

MACHINE 30 UPGRADED TO 750E
Ø95MM SCREW

1 Technical Data

1.1 Data Sheets

1.1.1 Data Sheet Ergotech 650/1000

Model description		Ergotech 650/1000 - 5200
International size code		6500 - 5200
Clamping unit		6500
Clamping force	kN	6500
Locking force	kN	7150
Max. mould opening stroke	mm	930
Min. mould mounting height	mm	450
Max. mould mounting height	mm	950
Max. daylight between platens	mm	1880
Overall size of platens	h x v	1450 x 1350
Daylight distance between tie bars	h x v	1000 x 900
Max mould weight	kg	8600
Max weight content on moving platen	kg	5700
Hydraulic Ejector		
Ejection stroke	mm	300
Ejection force	kN	138
Ejector retraction force	kN	58

Data Sheet Ergotech 650/1000 - continued

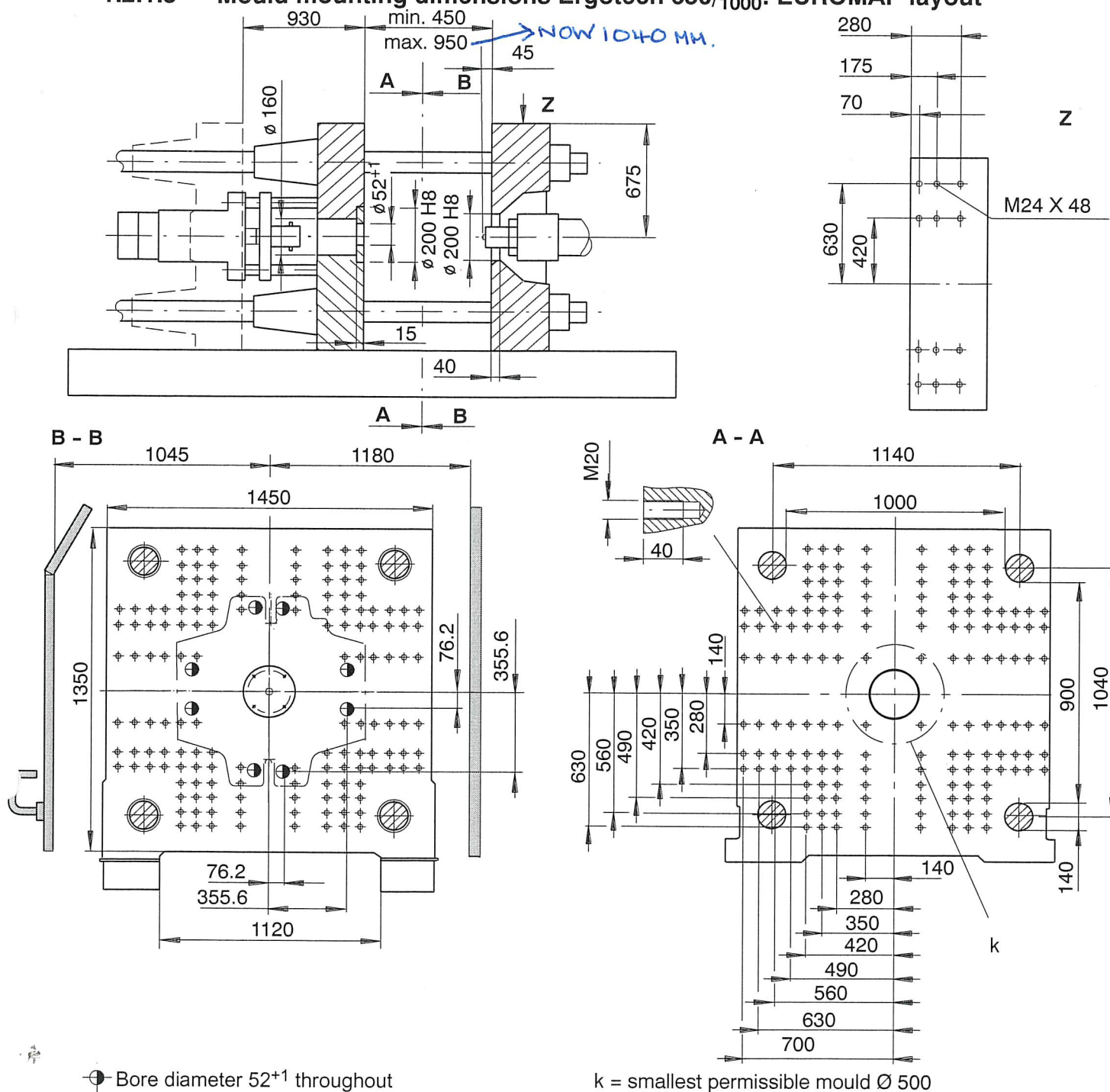
Injection unit		5200			
Screw cylinder		Standard			Special
Screw diameter	mm	80	95 *	110	95
L / D - Ratio		24	20	20	23
Injection pressure (at 400 °C)	bar	2380	1832	1367	1832
Cylinder head volume	cm ³	2011	2835	3801	2835
Shot weight in (PS)	g	1810	2550	3420	-
Shot weight in (PE)	g	-	-	-	2010
Max. metering stroke	mm	400			
Max. dist. of nozzle retraction	mm	720			
Nozzle dipping depth (SVO)	mm	45 (30 for SPI)			
Nozzle sealing force	kN	110			
Heating capac. of screw cylind.	kW	42.6	42.6	59.0	59.0
Electrical screw drive (WA)	kW	51			
Hopper capacity	Ltr.	110			
General Data		650/1000 - 5200			
Oil tank capacity	Ltr.	1300			
Pump unit	kW	74 / 90			
Total installed electrical rating	kW	117/133 ***	117 / 133 ***	133 / 149 ***	133 / 149 ***
Number of dry cycles to EUROMAP 6		4,20s-700mm / 3,90s-700mm			
Net weight (without oil) Clamping unit / Injection Unit	kg	25700 / 7500			
Machine dimensions L x W x H	m	10.1* x 2.5 x 2.6			
Continuous sound pressure level	dB (A)	70**			

