60%** off the base price*

Subscription duration*
Use longer and save!

1 year	€€€€
2 years	€€€
3 years	€€
4 years	€

Number of machines**
The more machines, the lower the price.

€€€€	
€€€	
€€	
€	

*The graphics are only used to illustrate the offer and do not provide information about the exact cost savings! Please ask us directly about your price advantage.

TECHNICAL DATA

Content

Sumitomo (SHI) Demag		IntElect 50 / IntElect S 50		
International size description		500-65	500-110	500-250
Clamping unit		50		
Clamping force / locking force, max.	[kN]	500 / 550		
Mould opening stroke, max.	[mm]	250		
Mould height, min. / max.:				
>Standard OP0210	[mm]	160 / 350		
>Increased OP0211	[mm]	160 / 400		
Distance between tie bars (h x v):	[mm]			
>Standard	[mm]	360 x 360		
>Increased OP2032	[mm]	370 x 370		
Min. permissible mould diameter (k)	[mm]	216		
Mould weight / mov. / fixed, max.	[kg]	490 / 320 / 245		
Ejector stroke / force / speed, max.: [1]				
>Standard	[mm / kN / mm/s]	120 / 21 / 333		
>Speed increased OP2636	[mm / kN / mm/s]	70 / 26 / 500		

Injection unit		65			110				250		
Screw diameter	[mm]	14	18	22	18	22	25	30	22	25	30
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20	20	20	20	20
L/D ratio OP0612 / OP0627	[mm]	-	-	-	-	-	-	-	-	-	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2800	2800	2220	2800	2800	2222	1543	2800	2800	2510
Injection volume, max.	[cm³]	12	20	30	23	40	51	73	40	61	99
Injection speed, max.: [2]											
>Standard OP0314	[mm/s]		200			200				200	
>Speed OP0315	[mm/s]		350			350				350	
>High-Speed OP0316	[mm/s]		550			500				-	
Injection rate, max.: [2]											
>Standard OP0314	[cm³/s]	31	51	76	51	76	98	141	76	98	141
>Speed OP0315	[cm³/s]	54	89	133	89	133	172	247	133	172	247
>High-Speed OP0316	[cm³/s]	85	140	209	127	190	245	353	-	-	-
Plasticising rate, max. (PS): [3]											
>Standard OP0314	[g/s]	1,3	3,7	6	3,7	6	10	16,7	6	10	16,7
>OP0315 / OP0316	[g/s]	1,7	5	8,3	5	8,3	13,8	22,9	6,8	11,3	18,8
Nozzle stroke, max. [4]	[mm]		380			380				380	
Nozzle sealing force / speed, max.:											
>Standard	[kN / mm/s]		30 / 23			30 / 23				30 / 23	
>Increased OP1336	[kN / mm/s]		30 / 120			30 / 120				43 / 120	

General data		50-65			50-110				50-250		
Dry cycle time (Euromap 6):											
>Standard OP0215 [5]	[s-mm]		1,2 - 250			1,2 - 250				1,2 - 250	
>IntElect S OP0202	[s-mm]		0,8 - 250			0,8 - 250				0,8 - 250	
Net weight [6]	[kg]		2800			2900				3100	
Motor end projection, max. (h):											
>Standard + L/D 20	[mm]	0	39	110	134	205	267	395	365	427	555
>IntElect S + L/D 20	[mm]	0	39	110	134	205	267	395	365	427	555
>IntElect S + L/D 25	[mm]	-	-	-	-	-	-	-	-	-	-

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

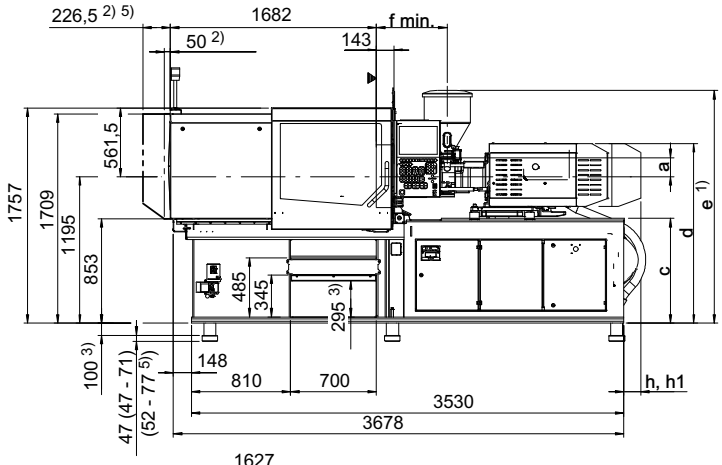
3) Plasticising rate depends on processing conditions and the material used.

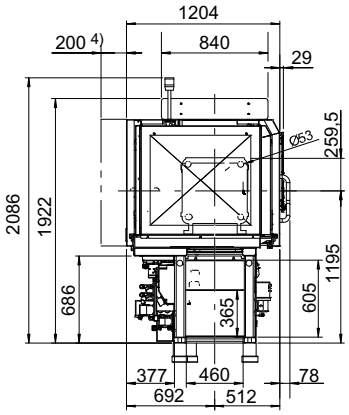
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

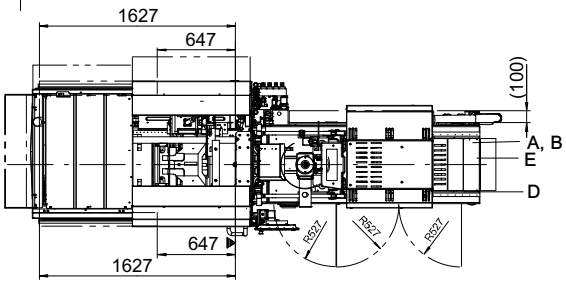
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect 50 / IntElect S 50

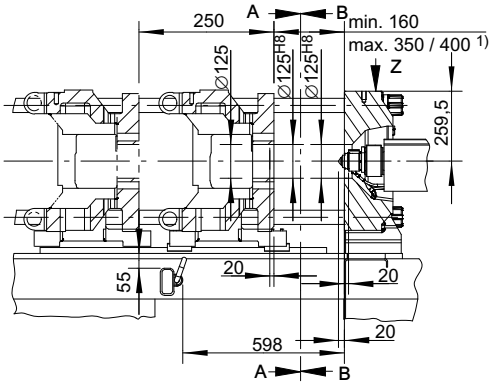






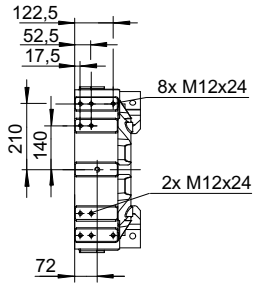
1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
5) IntElect S
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect 50 / IntElect S 50

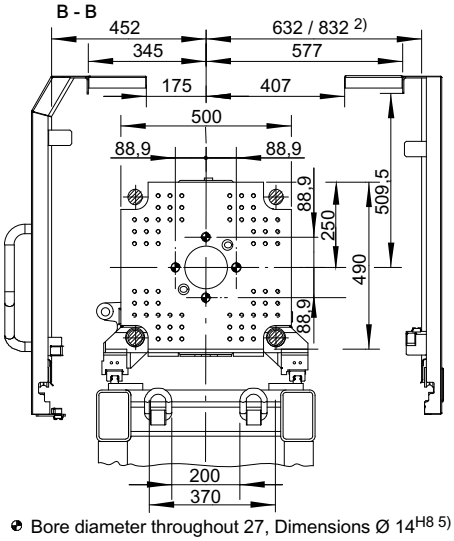


1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP2032 Distance between tie bars, increased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate

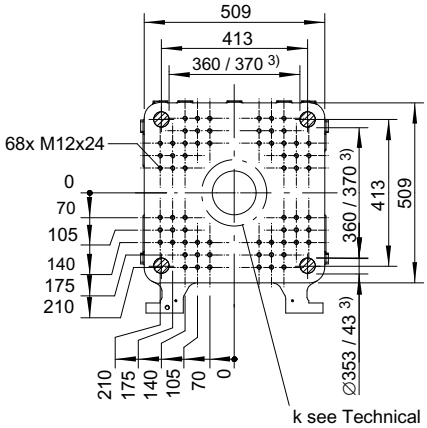
Z Hole pattern for robot / sprue picker on fixed platen 4)
EUROMAP 18-E6



Movable platen
B - B



Fixed platen
A - A



k see Technical Description

Bore diameter throughout 27, Dimensions Ø 14^{H8} 5)

Sumitomo (SHI) Demag		IntElect 75 / IntElect S 75			
International size description		750-65	750-110	750-250	750-450 / 460
Clamping unit		**75**			
Clamping force / locking force, max.	[kN]	750 / 825			
Mould opening stroke, max.	[mm]	300			
Mould height, min. / max.:					
>Standard OP0210	[mm]	160 / 410			
>Increased OP0211	[mm]	160 / 460			
Distance between tie bars (h x v):	[mm]				
>Standard	[mm]	420 x 420			
>Increased OP2032	[mm]	-			
Min. permissible mould diameter (k)	[mm]	252			
Mould weight / mov. / fixed, max.	[kg]	760 / 500 / 380			
Ejector stroke / force / speed, max.: [1]					
>Standard	[mm / kN / mm/s]	130 / 26 / 333			
>Speed increased OP2636	[mm / kN / mm/s]	80 / 26 / 500			

Injection unit		65			110				250				450 / 460		
Screw diameter	[mm]	14	18	22	18	22	25	30	22	25	30	35	30	35	40
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20	20	20	20	20	20	20	20	20
L/D ratio OP0612 / OP0627	[mm]	-	-	-	-	-	-	-	-	-	-	-	25	-	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2800	2800	2220	2800	2800	2222	1543	2800	2800	2510	1850	2800	2790	2140
Injection volume, max.	[cm³]	12	20	30	23	40	51	73	40	61	99	135	113	154	201
Injection speed, max.: [2]															
>Standard OP0314	[mm/s]	200			200				200				200		
>Speed OP0315	[mm/s]	350			350				350				350		
>High-Speed OP0316	[mm/s]	550			500				-				-		
Injection rate, max.: [2]															
>Standard OP0314	[cm³/s]	31	51	76	51	76	98	141	76	98	141	192	141	192	251
>Speed OP0315	[cm³/s]	54	89	133	89	133	172	247	133	172	247	337	247	337	440
>High-Speed OP0316	[cm³/s]	85	140	209	127	190	245	353	-	-	-	-	-	-	-
Plasticising rate, max. (PS): [3]															
>Standard OP0314	[g/s]	1,3	3,7	6	3,7	6	10	16,7	6	10	16,7	22,7	16,7	22,7	33,3
>OP0315 / OP0316	[g/s]	1,7	5	8,3	5	8,3	13,8	22,9	6,8	11,3	18,8	25,5	18,8	25,5	37,5
Nozzle stroke, max. [4]	[mm]	380			380				380				380		
Nozzle sealing force / speed, max.:															
>Standard	[kN / mm/s]	30 / 23			30 / 23				30 / 23				30 / 23		
>Increased OP1336	[kN / mm/s]	30 / 120			30 / 120				43 / 120				43 / 120		

General data		75-65			75-110				75-250				75-450 / 460		
Dry cycle time (Euromap 6):															
>Standard OP0215 [5]	[s-mm]	1,3 - 287			1,3 - 287				1,3 - 287				1,3 - 287		
>IntElect S OP0202	[s-mm]	0,9 - 287			0,9 - 287				0,9 - 287				0,9 - 287		
Net weight [6]	[kg]	3600			3700				3800				4000 / 4200		
Motor end projection, max. (h):															
>Standard + L/D 20	[mm]	0	39	110	134	205	267	395	365	427	555	700	717	862	979
>IntElect S + L/D 20	[mm]	0	39	110	134	205	267	395	365	427	555	700	831	976	1093
>IntElect S + L/D 25	[mm]	-	-	-	-	-	-	-	-	-	-	-	981	-	-

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Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

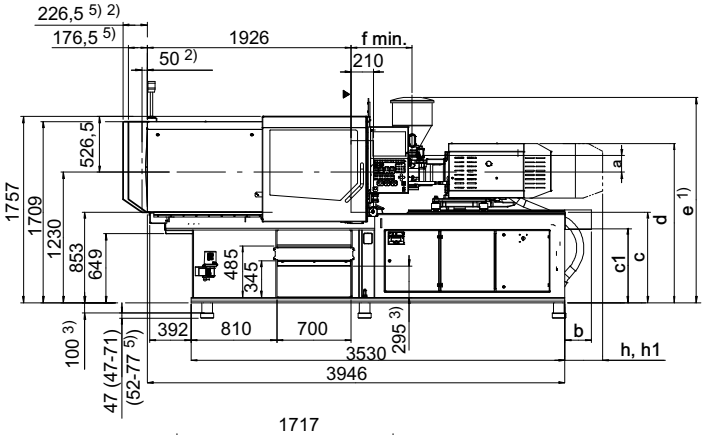
3) Plasticising rate depends on processing conditions and the material used.

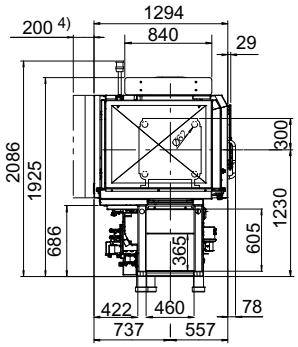
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

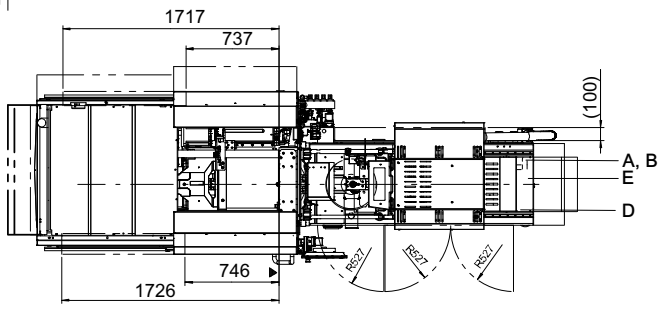
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect 75 / IntElect S 75

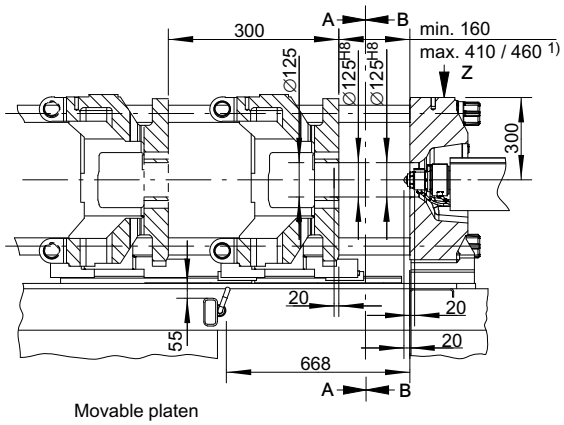






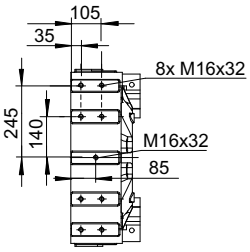
1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
5) IntElect S
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect 75 / IntElect S 75

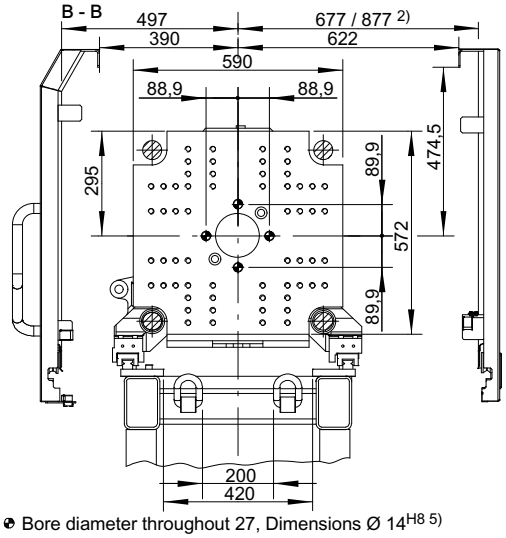


Z Hole pattern for robot / sprue picker on fixed platen 4)
EUROMAP 18-E7

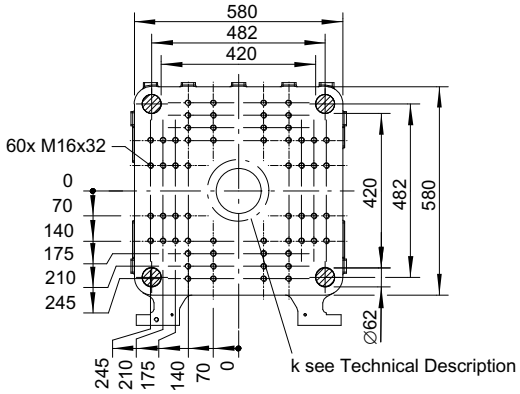
1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate



Movable platen
B - B



Fixed platen
A - A



Bore diameter throughout 27, Dimensions Ø 14H8 5)

Sumitomo (SHI) Demag		IntElect 100 / IntElect S 100				
International size description		1000-110	1000-250	1000-450 / 460	1000-560	1000-700
Clamping unit		100				
Clamping force / locking force, max.	[kN]	1000 / 1100				
Mould opening stroke, max.	[mm]	350				
Mould height, min. / max.:						
>Standard OP0210	[mm]	180 / 450				
>Increased OP0211	[mm]	180 / 550				
Distance between tie bars (h x v):	[mm]					
>Standard	[mm]	460 x 460				
>Increased OP2032	[mm]	470 x 470				
Min. permissible mould diameter (k)	[mm]	276				
Mould weight / mov. / fixed, max.	[kg]	1050 / 700 / 525				
Ejector stroke / force / speed, max.: [1]						
>Standard	[mm / kN / mm/s]	150 / 32 / 333				
>Speed increased OP2636	[mm / kN / mm/s]	100 / 50 / 500				

