

Technical Data

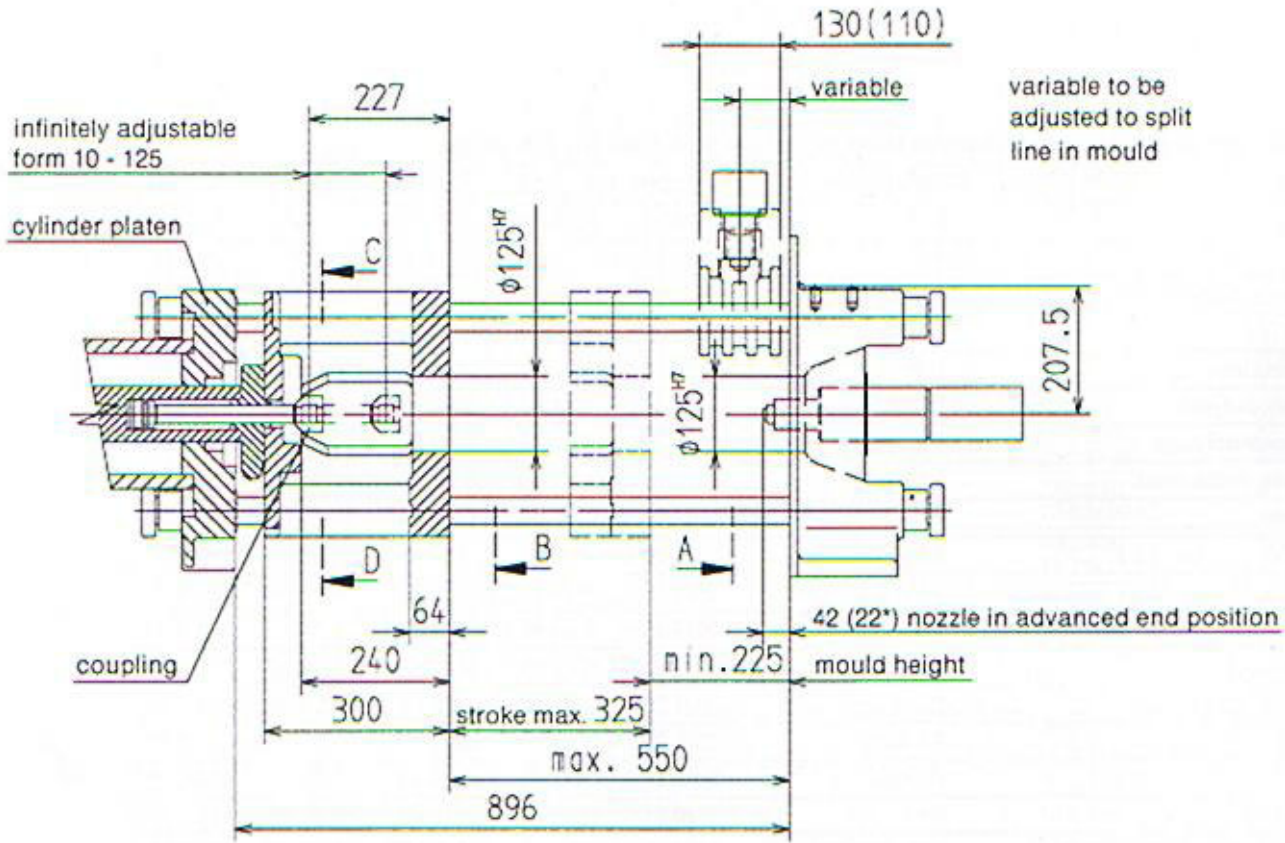


Technical Data 270 M

Machine model		270 M 250-75	270 M 350-90	270 M 500-90	270 M 500-210
International size ¹		250-75	350-90	500-90	500-210
Clamping unit					
Clamping pressure	max. kN/US-tons	250/27.5	350/38.5	500/55	500/55
Mould protection force	max. kN/US-tons	26/2.86	31/3.41	31/3.41	31/3.41
Max. opening force	max. kN/US-tons	26/100 2.86/11	31/120 3.41/13.2	31/120 3.41/13.2	31/120 3.41/13.2
Mould opening stroke	max. mm/in.	325/12.80	325/12.80	325/12.80	325/12.80
Mould height	min. mm/in.	225/8.86	225/8.86	225/8.86	225/8.86
Day light	max. mm/in.	550/21.65	550/21.65	550/21.65	550/21.65
Distance between tie bars	mm in.	270x270 10.63x10.63	270x270 10.63x10.63	270x270 10.63x10.63	270x270 10.63x10.63
Platen size (hor. x vert.)	mm in.	400x400 15.75x15.75	400x400 15.75x15.75	400x400 15.75x15.75	400x400 15.75x15.75
Mould diameter	max. mm/in.	400/15.75	400/15.75	400/15.75	400/15.75
Ejector force	max. kN/US-tons	26/2.86	31.4/3.45	31.4/3.45	31.4/3.45
Ejector stroke	max. mm/in.	125/4.92	125/4.92	125/4.92	125/4.92
Injection Unit					
Screw diameter	mm in.	20/25/30 0.79/0.98/1.18	20/25/30 0.79/0.98/1.18	20/25/30 0.79/0.98/1.18	30/35/40 1.18/1.38/1.58
Screw length	L/D	25/20/16.7	25/20/16.7	25/20/16.7	23.3/20/17.5
Screw stroke	max. mm/in.	100/3.94	100/3.94	100/3.94	150/5.91
Swept volume	max. cm ³ cu.in.	31/49/70 1.89/2.99/4.27	31/49/70 1.89/2.99/4.27	31/49/70 1.89/2.99/4.27	106/144/188 6.47/8.79/11.47
Shot capacity ³	max. g/PS oz.	25/40/58 0.88/1.41/2.05	25/40/58 0.88/1.41/2.05	25/40/58 0.88/1.41/2.05	90/120/158 3.17/4.23/5.57
