

Chapter 6 Technical data of the complete machine and outline drawing

6.1 Main data of the machine.....	6-2
6.2 Dimension for mold installation	6-3
6.3 Overall dimension drawing of the machine	6-5
6.4 Dimension drawing for injection unit	6-6
6.5 Outline drawing of the machine.....	6-9
6.6 Electrical interface layout	6-10

6.1 Main data of the machine

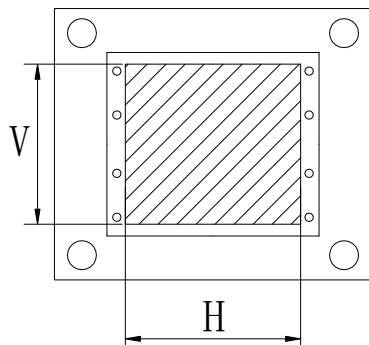
	Machine model	ZE400-50(h)*	
Injection unit	Screw type	A	B
	Screw diameter mm	16	19
	L/D ratio	21	20
	Injection stroke mm	60	
	Shot volume cm ³	12	17
	Injection capacity (PS) g	11	15.5
	Injection speed mm/s	200 (350)*	
	Injection pressure Mpa Kgf/cm ²	280	260
		2850	2650
	Hold pressure Mpa Kgf/cm ²	234	198
		2380	2020
	Screw rotate speed RPM	400	
	Nozzle contact force KN(tf)	9.8 {1.0}	
	Nozzle in size mm	45	
	Heater power KW	4.3	4.6
Clamping unit	Clamping force KN	400	
	Toggle stroke mm	235	
	Space between tie bars H*V mm	320*280	
	Minimal mold size H*V mm	205*180	
	Mold height mm	150-320	
	Ejector stroke mm	60	
	Ejector force KN(tf)	9.8 {1.0}	
Other	Hopper capacity L	15	
	Dimension L*W*H m	3.61*1.2*1.75	
	Machine weight tf	2.8	

Notes:

1. The above data will change subject to design improvement or other reasons.
2. The maximum injection pressure and hold pressure are limited by different injection molding conditions.
3. The maximum injection volume is the product of [screw barrel cross-section area]×[injection stroke].
4. The injection capacity is calculated by polystyrene (PS) and may be different due to different material grades, injection conditions and molds.
5. Numerical values in { } are reference values.
 1MPa=10.2kgf/cm², 1KN=0.102tf
6. () * represents relative parameters of high speed machines.