Injection unit		110				250					450 / 460				560			700		
Screw diameter	[mm]	18	22	25	30	22	25	30	35	40	30	35	40	45	35	40	45	35	40	45
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
L/D ratio OP0612 / OP0627	[mm]	-	-	-	-	-	-	-	-	-	25	25	-	-	-	-	-	25	25	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2800	2800	2222	1543	2800	2800	2510	1850	1410	2800	2790	2140	1690	2800	2418	2200	2800	2418	2200
Injection volume, max.	[cm³]	23	40	51	73	40	61	99	135	176	113	154	201	254	154	201	254	178	251	318
Injection speed, max.: [2]																				
>Standard OP0314	[mm/s]	200				200					200				200			-		
>Speed OP0315	[mm/s]	350				350					350				350			350		
>High-Speed OP0316	[mm/s]	500				-					-				-			-		
Injection rate, max.: [2]																				
>Standard OP0314	[cm³/s]	51	76	98	141	76	98	141	192	251	141	192	251	318	192	251	318	-	-	-
>Speed OP0315	[cm³/s]	89	133	172	247	133	172	247	337	440	247	337	440	556	337	440	556	337	440	556
>High-Speed OP0316	[cm³/s]	127	190	245	353	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Plasticising rate, max. (PS): [3]																				
>Standard OP0314	[g/s]	3,7	6	10	16,7	6	10	16,7	22,7	33,3	16,7	22,7	33,3	42	22,7	33,3	42	-	-	-
>OP0315 / OP0316	[g/s]	5	8,3	13,8	22,9	6,8	11,3	18,8	25,5	37,5	18,8	25,5	37,5	47,3	25,5	37,5	47,3	25,5	37,5	47,3
Nozzle stroke, max. [4]	[mm]	380				380					380				450			450		
Nozzle sealing force / speed, max.:																				
>Standard	[kN / mm/s]	30 / 23				30 / 23					30 / 23				30 / 23			30 / 23		
>Increased OP1336	[kN / mm/s]	30 / 120				43 / 120					43 / 120				43 / 120			43 / 120		

General data		100-110				100-250					100-450 / 460				100-560			100-700		
Dry cycle time (Euromap 6):																				
>Standard OP0215 [5]	[s-mm]	1,3 - 322				1,3 - 322					1,3 - 322				1,3 - 322			-		
>IntElect S OP0202	[s-mm]	0,9 - 322				0,9 - 322					0,9 - 322				-			0,9 - 322		
Net weight [6]	[kg]	4800				4900					5000 / 5250				5250			5450		
Motor end projection, max. (h):																				
>Standard + L/D 20	[mm]	9	80	142	270	240	302	430	575	692	592	737	854	1016	851	968	1130	-	-	-
>IntElect S + L/D 20	[mm]	9	80	142	270	240	302	430	575	692	706	851	968	1130	-	-	-	1006	1123	1259
>IntElect S + L/D 25	[mm]	-	-	-	-	-	-	-	-	-	856	1025	-	-	-	-	-	1026	1328	-

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

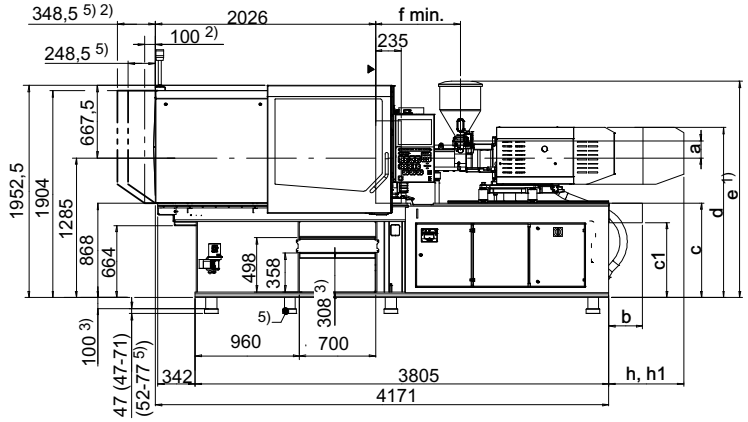
3) Plasticising rate depends on processing conditions and the material used.

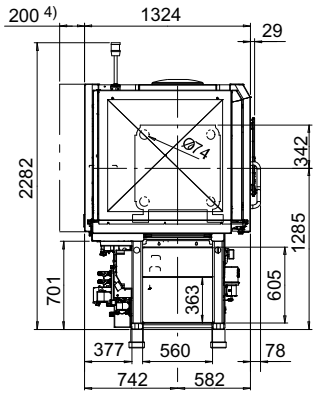
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

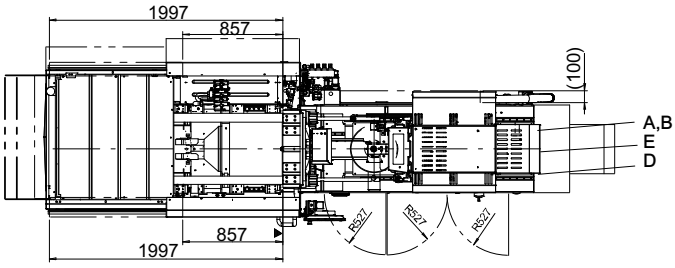
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect 100 / IntElect S 100

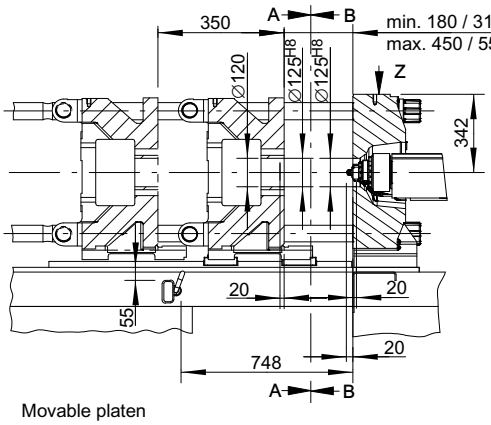






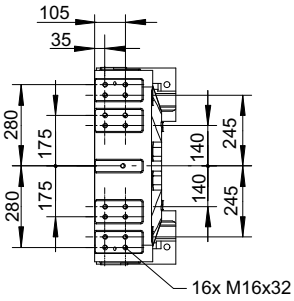
1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
5) IntElect S
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10
Machine dimension without OP2032

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect 100 / IntElect S 100

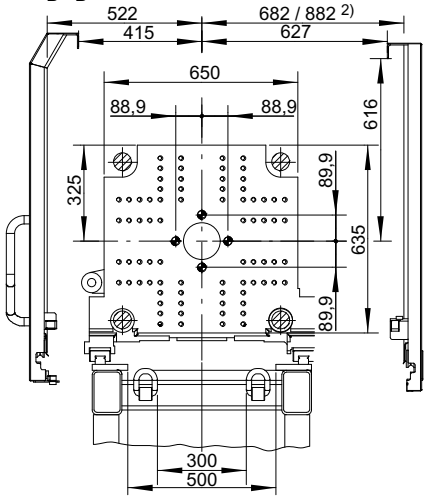


1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP2032 Distance between tie bars, increased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate
6) OP2621 Middle platen support

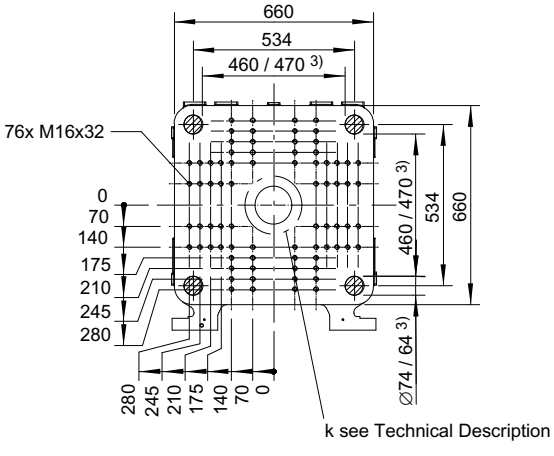
Z Hole pattern for robot / sprue picker on fixed platen 4)
EUROMAP 18-E7/E8/E9



Movable platen
B - B



Fixed platen
A - A



Bore diameter throughout 27, Dimensions Ø 14^{H8} 5)

Sumitomo (SHI) Demag		IntElect 130 / IntElect S 130																					
International size description		1300-110				1300-250					1300-450 / 460				1300-560				1300-700				
Clamping unit		130																					
Clamping force / locking force, max.	[kN]	1300 / 1430																					
Mould opening stroke, max.	[mm]	400																					
Mould height, min. / max.:																							
>Standard OP0210	[mm]	180 / 450																					
>Increased OP0211	[mm]	180 / 550																					
Distance between tie bars (h x v):	[mm]																						
>Standard	[mm]	510 x 510																					
>Increased OP2032	[mm]	520 x 520																					
Min. permissible mould diameter (k)	[mm]	306																					
Mould weight / mov. / fixed, max.	[kg]	1290 / 860 / 645																					
Ejector stroke / force / speed, max.: [1]																							
>Standard	[mm / kN / mm/s]	150 / 32 / 333																					
>Speed increased OP2636	[mm / kN / mm/s]	100 / 50 / 500																					
Injection unit		110				250					450 / 460				560				700				
Screw diameter	[mm]	18	22	25	30	22	25	30	35	40	30	35	40	45	35	40	45	50	35	40	45	50	
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	
L/D ratio OP0612 / OP0627	[mm]	-	-	-	-	-	-	-	-	-	25	25	-	-	-	-	-	-	25	25	-	-	
Injection pressure, max. (up to 400 °C) [2]	[bar]	2800	2800	2222	1543	2800	2800	2510	1850	1410	2800	2790	2140	1690	2800	2418	2200	1780	2800	2418	2200	1780	
Injection volume, max.	[cm³]	23	40	51	73	40	61	99	135	176	113	154	201	254	154	201	254	314	178	251	318	393	
Injection speed, max.: [2]																							
>Standard OP0314	[mm/s]	200				200					200				200				-				
>Speed OP0315	[mm/s]	350				350					350				350				350				
>High-Speed OP0316	[mm/s]	500				-					-				-				-				
Injection rate, max.: [2]																							
>Standard OP0314	[cm³/s]	51	76	98	141	76	98	141	192	251	141	192	251	318	192	251	318	393	-	-	-	-	
>Speed OP0315	[cm³/s]	89	133	172	247	133	172	247	337	440	247	337	440	556	337	440	556	687	337	440	556	687	
>High-Speed OP0316	[cm³/s]	127	190	245	353	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
Plasticising rate, max. (PS): [3]																							
>Standard OP0314	[g/s]	3,7	6	10	16,7	6	10	16,7	22,7	33,3	16,7	22,7	33,3	42	22,7	33,3	42	57,3	-	-	-	-	
>OP0315 / OP0316	[g/s]	5	8,3	13,8	22,9	6,8	11,3	18,8	25,5	37,5	18,8	25,5	37,5	47,3	25,5	37,5	47,3	64,5	25,5	37,5	47,3	64,5	
Nozzle stroke, max. [4]	[mm]	380				380					380				450				450				
Nozzle sealing force / speed, max.:																							
>Standard	[kN / mm/s]	30 / 23				30 / 23					30 / 23				30 / 23				30 / 23				
>Increased OP1336	[kN / mm/s]	30 / 120				43 / 120					43 / 120				43 / 120				43 / 120				
General data		130-110				130-250					130-450 / 460				130-560				130-700				
Dry cycle time (Euromap 6):																							
>Standard OP0215 [5]	[s-mm]	1,4 - 357				1,4 - 357					1,4 - 357				1,4 - 357				-				
>IntElect S OP0202	[s-mm]	1,0 - 357				1,0 - 357					1,0 - 357				-				1,0 - 357				
Net weight [6]	[kg]	5250				5400					5550 / 5800				5800				6000				
Motor end projection, max. (h):																							
>Standard + L/D 20	[mm]	19	90	152	280	250	312	440	585	702	602	747	864	1026	861	978	1040	1283	-	-	-	-	
>IntElect S + L/D 20	[mm]	19	90	152	280	250	312	440	585	702	776	921	1038	1200	-	-	-	-	1016	1133	1295	1438	
>IntElect S + L/D 25	[mm]	-	-	-	-	-	-	-	-	-	926	1095	-	-	-	-	-	-	1190	1338	-	-	

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

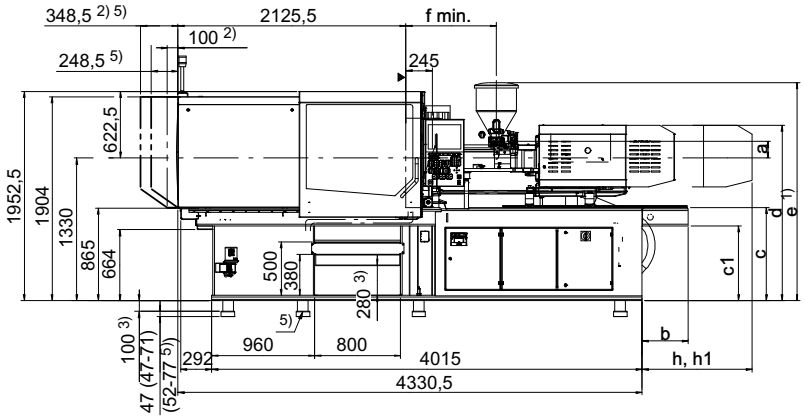
3) Plasticising rate depends on processing conditions and the material used.

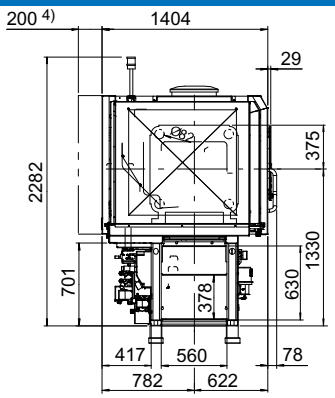
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

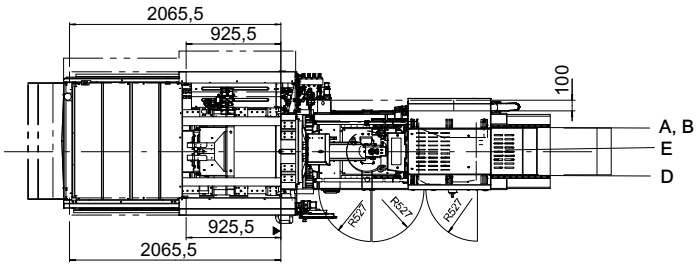
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect 130 / IntElect S 130





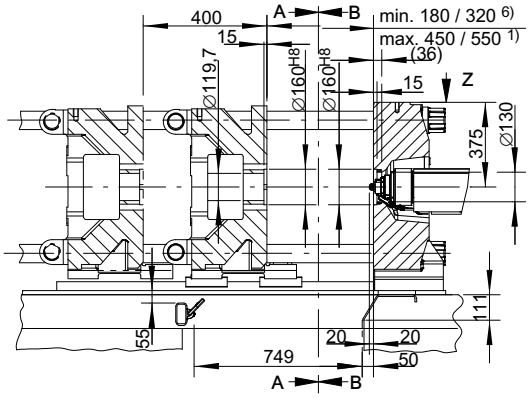


1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
5) IntElect S

A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10

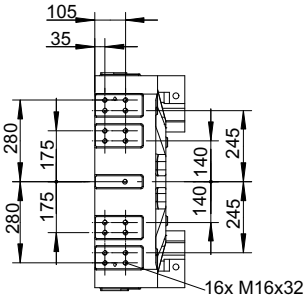
Machine dimension without OP2032

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect 130 / IntElect S 130

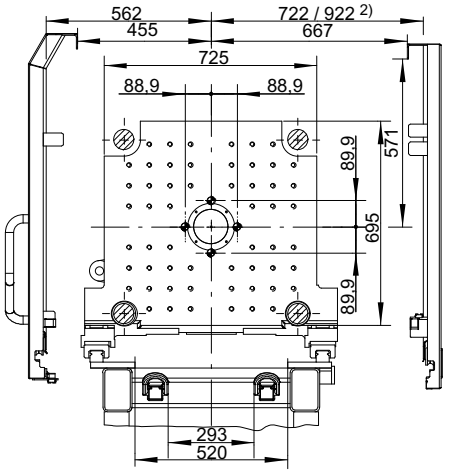


1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP2032 Distance between tie bars, increased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate
6) OP2621 Middle platen support

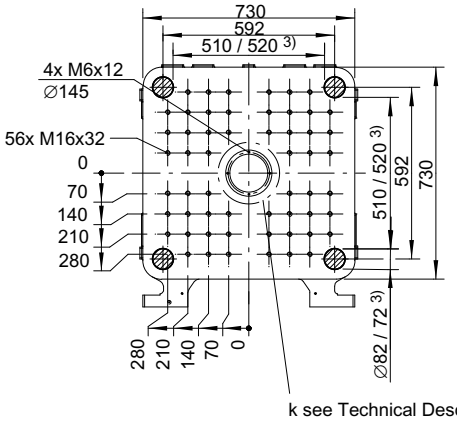
Z Hole pattern for robot / sprue picker on fixed platen 4)
EUROMAP 18-E7/E8/E9



Movable platen
B - B



Fixed platen
A - A



k see Technical Description

Bore diameter throughout 27, Dimensions Ø 14H8 5)

Sumitomo (SHI) Demag		IntElect 180 / IntElect S 180			
International size description		1800-250	1800-450 / 460	1800-560	1800-700
Clamping unit		**180**			
Clamping force / locking force, max.	[kN]	1800 / 1980			
Mould opening stroke, max.	[mm]	450			
Mould height, min. / max.:					
>Standard OP0210	[mm]	200 / 500			
>Increased OP0211	[mm]	200 / 600			
Distance between tie bars (h x v):	[mm]				
>Standard	[mm]	560 x 560			
>Increased OP2032	[mm]	570 x 570			
Min. permissible mould diameter (k)	[mm]	336			
Mould weight / mov. / fixed, max.	[kg]	1750 / 1160 / 875			
Ejector stroke / force / speed, max.: [1]					
>Standard	[mm / kN / mm/s]	150 / 45 / 333			
>Speed increased OP2636	[mm / kN / mm/s]	100 / 50 / 500			

Injection unit		250					450 / 460				560				700			
Screw diameter	[mm]	22	25	30	35	40	30	35	40	45	35	40	45	50	35	40	45	50
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
L/D ratio OP0612 / OP0627	[mm]	-	-	-	-	-	25	25	-	-	-	-	-	-	25	25	-	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2800	2800	2510	1850	1410	2800	2790	2140	1690	2800	2418	2200	1780	2800	2418	2200	1780
Injection volume, max.	[cm³]	40	61	99	135	176	113	154	201	254	154	201	254	314	178	251	318	393
Injection speed, max.: [2]																		
>Standard OP0314	[mm/s]			200				200				200				-		
>Speed OP0315	[mm/s]			350				350				350				350		
>High-Speed OP0316	[mm/s]			-				-				-				-		
Injection rate, max.: [2]																		
>Standard OP0314	[cm³/s]	76	98	141	192	251	141	192	251	318	192	251	318	393	-	-	-	-
>Speed OP0315	[cm³/s]	133	172	247	337	440	247	337	440	556	337	440	556	687	337	440	556	687
>High-Speed OP0316	[cm³/s]	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Plasticising rate, max. (PS): [3]																		
>Standard OP0314	[g/s]	6	10	16,7	22,7	33,3	16,7	22,7	33,3	42	22,7	33,3	42	57,3	-	-	-	-
>OP0315 / OP0316	[g/s]	6,8	11,3	18,8	25,5	37,5	18,8	25,5	37,5	47,3	25,5	37,5	47,3	64,5	25,5	37,5	47,3	64,5
Nozzle stroke, max. [4]	[mm]			380				380				450				450		
Nozzle sealing force / speed, max.:																		
>Standard	[kN / mm/s]			30 / 23				30 / 23				30 / 23				30 / 23		
>Increased OP1336	[kN / mm/s]			43 / 120				43 / 120				43 / 120				43 / 120		

General data		180-250					180-450 /460				180-560				180-700			
Dry cycle time (Euromap 6):																		
>Standard OP0215 [5]	[s-mm]			1,5 - 392				1,5 - 392				1,5 - 392				-		
>IntElect S OP0202	[s-mm]			1,2 - 392				1,2 - 392				-				1,2 - 392		
Net weight [6]	[kg]			6750				7000 / 7200				7200				7400		
Motor end projection, max. (h):																		
>Standard + L/D 20	[mm]	165	227	355	500	617	517	662	779	941	776	893	1055	1198	-	-	-	-
>IntElect S + L/D 20	[mm]	165	227	355	500	617	631	776	893	1055	-	-	-	-	931	1048	1210	1353
>IntElect S + L/D 25	[mm]	-	-	-	-	-	781	950	-	-	-	-	-	-	1105	1253	-	-

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

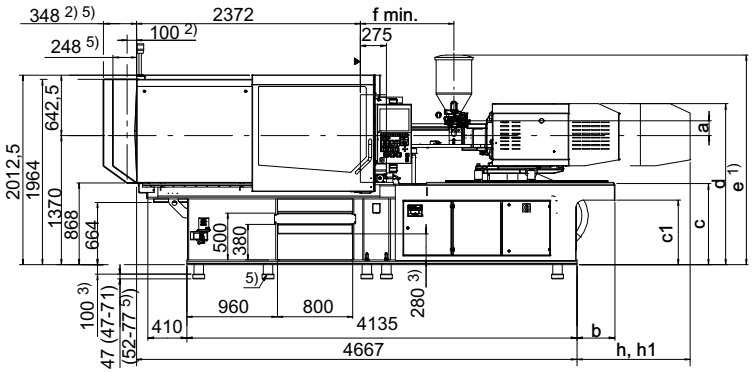
3) Plasticising rate depends on processing conditions and the material used.