*) without extension of injection unit, see chap. 2.2

**) Operator side measured to EN 201 - annex D, see chap. 3.1.6

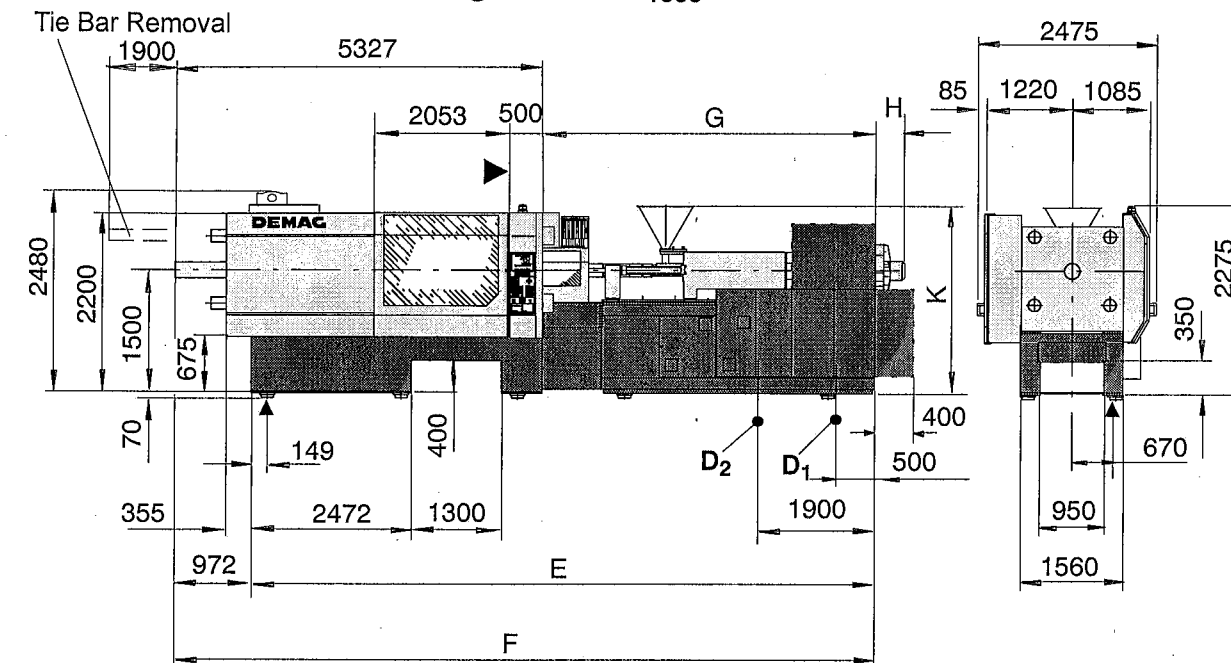
***) Ergotech with el. screw drive the total installed electrical rating increases by the rating of the screw drive

1.2.1.3 Mould mounting dimensions Ergotech 650/1000: EUROMAP layout



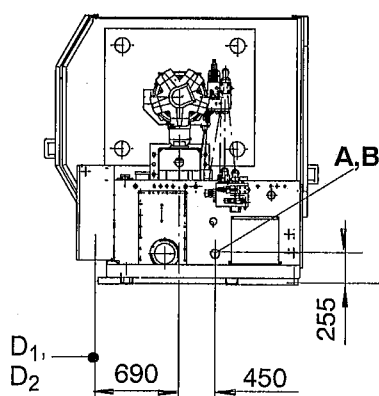
2.3 Installation Plans

2.3.1 Installation Plan Ergotech 650/1000



▲ reference point for foundation

- mould mounting surfaces (fixed platen)



