

The racing machine



DemagPlastics Group

Technical Description

EL-EXIS S

1.000 – 7.000 kN

Technical Data EL-EXIS S 100/475

Demag Plastics Group		EL-EXIS S 100/475														
Model description		EL-EXIS S 100/475-320					EL-EXIS S 100/475-440					EL-EXIS S 100/475-610				
International size description		1000-320					1000-440					1000-610				
Clamping unit		100/475														
Clamping force	[kN]	1000														
Locking force	[kN]	1100														
Max. mould opening stroke	[mm]	445														
Min. mould height	[mm]	230														
Max./enlarged mould height	[mm]	460/560														
Overall size of platens/enlarged	[mm]	905/1005														
Mould platen (h x v)	[mm]	690x660														
Distance between tie bars (h x v)	[mm]	475x450														
Max. mould weight	[kg]	1450 ²⁾														
Max. mould weight on movable platen	[kg]	730														
Max. mould weight on fixed platen	[kg]	1100														
Ejection stroke	[mm]	140														
Ejection force	[kN]	59														
Retraction force	[kN]	29														
Injection unit		320					440					610				
Screw diameter	[mm]	30	35	40	30	35	35	40	45	35	40	40	45	50	40	45
Screw geometry		standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio		20	20	20	25	25	20	20	20	25	25	20	20	20	25	25
Injection pressure (up to 400 °C)	[bar]	2420	1877	1437	2420	1877	2423	1855	1466	2423	1855	2418	1973	1598	2418	1973
Cylinder head volume, max.	[cm ³]	124	168	220	124	168	177	231	293	177	231	255	323	399	255	323
Max. shot weight (PS, PE*)	[g]	110	150	200	90*	120*	160	210	270	130*	170*	230	290	360	190*	240*
Rate of injection																
> with accumulator	[cm ³ /s]	710	910	1130	710	910	910	1130	1350	910	1130	1130	1350	1570	1130	1350
Plasticising rate (PS, PE*)	[g/s]	27	32	31	23*	27*	37	44	39	32*	38*	48	52	56	42*	47*
Max. screw stroke	[mm]	175	175	175	175	175	184	184	184	184	184	203	203	203	203	203
Distance of nozzle retraction, SVO/SVP	[mm]	350/235					350/235					350/235				
Max. nozzle dipping depth (SVO)	[mm]	20					20					20				
Nozzle sealing force	[kN]	80					80					80				
Hopper capacity	[ltr.]	70					70					70				
General data		100/475-320					100/475-440					100/475-610				
Oil tank capacity	[ltr.]	400					400					400				
Installed electrical rating																
> pump unit ³⁾	[kW]	15					15					15				
> electric screw drive ³⁾	[≈ kW]	15					22					27				
> capacity clamp unit ³⁾	[≈ kW]	22					22					22				
> heating capacity of screw cylinder	[≈ kW]	7,9	8,3	11,7	11	13	8,3	11,7	13	13	16	11,7	13	14,8	16	19
> total capacity	[≈ kW]	60	60	64	63	65	67	71	72	72	75	76	77	79	80	83
Dry cycles (Euromap 6a, 01/07)	[s-mm]	1,15-332					1,15-332					1,15-332				
Net weight (without oil)	[≈ kg]	6550					6850					6850				
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	4,9x1,6x2,1					4,9x1,6x2,1					4,9x1,6x2,1				
Electric drive projection (H) ⁵⁾	[mm]	0/0	0/0	0/222	0/0	0/276	0/0	0/332	138/488	34/384	182/532	3/353	159/509	318/668	203/553	384/734

We reserve the right to make changes as a result of further technical advantages

- 1) homogenisation screw
- 2) increased mould weights for stack moulds on demand
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact / max. distance of nozzle retraction

Technical Data EL-EXIS S 125/475

Demag Plastics Group		EL-EXIS S 125/475														
Model description		EL-EXIS S 125/475-320					EL-EXIS S 125/475-440					EL-EXIS S 125/475-610				
International size description		1250-320					1250-440					1250-610				
Clamping unit		125/475														
Clamping force	[kN]	1250														
Locking force	[kN]	1375														
Max. mould opening stroke	[mm]	445														
Min. mould height	[mm]	230														
Max./enlarged mould height	[mm]	460/560														
Overall size of platens/enlarged	[mm]	905/1005														
Mould platen (h x v)	[mm]	690x660														
Distance between tie bars (h x v)	[mm]	475x450														
Max. mould weight	[kg]	1450 ²⁾														
Max. mould weight on movable platen	[kg]	730														
Max. mould weight on fixed platen	[kg]	1100														
Ejection stroke	[mm]	140														
Ejection force	[kN]	59														
Retraction force	[kN]	29														
Injection unit		320					440					610				
Screw diameter	[mm]	30	35	40	30	35	35	40	45	35	40	40	45	50	40	45
Screw geometry		standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio		20	20	20	25	25	20	20	20	25	25	20	20	20	25	25
Injection pressure (up to 400 °C)	[bar]	2420	1877	1437	2420	1877	2423	1855	1466	2423	1855	2418	1973	1598	2418	1973
Cylinder head volume, max.	[cm ³]	124	168	220	124	168	177	231	293	177	231	255	323	399	255	323
Max. shot weight (PS, PE*)	[g]	110	150	200	90*	120*	160	210	270	130*	170*	230	290	360	190*	240*
Rate of injection																
> with accumulator	[cm ³ /s]	710	910	1130	710	910	910	1130	1350	910	1130	1130	1350	1570	1130	1350
Plasticising rate (PS, PE*)	[g/s]	27	32	31	23*	27*	37	44	39	32*	38*	48	52	56	42*	47*
Max. screw stroke	[mm]	175	175	175	175	175	184	184	184	184	184	203	203	203	203	203
Distance of nozzle retraction, SVO/SVP	[mm]	350/235					350/235					350/235				
Max. nozzle dipping depth (SVO)	[mm]	20					20					20				
Nozzle sealing force	[kN]	80					80					80				
Hopper capacity	[ltr.]	70					70					70				
General data		125/475-320					125/475-440					125/475-610				
Oil tank capacity	[ltr.]	400					400					400				
Installed electrical rating																
> pump unit ³⁾	[kW]	15					15					15				
> electric screw drive ³⁾	[≈ kW]	15					22					27				
> capacity clamp unit ³⁾	[≈ kW]	22					22					22				
> heating capacity of screw cylinder	[≈ kW]	7,9	8,3	11,7	11	13	8,3	11,7	13	13	16	11,7	13	14,8	16	19
> total capacity	[≈ kW]	60	60	64	63	65	67	71	72	72	75	76	77	79	80	83
Dry cycles (Euromap 6a, 01/07)	[s-mm]	1,15-332					1,15-332					1,15-332				
Net weight (without oil)	[≈ kg]	6550					6850					6850				
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	4,9x1,6x2,1					4,9x1,6x2,1					4,9x1,6x2,1				
Electric drive projection (H) ⁵⁾	[mm]	0/0	0/0	0/222	0/0	0/276	0/0	0/332	138/488	34/384	182/532	3/353	159/509	318/668	203/553	384/734

We reserve the right to make changes as a result of further technical advantages

- 1) homogenisation screw
- 2) increased mould weights for stack moulds on demand
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact / max. distance of nozzle retraction