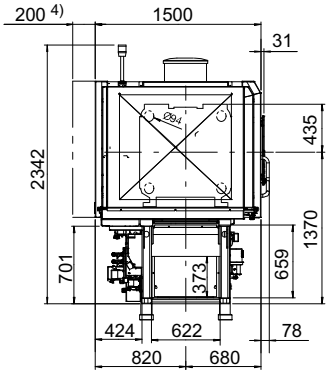
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

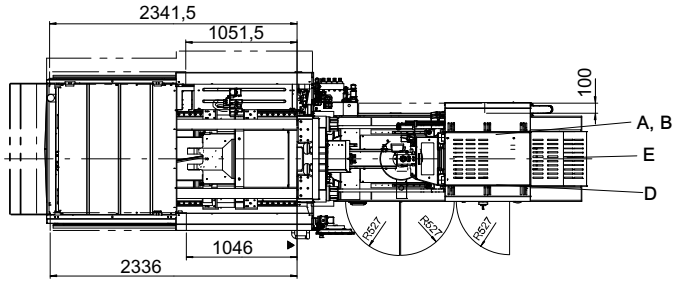
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect 180 / IntElect S 180

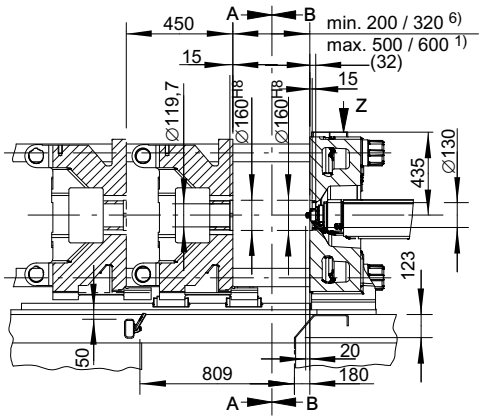






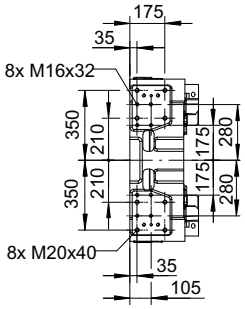
1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
5) IntElect S
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10
Machine dimension without OP2032

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect 180 / IntElect S 180

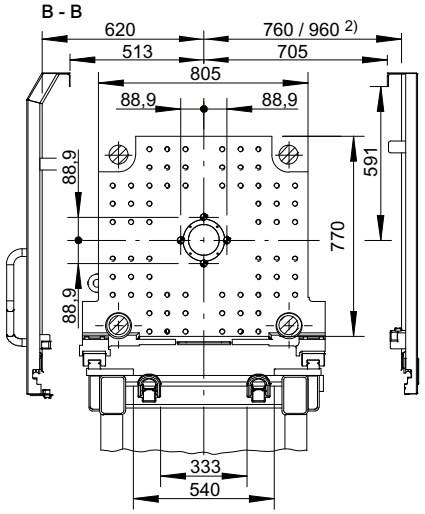


1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP2032 Distance between tie bars, increased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate
6) OP2621 Middle platen support

Z Hole pattern for robot / sprue picker on fixed platen 4)
EUROMAP 18-E8/E9/E10

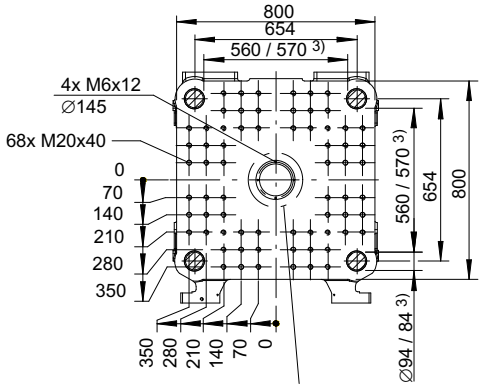


Movable platen
B - B



Bore diameter throughout 27, Dimensions Ø 14H8 5)

Fixed platen
A - A



k see Technical Description

Sumitomo (SHI) Demag		IntElect 220		
International size description		2200-700	2200-1100	2200-1600
Clamping unit		**220**		
Clamping force / locking force, max.	[kN]	2200 / 2420		
Mould opening stroke, max.	[mm]	575		
Mould height, min. / max.:				
>Standard OP0210	[mm]	300 / 600		
>Increased OP0211	[mm]	300 / 800		
Distance between tie bars (h x v):	[mm]			
>Standard	[mm]	660 x 660		
Min. permissible mould diameter (k)	[mm]	400		
Mould weight / mov. / fixed, max.	[kg]	4300 / 2500 / 3300		
Ejector stroke / force / speed, max.: [1]				
>Standard	[mm / kN / mm/s]	220 / 60 / 270		
>Force increased OP2192	[mm / kN / mm/s]	220 / 100 / 270		
>Speed increased OP2636	[mm / kN / mm/s]	100 / 100 / 440		

Injection unit		700				1100			1600		
Screw diameter	[mm]	35	40	45	50	45	50	60	50	60	70
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20	20	20	20	20
L/D ratio OP0612 / OP0627	[mm]	-	-	-	-	-	-	-	-	-	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2800	2418	2200	1780	2426	2348	1630	2426	2073	1523
Injection volume, max.	[cm³]	178	251	318	393	363	511	735	550	820	1116
Injection speed, max.: [2]											
>Standard OP0314	[mm/s]	200				160			160		
>Speed OP0315	[mm/s]	-				-			-		
Injection rate, max.: [2]											
>Standard OP0314	[cm³/s]	192	251	318	393	254	314	452	314	452	616
>Speed OP0315	[cm³/s]	-	-	-	-	-	-	-	-	-	-
Plasticising rate, max. (PS): [3]											
>Standard OP0314	[g/s]	22,7	33,3	42	57,3	26,3	37,5	58,3	37,5	58,3	83,3
>OP0315 / OP0316	[g/s]	-	-	-	-	-	-	-	-	-	-
Nozzle stroke, max. [4]	[mm]	450				450			450		
Nozzle sealing force / speed, max.:											
>Standard	[kN / mm/s]	43 / 66				58 / 73			58 / 73		
>Increased OP1337	[kN / mm/s]	43 / 120				58 / 120			58 / 120		

General data		220-700				220-1100			220-1600		
Dry cycle time (Euromap 6):											
>Standard OP0215 [5]	[s-mm]	1,6 - 462				1,6 - 462			1,6 - 462		
>IntElect S OP0202	[s-mm]	-				-			-		
Net weight [6]	[kg]	12200				14800			14900		
Motor end projection, max. (h):											
>Standard + L/D 20	[mm]	0	33	195	338	367	525	816	635	926	1231
>IntElect S + L/D 20	[mm]	0	33	195	338	-	-	-	-	-	-
>IntElect S + L/D 25	[mm]	84	233	413	-	-	-	-	-	-	-

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

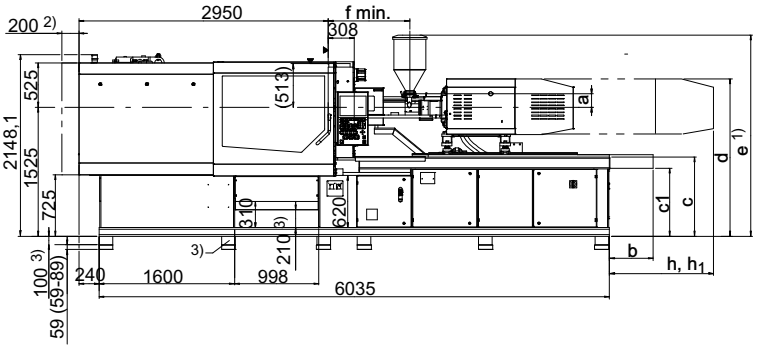
3) Plasticising rate depends on processing conditions and the material used.

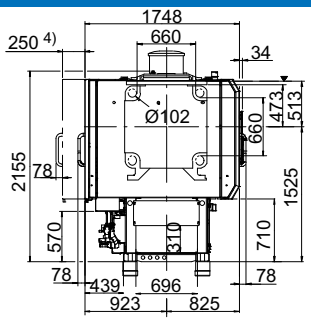
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

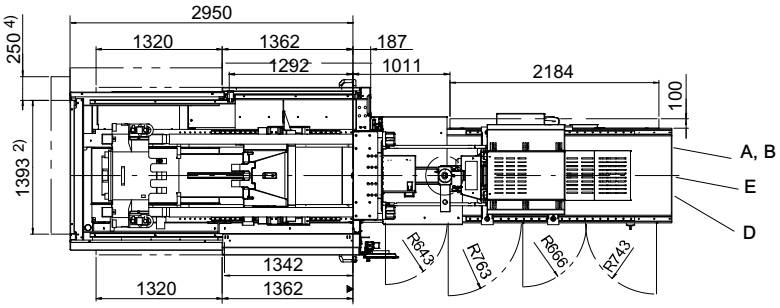
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect 220

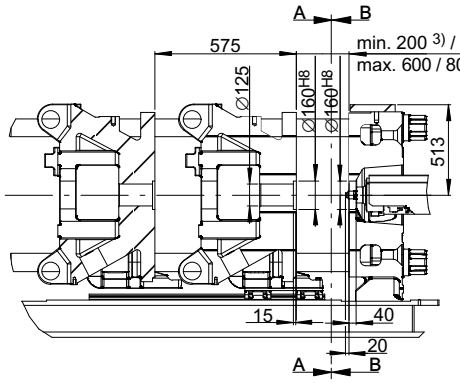






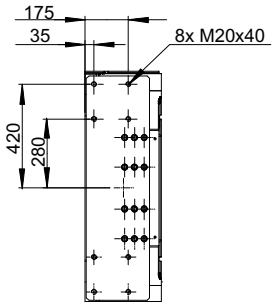
1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect 220

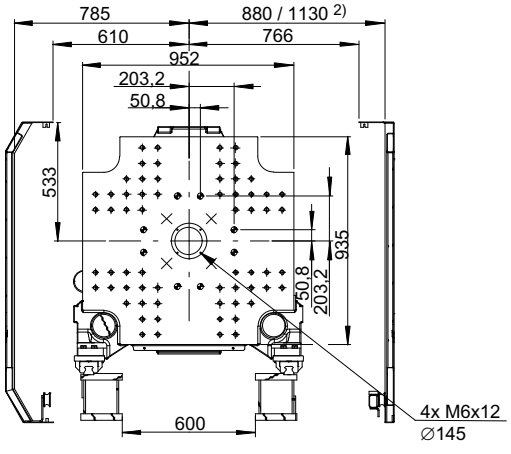


1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP0214 Mould height decreased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate

Z Hole pattern for robot / sprue picker on fixed platen 4)

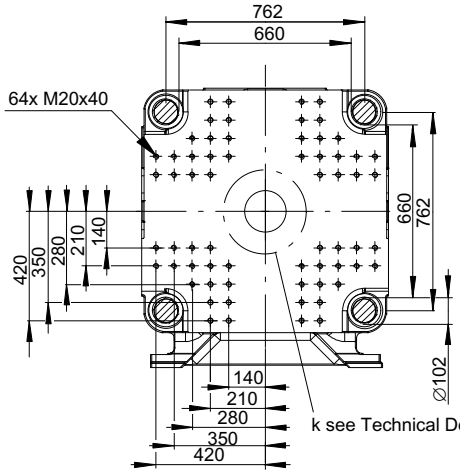


Movable platen
B - B



Bore diameter throughout 27+1 5)

Fixed platen
A - A



Sumitomo (SHI) Demag		IntElect S 220		
International size description		2200-700	2200-1100	2200-1400
Clamping unit		**220**		
Clamping force / locking force, max.	[kN]	2200 / 2420		
Mould opening stroke, max.	[mm]	575		
Mould height, min. / max.:				
>Standard OP0210	[mm]	300 / 600		
>Increased OP0211	[mm]	300 / 800		
Distance between tie bars (h x v):	[mm]			
>Standard	[mm]	660 x 660		
Min. permissible mould diameter (k)	[mm]	400		
Mould weight / mov. / fixed, max.	[kg]	4300 / 2500 / 3300		
Ejector stroke / force / speed, max.: [1]				
>Standard	[mm / kN / mm/s]	220 / 60 / 270		
>Force increased OP2192	[mm / kN / mm/s]	220 / 100 / 270		
>Speed increased OP2636	[mm / kN / mm/s]	100 / 100 / 440		

Injection unit		700				1000			1400		
Screw diameter	[mm]	35	40	45	50	45	50	60	50	60	70
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20	20	20	20	20
L/D ratio OP0612 / OP0627	[mm]	-	25	25	-	25	25	-	25	25	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2800	2418	2200	1780	2400	2400	1666	2400	2000	1470
Injection volume, max.	[cm³]	178	251	318	393	333	412	593	451	649	884
Injection speed, max.: [2]											
>Standard OP0314	[mm/s]			-			-			-	
>Speed OP0315	[mm/s]			350			350			350	
Injection rate, max.: [2]											
>Standard OP0314	[cm³/s]	-	-	-	-	-	-	-	-	-	-
>Speed OP0315	[cm³/s]	337	440	556	687	556	687	989	686	989	1346
Plasticising rate, max. (PS): [3]											
>Standard OP0314	[g/s]	-	-	-	-	-	-	-	-	-	-
>OP0315 / OP0316	[g/s]	25,5	37,5	47,3	64,5	53	73	119	60	98	140
Nozzle stroke, max. [4]	[mm]			450			420			420	
Nozzle sealing force / speed, max.:											
>Standard	[kN / mm/s]			43 / 66			80 / 73			80 / 73	
>Increased OP1337	[kN / mm/s]			43 / 120			80 / 120			80 / 120	

General data		220-700				220-1000			220-1400		
Dry cycle time (Euromap 6):											
>Standard OP0215 [5]	[s-mm]			-			-			-	
>IntElect S OP0202	[s-mm]			1,6 - 462			1,6 - 462			1,6 - 462	
Net weight [6]	[kg]			12200			15600			15700	
Motor end projection, max. (h):											
>Standard + L/D 20	[mm]	-	-	-	-	-	-	-	-	-	-
>IntElect S + L/D 20	[mm]	0	33	195	338	0	0	189	0	269	574
>IntElect S + L/D 25	[mm]	84	233	413	-	0	164	-	244	569	-

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

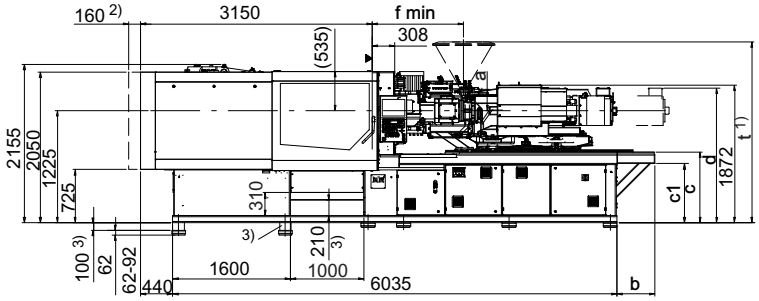
3) Plasticising rate depends on processing conditions and the material used.