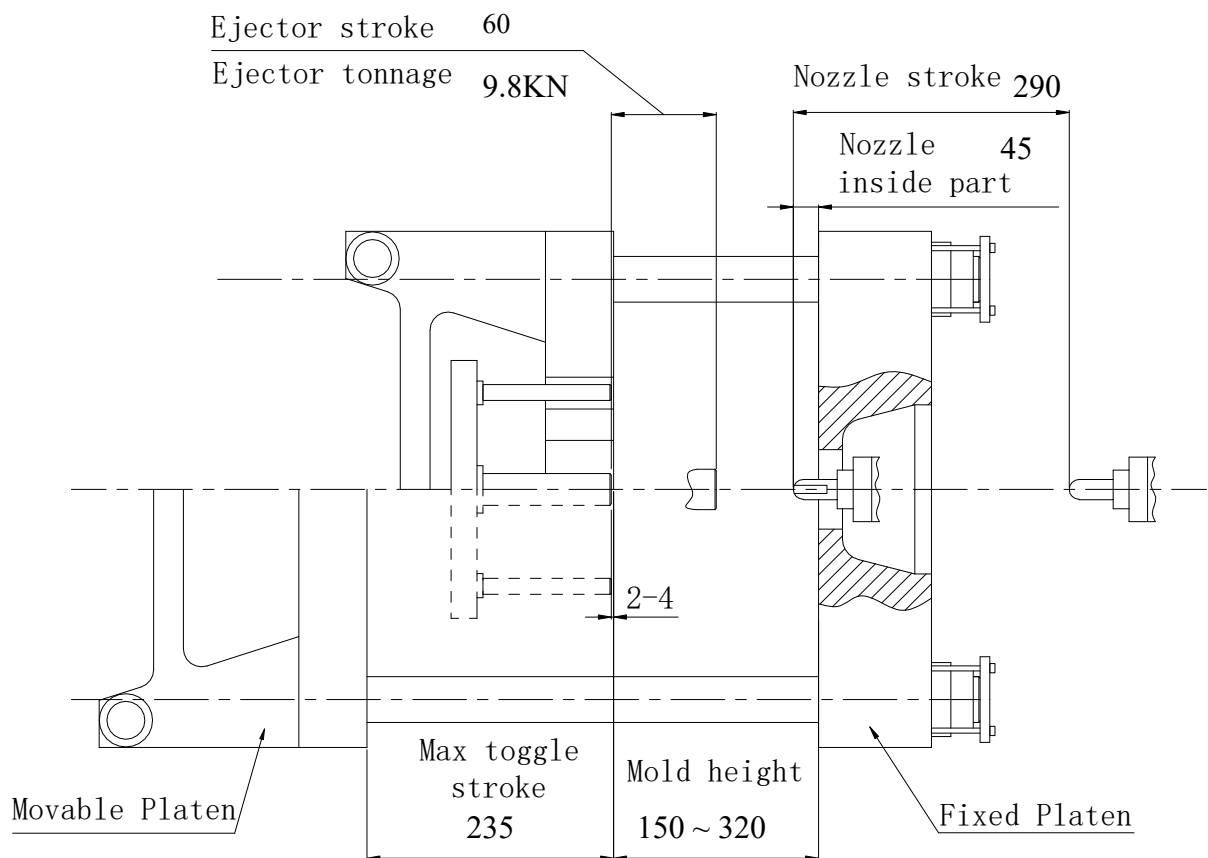
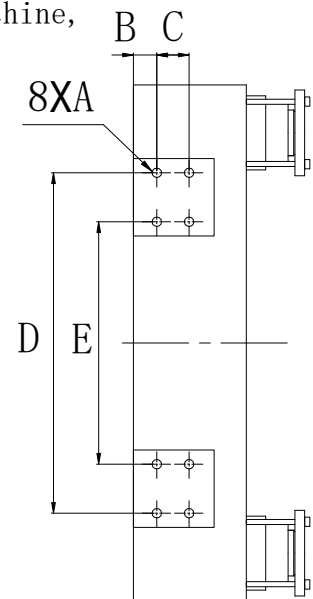
6.2 Dimension for mold installation

To maintain the properties of injection molding machine,
Please be sure the mold size be larger than H.V