Injection pressure	max. bar psi	2450/1570/1090 34,800/22,300/ 15,500	2500/1860/1290 35,600/26,500/ 18,400	2500/1860/1290 35,600/26,500/ 18,400	2050/1500/1150 29,150/21,300/ 16,350
Injection flow	max. cm ³ /s cu.in./sec.	50/78/110 3.05/4.76/6.71	56/88/125 3.42/5.37/7.63	75/115/165 4.58/7.02/10.07	110/150/200 6.71/9.15/12.20
Back pressure	max. bar/psi psi	450/290/200 6,400/4,100/ 2,850	320/235/180 6,400/4,100/ 2,850	320/235/180 6,400/4,100/2,850	320/235/180 4,550/3,300/ 2,550
Screw circumferential speed	max. m/min. ft./min.	18/23/27 59.06/75.46/ 88.59	29/37/44 95.15/121.40/ 144.35	41/52/62 134.52/170.61/ 203.42	49/57/65 160.77/187.02/ 213.27
Screw torque	max. Nm/ft./lbs.	245/180.7	290/213.9	290/213.9	360/265.5
Nozzle contact force	max. kN/US-tons	50/5.5	60/6.6	60/6.6	60/6.6
Nozzle retract stroke	max. mm/in.	180/7.09	180/7.09	180/7.09	240/9.45
Cylinder and nozzle heating	KW	3.9	5.1	5.1	5.1
Number of heating zones	-	4 + 1	4 + 1	4 + 1	4 + 1
Material hopper capacity	Liters/lbs.	50/100	50/100	50/100	50/100
Material Flow ⁴	max. g/s				
Hydraulic, Drive, General					
Pump motor	kW	7.5	11	15	15
Dry Cycle Time ⁴	s	1.9	1.8	1.7	1.7
Total connected load ²	kW	12	15.5	19.5	20.5
Colour: plastic coating, structure green RAL 6011					
Control Cabinet					
Safety Instructions		DIN VDE 0113	DIN VDE 0113	DIN VDE 0113	DIN VDE 0113
Shock-proof socket		1 x 10 A	1 x 10 A	1 x 10 A	1 x 10 A
Ce-socket		1 x 16 A	1 x 16 A	1 x 16 A	1 x 16 A

1) 1st figure: clamping pressure (kN)
2nd figure: max. swept volume (cm³) x max. injection pressure (kbar)
2) 380 / 220 V, 3 phase, 50 cycles