Technical Data EL-EXIS S 150/500

Demag Plastics Group		EL-EXIS S 150/500														
Model description		EL-EXIS S 150/500-440					EL-EXIS S 150/500-610					EL-EXIS S 150/500-840				
International size description		1500-440					1500-610					1500-840				
Clamping unit		150/500														
Clamping force	[kN]	1500														
Locking force	[kN]	1650														
Max. mould opening stroke	[mm]	495														
Min. mould height	[mm]	250														
Max./enlarged mould height	[mm]	560/660														
Overall size of platens/enlarged	[mm]	1055/1155														
Mould platen (h x v)	[mm]	750x750														
Distance between tie bars (h x v)	[mm]	500x500														
Max. mould weight	[kg]	2200 ²⁾														
Max. mould weight on movable platen	[kg]	1150														
Max. mould weight on fixed platen	[kg]	1700														
Ejection stroke	[mm]	160														
Ejection force	[kN]	59														
Retraction force	[kN]	29														
Injection unit		440					610					840				
Screw diameter	[mm]	35	40	45	35	40	40	45	50	40	45	45	50	60	45	50
Screw geometry		standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio		20	20	20	25	25	20	20	20	25	25	20	20	20	25	25
Injection pressure (up to 400 °C)	[bar]	2423	1855	1466	2423	1855	2418	1973	1598	2418	1973	2402	1946	1351	2402	1946
Cylinder head volume, max.	[cm ³]	177	231	293	177	231	255	323	399	255	323	358	442	636	358	442
Max. shot weight (PS, PE*)	[g]	160	210	270	130*	170*	230	290	360	190*	240*	330	400	580	260*	320*
Rate of injection																
> with accumulator	[cm ³ /s]	910	1130	1350	910	1130	1130	1350	1570	1130	1350	1350	1570	1970	1350	1570
Plasticising rate (PS, PE*)	[g/s]	37	44	39	32*	38*	48	52	56	42*	47*	53	60	65	48*	50*
Max. screw stroke	[mm]	184	184	184	184	184	203	203	203	203	203	225	225	225	225	225
Distance of nozzle retraction, SVO/SVP	[mm]	350/235					350/235					350/201				
Max. nozzle dipping depth (SVO)	[mm]	20					20					20				
Nozzle sealing force	[kN]	80					80					80				
Hopper capacity	[ltr.]	70					70					70				
General data		150/500-440					150/500-610					150/500-840				
Oil tank capacity	[ltr.]	400					400					400				
Installed electrical rating																
> pump unit ³⁾	[kW]	15					15					15				
> electric screw drive ³⁾	[≈ kW]	22					27					32				
> capacity clamp unit ³⁾	[≈ kW]	22					22					22				
> heating capacity of screw cylinder	[≈ kW]	8	12	13	13	16	12	13	15	16	19	13	15	23	19	22
> total capacity	[≈ kW]	67	71	72	72	75	76	77	79	80	83	82	84	92	88	91
Dry cycles (Euromap 6a, 01/07)	[s-mm]	1,25-350					1,25-350					1,25-350				
Net weight (without oil)	[≈ kg]	7900					7900					8200				
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	5,2x1,7x2,1					5,2x1,7x2,1					5,2x1,7x2,1				
Electric drive projection (H) ⁵⁾	[mm]	0/0	0/282	88/438	0/334	142/492	3/353	159/505	318/668	203/553	384/734	379/729	538/888	829/1179	604/954	788/1138

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- 2) increased mould weights for stack moulds on demand
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact / max. distance of nozzle retraction

Technical Data EL-EXIS S 200/560

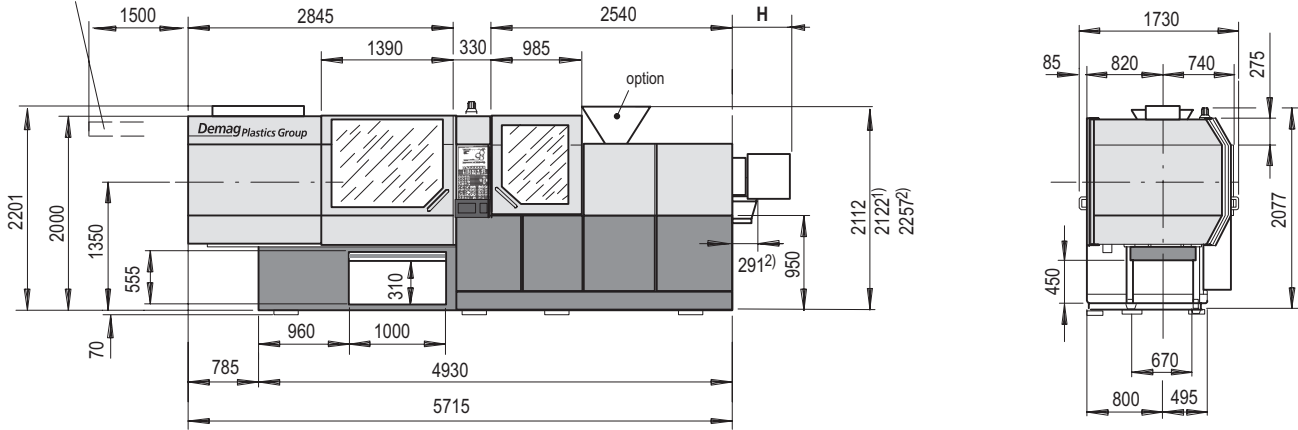
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Model description		EL-EXIS S 200/560-610					EL-EXIS S 200/560-840					EL-EXIS S 200/560-1450				
International size description		2000-610					2000-840					2000-1450				
Clamping unit		200/560														
Clamping force	[kN]	2000														
Locking force	[kN]	2200														
Max. mould opening stroke	[mm]	570														
Min. mould height	[mm]	310														
Max./enlarged mould height	[mm]	660/760														
Overall size of platens/enlarged	[mm]	1230/1330														
Mould platen (h x v)	[mm]	830x830														
Distance between tie bars (h x v)	[mm]	560x560														
Max. mould weight	[kg]	3300 ²⁾														
Max. mould weight on movable platen	[kg]	1700														
Max. mould weight on fixed platen	[kg]	2500														
Ejection stroke	[mm]	180														
Ejection force	[kN]	69														
Retraction force	[kN]	31														
Injection unit		610					840					1450				
Screw diameter	[mm]	40	45	50	40	45	45	50	60	45	50	50	60	70	50	60
Screw geometry		standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio		20	20	20	25	25	20	20	20	25	25	20	20	20	25	25
Injection pressure (up to 400 °C)	[bar]	2418	1973	1598	2418	1973	2402	1946	1351	2402	1946	2426	1905	1400	2426	1905
Cylinder head volume, max.	[cm ³]	255	323	399	255	323	358	442	636	358	442	530	763	1039	530	763
Max. shot weight (PS, PE*)	[g]	230	290	360	190*	240*	330	400	580	260*	320*	480	690	950	390*	560*
Rate of injection																
> with accumulator	[cm ³ /s]	1130	1350	1570	1130	1350	1350	1570	1970	1350	1570	1570	1970	2290	1570	1970
Plasticising rate (PS, PE*)	[g/s]	48	52	56	42*	47*	53	60	65	48*	50*	64	76	80	53*	68*
Max. screw stroke	[mm]	203	203	203	203	203	225	225	225	225	225	270	270	270	270	270
Distance of nozzle retraction, SVO/SVP	[mm]	400/285					400/251					400/251				
Max. nozzle dipping depth (SVO)	[mm]	20					20					20				
Nozzle sealing force	[kN]	80					80					110				
Hopper capacity	[ltr.]	70					70					110				
General data		200/560-610					200/560-840					200/560-1450				
Oil tank capacity	[ltr.]	500														
Installed electrical rating																
> pump unit ³⁾	[kW]	15														
> electric screw drive ³⁾	[≈ kW]	27														
> capacity clamp unit ³⁾	[≈ kW]	32														
> heating capacity of screw cylinder	[≈ kW]	12	13	15	16	19	13	15	23	19	22	15	23	27	22	31
> total capacity	[≈ kW]	86	87	89	90	93	92	94	102	98	101	107	115	119	114	123
Dry cycles (Euromap 6a, 01/07)	[s-mm]	1,35-392														
Net weight (without oil)	[≈ kg]	10650														
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	5,7x1,7x2,2														
Electric drive projection (H) ⁵⁾	[mm]	0/0	0/359	118/518	3/403	184/584	179/579	338/738	629/1029	404/804	588/988	530/930	821/1221	1125/1525	780/1180	1121/1521

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- 1) homogenisation screw
- 2) increased mould weights for stack moulds on demand
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact / max. distance of nozzle retraction

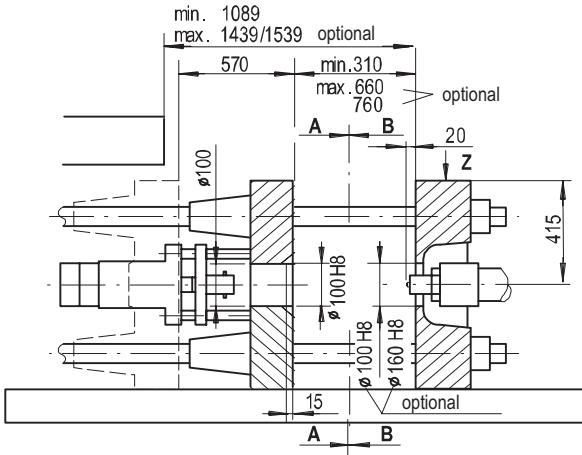
Machine dimensions EL-EXIS S 200/560

Tie Bar Removal



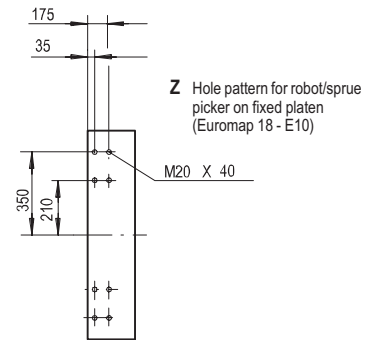
- 1) valid for injection unit 840
- 2) valid for injection unit 1450