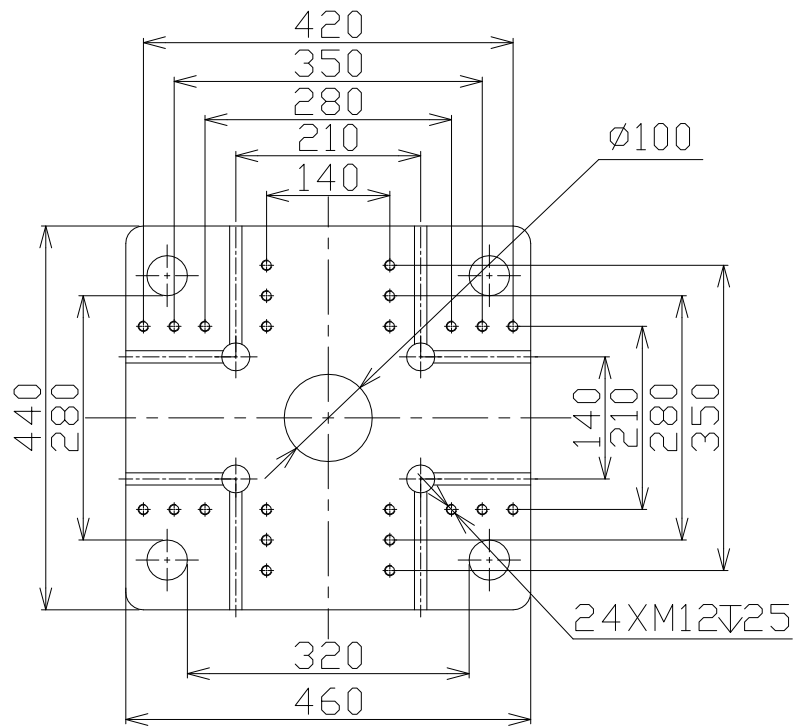


H	V
205	180

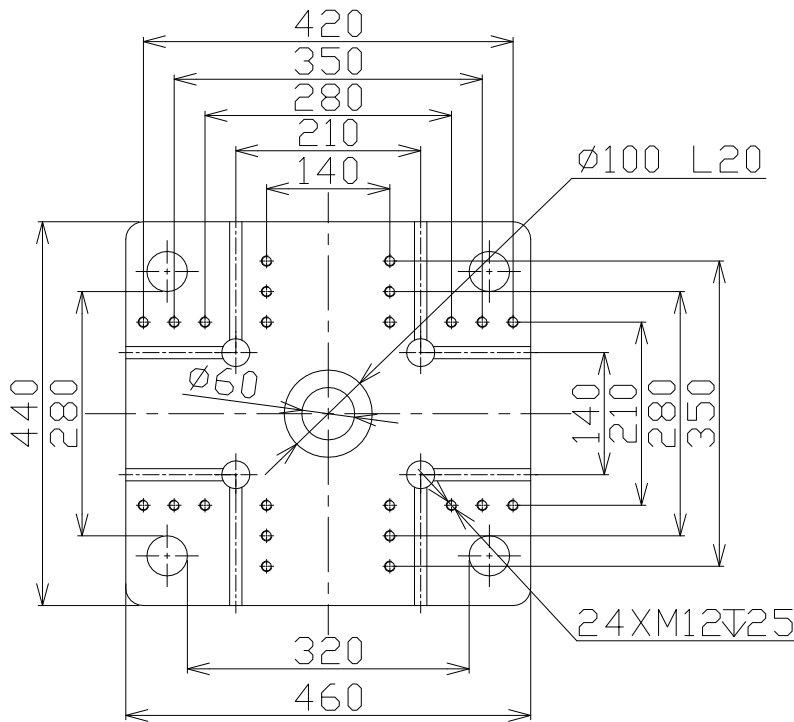
A	B	C	D	E