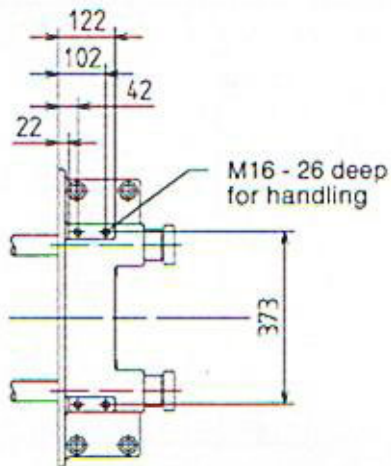
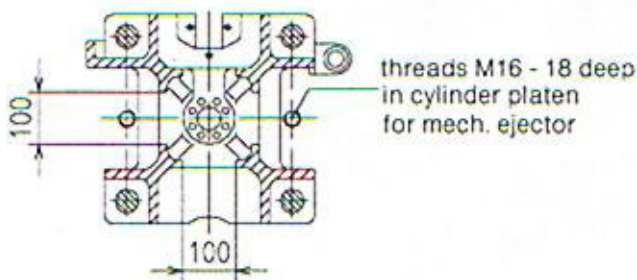
3) calculated with fill factor = 0.8
4) according to Euromap



Ejector Stroke

C-D

www.stvconnect.co.uk



Bore only whrn your want a short sprue.

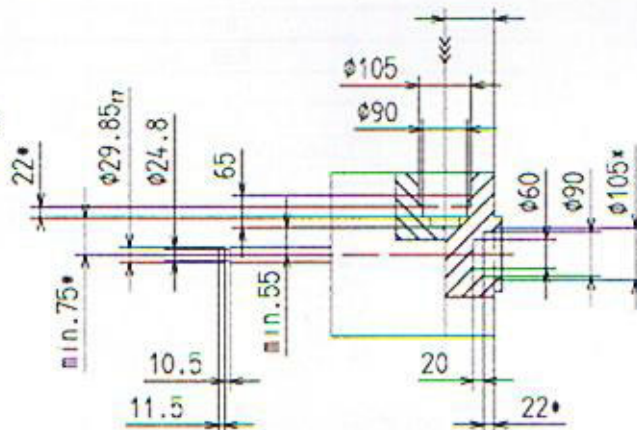
For parting line injection:

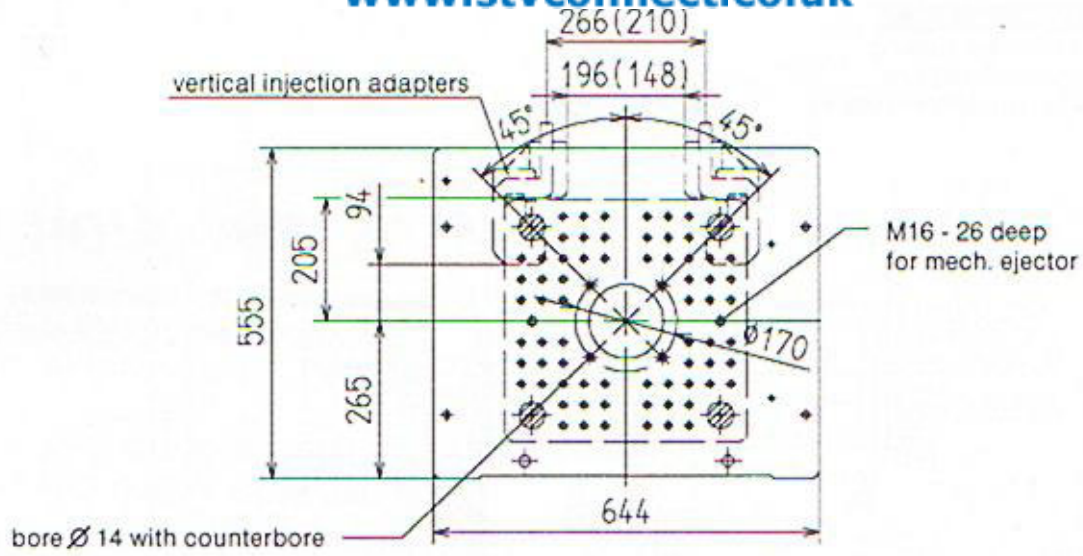
Dim. a min. = 60mm or 65mm with hydraulic nozzle (75mm or 95mm with hydraulic nozzle)

Dim. a max. = mould length minus 60mm/65mm (75mm/95mm), but no more than 235mm (250mm)