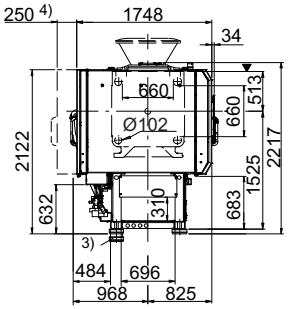
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

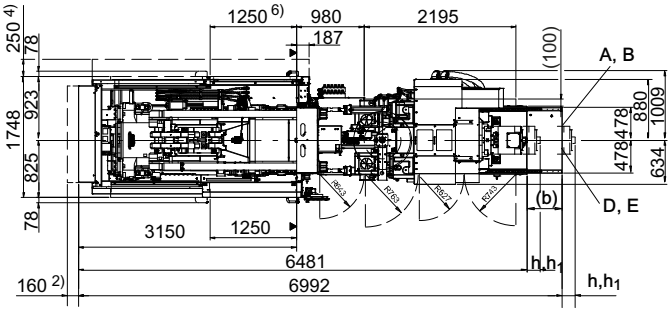
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect S 220



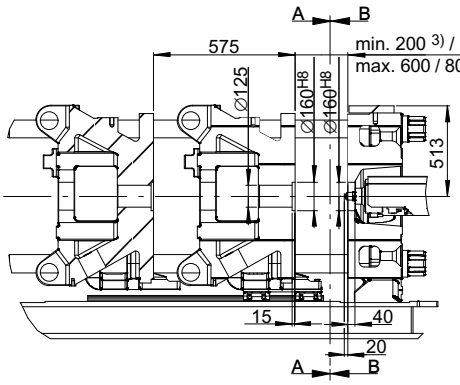




1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
6) OP2171 / OP0766 operation with opened safety gate

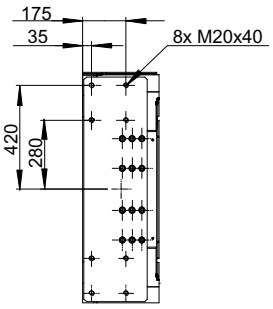
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect S 220

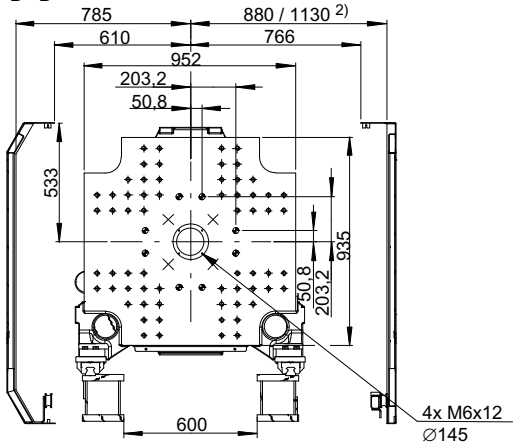


1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP0214 Mould height decreased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate

Z Hole pattern for robot / sprue picker on fixed platen 4)

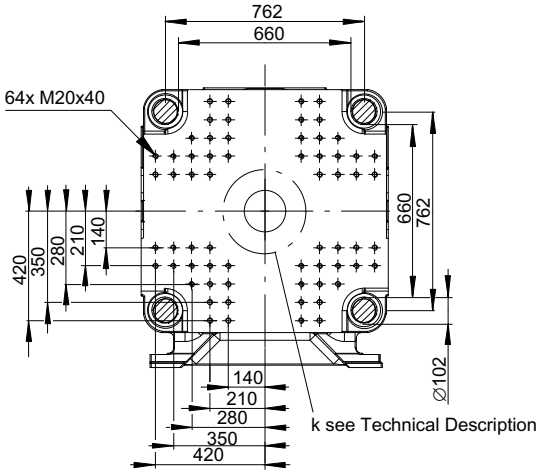


Movable platen
B - B



◔ Bore diameter throughout 27^{+1} 5)

Fixed platen
A - A



Sumitomo (SHI) Demag		IntElect 280		
International size description		2800-1100	2800-1600	2800-2200
Clamping unit		**280**		
Clamping force / locking force, max.	[kN]	2800 / 3080		
Mould opening stroke, max.	[mm]	625		
Mould height, min. / max.:				
>Standard OP0210	[mm]	350 / 650		
>Increased OP0211	[mm]	350 / 850		
Distance between tie bars (h x v):	[mm]			
>Standard	[mm]	730 x 730		
Min. permissible mould diameter (k)	[mm]	400		
Mould weight / mov. / fixed, max.	[kg]	4700 / 2650 / 3600		
Ejector stroke / force / speed, max.: [1]				
>Standard	[mm / kN / mm/s]	220 / 60 / 270		
>Force increased OP2192	[mm / kN / mm/s]	220 / 100 / 270		
>Speed increased OP2636	[mm / kN / mm/s]	100 / 100 / 440		

Injection unit		1100			1600			2200		
Screw diameter	[mm]	45	50	60	50	60	70	60	70	80
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20	20	20	20
L/D ratio OP0612 / OP0627	[mm]	-	-	-	-	-	-	-	-	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2426	2348	1630	2426	2073	1523	2426	1877	1437
Injection volume, max.	[cm³]	363	511	735	550	820	1116	891	1232	1608
Injection speed, max.: [2]										
>Standard OP0314	[mm/s]		160			160			160	
>Speed OP0315	[mm/s]		-			-			-	
Injection rate, max.: [2]										
>Standard OP0314	[cm³/s]	254	314	452	314	452	616	452	616	804
>Speed OP0315	[cm³/s]	-	-	-	-	-	-	-	-	-
Plasticising rate, max. (PS): [3]										
>Standard OP0314	[g/s]	26,3	37,5	58,3	37,5	58,3	83,3	58,3	83,3	116,7
>OP0315 / OP0316	[g/s]	-	-	-	-	-	-	-	-	-
Nozzle stroke, max. [4]	[mm]		450			450		520	520	520
Nozzle sealing force / speed, max.:										
>Standard	[kN / mm/s]		58 / 73			58 / 73			58 / 73	
>Increased OP1337	[kN / mm/s]		58 / 120			58 / 120			58 / 120	

General data		280-1100			280-1600			280-2200		
Dry cycle time (Euromap 6):										
>Standard OP0215 [5]	[s-mm]		1,7 - 511			1,7 - 511			1,7 - 511	
>IntElect S OP0202	[s-mm]		-			-			-	
Net weight [6]	[kg]		16600			16600			17500	
Motor end projection, max. (h):										
>Standard + L/D 20	[mm]	67	225	516	335	626	931	630	630	870
>IntElect S + L/D 20	[mm]	-	-	-	-	-	-	-	-	-
>IntElect S + L/D 25	[mm]	-	-	-	-	-	-	-	-	-

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

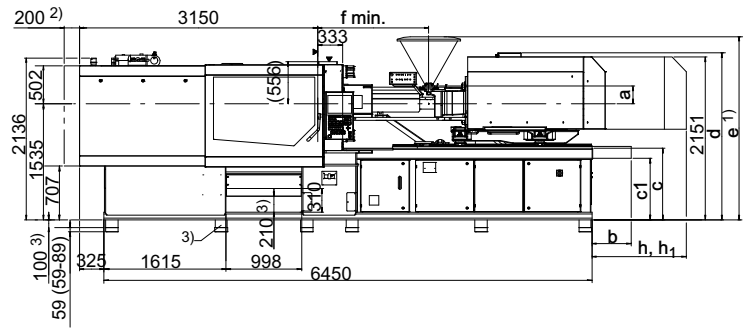
3) Plasticising rate depends on processing conditions and the material used.

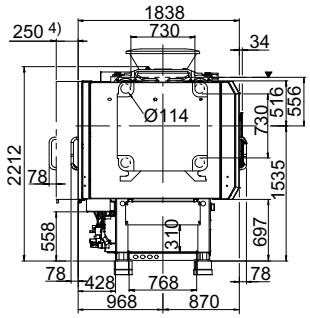
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

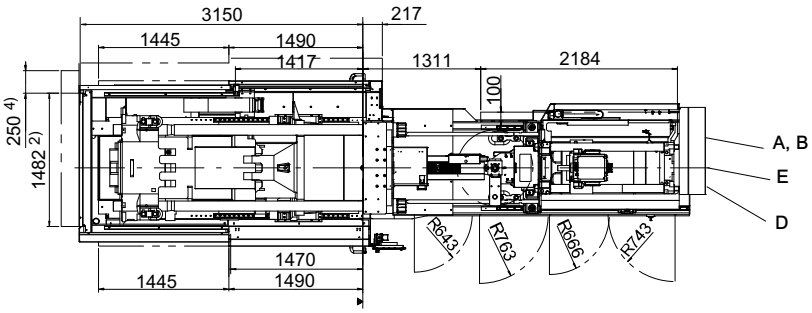
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect 280

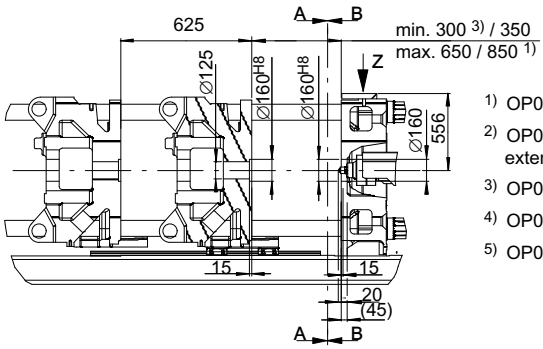






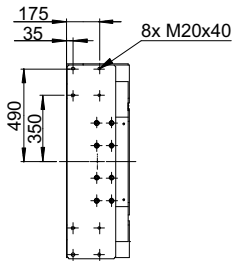
1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect 280

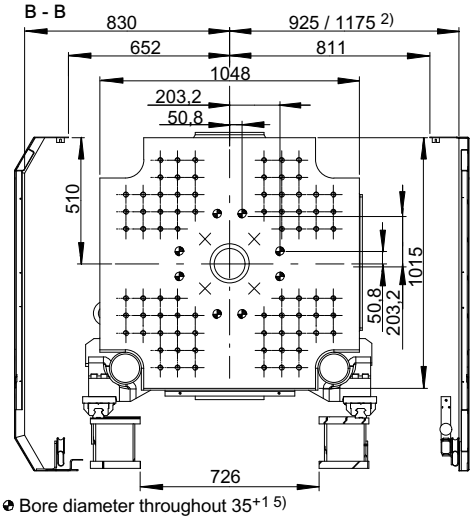


1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP0214 Mould height decreased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate

Z Hole pattern for robot / sprue picker on fixed platen 4)

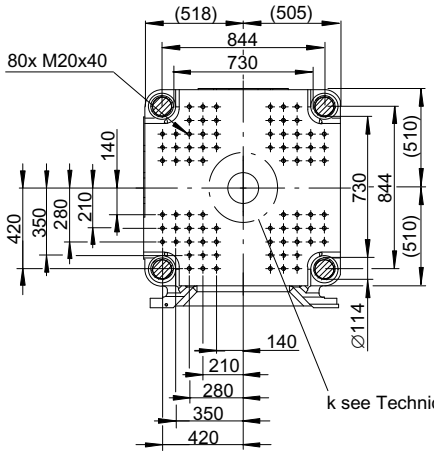


Movable platen
B - B



◔ Bore diameter throughout 35+1 5)

Fixed platen
A - A



k see Technical Description

Sumitomo (SHI) Demag		IntElect S 280		
International size description		2800-1000	2800-1400	2800-2000
Clamping unit		**280**		
Clamping force / locking force, max.	[kN]	2800 / 3080		
Mould opening stroke, max.	[mm]	625		
Mould height, min. / max.:				
>Standard OP0210	[mm]	350 / 650		
>Increased OP0211	[mm]	350 / 850		
Distance between tie bars (h x v):	[mm]			
>Standard	[mm]	730 x 730		
Min. permissible mould diameter (k)	[mm]	400		
Mould weight / mov. / fixed, max.	[kg]	4700 / 2650 / 3600		
Ejector stroke / force / speed, max.: [1]				
>Standard	[mm / kN / mm/s]	220 / 60 / 270		
>Force increased OP2192	[mm / kN / mm/s]	220 / 100 / 270		
>Speed increased OP2636	[mm / kN / mm/s]	100 / 100 / 440		

Injection unit		1000			1400			2000		
Screw diameter	[mm]	45	50	60	50	60	70	60	70	80
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20	20	20	20
L/D ratio OP0612 / OP0627	[mm]	25	25	-	25	25	-	25	25	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2400	2400	1666	2400	2000	1470	2400	1950	1493
Injection volume, max.	[cm³]	333	412	593	451	649	884	706	961	1256
Injection speed, max.: [2]										
>Standard OP0314	[mm/s]		-			-			-	
>Speed OP0315	[mm/s]		350			350			350	
Injection rate, max.: [2]										
>Standard OP0314	[cm³/s]	-	-	-	-	-	-	-	-	-
>Speed OP0315	[cm³/s]	556	687	989	686	989	1346	989	1346	1758
Plasticising rate, max. (PS): [3]										
>Standard OP0314	[g/s]	-	-	-	-	-	-	-	-	-
>OP0315 / OP0316	[g/s]	53	73	119	60	98	140	84	120	168
Nozzle stroke, max. [4]	[mm]		420		420	420	420	550	550	550
Nozzle sealing force / speed, max.:										
>Standard	[kN / mm/s]		80 / 73			80 / 73			80 / 73	
>Increased OP1337	[kN / mm/s]		80 / 120			80 / 120			80 / 120	

General data		280-1000			280-1400			280-2000		
Dry cycle time (Euromap 6):										
>Standard OP0215 [5]	[s-mm]		-			-			-	
>IntElect S OP0202	[s-mm]		1,7 - 511			1,7 - 511			1,7 - 511	
Net weight [6]	[kg]		17400			17500			18700	
Motor end projection, max. (h):										
>Standard + L/D 20	[mm]	-	-	-	-	-	-	-	-	-
>IntElect S + L/D 20	[mm]	-	115	406	-	-	273	-	297	516
>IntElect S + L/D 25	[mm]	182	381	-	-	268	-	292	616	-

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other.
Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

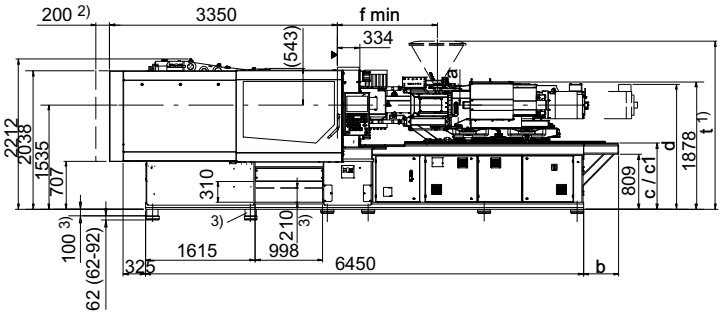
3) Plasticising rate depends on processing conditions and the material used.

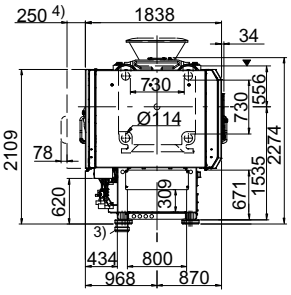
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

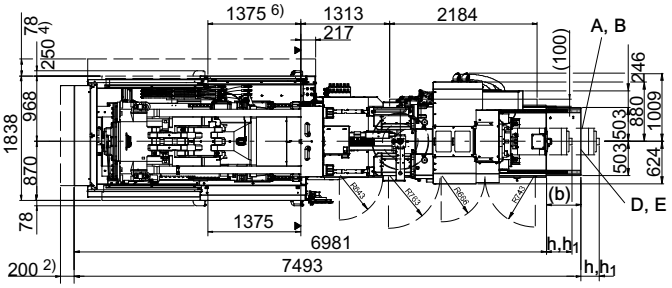
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect S 280





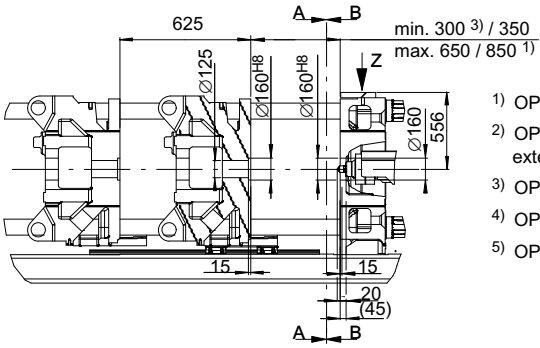


1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
6) OP2171 / OP0766 operation with opened safety gate

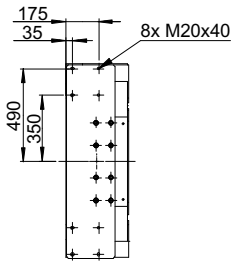
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect S 280

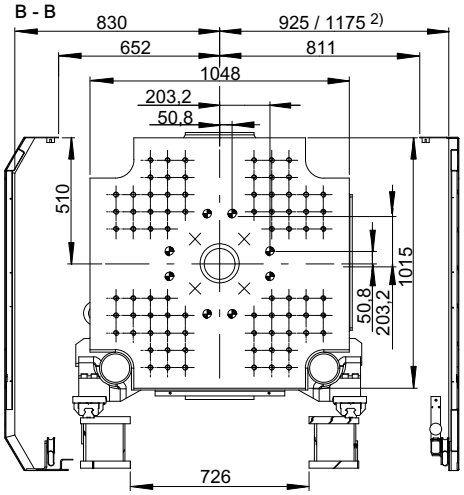
Z Hole pattern for robot / sprue picker on fixed platen 4)



1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP0214 Mould height decreased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate

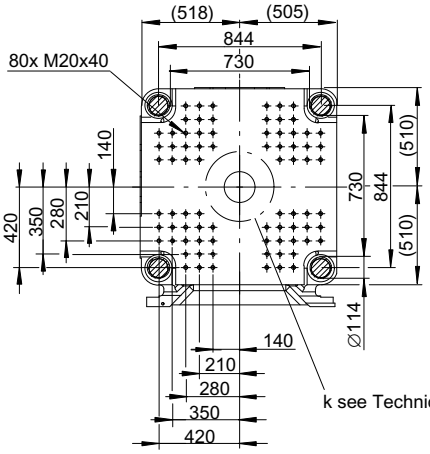


Movable platen
B - B



◴ Bore diameter throughout 35+1 5)

Fixed platen
A - A



k see Technical Description

Sumitomo (SHI) Demag		IntElect 350	
International size description		3500-1600	3500-2200
Clamping unit		**350**	
Clamping force / locking force, max.	[kN]	3500 / 3850	
Mould opening stroke, max.	[mm]	725	
Mould height, min. / max.:			
>Standard OP0210	[mm]	400 / 700	
>Increased OP0211	[mm]	400 / 900	
Distance between tie bars (h x v):	[mm]		
>Standard	[mm]	830 x 830	
Min. permissible mould diameter (k)	[mm]	450	
Mould weight / mov. / fixed, max.	[kg]	6600 / 3800 / 5100	
Ejector stroke / force / speed, max.: [1]			
>Standard	[mm / kN / mm/s]	250 / 60 / 270	
>Force increased OP2192	[mm / kN / mm/s]	250 / 100 / 270	
>Speed increased OP2636	[mm / kN / mm/s]	100 / 100 / 440	

Injection unit		1600			2200		
Screw diameter	[mm]	50	60	70	60	70	80
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20
L/D ratio OP0612 / OP0627	[mm]	-	-	-	-	-	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2426	2073	1523	2426	1877	1437
Injection volume, max.	[cm³]	550	820	1116	891	1232	1608
Injection speed, max.: [2]							
>Standard OP0314	[mm/s]		160			160	
>Speed OP0315	[mm/s]		-			-	
Injection rate, max.: [2]							
>Standard OP0314	[cm³/s]	314	452	616	452	616	804
>Speed OP0315	[cm³/s]	-	-	-	-	-	-
Plasticising rate, max. (PS): [3]							
>Standard OP0314	[g/s]	37,5	58,3	83,3	58,3	83,3	116,7
>OP0315 / OP0316	[g/s]	-	-	-	-	-	-
Nozzle stroke, max. [4]	[mm]		450			520	
Nozzle sealing force / speed, max.:							
>Standard	[kN / mm/s]		58 / 73			58 / 73	
>Increased OP1337	[kN / mm/s]		58 / 120			58 / 120	

General data		350-1600			350-2200		
Dry cycle time (Euromap 6):							
>Standard OP0215 [5]	[s-mm]		1,9 - 581			1,9 - 581	
>IntElect S OP0202	[s-mm]		-			-	
Net weight [6]	[kg]		19900			20700	
Motor end projection, max. (h):							
>Standard + L/D 20	[mm]	335	626	931	727	1032	1246
>IntElect S + L/D 20	[mm]	-	-	-	-	-	-
>IntElect S + L/D 25	[mm]	-	-	-	-	-	-

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

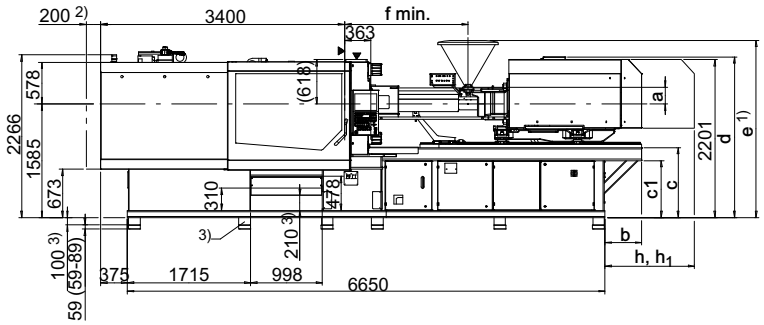
3) Plasticising rate depends on processing conditions and the material used.