M12	30	35	420	280



Mold size parameters



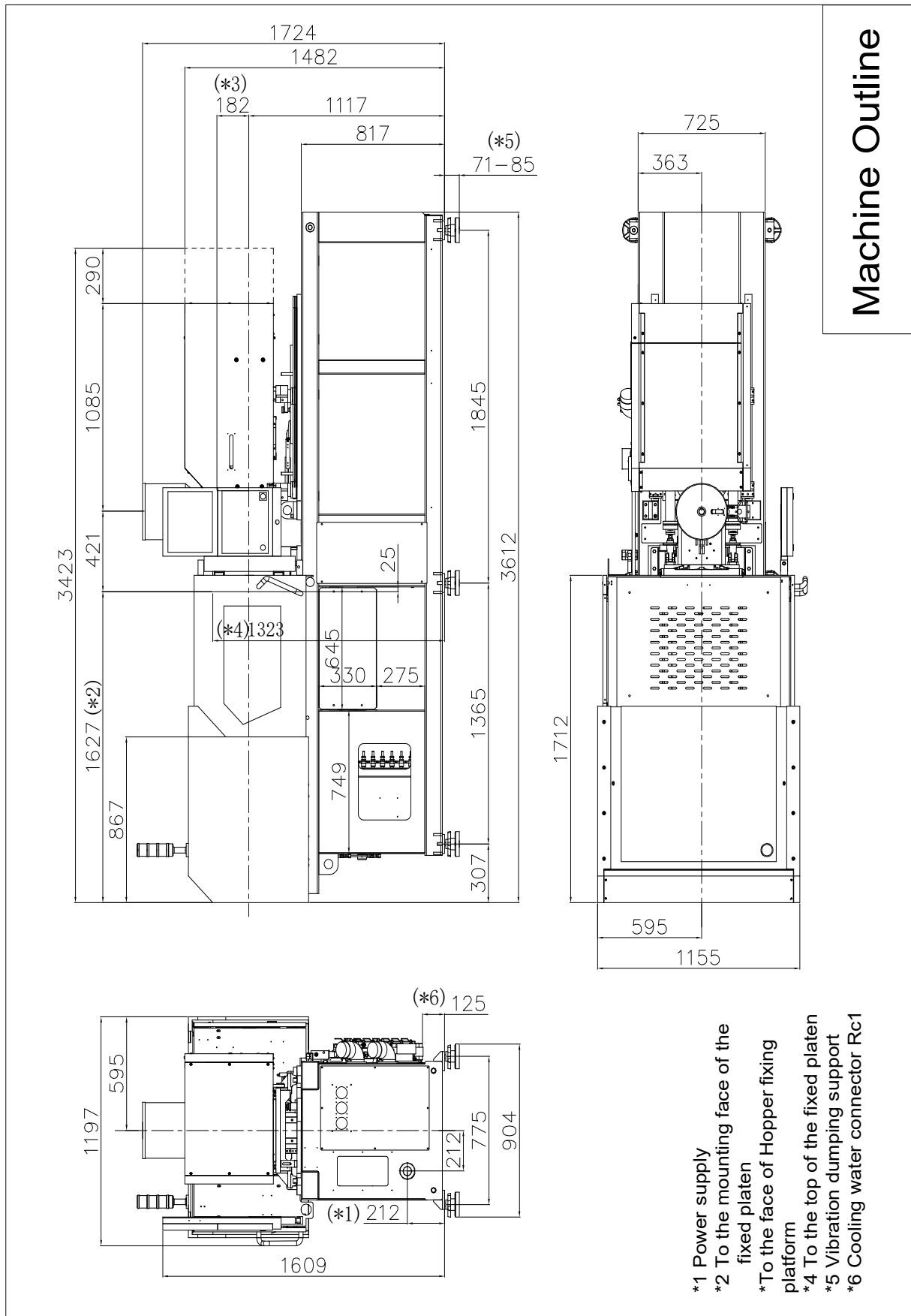
Fixed platen



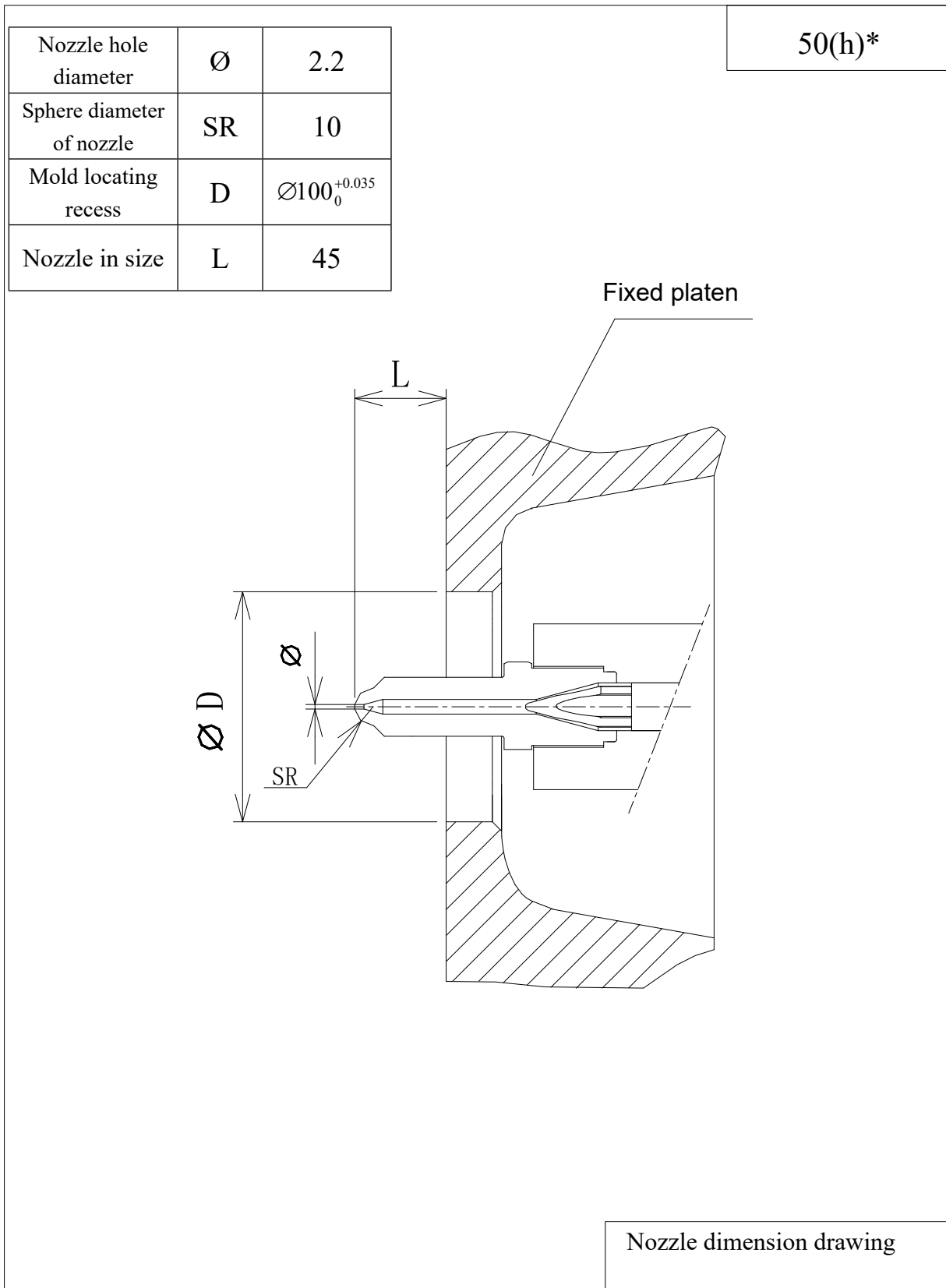