Platen dimensions EL-EXIS S 200/560



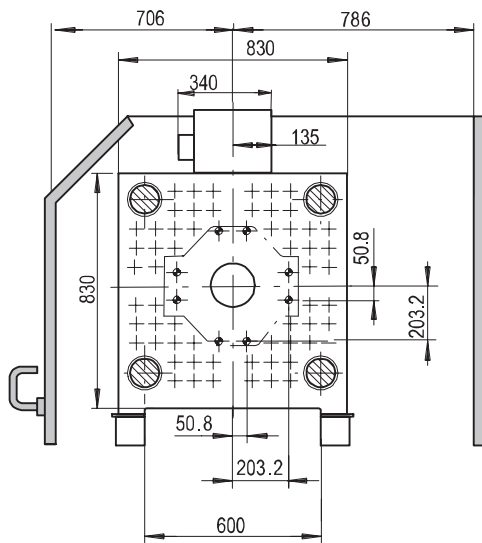
Moving platen

B - B

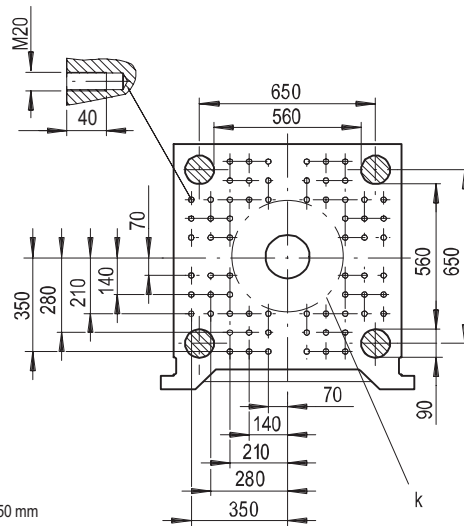


Fixed platen

A - A



Hole pattern according Euromap
 k = minimum permissible mould \varnothing 350 mm
 \varnothing Bore diameter \varnothing 27 through holes



Technical Data EL-EXIS S 250/630

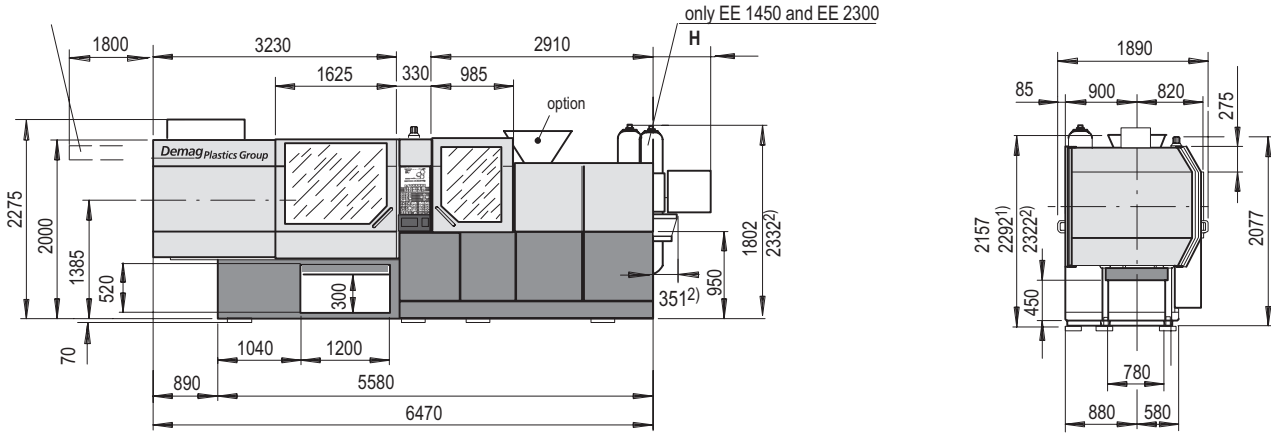
Demag Plastics Group		EL-EXIS S 250/630														
Model description		EL-EXIS S 250/630-840					EL-EXIS S 250/630-1450					EL-EXIS S 250/630-2300				
International size description		2500-840					2500-1450					2500-2300				
Clamping unit		250/630														
Clamping force	[kN]	2500														
Locking force	[kN]	2750														
Max. mould opening stroke	[mm]	670														
Min. mould height	[mm]	330														
Max./enlarged mould height	[mm]	710/830														
Overall size of platens/enlarged	[mm]	1380/1500														
Mould platen (h x v)	[mm]	950x950														
Distance between tie bars (h x v)	[mm]	630x630														
Max. mould weight	[kg]	4300 ²⁾														
Max. mould weight on movable platen	[kg]	2200														
Max. mould weight on fixed platen	[kg]	3300														
Ejection stroke	[mm]	200/180														
Ejection force	[kN]	69/149														
Retraction force	[kN]	31/54														
Injection unit		840					1450					2300				
Screw diameter	[mm]	45	50	60	45	50	50	60	70	50	60	60	70	80	60	70
Screw geometry		standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio		20	20	20	25	25	20	20	20	25	25	20	20	20	25	25
Injection pressure (up to 400 °C)	[bar]	2402	1946	1351	2402	1946	2426	1905	1400	2426	1905	2420	1877	1437	2420	1877
Cylinder head volume, max.	[cm ³]	358	442	636	358	442	530	763	1039	530	763	891	1212	1583	891	1212
Max. shot weight (PS, PE*)	[g]	330	400	580	260*	320*	480	690	950	390*	560*	810	1100	1440	650*	880*
Rate of injection																
> with accumulator	[cm ³ /s]	1350	1570	1970	1350	1570	1570	1970	2290	1570	1970	1970	2290	2480	1970	2290
Plasticising rate (PS, PE*)	[g/s]	53	60	65	48*	50*	64	76	80	53*	68*	84	87	93	75*	79*
Max. screw stroke	[mm]	225	225	225	225	225	270	270	270	270	270	315	315	315	315	315
Distance of nozzle retraction, SVO/SVP	[mm]	440/291					440/291					440/291				
Max. nozzle dipping depth (SVO)	[mm]	20					20					20				
Nozzle sealing force	[kN]	80					110					110				
Hopper capacity	[ltr.]	70					110					110				
General data		250/630-840					250/630-1450					250/630-2300				
Oil tank capacity	[ltr.]	700					700					700				
Installed electrical rating																
> pump unit ³⁾	[kW]	22					22					22				
> electric screw drive ³⁾	[≈ kW]	32					38					47				
> capacity clamp unit ³⁾	[≈ kW]	32					32					32				
> heating capacity of screw cylinder	[≈ kW]	13	15	23	19	22	15	23	27	22	31	23	27	31	31	37
> total capacity	[≈ kW]	99	101	109	105	108	107	115	119	114	123	124	128	132	132	138
Dry cycles (Euromap 6a, 01/07)	[s-mm]	1,40-441					1,40-441					1,40-441				
Net weight (without oil)	[≈ kg]	13700					14200					14900				
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	6,5x1,9x2,3					6,5x1,9x2,3					6,5x1,9x2,3				
Electric drive projection (H) ⁵⁾	[mm]	0/249	0/408	259/699	34/474	218/658	160/600	451/891	755/1195	410/850	751/1191	500/940	804/1244	1110/1550	800/1240	1154/1594

We reserve the right to make changes as a result of further technical advantages

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- 2) increased mould weights for stack moulds on demand
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact / max. distance of nozzle retraction