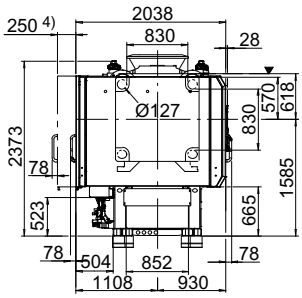
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

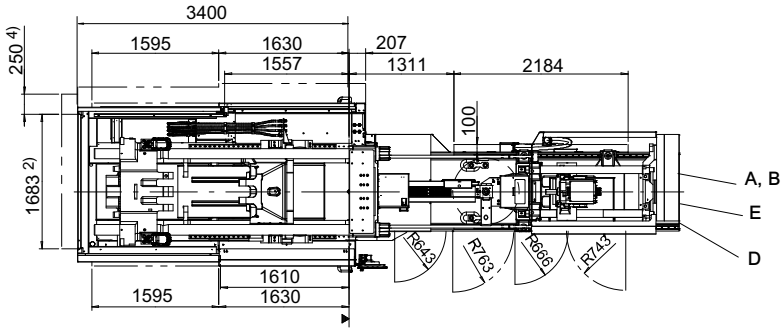
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect 350



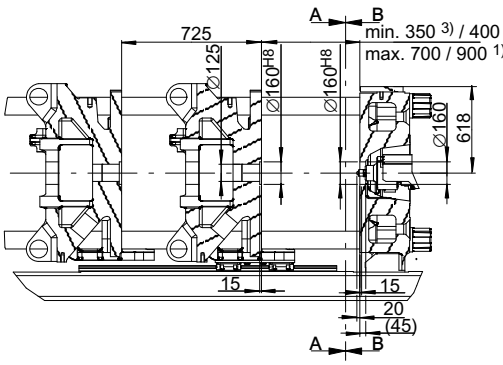




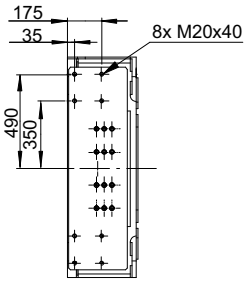
1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect 350

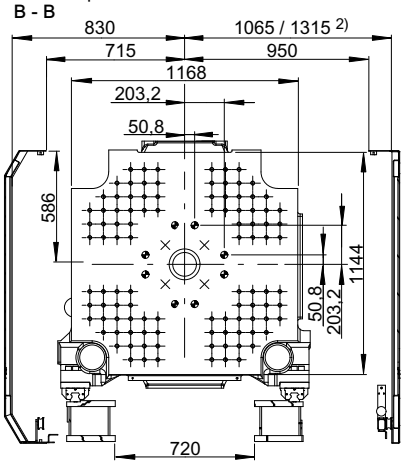
Z Hole pattern for robot / sprue picker on fixed platen 4)



1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP0214 Mould height decreased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate

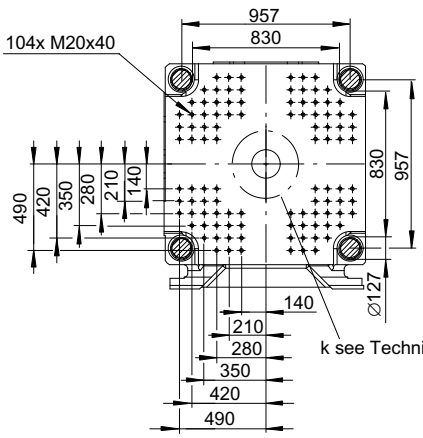


Movable platen
B - B



Bore diameter throughout 35+1 5)

Fixed platen
A - A



Sumitomo (SHI) Demag		IntElect S 350	
International size description		3500-1400	3500-2000
Clamping unit		**350**	
Clamping force / locking force, max.	[kN]	3500 / 3850	
Mould opening stroke, max.	[mm]	725	
Mould height, min. / max.:			
>Standard OP0210	[mm]	400 / 700	
>Increased OP0211	[mm]	400 / 900	
Distance between tie bars (h x v):	[mm]		
>Standard	[mm]	830 x 830	
Min. permissible mould diameter (k)	[mm]	450	
Mould weight / mov. / fixed, max.	[kg]	6600 / 3800 / 5100	
Ejector stroke / force / speed, max.: [1]			
>Standard	[mm / kN / mm/s]	250 / 60 / 270	
>Force increased OP2192	[mm / kN / mm/s]	250 / 100 / 270	
>Speed increased OP2636	[mm / kN / mm/s]	100 / 100 / 440	

Injection unit		1400			2000		
Screw diameter	[mm]	50	60	70	60	70	80
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20
L/D ratio OP0612 / OP0627	[mm]	25	25	-	25	25	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2400	2000	1470	2400	1950	1493
Injection volume, max.	[cm³]	451	649	884	706	961	1256
Injection speed, max.: [2]							
>Standard OP0314	[mm/s]		-			-	
>Speed OP0315	[mm/s]		350			350	
Injection rate, max.: [2]							
>Standard OP0314	[cm³/s]	-	-	-	-	-	-
>Speed OP0315	[cm³/s]	686	989	1346	989	1346	1758
Plasticising rate, max. (PS): [3]							
>Standard OP0314	[g/s]	-	-	-	-	-	-
>OP0315 / OP0316	[g/s]	60	98	140	84	120	168
Nozzle stroke, max. [4]	[mm]		420			550	
Nozzle sealing force / speed, max.:							
>Standard	[kN / mm/s]		80 / 73			80 / 73	
>Increased OP1337	[kN / mm/s]		80 / 120			80 / 120	

General data		350-1400			350-2000		
Dry cycle time (Euromap 6):							
>Standard OP0215 [5]	[s-mm]		-			-	
>IntElect S OP0202	[s-mm]		1,9 - 581			1,9 - 581	
Net weight [6]	[kg]		20700			21900	
Motor end projection, max. (h):							
>Standard + L/D 20	[mm]	-	-	-	-	-	-
>IntElect S + L/D 20	[mm]	0	0	279	0	297	516
>IntElect S + L/D 25	[mm]	0	274	-	292	616	-

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other.
Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

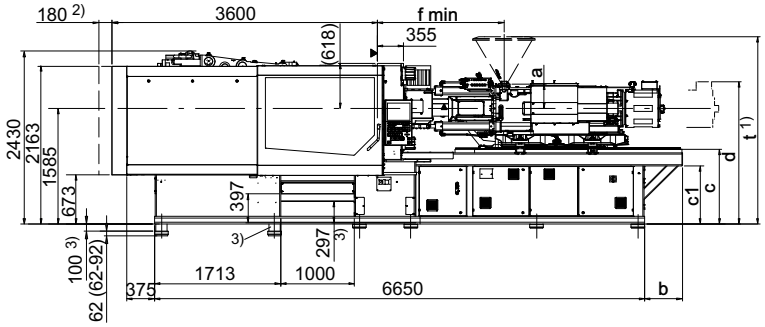
3) Plasticising rate depends on processing conditions and the material used.

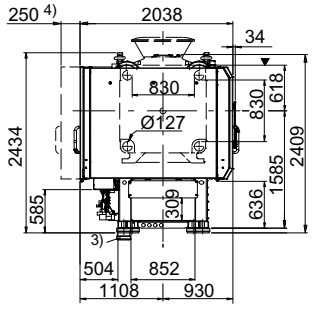
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

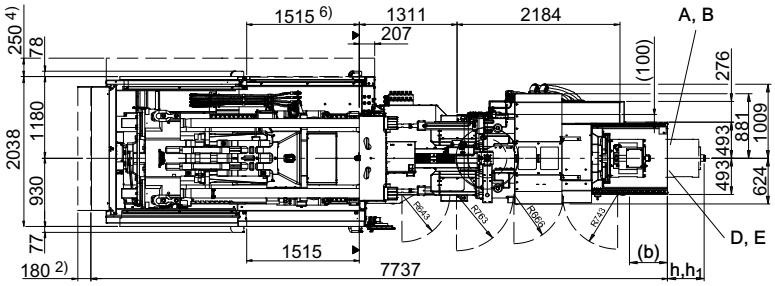
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect S 350



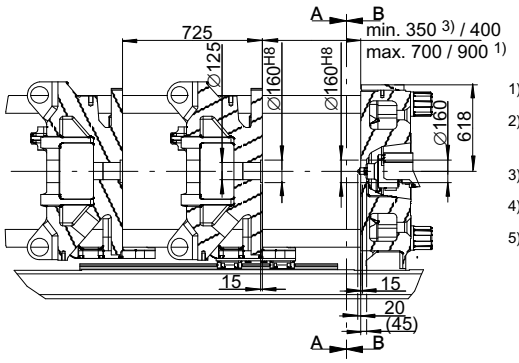




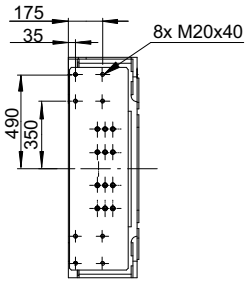
1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
6) OP2171 / OP0766 operation with opened safety gate
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect S 350

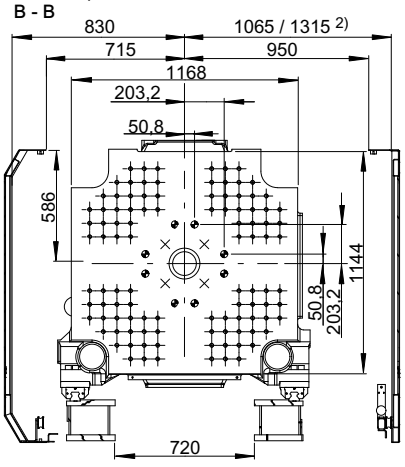
Z Hole pattern for robot / sprue picker on fixed platen 4)



1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP0214 Mould height decreased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate

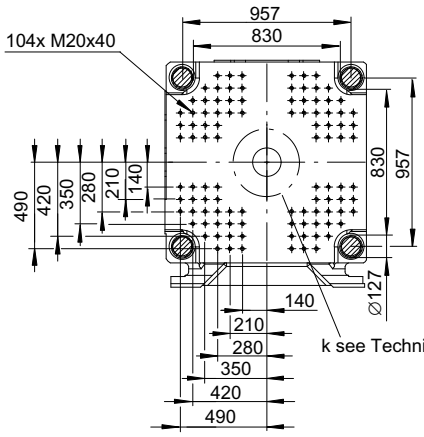


Movable platen
B - B



Bore diameter throughout 35^{+1} 5)

Fixed platen
A - A



k see Technical Description

Sumitomo (SHI) Demag		IntElect 450 / 500	
International size description		4500-2200	4500-3000
Clamping unit		**450 / 500**	
Clamping force / locking force, max.	[kN]	4500 (4950) / 5000 (5500)	
Mould opening stroke, max.	[mm]	825	
Mould height, min. / max.:			
>Standard OP0210	[mm]	450 / 850	
>Increased OP0211	[mm]	450 / 1050	
Distance between tie bars (h x v):	[mm]		
>Standard	[mm]	920 x 920	
Min. permissible mould diameter (k)	[mm]	500	
Mould weight / mov. / fixed, max.	[kg]	8700 / 5200 / 6700	
Ejector stroke / force / speed, max.: [1]			
>Standard	[mm / kN / mm/s]	250 / 100 / 270	
>Force increased OP2192	[mm / kN / mm/s]	250 / 150 / 270	
>Speed increased OP2636	[mm / kN / mm/s]	100 / 100 / 440	

Injection unit		2200			3000		
Screw diameter	[mm]	60	70	80	70	80	95
L/D ratio OP0610 / OP0611	[mm]	20	20	20	23	20	20
L/D ratio OP0612 / OP0627	[mm]	-	-	-	-	-	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2426	1877	1437	2423	1855	1329
Injection volume, max.	[cm³]	891	1232	1608	1385	1810	2552
Injection speed, max.: [2]							
>Standard OP0314	[mm/s]		160			160	
>Speed OP0315	[mm/s]		-			-	
Injection rate, max.: [2]							
>Standard OP0314	[cm³/s]	452	616	804	616	804	1134
>Speed OP0315	[cm³/s]	-	-	-	-	-	-
Plasticising rate, max. (PS): [3]							
>Standard OP0314	[g/s]	58,3	83,3	116,7	83,3	116,7	187,5
>OP0315 / OP0316	[g/s]	-	-	-	-	-	-
Nozzle stroke, max. [4]	[mm]		520			520	
Nozzle sealing force / speed, max.:							
>Standard	[kN / mm/s]		58 / 73			58 / 73	
>Increased OP1337	[kN / mm/s]		58 / 120			58 / 120	

General data		450-2200			450-3000		
Dry cycle time (Euromap 6):							
>Standard OP0215 [5]	[s-mm]		2,7 - 644			2,7 - 644	
>IntElect S OP0202	[s-mm]		-			-	
Net weight [6]	[kg]		27200			28500	
Motor end projection, max. (h):							
>Standard + L/D 20	[mm]	141	446	661	1223	1222	1590
>IntElect S + L/D 20	[mm]	-	-	-	-	-	-
>IntElect S + L/D 25	[mm]	-	-	-	-	-	-

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

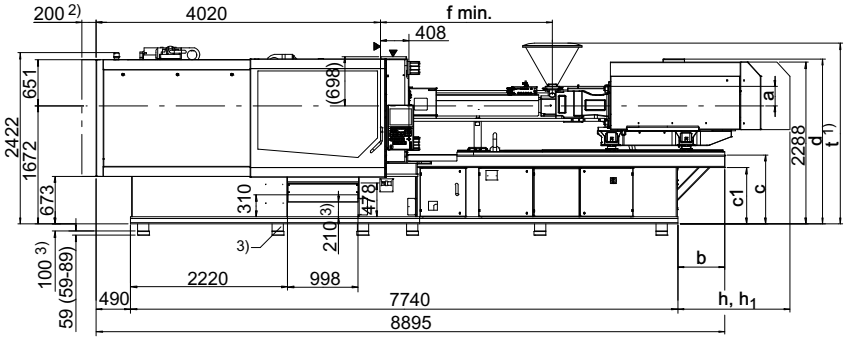
3) Plasticising rate depends on processing conditions and the material used.

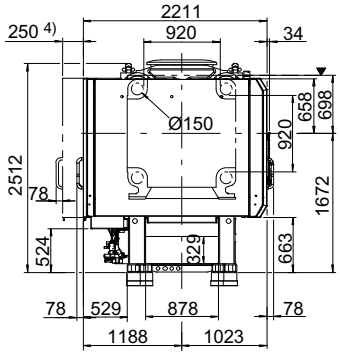
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

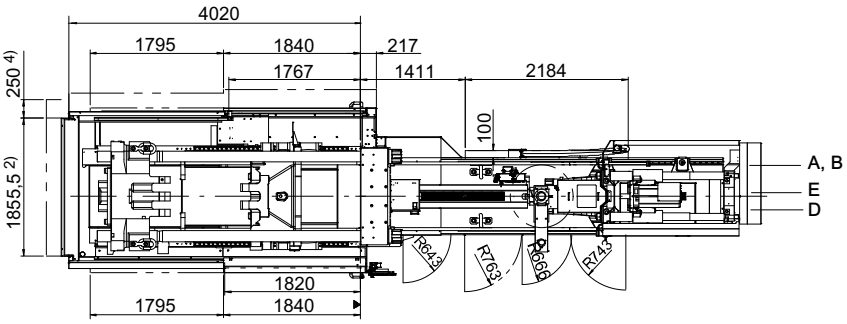
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect 450 / 500

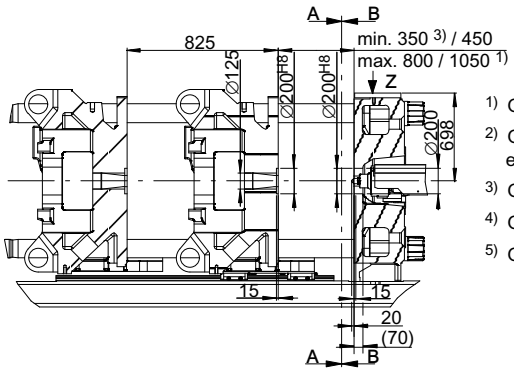






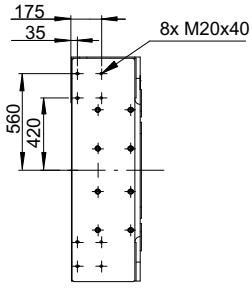
1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect 450 / 500



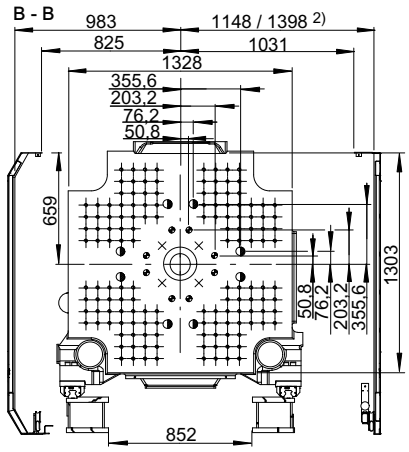
1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP0214 Mould height decreased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate

Z Hole pattern for robot / sprue picker on fixed platen 4)