Movable platen

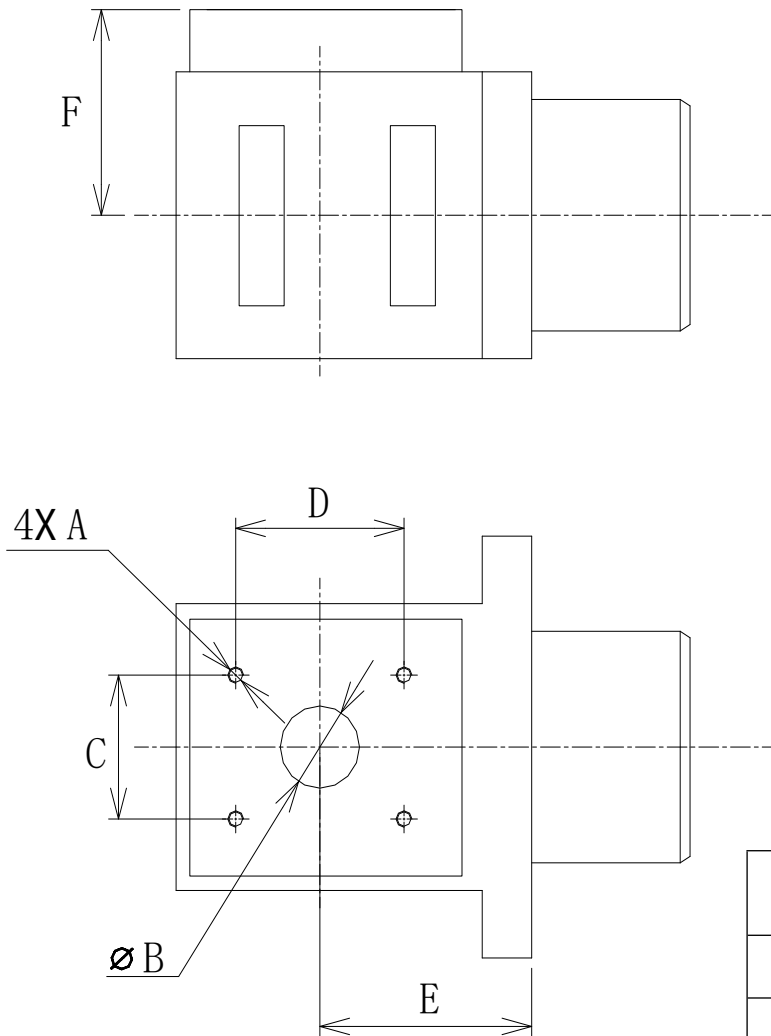
Platen dimensions

6.3 Overall dimension