		Connecting the Cooling Water Supply	
		together	separate *)
A	Cooling water inlet	1 "	1 "
B	Cooling water outlet	1 1/2 "	1 "

*) 1x mould cooling and 1x hydraulic oil cooling/feed zone cooling
(Option)

D₁	Electrical connection Supply I	
D₂	Electrical connection Supply II	

Injection unit	E	F	G	H	K
EE 3300	9135	10097	4770	565	2402
EE 5200	9135	10097	4770	1207	2432
EE 8000	9575	10537	5210	1472	2452

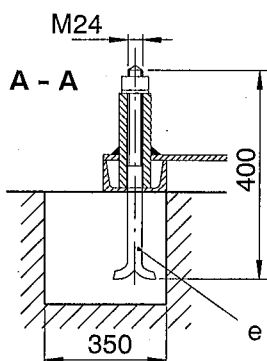
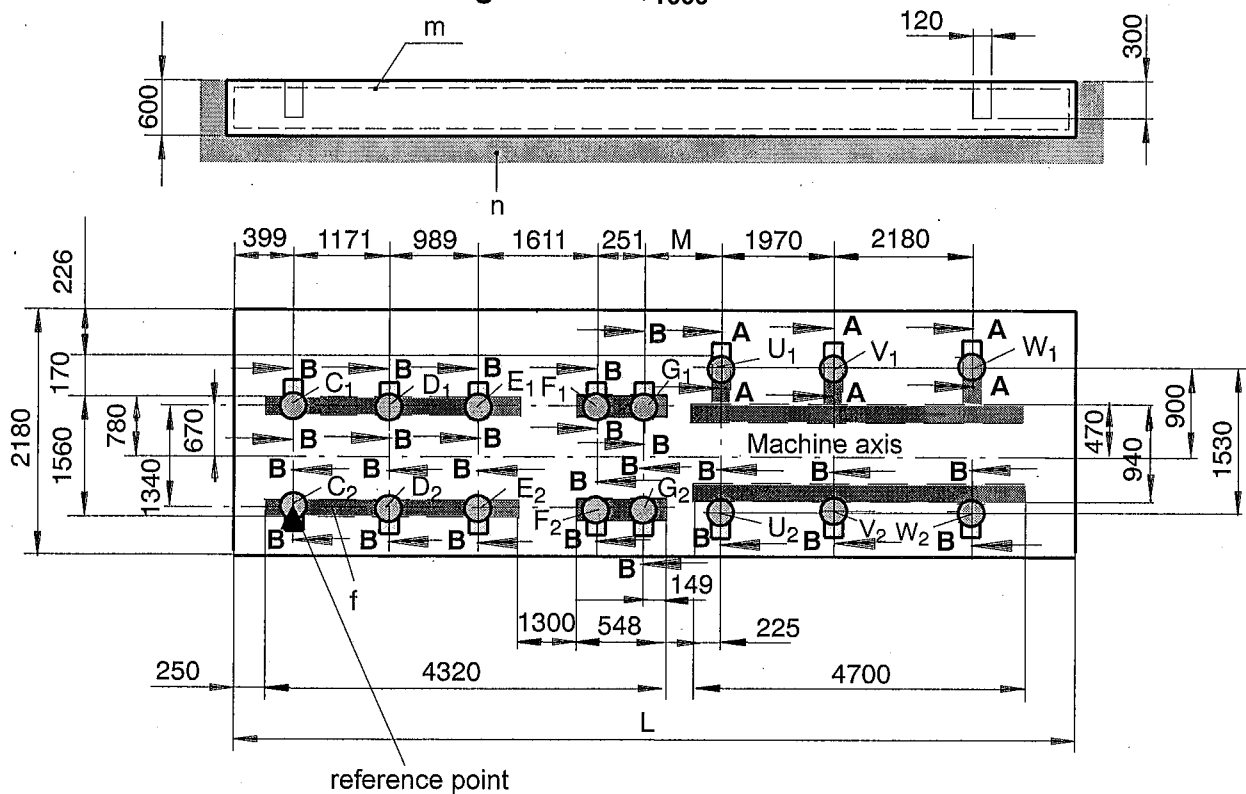


Note:

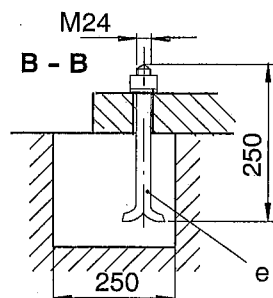
The machine must have a clearance of approx. 1.5m on all sides, including all extended or overhanging units (squeezing danger).