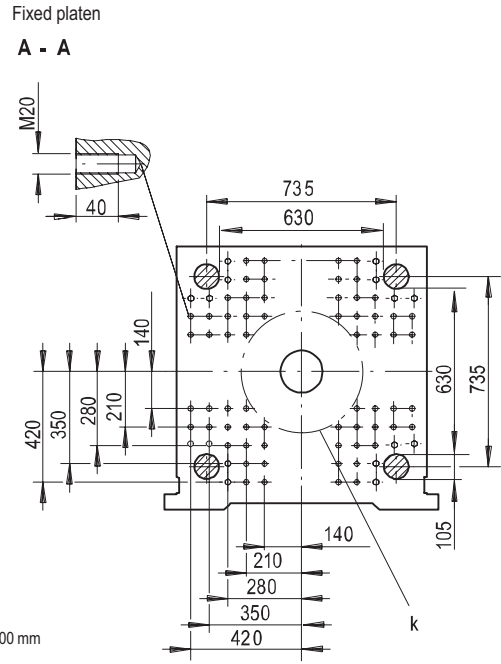
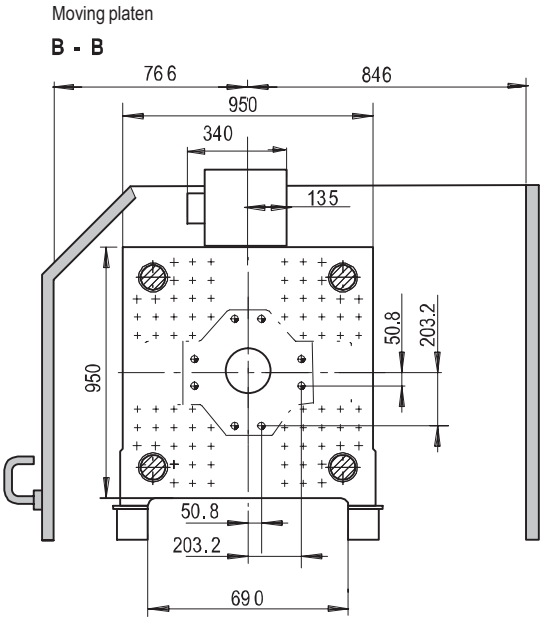
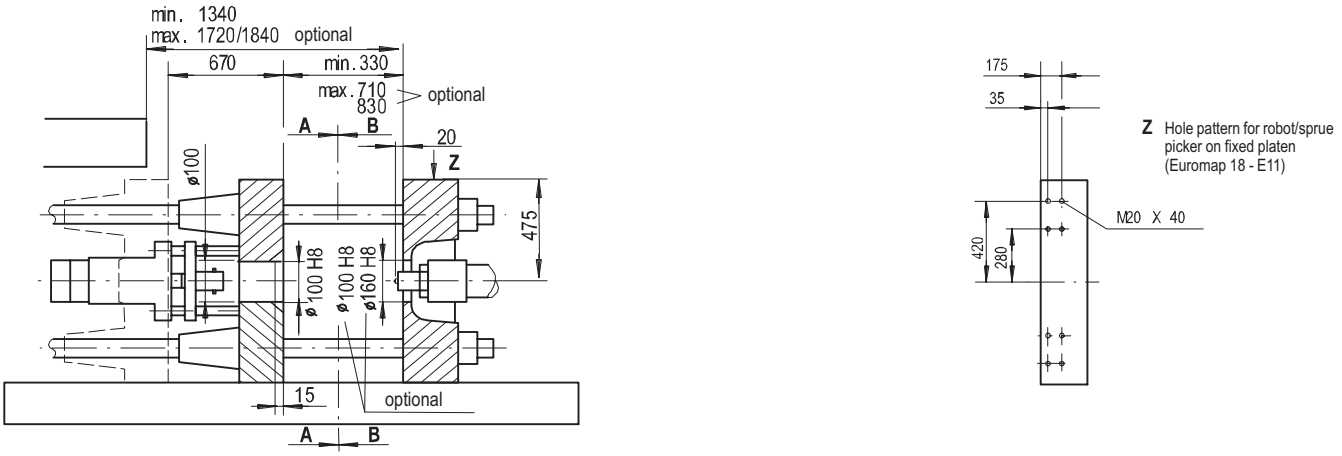
Machine dimensions EL-EXIS S 250/630

Tie Bar Removal



- 1) valid for injection unit 1450
- 2) valid for injection unit 2300

Platen dimensions EL-EXIS S 250/630



Hole pattern according Euromap
k = minimum permissible mould \varnothing 400 mm
⊕ Bore diameter \varnothing 27 through holes

Technical Data EL-EXIS S 300/720

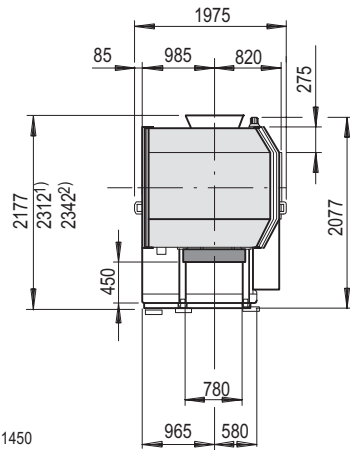
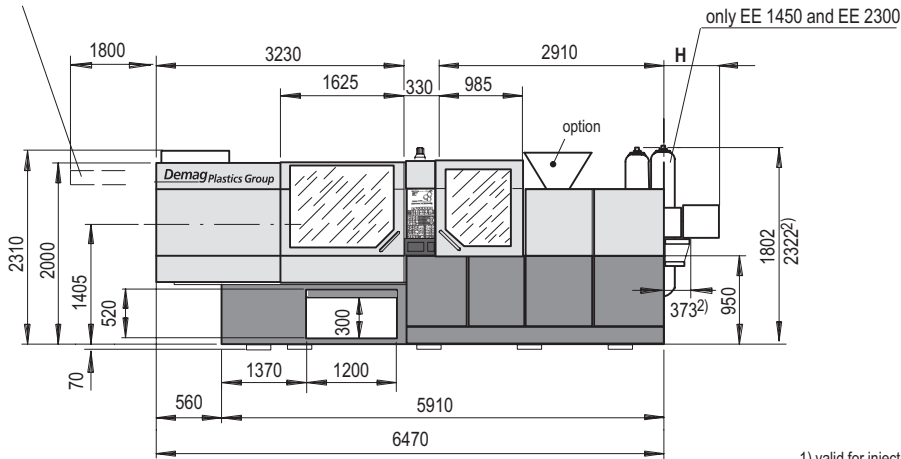
Demag Plastics Group		EL-EXIS S 300/720														
Model description		EL-EXIS S 300/720-840					EL-EXIS S 300/720-1450					EL-EXIS S 300/720-2300				
International size description		3000-840					3000-1450					3000-2300				
Clamping unit		300/720														
Clamping force	[kN]	3000														
Locking force	[kN]	3300														
Max. mould opening stroke	[mm]	670														
Min. mould height	[mm]	330														
Max./enlarged mould height	[mm]	710/830														
Overall size of platens/enlarged	[mm]	1380/1500														
Mould platen (h x v)	[mm]	1040x950														
Distance between tie bars (h x v)	[mm]	720x650														
Max. mould weight	[kg]	4700 ²⁾														
Max. mould weight on movable platen	[kg]	2400														
Max. mould weight on fixed platen	[kg]	3600														
Ejection stroke	[mm]	200														
Ejection force	[kN]	69														
Retraction force	[kN]	31														
Injection unit		840					1450					2300				
Screw diameter	[mm]	45	50	60	45	50	50	60	70	50	60	60	70	80	60	70
Screw geometry		standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio		20	20	20	25	25	20	20	20	25	25	20	20	20	25	25
Injection pressure (up to 400 °C)	[bar]	2402	1946	1351	2402	1946	2426	1905	1400	2426	1905	2420	1877	1437	2420	1877
Cylinder head volume, max.	[cm ³]	358	442	636	358	442	530	763	1039	530	763	891	1212	1583	891	1212
Max. shot weight (PS, PE*)	[g]	330	400	580	260*	320*	480	690	950	390*	560*	810	1100	1440	650*	880*
Rate of injection																
> with accumulator	[cm ³ /s]	1350	1570	1970	1350	1570	1570	1970	2290	1570	1970	1970	2290	2480	1970	2290
Plasticising rate (PS, PE*)	[g/s]	53	60	65	48*	50*	64	76	80	53*	68*	84	87	93	75*	79*
Max. screw stroke	[mm]	225	225	225	225	225	270	270	270	270	270	315	315	315	315	315
Distance of nozzle retraction, SVO/SVP	[mm]	440/321					440/321					440/321				
Max. nozzle dipping depth (SVO)	[mm]	20					20					20				
Nozzle sealing force	[kN]	80					110					110				
Hopper capacity	[ltr.]	70					110					110				
General data		300/720-840					300/720-1450					300/720-2300				
Oil tank capacity	[ltr.]	700					700					700				
Installed electrical rating																
> pump unit ³⁾	[kW]	22					22					22				
> electric screw drive ³⁾	[≈ kW]	32					38					47				
> capacity clamp unit ³⁾	[≈ kW]	37					37					37				
> heating capacity of screw cylinder	[≈ kW]	13	15	23	19	22	15	23	27	22	31	23	27	31	31	37
> total capacity	[≈ kW]	104	106	114	110	113	112	120	124	119	128	129	133	137	137	143
Dry cycles (Euromap 6a, 01/07)	[s-mm]	1,50-504					1,50-504					1,50-504				
Net weight (without oil)	[≈ kg]	15200					15700					16400				
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	6,5x2x2,3					6,5x2x2,3					6,5x2x2,3				
Electric drive projection (H) ⁵⁾	[mm]	0/279	0/438	259/729	34/504	218/688	160/630	451/921	755/1225	410/880	751/1221	500/970	804/1274	1110/1580	800/1270	1154/1624

We reserve the right to make changes as a result of further technical advantages

- 1) homogenisation screw
- 2) increased mould weights for stack moulds on demand
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact / max. distance of nozzle retraction