drawing of the machine



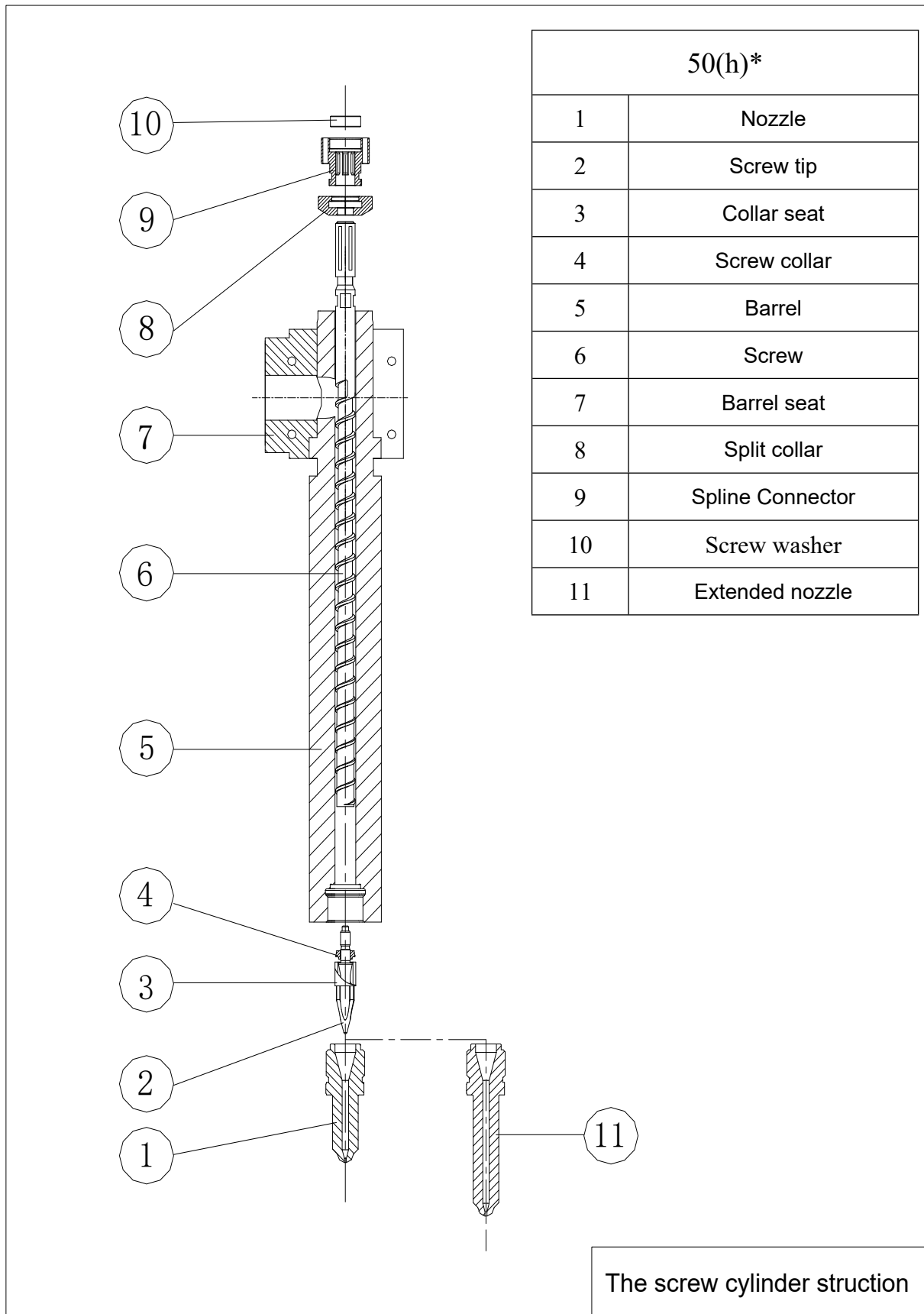
6.4 Dimension drawing for injection unit