2.4 Foundation Plans

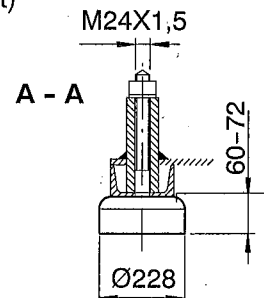
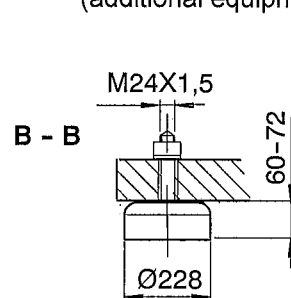
2.4.1 Foundation Plan Ergotech 650/1000



with rag bolts



with flexible anti-vibration machine mounts
(additional equipment)



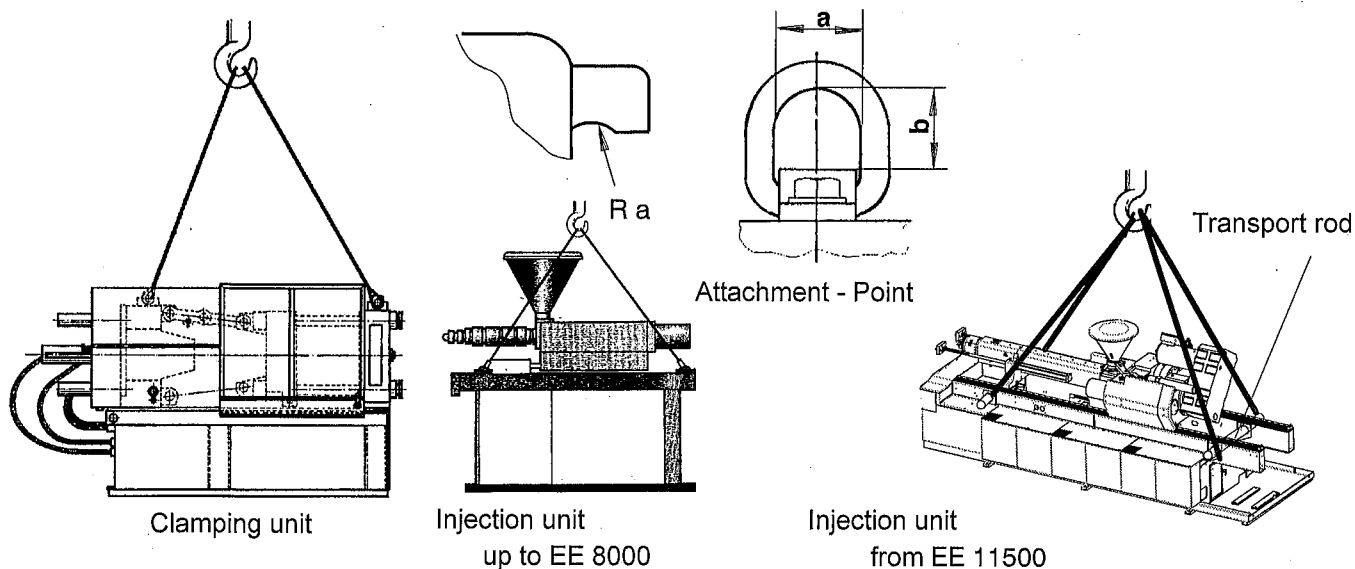
e	Rag bolt DIN 529	f	supporting surface	m	structured steel material Q 222	n	waxed floor
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Injection unit	EE 3300	EE 5200	EE 8000
L	9640	9640	10080
M	464	464	904

2 Commissioning and Dismantling

2.1 Cable Suspension Diagrams and machine weights

2.1.1 Cable Suspension Diagram and machine weights - Ergotech 420/800 and 500/900 up to 2000/1800



Picture 1: Cable suspension diagram Ergotech 420/800 and 500/900 up to 2000/1800

		Clamping unit							
		420	500	650	800	1000	1300	1500	2000
Weight without hydraulic oil	kg	13600	16500	25700	33500	52500	68000	74000	100000
Attachment-Point a/b	mm	75 /114	75 /114	80 /48	80 /48	80 /48	80 /48	80 /48	50

Table 1: Weights Clamping unit

		Injection unit							
		1450	2300	3300 I	3300 II	5200	8000	11500	16000
Weight without hydraulic oil	kg	4100	4400	5400	7100	7500	9400	20000	21000
Attachment-Point a/b	mm	Ø 48	Ø 48	Ø 48	Ø 65	Ø 65	Ø 65	-	-
Transport rod	mm	-	-	-	-	-	-	Ø 133	Ø 133
		MB I 45-55 kW			MB II 74-110 kW			MB III	

Table 2: Weights Injection unit