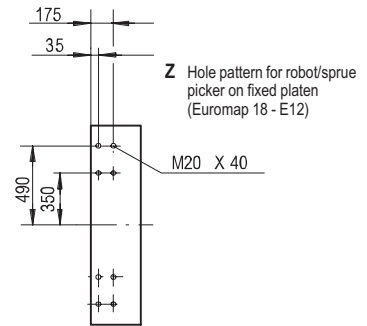
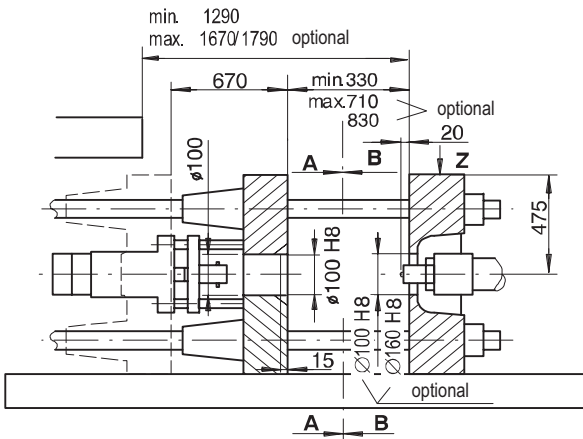
Machine dimensions EL-EXIS S 300/720

Tie Bar Removal



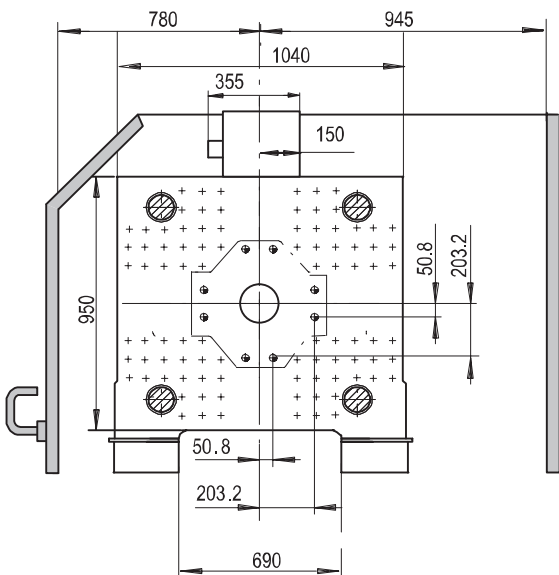
- 1) valid for injection unit 1450
- 2) valid for injection unit 2300

Platen dimensions EL-EXIS S 300/720



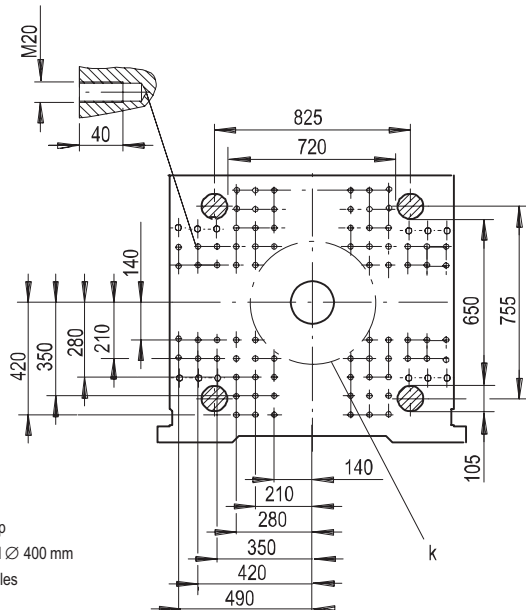
Moving platen

B - B



Fixed platen

A - A



Hole pattern according Euromap
 k = minimum permissible mould ϕ 400 mm
 ϕ Bore diameter ϕ 27 through holes

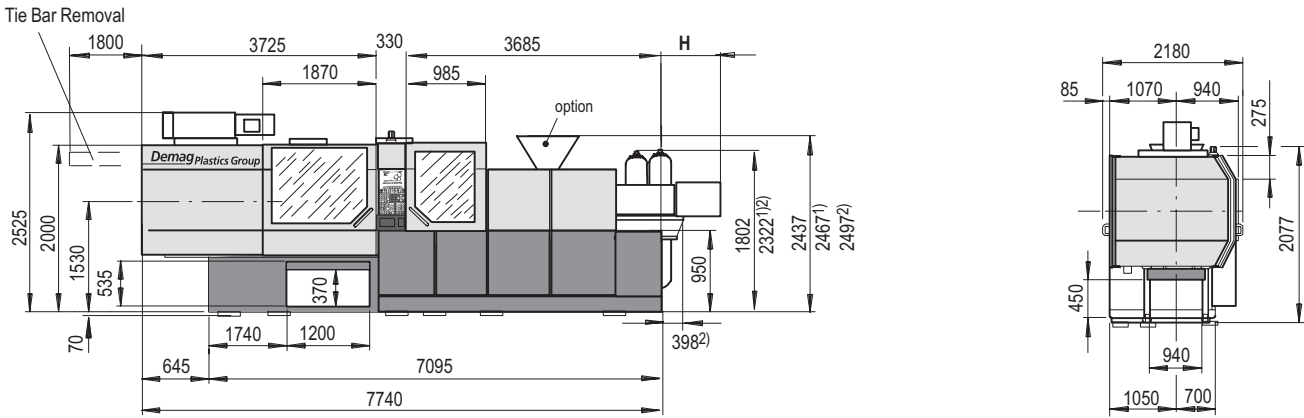
Technical Data EL-EXIS S 350/810

Demag Plastics Group		EL-EXIS S 350/810														
Model description		EL-EXIS S 350/810-1450					EL-EXIS S 350/810-2300					EL-EXIS S 350/810-3300				
International size description		3500-1450					3500-2300					3500-3300				
Clamping unit		350/810														
Clamping force	[kN]	3500														
Locking force	[kN]	3850														
Max. mould opening stroke	[mm]	705														
Min. mould height	[mm]	380														
Max./enlarged mould height	[mm]	820/940														
Overall size of platens/enlarged	[mm]	1525/1645														
Mould platen (h x v)	[mm]	1200x1100														
Distance between tie bars (h x v)	[mm]	810x710														
Max. mould weight	[kg]	6600 ²⁾														
Max. mould weight on movable platen	[kg]	3400														
Max. mould weight on fixed platen	[kg]	5100														
Ejection stroke	[mm]	230/200														
Ejection force	[kN]	96/214														
Retraction force	[kN]	41/118														
Injection unit		1450					2300					3300				
Screw diameter	[mm]	50	60	70	50	60	60	70	80	60	70	70	80	95	70	80
Screw geometry		standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio		20	20	20	25	25	20	20	20	25	25	23	20	20	23	24
Injection pressure (up to 400 °C)	[bar]	2426	1905	1400	2426	1905	2420	1877	1437	2420	1877	2423	1855	1316	2423	1855
Cylinder head volume, max.	[cm ³]	530	763	1039	530	763	891	1212	1583	891	1212	1362	1779	2509	1362	1779
Max. shot weight (PS, PE*)	[g]	480	690	950	390*	560*	810	1100	1440	650*	880*	1240	1620	2280	990*	1300*
Rate of injection																
> with accumulator	[cm ³ /s]	1570	1970	2290	1570	1970	1970	2290	2480	1970	2290	2290	2480	3060	2290	2480
Plasticising rate (PS, PE*)	[g/s]	64	76	80	53*	68*	84	87	93	75*	79*	94	100	104	84*	89*
Max. screw stroke	[mm]	270	270	270	270	270	315	315	315	315	315	354	354	354	354	354
Distance of nozzle retraction, SVO/SVP	[mm]	620/471					620/471					620/383				
Max. nozzle dipping depth (SVO)	[mm]	20					20					20				
Nozzle sealing force	[kN]	110					110					110				
Hopper capacity	[ltr.]	110					110					110				
General data		350/810-1450					350/810-2300					350/810-3300				
Oil tank capacity	[ltr.]	730					730					730				
Installed electrical rating																
> pump unit ³⁾	[kW]	22					37					37				
> electric screw drive ³⁾	[≈ kW]	38					47					53				
> capacity clamp unit ³⁾	[≈ kW]	47					47					47				
> heating capacity of screw cylinder	[≈ kW]	15	23	27	22	31	23	27	31	31	37	31	31	43	31	43
> total capacity	[≈ kW]	122	130	134	129	138	154	158	162	162	168	168	168	180	168	180
Dry cycles (Euromap 6a, 01/07)	[s-mm]	1,60-567					1,60-567					1,60-567				
Net weight (without oil)	[≈ kg]	20700					21000					22000				
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	7,8x2,2x2,6					7,8x2,2x2,6					7,8x2,2x2,6				
Electric drive projection (H) ⁵⁾	[mm]	0/0	0/296	0/600	0/255	0/596	0/345	29/649	335/955	25/645	379/999	873/1493	873/1493	1240/1860	873/1493	1240/1860