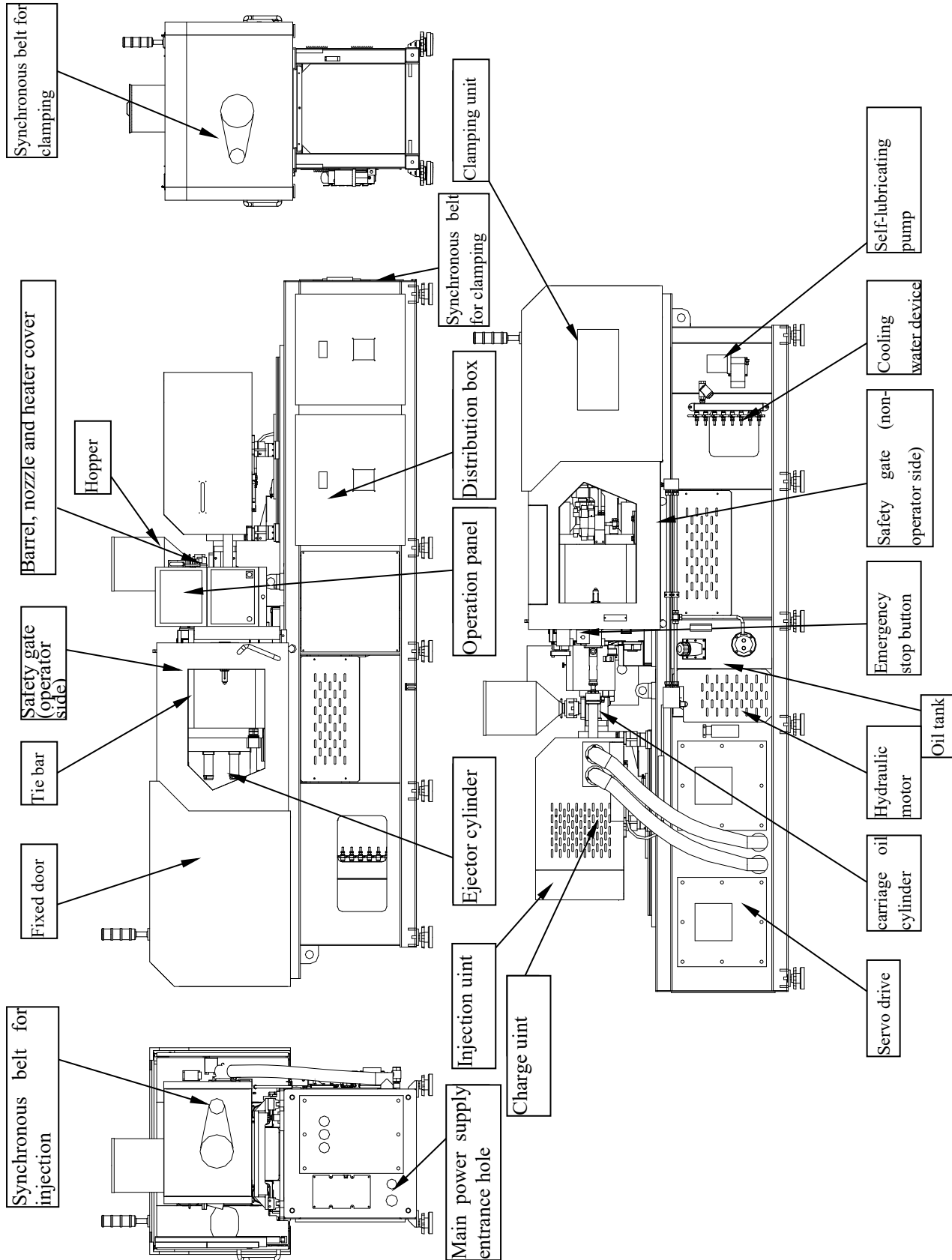


50(h)*	
A	M8
B	30
C	70
D	85
E	59
F	95

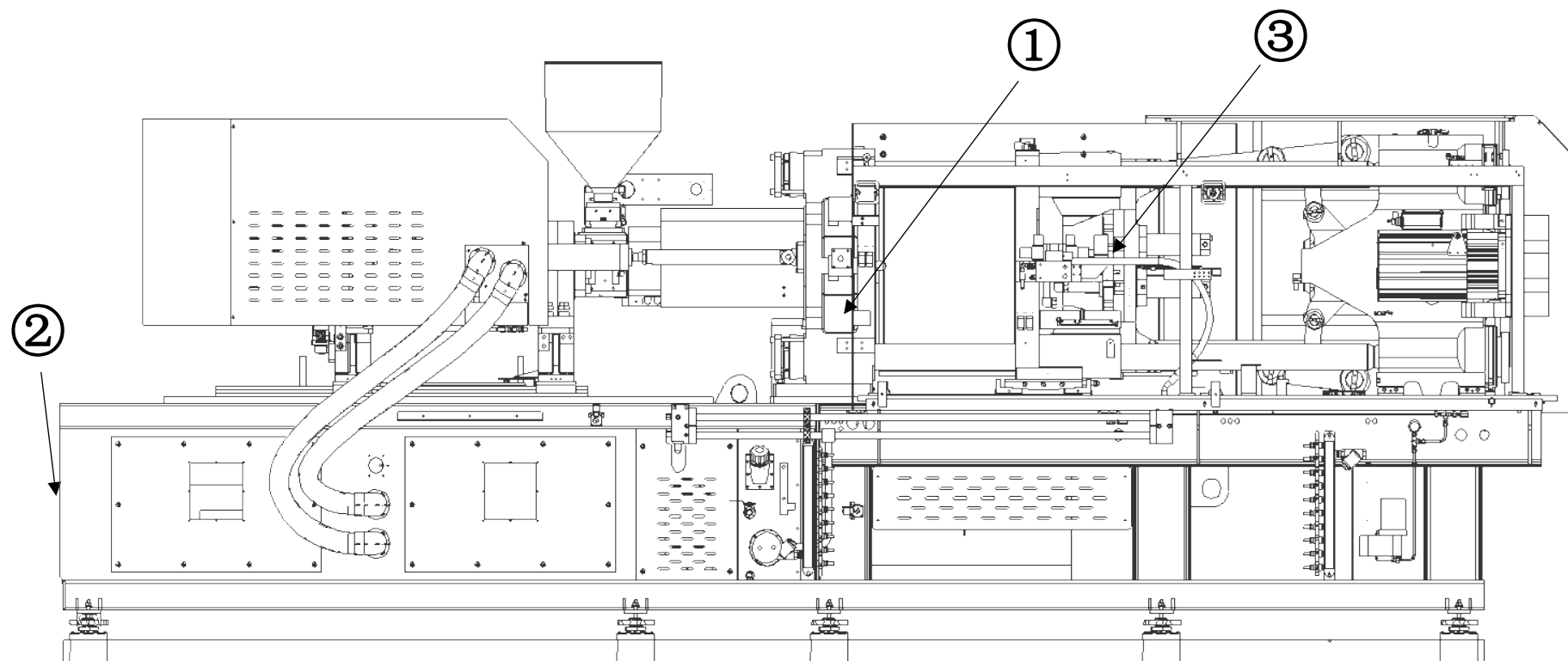
Barrel seat dimension



6.5 Outline drawing of the machine



6.6 Electrical interface layout



Notes

No.	Name	Remarks
①	robot interface	
②	External power supply	
③	fixed half core signal interface & Moving half core signal interface	