Movable platen

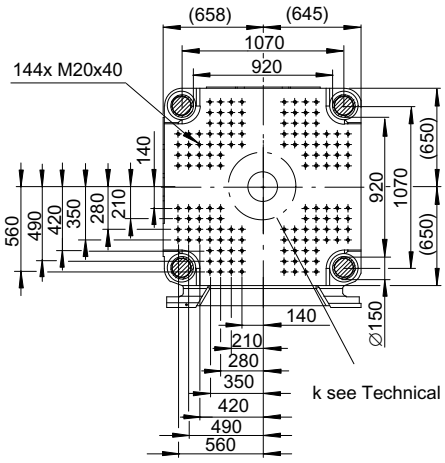
B - B



◓ Bore diameter throughout 35^{+1} 5)
◑ Bore diameter throughout 52^{+1}

Fixed platen

A - A



k see Technical Description

Sumitomo (SHI) Demag		IntElect S 450		
International size description		4500-2000		
Clamping unit		**450**		
Clamping force / locking force, max.	[kN]	4500 (4950)		
Mould opening stroke, max.	[mm]	825		
Mould height, min. / max.:				
>Standard OP0210	[mm]	450 / 850		
>Increased OP0211	[mm]	450 / 1050		
Distance between tie bars (h x v):	[mm]			
>Standard	[mm]	920 x 920		
Min. permissible mould diameter (k)	[mm]	500		
Mould weight / mov. / fixed, max.	[kg]	8700 / 5200 / 6700		
Ejector stroke / force / speed, max.: [1]				
>Standard	[mm / kN / mm/s]	250 / 100 / 270		
>Force increased OP2192	[mm / kN / mm/s]	250 / 150 / 270		
>Speed increased OP2636	[mm / kN / mm/s]	100 / 100 / 440		
Injection unit		**2000**		
Screw diameter	[mm]	60	70	80
L/D ratio OP0610 / OP0611	[mm]	20	20	20
L/D ratio OP0612 / OP0627	[mm]	25	25	-
Injection pressure, max. (up to 400 °C) [2]	[bar]	2400	1950	1533
Injection volume, max.	[cm³]	706	961	1256
Injection speed, max.: [2]				
>Standard OP0314	[mm/s]		-	
>Speed OP0315	[mm/s]		350	
Injection rate, max.: [2]				
>Standard OP0314	[cm³/s]	-	-	-
>Speed OP0315	[cm³/s]	989	1346	1758
Plasticising rate, max. (PS): [3]				
>Standard OP0314	[g/s]	-	-	-
>OP0315 / OP0316	[g/s]	84	120	168
Nozzle stroke, max. [4]	[mm]		550	
Nozzle sealing force / speed, max.:				
>Standard	[kN / mm/s]		80 / 73	
>Increased OP1337	[kN / mm/s]		80 / 120	
General data		**450-2000**		
Dry cycle time (Euromap 6):				
>Standard OP0215 [5]	[s-mm]		-	
>IntElect S OP0202	[s-mm]		2,4 - 644	
Net weight [6]	[kg]		28400	
Motor end projection, max. (h):				
>Standard + L/D 20	[mm]	-	-	-
>IntElect S + L/D 20	[mm]	0	0	0
>IntElect S + L/D 25	[mm]	0	0	-

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

1) Stroke limited with turntable, for details see information on integrated turntable

2) Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

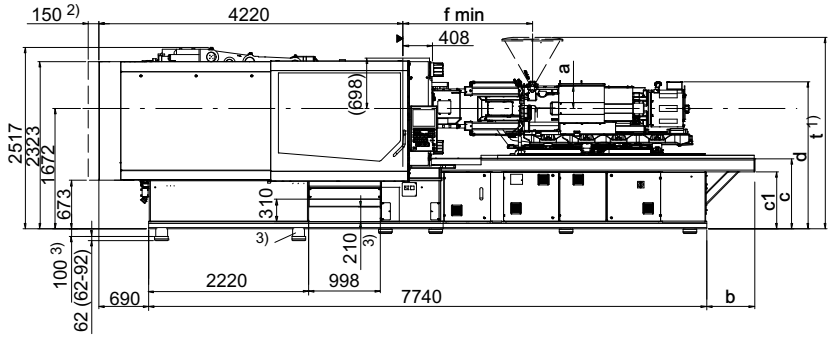
3) Plasticising rate depends on processing conditions and the material used.

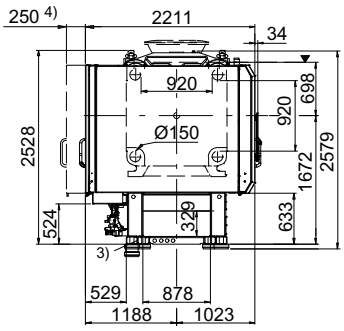
4) The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

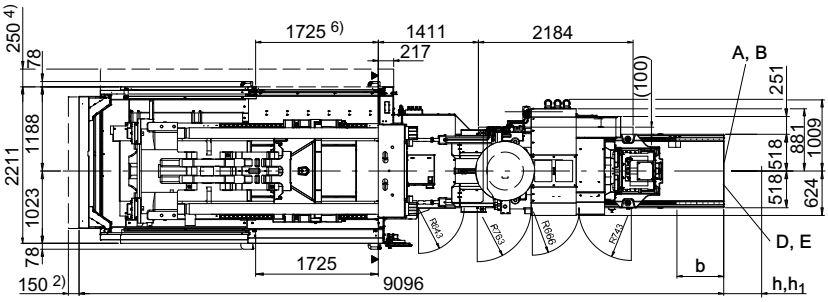
5) Minimum cycle time IntElect 50t - 100t = 5 s; IntElect 130t - 180t = 6 s; IntElect 220t - 350t = 8 s; IntElect 450t - 500t = 12 s

6) Machine weight for standard machine, weight may vary depending on equipment.

Machine dimensions IntElect S 450

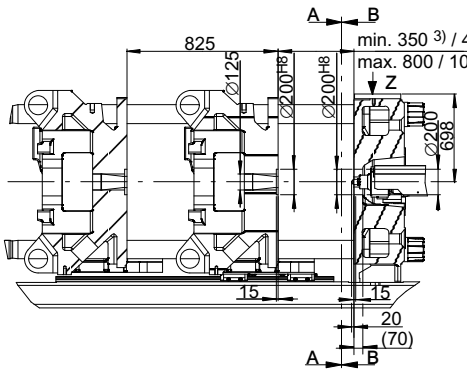






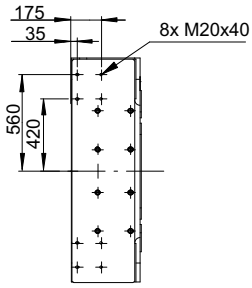
1) OP0320 Material hopper optional
2) OP0211 Mould height increased
3) OP0122 Machine height increase
4) OP0242 Safety guard on non-operator side extended
6) OP2171 / OP0766 operation with opened safety gate
A Cooling water inlet, machine Ø19
B Cooling water outlet, machine Ø19
D Electrical connection
E Pneumatic connection Ø10

Platen dimensions - Hole pattern according to EUROMAP (OP0204, OP0205) IntElect S 450



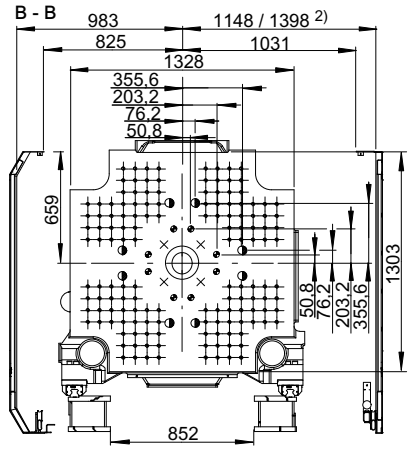
1) OP0211 Mould height increased
2) OP0242 Safety guard on non-operator side extended
3) OP0214 Mould height decreased
4) OP0050 Mechanical interface for handling unit
5) OP0205 Side-ejector plate

Z Hole pattern for robot / sprue picker on fixed platen 4)



Movable platen

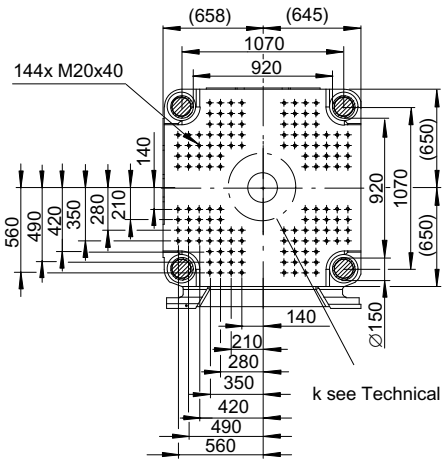
B - B



◕ Bore diameter throughout 35^{+1} 5)
◑ Bore diameter throughout 52^{+1}

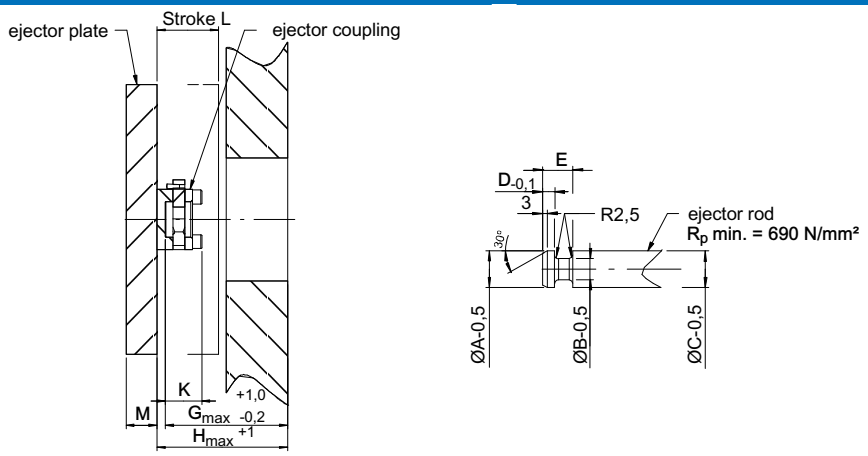
Fixed platen

A - A



k see Technical Description

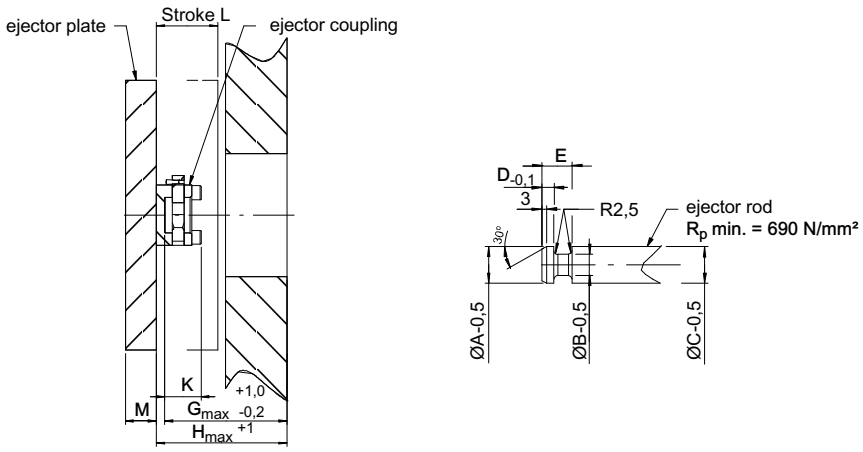
Ejector - dimensions IntElect



Machine type	Specification	Dimensions [mm]				
		A	B	C	D	E
IntElect 50	OP2196	24,5	14	24,5	7,8	20
IntElect 75	OP2636	24,5	14	24,5	7,8	20
IntElect 100	OP2196	24,5	14	24,5	7,8	20
IntElect 130	OP2636	44,5	26	44,5	9,5	26
IntElect 180	OP2196	44,5	26	44,5	9,5	26
	OP2636	44,5	26	44,5	9,5	26
IntElect 220	OP2195	44,5	26	44,5	9,5	26
	OP2192	44,5	26	44,5	9,5	26
	OP2636	44,5	26	44,5	9,5	26
IntElect 280	OP2195	44,5	26	44,5	9,5	26
	OP2192	44,5	26	44,5	9,5	26
	OP2636	44,5	26	44,5	9,5	26
IntElect 350	OP2195	44,5	26	44,5	9,5	26
	OP2192	44,5	26	44,5	9,5	26
	OP2636	44,5	26	44,5	9,5	26
IntElect 450	OP2195	44,5	26	44,5	9,5	26
	OP2192	44,5	26	44,5	9,5	26
	OP2636	44,5	26	44,5	9,5	26

OP2196 Standard 50t - 180t
OP2195 Standard 220t - 450t
OP2192 Force increased
OP2636 Speed increased

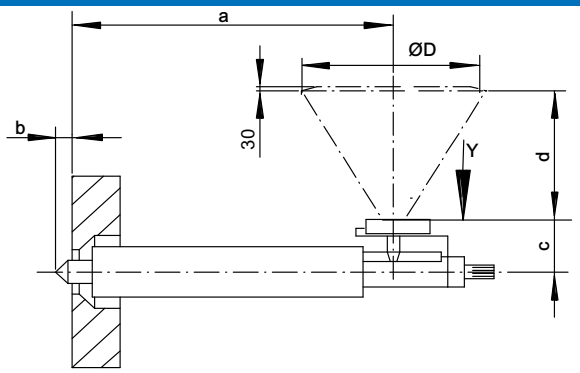
Ejector - dimensions IntElect

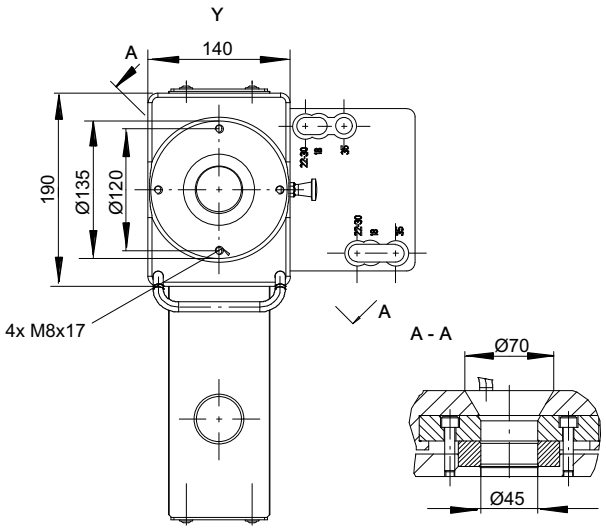


Machine type	Specification	Dimensions [mm]					
		H_{max}	K (OP0022)	K (OP2193)	G_{max}	Stroke L	M
IntElect 50	OP2196	207	32,2	38	184	120	40
	OP2636	185	32,2	38	162	70	50
IntElect 75	OP2196	227	32,2	38	204	130	40
	OP2636	205	32,2	38	182	80	50
IntElect 100	OP2196	254	32,2	38	243	150	45
	OP2636	253	47,2	44	214	100	50
IntElect 130	OP2196	259	32,2	38	248	150	45
	OP2636	258	47,2	44	219	100	50
IntElect 180	OP2196	279	47,2	44	268	150	65
	OP2636	308	47,2	44	269	100	50
IntElect 220	OP2195	432	47,2	47,5	427	220	63
	OP2192	432	47,2	47,5	427	220	63
	OP2636	327	47,2	47,5	322	100	63
IntElect 280	OP2195	432	47,2	47,5	427	220	63
	OP2192	432	47,2	47,5	427	220	63
	OP2636	327	47,2	47,5	322	100	63
IntElect 350	OP2195	462	47,2	47,5	457	250	63
	OP2192	462	47,2	47,5	457	250	63
	OP2636	357	47,2	47,5	352	100	63
IntElect 450	OP2195	528	47,2	47,5	523	250	75
	OP2192	528	47,2	47,5	523	250	75
	OP2636	423	47,2	47,5	418	100	75

OP2196 Standard 50t - 180t
OP2195 Standard 220t - 450t
OP2192 Force increased
OP2636 Speed increased
OP0022 ejector coupling manual
OP2193 ejector coupling semi-automatic

Material Loading - dimensions IntElect

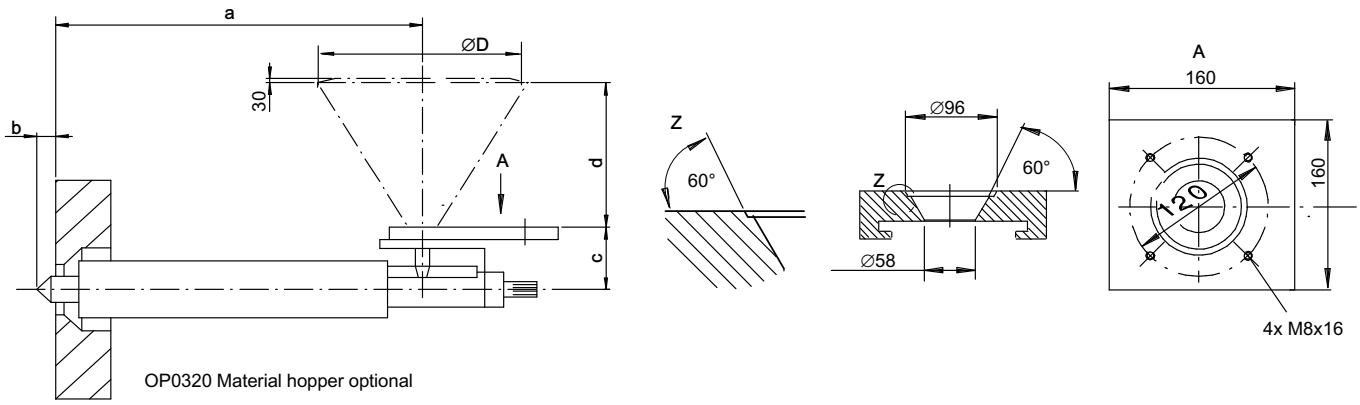




OP0320 Material hopper optional

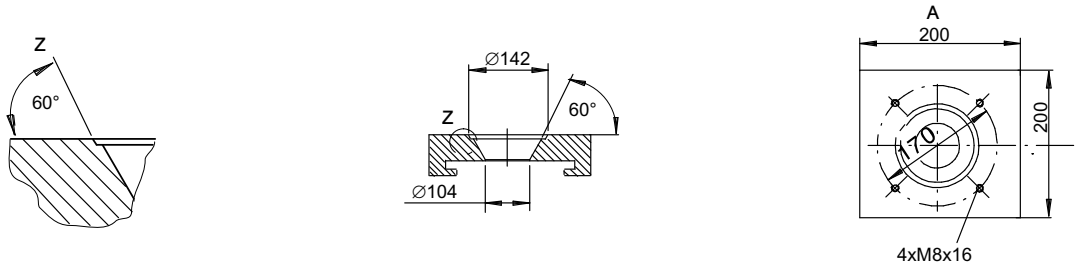
Injection unit	Screw diameter [mm]	Dimensions [mm]					
		Standard	L/D 25 OP0612 / OP0627	Standard			
		a	a	b	c	d	D
65	14	395	-	20	157	518	376
	18	505	-				
	22	591	-				
110	18	505	-	20	157	518	376
	22	591	-				
	25	653	-				
	30	781	-				
250	22	591	-	20	157	518	376
	25	653	-				
	30	781	-				
	35	887	-				
	40	990	-				
450	30	781	-	20	157	670	376
	35	887	-				
	40	990	-				
	45	1124	-				
460	30	781	930	20	157	670	376
	35	887	1061				
	40	990	-				
	45	1124	-				
560	35	887	-	20	157	670	376
	40	990	-				
	45	1124	-				
	50	1234	-				
700	35	887	1061	20	157	670	376
	40	990	1185				
	45	1124	-				
	50	1234	-				