We reserve the right to make changes as a result of further technical advantages

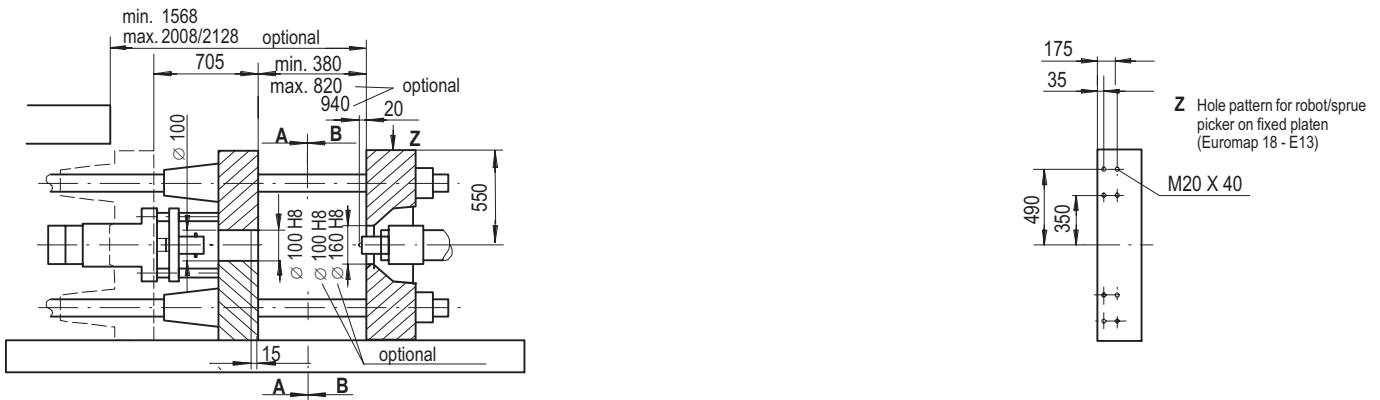
- 1) homogenisation screw
- 2) increased mould weights for stack moulds on demand
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact / max. distance of nozzle retraction

Machine dimensions EL-EXIS S 350/810

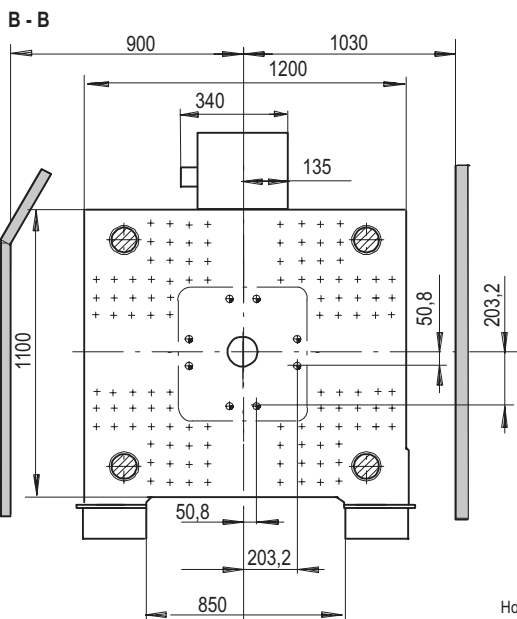


- 1) valid for injection unit 2300
- 2) valid for injection unit 3300

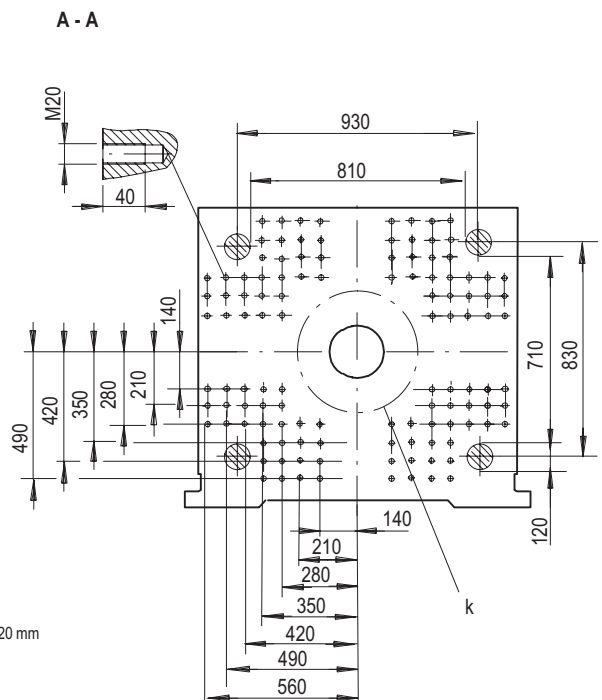
Platen dimensions EL-EXIS S 350/810



Moving platen



Fixed platen



Hole pattern according Euromap
 k = minimum permissible mould \varnothing 420 mm
 \varnothing Bore diameter \varnothing 27 through holes

Technical Data EL-EXIS S 420/810

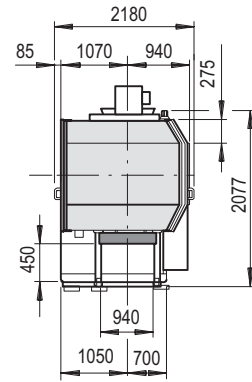
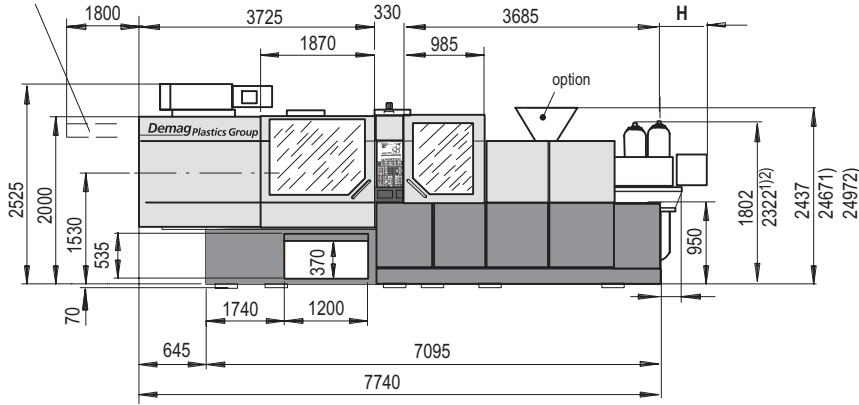
Demag Plastics Group		EL-EXIS S 420/810														
Model description		EL-EXIS S 420/810-1450					EL-EXIS S 420/810-2300					EL-EXIS S 420/810-3300				
International size description		4200-1450					4200-2300					4200-3300				
Clamping unit		420/810														
Clamping force	[kN]	4200														
Locking force	[kN]	4620														
Max. mould opening stroke	[mm]	705														
Min. mould height	[mm]	380														
Max./enlarged mould height	[mm]	820/940														
Overall size of platens/enlarged	[mm]	1525/1645														
Mould platen (h x v)	[mm]	1200x1100														
Distance between tie bars (h x v)	[mm]	810x710														
Max. mould weight	[kg]	6600 ²⁾														
Max. mould weight on movable platen	[kg]	3400														
Max. mould weight on fixed platen	[kg]	5100														
Ejection stroke	[mm]	230/200														
Ejection force	[kN]	96/214														
Retraction force	[kN]	41/118														
Injection unit		1450					2300					3300				
Screw diameter	[mm]	50	60	70	50	60	60	70	80	60	70	70	80	95	70	80
Screw geometry		standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio		20	20	20	25	25	20	20	20	25	25	23	20	20	23	24
Injection pressure (up to 400 °C)	[bar]	2426	1905	1400	2426	1905	2420	1877	1437	2420	1877	2423	1855	1316	2423	1855
Cylinder head volume, max.	[cm ³]	530	763	1039	530	763	891	1212	1583	891	1212	1362	1779	2509	1362	1779
Max. shot weight (PS, PE*)	[g]	480	690	950	390*	560*	810	1100	1440	650*	880*	1240	1620	2280	990*	1300*
Rate of injection																
> with accumulator	[cm ³ /s]	1570	1970	2290	1570	1970	1970	2290	2480	1970	2290	2290	2480	3060	2290	2480
Plasticising rate (PS, PE*)	[g/s]	64	76	80	53*	68*	84	87	93	75*	79*	94	100	104	84*	89*
Max. screw stroke	[mm]	270	270	270	270	270	315	315	315	315	315	354	354	354	354	354
Distance of nozzle retraction, SVO/SVP	[mm]	620/471					620/471					620/383				
Max. nozzle dipping depth (SVO)	[mm]	20					20					20				
Nozzle sealing force	[kN]	110					110					110				
Hopper capacity	[ltr.]	110					110					110				
General data		420/810-1450					420/810-2300					420/810-3300				
Oil tank capacity	[ltr.]	730					730					730				
Installed electrical rating																
> pump unit ³⁾	[kW]	22					37					37				
> electric screw drive ³⁾	[≈ kW]	38					47					53				
> capacity clamp unit ³⁾	[≈ kW]	47					47					47				
> heating capacity of screw cylinder	[≈ kW]	15	23	27	22	31	23	27	31	31	37	31	31	43	31	43
> total capacity	[≈ kW]	122	130	134	129	138	154	158	162	162	168	168	168	180	168	180
Dry cycles (Euromap 6a, 01/07)	[s-mm]	1,70-567					1,70-567					1,70-567				
Net weight (without oil)	[≈ kg]	20700					21000					22000				
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	7,8x2,2x2,6					7,8x2,2x2,6					7,8x2,2x2,6				
Electric drive projection (H) ⁵⁾	[mm]	0/0	0/296	0/600	0/255	0/596	0/345	29/649	335/955	25/645	379/999	873/1493	873/1493	1240/1860	873/1493	1240/1860

