

1 Technical Data

1.1 Data Sheets

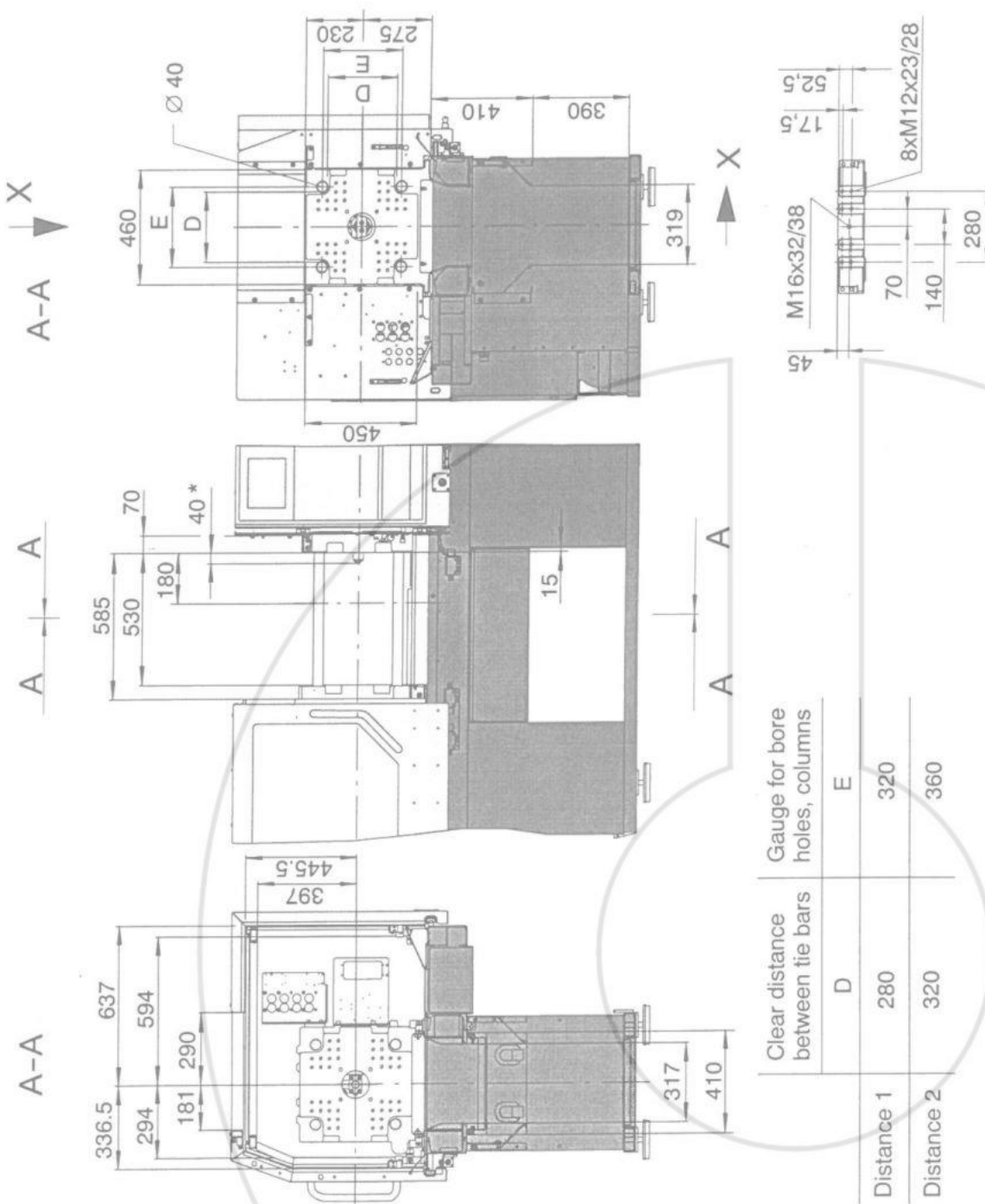
1.1.1 Data Sheet Ergotech 35 system

Model Description		
Internat. Size classification		350-80 / 250-120 / 250-200
Clamping Unit		350
Clamping Force	kN	350
Locking Force	kN	350
Clear distance between tie bars	mm	280 x 280 320 x 320
Maximum Opening Stroke	mm	350
Min. Mould mounting height	mm	180
Max. Daylight between platens	mm	530
Overall size of platens h x v	mm	460 x 450
Max. mould weight without plate support (ZE 262)	kg	230
Max. mould weight with plate support (ZE 262)	kg	400
of which mould weight on the moving mould mounting platen without plate support (ZE 262)	kg	150
of which mould weight on the moving mould mounting platen with plate support (ZE 262)	kg	300
Hydraulic ejector		
Ejection stroke	mm	100
Ejection force	kN	26
Ejector retraction force	kN	6



1.2 Mould space

1.2.1 Mould space size Ergotech 35, clear distance between tie bars 280mm and 320mm



* The nozzle immersion depth is reduced by 15 mm for pressure setting plastic.