() Dimensions only apply to 270 M 500-210

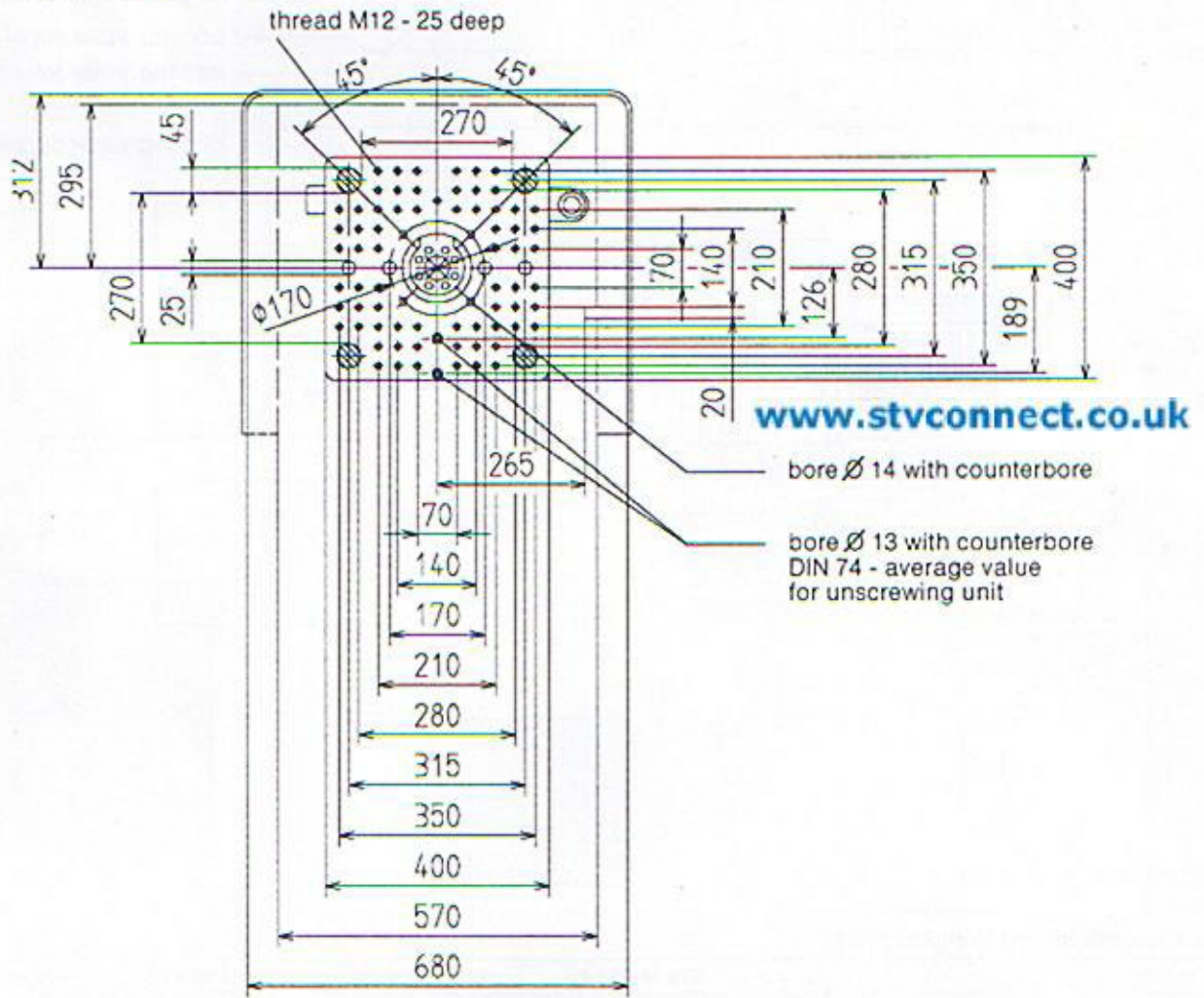
* Dimensions only apply to thermoset moulds