We reserve the right to make changes as a result of further technical advantages

- 1) homogenisation screw
- 2) increased mould weights for stack moulds on demand
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact / max. distance of nozzle retraction

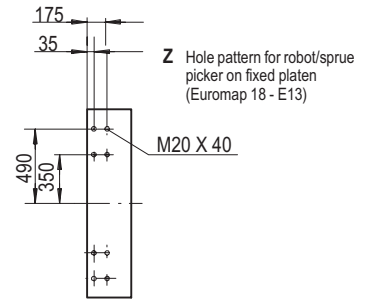
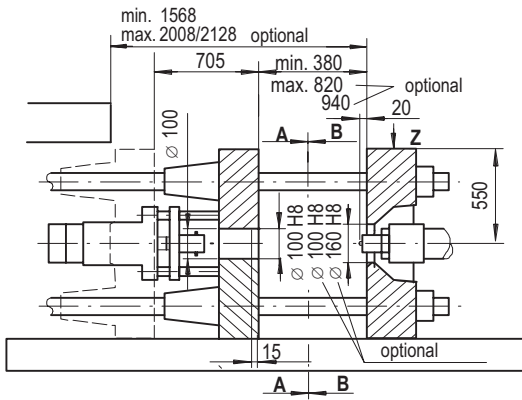
Machine dimensions EL-EXIS S 420/810

Tie Bar Removal

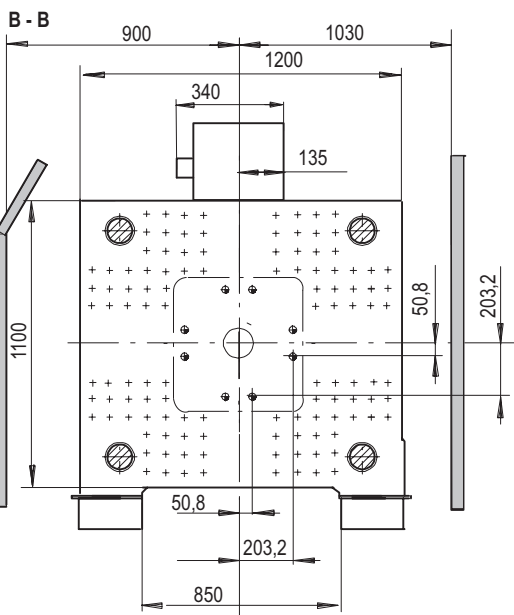


- 1) valid for injection unit 2300
- 2) valid for injection unit 3300

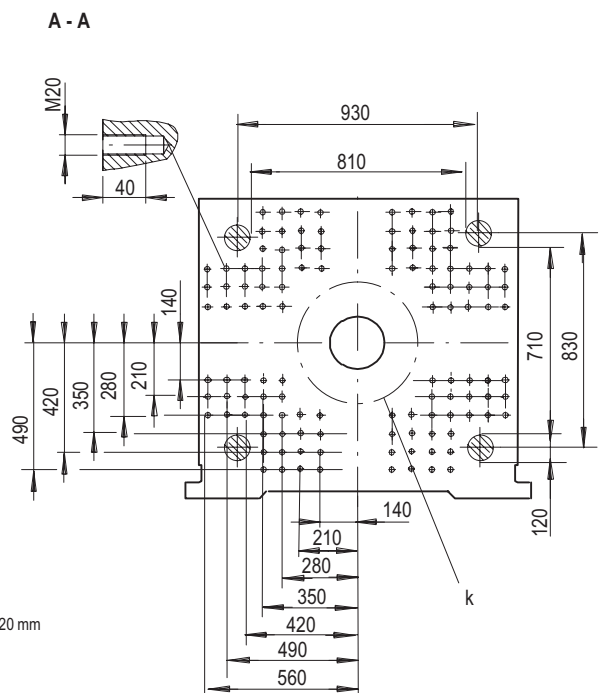
Platen dimensions EL-EXIS S 420/810



Moving platen



Fixed platen



Hole pattern according Euromap
 k = minimum permissible mould \varnothing 420 mm
 \varnothing Bore diameter \varnothing 27 through holes

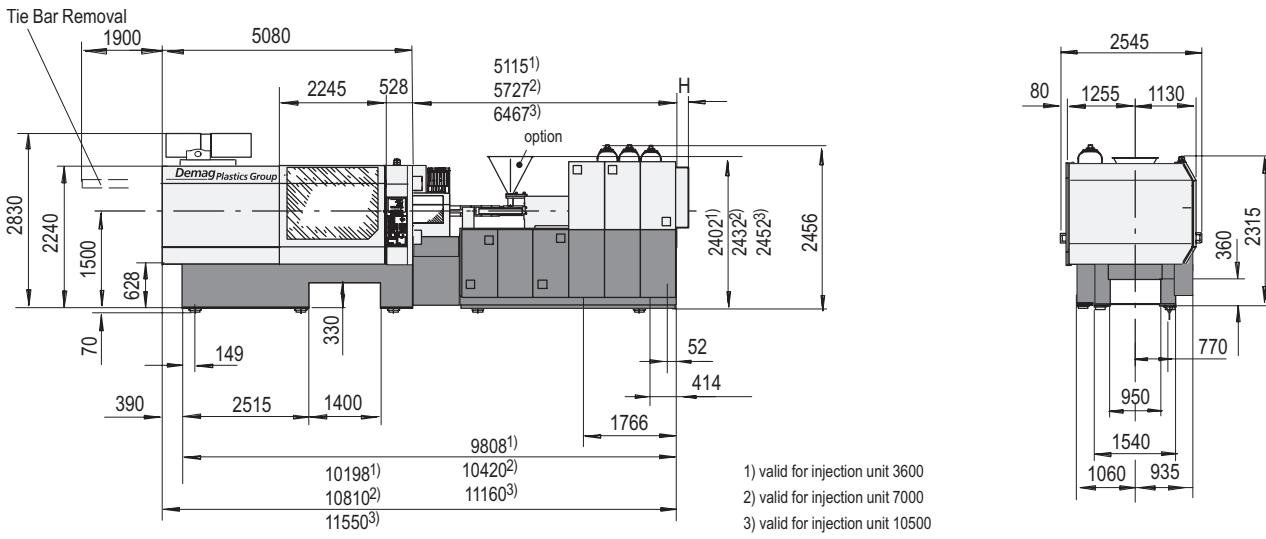
Technical Data EL-EXIS S 550/1020

Demag Plastics Group		EL-EXIS S 550/1020								
Model description		EL-EXIS S 550/1020-3600			EL-EXIS S 550/1020-7000			EL-EXIS S 550/1020-10500		
International size description		5500-3600			5500-7000			5500-10500		
Clamping unit		550/1020								
Clamping force	[kN]	5500								
Locking force	[kN]	6050								
Max. mould opening stroke	[mm]	930								
Min. mould height	[mm]	450								
Max./enlarged mould height	[mm]	950/1250								
Overall size of platens/enlarged	[mm]	1880/2180								
Mould platen (h x v)	[mm]	1450x1470								
Distance between tie bars (h x v)	[mm]	1020x1020								
Max. mould weight	[kg]	11200 ⁵⁾								
Max. mould weight on movable platen	[kg]	5700								
Max. mould weight on fixed platen	[kg]	8600								
Ejection stroke	[mm]	230								
Ejection force	[kN]	106								
Retraction force	[kN]	45								
Injection unit		3600			7000			10500		
Screw diameter	[mm]	70	80	95	80	95	110	95	110	130
Screw geometry		standard	standard	standard	standard	standard	standard	standard	standard	standard
L/D ratio		23	24	20	24	23	20	23	24	20
Injection pressure (up to 400 °C)	[bar]	2423	2051	1454	2391	2094	1562	2434	2006	1436
Cylinder head volume, max.	[cm ³]	1362	1779	2509	2388	3367	4514	3899	5227	7300
Max. shot weight (PS)	[g]	1240	1620	2280	2170	3060	4110	3550	4760	6640
Rate of injection										
> with accumulator	[cm ³ /s]	2694	3519	4253	3519	4253	4752	4253	4752	6637
Plasticising rate (PS)										
Max. screw stroke	[mm]	105	129	155	132	176	187	182	223	212
Max. screw stroke	[mm]	354	354	354	475	475	475	550	550	550
Distance of nozzle retraction, SVO/SVP	[mm]	800/563			800/563			800/563		
Max. nozzle dipping depth (SVO)	[mm]	30			30			30		
Nozzle sealing force	[kN]	110			110			110		
Hopper capacity	[ltr.]	110			110			110		
General data		550/1020-3600			550/1020-7000			550/1020-10500		
Oil tank capacity	[ltr.]	730			730			730		
Installed electrical rating										
> pump unit ¹⁾	[kW]	55			55			55		
> electric screw drive ¹⁾	[≈ kW]	80			90			115		
> capacity clamp unit ¹⁾	[≈ kW]	83			83			83		
> heating capacity of screw cylinder	[≈ kW]	32	44	44	44	59	61	61	81	81
> total capacity	[≈ kW]	250	262	262	272	287	289	314	334	334
Dry cycles (Euromap 6a, 01/07)	[s-mm]	1,9-714			1,9-714			1,9-714		
Net weight (without oil) ²⁾	[≈ kg]	26000/9800/35800			26000/10900/36900			26000/12900/38900		
Machine dimensions (l x w x h) ³⁾	[≈ m]	10,2x2,5x2,8			10,8x2,5x2,8			11,5x2,5x2,8		
Electric drive projection (H) ⁴⁾	[mm]	0/0	0/469	0/469	0/0	0/243	0/243	0/0	0/325	0/325