Material Loading - dimensions IntElect



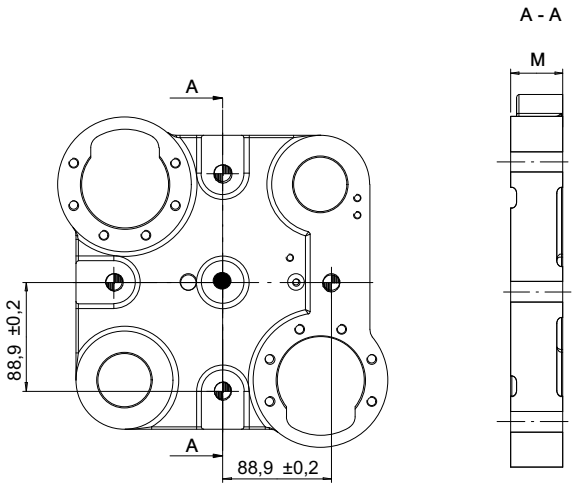
OP0320 Material hopper optional

Injection unit	Screw diameter [mm]	Dimensions [mm]					
		Standard	L/D 25 OP0612 / OP0627	Standard			
		a	a	b	c	d	D
1000	45	1118	1343	20	165	620	785
	50	1243	1509				
	60	1474	-				
1100	45	1118	-	20	165	620	785
	50	1243	-				
	60	1474	-				
1400	50	1243	1509	20	165	620	785
	60	1474	1774				
	70	1719	-				
1600	50	1243	-	20	165	620	785
	60	1474	-				
	70	1719	-				
2000	60	1474	1774	20	260	652	785
	70	1719	2098				
	80	1998	-				
2200	60	1474	-	20	165	620	785
	70	1719	-				
	80	1938	-				
2500	70	1719	2098	20	260	652	785
	80	1998	2397				
	95	-	-				



Injection unit	Screw diameter [mm]	Dimensions [mm]					
		Standard	L/D 25 OP0612 / OP0627	Standard			
		a	a	b	c	d	D
3000	70	1975	-	20	205	580	785
	80	2342	-				
	95	2332	-				

Side ejector holes in ejector plate IntElect 50-180 EUROMAP



● Thread M16

⊕ Bore Ø 14^{H8}

Mould connection dimensions	IntElect 50-75		IntElect 100-130	IntElect 180	IntElect 100-180
Ejector option	OP2196	OP2192 / 2636	OP2196	OP2192	OP2636
Depth M [mm] 1)	40	50	45	65	50

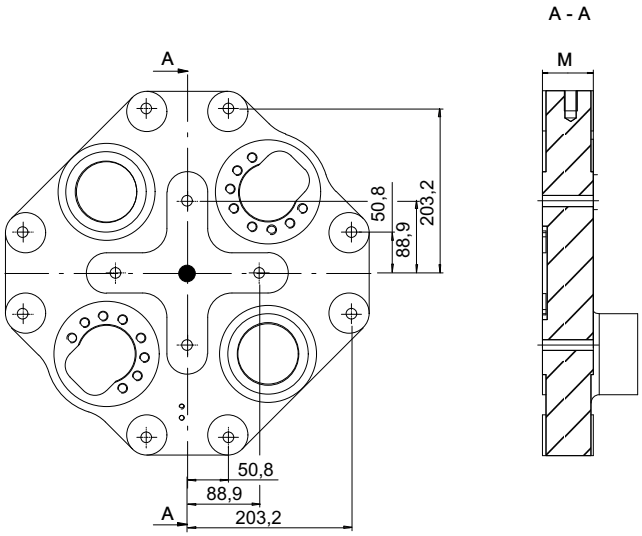
1) all threaded holes with continuous thread

OP2196 Standard

OP2192 Force increased

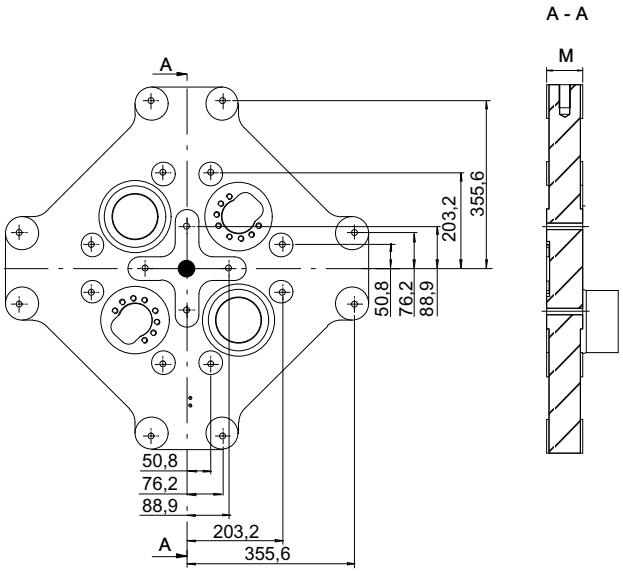
OP2636 Speed increased

Side ejector holes in ejector plate IntElect 220-350 EUROMAP



● Thread M20
⊕ Bore Ø 13,5 (12x)

Side ejector holes in ejector plate IntElect 450 EUROMAP



● Thread M24
⊕ Bore Ø 13,5 (20x)

Mould connection dimensions	IntElect 220-350	IntElect 450
Ejector option	OP2192 / 2195	OP2192 / 2195
Depth **M** [mm] 1)	63	75

1) all threaded holes with continuous thread
OP2192 Force increased
OP2195 Standard

	a	b	c	c1	d	e	$f_{min.}$	$h_{1\ max.}$ transport
IntElect 50-65	157	-	855	-	1450	1900	405	0
IntElect 50-110	157	-	855	-	1467	1900	507	134
IntElect 50-250	157	-	855	-	1477	1900	591	254
IntElect 75-65	157	0	855	-	1485	1935	405	0
IntElect 75-110	157	0	855	-	1502	1935	507	134
IntElect 75-250	157	0	855	-	1512	1935	591	354
IntElect 75-450	157	250	855	690	1537	1945	781	677
IntElect 75-460	157	250	855	690	1537	1945	781	757
IntElect 100-110	157	0	870	-	1557	1990	507	40
IntElect 100-250	157	0	870	-	1567	1990	591	360
IntElect 100-450	157	305	870	690	1592	2000	781	632
IntElect 100-460	157	305	870	690	1622	2000	887	632
IntElect 100-560	157	305	870	690	1622	2000	887	796
IntElect 100-700	157	305	870	690	1622	2000	887	796
IntElect 130-110	157	0	870	-	1602	2035	507	28
IntElect 130-250	157	0	870	-	1612	2035	591	300
IntElect 130-450	157	425	870	690	1637	2045	781	620
IntElect 130-460	157	425	870	690	1637	2045	887	620
IntElect 130-560	157	425	870	690	1667	2095	887	835
IntElect 130-700	157	425	870	690	1667	2095	887	990
IntElect 180-250	157	400	870	677	1652	2075	591	184
IntElect 180-450	157	400	870	677	1677	2085	781	507
IntElect 180-460	157	400	870	677	1677	2085	887	507
IntElect 180-560	157	400	870	677	1707	2085	887	771
IntElect 180-700	157	400	870	677	1707	2235	887	926
IntElect 220-700	157	6	935	795	1862	2390	845	186
IntElect 220-1100	230,6	517	935	805	2198	2409	1085	630
IntElect 220-1600	230,6	517	935	805	2198	2409	1178	1160
IntElect S 220-700	167	-	935	-	-	2473	845	0
IntElect S 220-1000	285,6	517	935	805	1831	2463	1085	0
IntElect S 220-1400	285,6	517	935	805	1831	2463	1243	262
IntElect 280-1100	230,6	6	945	795	2205	2419	1080	320
IntElect 280-1600	230,6	518	945	809	2205	2419	1178	780
IntElect 280-2200	230,6	518	945	809	2190	2419	1413	870
IntElect S 280-1000	285,6	-	945	-	1841	2473	1085	149
IntElect S 280-1400	285,6	518	945	809	1841	2473	1243	0
IntElect S 280-2000	335,6	518	945	809	1903	2523	1413	147
IntElect 350-1600	230,6	512	975	795	2255	2469	1178	820
IntElect 350-2200	230,6	512	975	795	2240	2469	1413	855
IntElect S 350-1400	285,6	512	975	795	1928	2523	1243	0
IntElect S 350-2000	335,6	512	975	795	1959	2573	1413	0
IntElect 450-2200	230,6	666	975	795	2327	2556	1413	275
IntElect 450-3000	270,6	666	975	795	2332	2556	1964 / 1965	1171
IntElect S 450-2000	335,6	666	975	795	2040	2652	1413	0

IntElect multi

Machine	Injection unit horizontal	Injection unit vertical	Injection unit left
IntElect 100	110 250 450 560	65 250	-
IntElect 130	110 250 450 560	65 250	65 * 250 * 450 *
IntElect 180	250 450 560	65 250 450	65 250 450
IntElect 220 / IntElect S 220	700 1000 1100 1400 1600	65 250 450	65 250 450
IntElect 280 / IntElect S 280	1000 1100 1400 1600 2000 2200	65 250 450	65 250 450
IntElect 350 / IntElect S 350	1400 1600 2000 2200	65 250 450	65 250 450
IntElect 450 / 500 IntElect S 450	2000 2200 3000	65 250 450	65 250 450

* On request

Clamping unit		100	130	180
Mould height, min. / max.:				
>Increased multi OP2121	[mm]	230 / 650	280 / 700	300 / 800
Distance between tie bars (h x v):	[mm]			
>Increased OP2032	[mm]	470 x 470	520 x 520	570 x 570
Mould weight / mov. / fixed, max.	[kg]	1500 / 1050 / 750	2000 / 1400 / 1000	2750 / 1925 / 1375
Ejector stroke / force / speed, max.: [1]				
>Standard	[mm / kN / mm/s]	150 / 32 / 333	150 / 32 / 333	150 / 45 / 333

Injection unit 2 V / L		65				250				450			
Screw diameter	[mm]	14	18	22	25	22	25	30	35	30	35	40	45
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20	20	20	20	20	20	20
L/D ratio OP0612 / OP0627 [2]	[mm]	-	-	-	-	-	-	-	-	25	25	-	-
Injection pressure, max. (up to 400 °C) [3]	[bar]	2800	2800	2220	1720	2800	2800	2510	1850	2800	2790	2140	1690
Injection volume, max.	[cm³]	12	20	30	38	40	61	99	135	113	154	201	254
Injection speed, max.: [3]													
>Standard OP0314	[mm/s]	200				200				200			
>Speed OP0315	[mm/s]	350				350				350			
>High-Speed OP0316	[mm/s]	550				-				-			
Injection rate, max.: [3]													
>Standard OP0314	[cm³/s]	31	51	76	98	76	98	141	192	141	192	251	318
>Speed OP0315	[cm³/s]	54	89	133	172	133	172	247	337	247	337	440	556
>High-Speed OP0316	[cm³/s]	85	140	209	270	-	-	-	-	-	-	-	-
Plasticising rate, max. (PS): [4]													
>Standard OP0314	[g/s]	1,3	3,7	6	10	6	10	16,7	22,7	16,7	22,7	33,3	42
>OP0315 / OP0316	[g/s]	1,7	5	8,3	13,8	6,8	11,3	18,8	25,5	18,8	25,5	37,5	47,3
Nozzle stroke, max. [5]	[mm]	450				450				450			
Nozzle sealing force / speed, max.:													
>Standard	[kN / mm/s]	30 / 23				30 / 23				30 / 23			

General data		65				250				450			
Net weight:													
>Injection-unit-L OP0302	[kg]	1117				1440				1667			
>Injection-unit-V OP0303	[kg]	1110				1403				1624			
>Safety fence incl. terminal OP0302	[kg]	150				165				165			
>Terminal OP0303	[kg]	85				85				85			
>Electrical cabinet	[kg]	150				150				150			
>Plasticizing-unit OP0610 / OP0611	[kg]	36	45	48	51	48	51	81	92	81	92	116	149

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

[1] Stroke limited with turntable, for details see information on integrated turntable

[2] IntElect S

[3] Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

[4] Plasticising rate depends on processing conditions and the material used.

[5] The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

Clamping unit		220	280	350	450 / 500
Mould height, min. / max.:					
>Increased OP0211	[mm]	300 / 800	350 / 850	400 / 900	450 / 1050
>Increased multi OP2121	[mm]	350 / 850	450 / 950	500 / 1000	600 / 1200
Distance between tie bars (h x v):	[mm]				
>Standard	[mm]	660 x 660	730 x 730	830 x 830	920 x 920
>Increased OP2032	[mm]	-	-	-	-
Mould weight / mov. / fixed, max.	[kg]	4300 / 2500 / 3300	4700 / 2650 / 3600	6600 / 3800 / 5100	8700 / 5200 / 6700
Ejector stroke / force / speed, max.: [1]					
>Standard	[mm / kN / mm/s]	220 / 60 / 270	220 / 60 / 270	250 / 60 / 270	250 / 100 / 270
>Force increased OP2192	[mm / kN / mm/s]	220 / 100 / 270	220 / 100 / 270	250 / 100 / 270	250 / 150 / 270
>Speed increased OP2636	[mm / kN / mm/s]	100 / 100 / 440	100 / 100 / 440	100 / 100 / 440	100 / 100 / 440

Injection unit 2 V / L		65				250				450			
Screw diameter	[mm]	14	18	22	25	22	25	30	35	30	35	40	45
L/D ratio OP0610 / OP0611	[mm]	20	20	20	20	20	20	20	20	20	20	20	20
Injection pressure, max. (up to 400 °C) [3]	[bar]	2800	2800	2220	1720	2800	2800	2510	1850	2800	2790	2140	1690
Injection volume, max.	[cm³]	12	20	30	38	40	61	99	135	113	154	201	254
Injection speed, max.: [3]													
>Standard OP0314	[mm/s]	200				200				200			
>Speed OP0315	[mm/s]	350				350				350			
>High-Speed OP0316	[mm/s]	550				-				-			
Injection rate, max.: [3]													
>Standard OP0314	[cm³/s]	31	51	76	98	76	98	141	192	141	192	251	318
>Speed OP0315	[cm³/s]	54	89	133	172	133	172	247	337	247	337	440	556
>High-Speed OP0316	[cm³/s]	85	140	209	270	-	-	-	-	-	-	-	-
Plasticising rate, max. (PS): [4]													
>Standard OP0314	[g/s]	1,3	3,7	6	10	6	10	16,7	22,7	16,7	22,7	33,3	42
>OP0315 / OP0316	[g/s]	1,7	5	8,3	13,8	6,8	11,3	18,8	25,5	18,8	25,5	37,5	47,3
Nozzle stroke, max. [5]	[mm]	450				450				450			
Nozzle sealing force / speed, max.:													
>Standard	[kN / mm/s]	30 / 23				30 / 23				30 / 23			

General data		65				250				450			
Net weight:													
>Injection-unit-L OP0302	[kg]	1117				1440				1667			
>Injection-unit-V OP0303	[kg]	1110				1403				1624			
>Safety fence incl. terminal OP0302	[kg]	150				165				165			
>Terminal OP0303	[kg]	85				85				85			
>Electrical cabinet	[kg]	150				150				150			
>Plasticizing-unit OP0610 / OP0611	[kg]	36	45	48	51	48	51	81	92	81	92	116	149

These technical specifications are based on information that was correct at time of printing and is subject to change without notice. These parameters are based on a 400 V supply voltage. Other supply voltages will affect the machine parameters.

Minimum achievable cycle-time of the machine can be limited by the actual drive utilisation

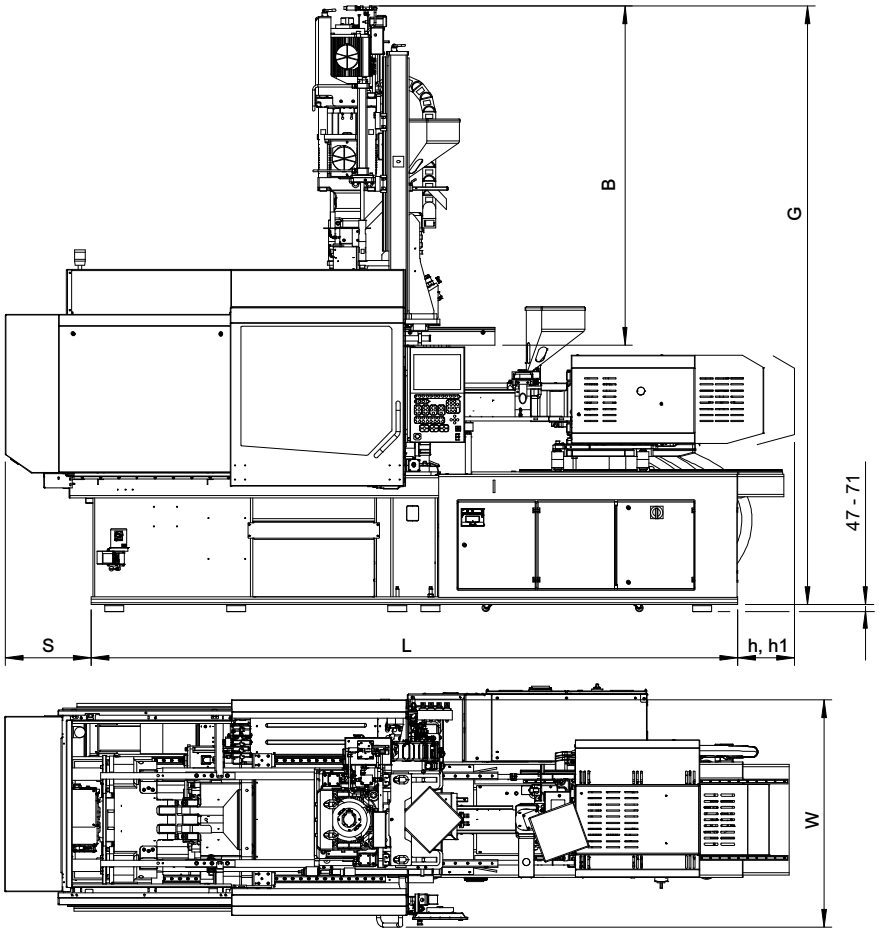
[1] Stroke limited with turntable, for details see information on integrated turntable

[3] Maximum injection pressure and maximum injection speed may be influenced by each other. Maximum injection pressure and maximum holding pressure cannot be provided over the whole cycle.