View A

Dimensions Movable Platen



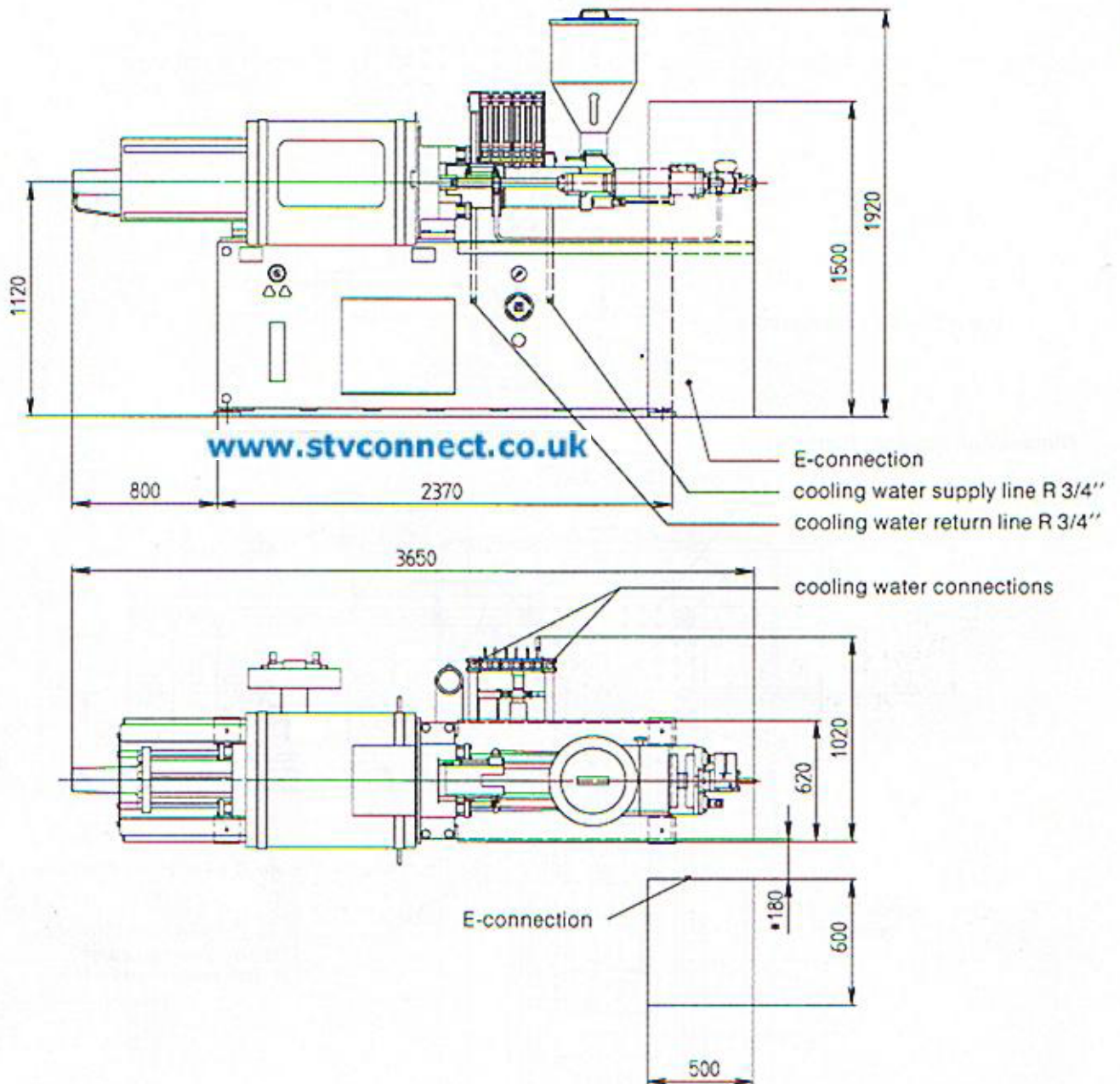
View B



Usable mould area when tie bars are retracted for mould mounting

Machine Dimensions and Weights

- dimensions not binding as control cabinet can be erected at different places



Machine Dimensions and Weights 270 M

Machine Model:		270 M 250-75	270 M 350-90	270 M 500-90	270 M 500-210
Height with vertical clamping unit	mm/in.	2950/116.1	2950/116.1	2950/116.1	3120/122.8
Crane height	mm/in.	3800/149.6	3800/149.6	3800/149.6	3800/149.6
Oil filling	kg/lbs.	220/485	220/485	220/485	220/485
Machine weight without oil filling	kg/lbs.	1720/3792	1720/3792	1720/3792	1910/4211
Weight of control cabinet	kg/lbs.	150/331	150/331	150/331	150/331
Electrical connection ⁶		A 35	A 50	A 63	A 63

6) Load resistance is distributed symmaetrically on the three phase