Fig. 1: Mould space size Ergotech 35, clear distance between tie bars 280mm and 320mm

Data Sheet Ergotech 35 system - continued

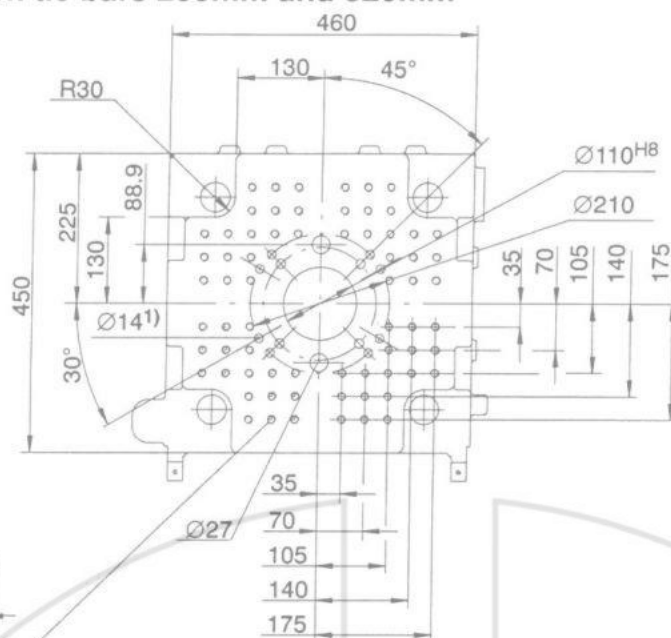
Injection Unit		35		
Plasticising cylinder		A	B	C
Screw diameter ¹⁾	mm	14	18	22
L / D - Ratio		20	20	20
Specific injection pressure	bar	2755 ²⁾	2110	1410
Cylinder head volume	ccm	13,9	22,9	34,2
Component Weight (PS)	g	12	20	30
Max. metering stroke	mm	90	90	90
Max. nozzle stroke	mm	170		
Nozzle dipping depth (SVO)	mm	30 ⁵⁾		
Nozzle sealing force	kN	60		
Heating capacity of screw cylinder	kW	4,0	5,0	5,1
Hopper capacity	Ltr.	35		
General data				
Oil tank capacity	Ltr.	160		
PŪmp unit	kW	11,0		
Total installed power	kW	15 ,0	16,0	16,1
Number of dry cycles to EUROMAP 6a	h ⁻¹	2250		
Net weight (without oil)	kg	2520 / 2620 ⁶⁾		
Machine dimensions L x B x H	m	3,36 ³⁾ x 1,2 x 2,0 / 3,5 x 1,2 x 2,0 ⁶⁾		
Sound level (depressurized circulation)	dB (AS)	56,0		
Sound level (power) ⁴⁾	dB (AS)	71,0		

- 1) Plasticising units with the same screw diameter are exchangeable between the single injection units.
2) On temperature settings above 400°C injection pressure is automatically reduced by machine controller.
3) In run-up state, max. measurements see Chapter 2.4 "Setting up plans"
4) Operator side, measured acc. to DIN EN ISO 3746
5) The nozzle immersion depth is reduced by 15 mm for pressure setting plastic.
6) to ZE 390 "fully clad"

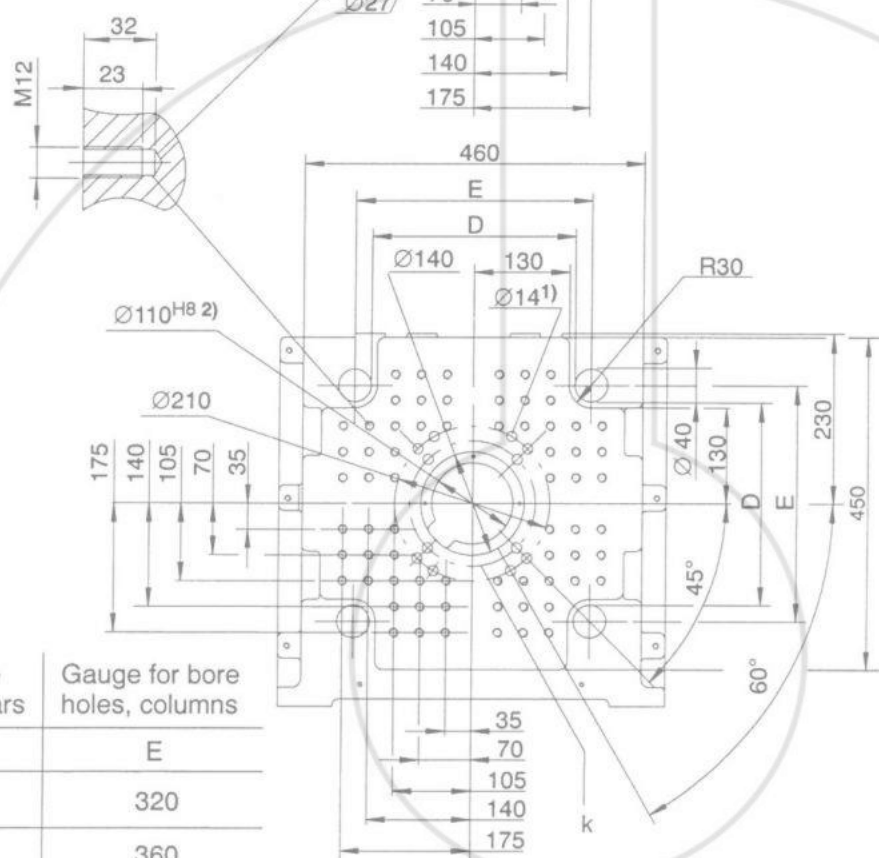


1.2.2 Mould fixing diagrams Ergotech 35 Universal, clear distance between tie bars 280mm and 320mm

Movable mould mounting plate



Fixed mould mounting plate



	Clear distance between tie bars	Gauge for bore holes, columns
	D	E
Distance 1	280	320
Distance 2	320	360

Note: k = Min. permissible mould diameter 160 mm

Note: 1) bores $\varnothing 14$ drilled through and spot faced from opposite end $\varnothing 20$

2) centering ring $\varnothing 125^{H8}$

Fig. 2: Mould fixing diagrams Ergotech 35 Universal, clear distance between tie bars 280mm and 320mm