[4] Plasticising rate depends on processing conditions and the material used.

[5] The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

Machine dimensions Injection unit vertical

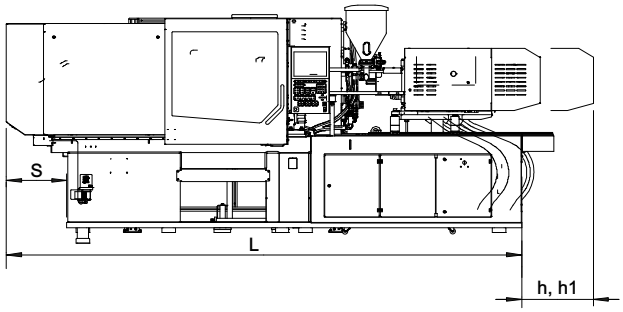


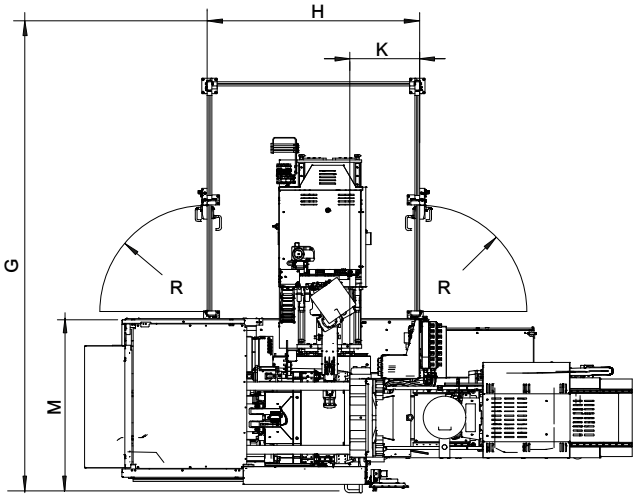
	Injection unit vertical	65 [mm]	65 [mm]	250 [mm]	250 [mm]	450 [mm]	450 [mm]
Clamping unit	Screw diameter	14 / 18	22 / 25	22 / 25	30 / 35	30 / 35	40 / 45
100	B	2020	2153	2355	2627	-	-
	G	3647	3780	2982	4254	-	-
	S	511		511		-	-
	L	4013		4013		-	-
	W	1402		1402		-	-
	h/h1 multi	IntElect mono -100 mm					
130	B	2020	2153	2355	2627	-	-
	G	3725	3858	4060	4332	-	-
	S	452		452		-	-
	L	4357		4357		-	-
	W	1482		1482		-	-
	h/h1 multi	IntElect mono - 125 mm					
180	B	2020	2153	2355	2627	2697	2976
	G	3825	3958	4160	4432	4502	4781
	S	252		252		252	
	L	4385		4385		4385	
	W	1578		1578		1578	
	h/h1 multi	IntElect mono					

Machine dimensions Injection unit vertical

	Injection unit vertical	65 [mm]	65 [mm]	250 [mm]	250 [mm]	450 [mm]	450 [mm]
Clamping unit	Screw diameter	14 / 18	22 / 25	22 / 25	30 / 35	30 / 35	40 / 45
220	B	2020	2153	2355	2627	2697	2976
	G	4058	4191	4393	4665	4735	5014
	S	240		240		240	
	L	6035		6035		6035	
	W	1748		1748		1748	
	h/h1 multi	IntElect mono					
280	B	2020	2153	2355	2627	2697	2976
	G	4111	4244	4446	4718	4788	5067
	S	325		325		325	
	L	6450		6450		6450	
	W	1838		1838		1838	
	h/h1 multi	IntElect mono					
350	B	2020	2153	2355	2627	2697	2976
	G	4223	4356	4558	4830	4900	5179
	S	375		375		375	
	L	6650		6650		6650	
	W	2038		2038		2038	
	h/h1 multi	IntElect mono					
450 / 500	B	2020	2153	2355	2627	2697	2976
	G	4390	4523	4725	4997	5067	5346
	S	490		490		490	
	L	7740		7740		7740	
	W	2211		2211		2211	
	h/h1 multi	IntElect mono					

Machine dimensions Injection unit left



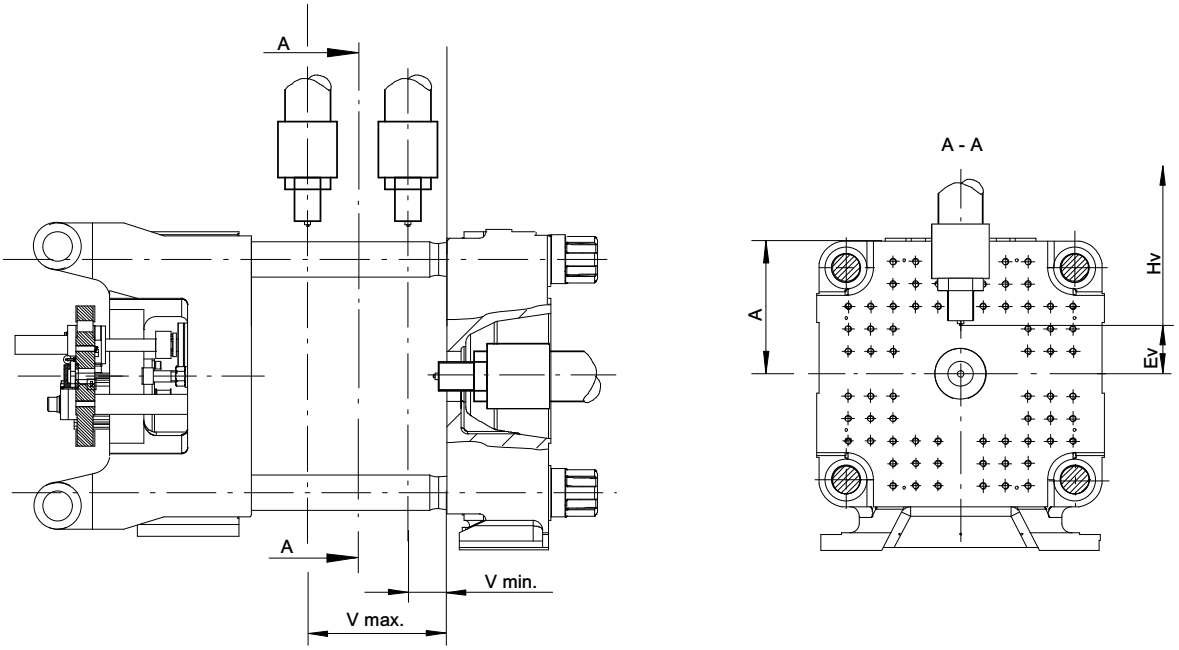


	Injection unit left	65 [mm]	65 [mm]	250 [mm]	250 [mm]	450 [mm]	450 [mm]
Clamping unit	Screw diameter	14 / 18	22 / 25	22 / 25	30 / 35	30 / 35	40 / 45
130	S	564		564		564	
	L	4245		4245		4245	
	H	1755		1755		1755	
	K	650		650		650	
	G	3607		3837		4237	
	M	2000		2000		2000	
	R	990		990		990	
	h/h1 multi	IntElect mono					
180	S	630		630		630	
	L	4385		4385		4385	
	H	1755		1755		1755	
	K	650		650		650	
	G	3708		3938		4338	
	M	2000		2000		2000	
	R	990		990		990	
	h/h1 multi	IntElect mono					
220	S	240		240		240	
	L	6035		6035		6035	
	H	2100		2100		2100	
	K	563		563		563	
	G	3976		4206		4606	
	M	2200		2200		2200	
	R	982		982		982	
	h/h1 multi	IntElect mono					

Machine dimensions Injection unit left

	Injection unit left	65 [mm]	65 [mm]	250 [mm]	250 [mm]	450 [mm]	450 [mm]
Clamping unit	Screw diameter	14 / 18	22 / 25	22 / 25	30 / 35	30 / 35	40 / 45
280	S	325		325		325	
	L	6450		6450		6450	
	H	2100		2100		2100	
	K	563		563		563	
	G	4067		4297		4697	
	M	2200		2200		2200	
	R	982		982		982	
	h/h1 multi	IntElect mono					
350	S	375		375		375	
	L	6650		6650		6650	
	H	2230		2230		2230	
	K	563		563		563	
	G	4266		4496		4896	
	M	2200		2200		2200	
	R	982		982		982	
	h/h1 multi	IntElect mono					
450 / 500	S	490		490		490	
	L	7740		7740		7740	
	H	2450		2450		2450	
	K	563		563		563	
	G	4439		4669		5069	
	M	2200		2200		2200	
	R	982		982		982	
	h/h1 multi	IntElect mono					

Dipping depth and traverse distance Injection unit 2 vertical

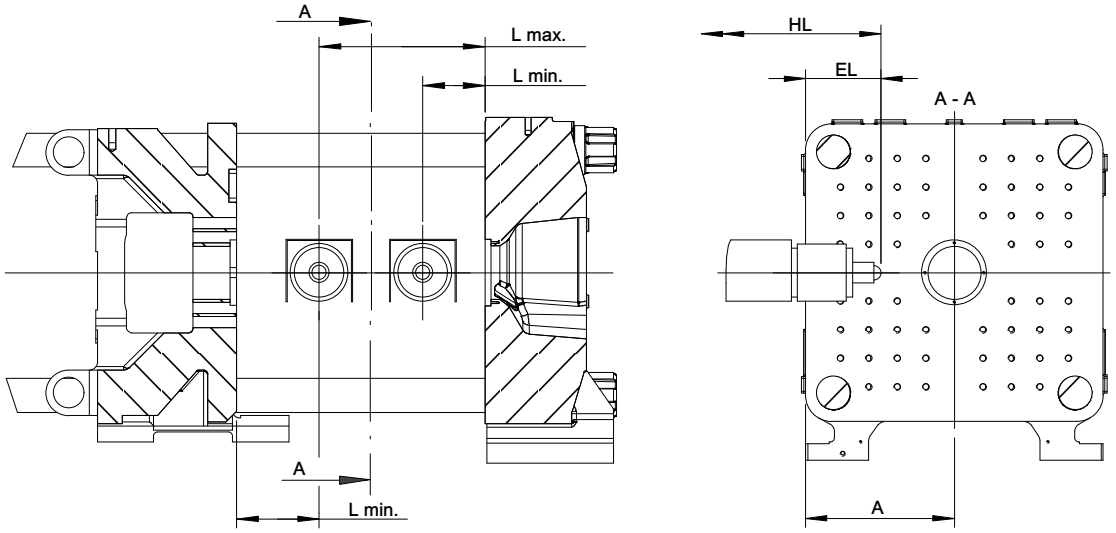


Clamping unit	100	130	180	220	280	350	450
A [mm]	342	375	435	513	556	618	698

Injection unit vertical	Screw diameter [mm]	Ev min. ** [mm]	Hv [mm]	V min. [mm]	V max. [mm]
65	14	150	450	85	220
	18	280			
	22	250			
	25	310			
250	22	250	450	85	220
	25	310			
	30	170		95	
	35	310			
450	30	170	450	95	220
	35	310			
	40	160			
	45	310		105	

** Minimum distance to nozzle center
The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

Dipping depth and traverse distance Injection unit 2 left

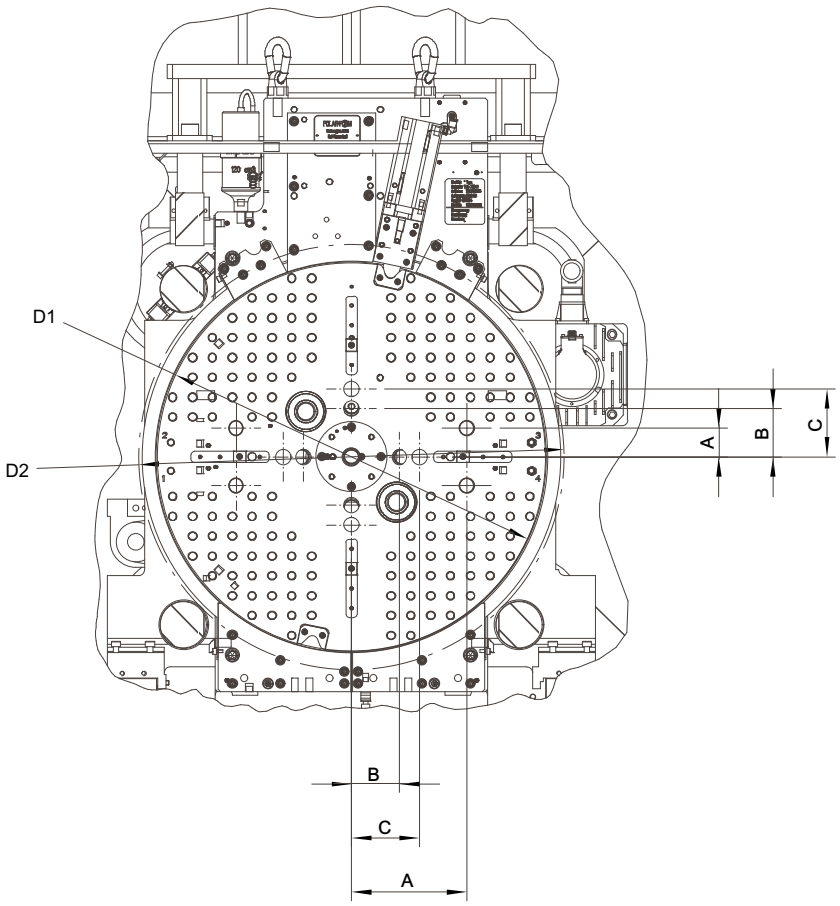


Clamping unit	100	130	180	220	280	350	450
A [mm]	(325) *	360	390	473	518	578	658

Injection unit left	Screw diameter [mm]	EL min. ** (OP0652) [mm]	EL min. ** (OP06653) [mm]	HL [mm]	L min. [mm]	L max. [mm]
65	14	60	1)	450	85	300
	18	190	275			
	22	190	275			
	25	250	335			
250	22	150	235	450	85	300
	25	210	295			
	30	90	195		95	
	35	230	335			
450	30	90	195	450	95	300
	35	230	335			
	40	80	185			
	45	230	335		105	

* On request
** Minimum distance to nozzle center
The max. nozzle stroke is valid for standard open nozzle (OP0652) and L/D = 20. Nozzle stroke is shorter with special or optional nozzle and L/D > 20.

Integrated turntable with side ejector OP0201 / OP2051



Clamping unit		100	130	180
Distance between tie bars (h x v):	[mm]	470 x 470	520 x 520	570 x 570
Distance between tie bar diagonal (D2)	[mm]	681	755	831
Ejector stroke / force / speed, max.: [1]				
>Standard	[mm / kN / mm/s]	- [4] / 32 / 333	- [4] / 32 / 333	- [4] / 45 / 333
>Force increased OP2192	[mm / kN / mm/s]	-	-	-
>Speed increased OP2636	[mm / kN / mm/s]	-	-	-
Turntable geometry / weight:				
>Diameter turning plate (D1)	[mm]	656	728	800
Turntable thickness	[mm]	128	128	148
Max. mould weight on turntable	[kg]	600	800	1100
Turning time	[s] / [kg]	>0,9 / 600	>0,9 / 800	>0,9 / 1100
Media transfer turntable: [2]				
>Number of temperature control circuits standard		0 - 2	0 - 2	0 - 4
>Temperature / pressure of temperature control circuit, max.	[°C] / [bar]	120 / 10		
>Number of hydraulic circuits standard		0 - 2	0 - 2	0 - 2
>Pressure of hydraulic circuit, max.	[bar]	160		
>Number of circuits, max.		5	5	9
Dimensional sketch ejector bore: [3]				
>A (horizontal / vertical)		±203,2 / ±50,8 (4x ∅27)	±203,2 / ±50,8 (4x ∅27)	±203,2 / ±50,8 (4x ∅27)
>B (horizontal / vertical)		±85 / ±85 (4x ∅27)	±85 / ±85 (4x ∅27)	-
>C (horizontal / vertical)		±120 / ±120 (4x ∅27)	±120 / ±120 (4x ∅27)	±120 / ±120 (4x ∅27)

1) Changes on request
2) Equipment (number, distribution of hydraulics / temperature control / pneumatics) deviating from "standard" on request
3) for OP2051
4) Stroke on request
5) Specified stroke applies to the combination of ejector "version with dismantled coupling of the ejector" with media transfer of the "standard" turntable (see below);

Integrated turntable with side ejector OP0201 / OP2051

220	280	350	450
660 x 660	730 x 730	830 x 830	920 x 920
966	1070	1216	1353
150 [3] / 60 / 270	150 [3] / 60 / 270	180 [3] / 60 / 270	130 [3] / 100 / 270
150 [3] / 100 / 270	150 [3] / 100 / 270	180 [3] / 100 / 270	130 [3] / 150 / 270
-	-	-	-
904	1000	1120	1210
148	160	160	188
1500	1400	2300	3200
>1,0 / 1500	>1,2 / 1400	>1,6 / 2300	>1,9 / 3200
0 - 4	0 - 4	0 - 4	0 - 4
120 / 10			
0 - 2	0 - 2	0 - 2	0 - 4
160			
9	9	9	9
±203,2 / ±50,8 (4x ∅27)	±203,2 / ±50,8 (4x ∅35)	±203,2 / ±50,8 (4x ∅35)	±203,2/ ±50,8 (4x ∅35)
±50,8 / ±203,2 (4x ∅27)	±50,8 / ±203,2 (4x ∅35)	±50,8 / ±203,2 (4x ∅35)	±50,8 / ±203,2 (4x ∅35)
±120 / ±120 (4x ∅27)	±120 / ±120 (4x ∅35)	±120 / ±120 (4x ∅35)	±76,2 / ±355,6 (4x ∅52)

Practical values of melt correction factor for use in calculation of shot weight for some common plastics.	
Material	Melt correction factor
HD-PE	0,75
LD-PE	0,73
PP	0,73
PS	0,91
SB	0,91
ABS	0,91
SAN	0,91
PA	0,93
PA 6 +30 % GF	1,14
PC	0,97
PC/ABS	0,94
PMMA	0,97
POM	1,15
PET	1,08
PBT	1,08
CA	1,03
CAB	0,98
PVC-w	1,05
PVC-h	1,15

shot weight = melt correction factor x swept volume

The melt correction factor takes into account the change in volume at process temperature and also includes a factor for the flow characteristics of the shut off device on the end of the screw.

Certified according to VDA 6.4

Sumitomo SHI DEMAG

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