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Data Sheet



Code: In 7214 550 19

Brand: TOYO

Model: Si 550 IV

Year: 2009

Tonnage: 550

Clearence between tie-bars: 970x970

Screw diameter: 90

Calculated shot volume: 2863

Min/Max mould thickness: 400-800

Robot connection Euromap-12: Yes

Mov. plasten stroke: 900

Air ejection: 4

Description:

Working hours: 59500

n. 4 radial air

screw diameter 90mm

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1 PLASTAR Si-550Ⅳ Specifications

Injection		Injection system	—	In-line screw					
		Injection unit type	—	K			L		
		Injection stroke	mm	306	375		420	450	
		Screw diameter	mm	68	75	83	83	90	100
		Theoretical injection capacity	cm^3	1111	1657	2029	2272	2863	3534
	Standard	Injection unit	–	K600B			L750B		
		Injection rate	cm^3/s	654	795	974	920	1081	1335
		Max. injection speed	mm/s	180	180	180	170	170	170
		Max. injection pressure	MPa	215.6	176.4	147.0	215.6	186.2	151.9
		Max. injection holding pre	MPa	196.0	156.8	127.4	196.0	166.6	137.2
	Recovery rate(PS)		kg/h	225.0	297.0	397.0	397.0	450.0	612.0
	Screw revolution speed		min^{-1}	200			170		
	Nozzle pressing force		kN	39.0			39.0		

Clamping	Clamping system	—	Double toggle
	Clamping force	kN	5390
	Clamping stroke	mm	900
	Min. mold height	mm	400
	Max. mold height	mm	800【900】
	Tie bar clearance (H×V)	mm	970×970
	Die plate size (H×V)	mm	1320×1320
	Ejector force	kN	117.6
	Ejector stroke	mm	180

Others	Heater capacity	kW	24.80	31.20	38.80	38.80	49.40	53.40
	Mold height motor output	kW	1.5					
	Nozzle touch motor output	kW	0.4			2.9		
	Machine dimensions <L>	mm	9380			9521	9797	10024
	Machine dimensions <W×H>	mm	2089×2445					
	Power source	–	Three-phase AC200V/200, 220V±10%/415V±10% 50Hz/60Hz					
	Main breaker capacity	A	400			500		
	Total electric capacity	kVA	98			125		
	Calbe size 200V class【400V class※1】	mm^2	150【60】			200【100】		
	Machine weight	t	30.7			33.7		

NOTES

- The figures are subject to change without any legal obligation on the part of the manufacture.
- The specifications are expressed in SI. (1MPa=10.2kgf/cm^2 1kN=0.102tonf)
- The maximum injecting pressure and the maximum holding pressure are attainable maximum set values. There values may be limited by molding conditions and cycle time.
- The injection rate and the maximum injecting speed are calculated Values. These values may be limited by set injecting pressures.
- When a screw with wide diameter is used, some resins may not be accepted.
- When the machine is attached with an option, the capacity of the breaker. may be changed.
- The values in brackets are applied to machines with options.

※1.A transformer(option) is necessary on the machine side.

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