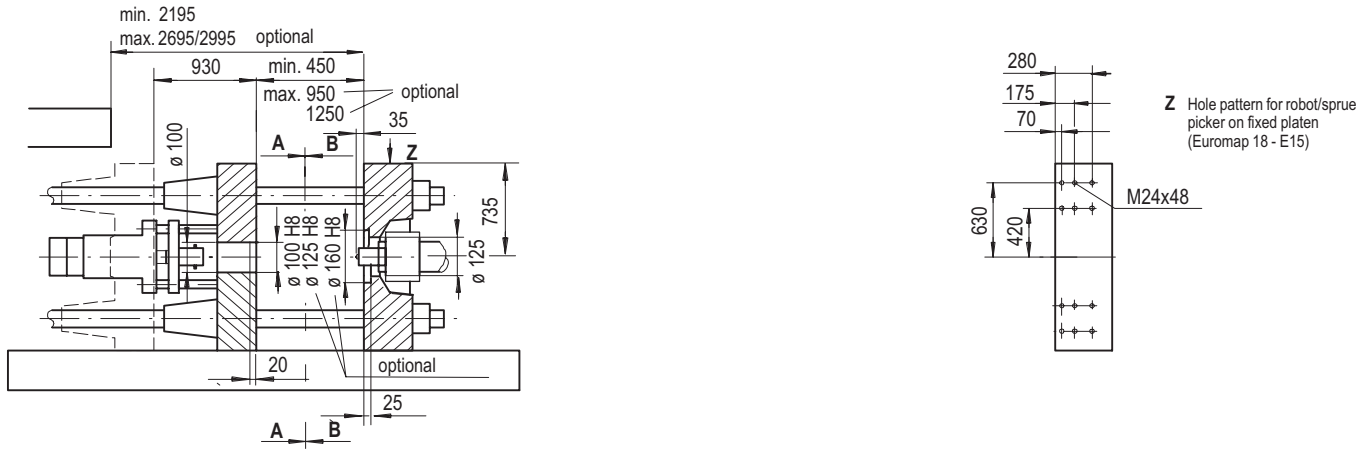
We reserve the right to make changes as a result of further technical advantages

- 1) parallel movement of all axis possible
- 2) Clamping unit/Injection unit/General
- 3) without extension of the drive over the machine base
- 4) at nozzle contact / max. distance of nozzle retraction
- 5) increased mould weights for stack moulds on demand

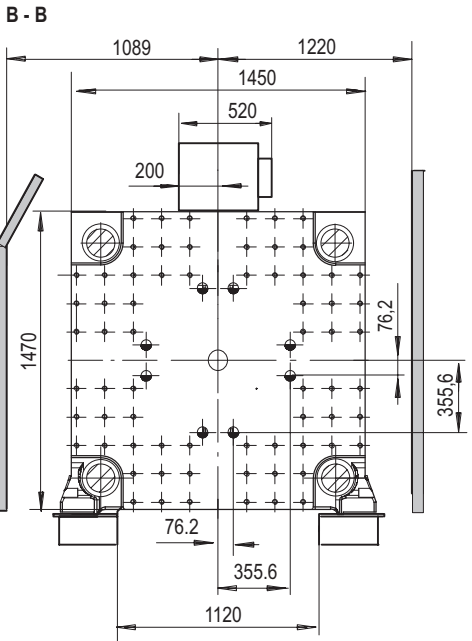
Machine dimensions EL-EXIS S 550/1020



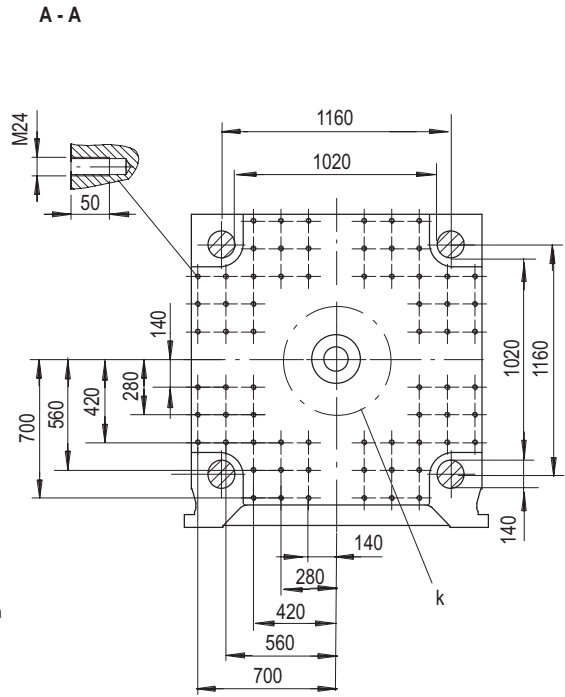
Platen dimensions EL-EXIS S 550/1020



Moving platen



Fixed platen



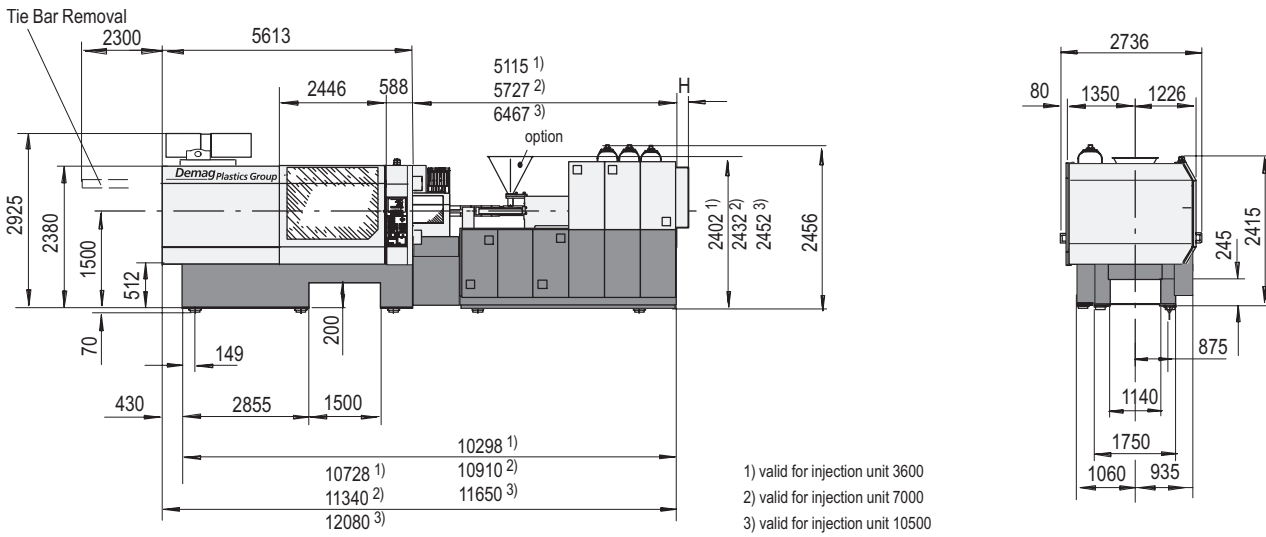
Technical Data EL-EXIS S 700/1120

Demag Plastics Group		EL-EXIS S 700/1120								
Model description		EL-EXIS S 700/1120-3600			EL-EXIS S 700/1120-7000			EL-EXIS S 700/1120-10500		
International size description		7000-3600			7000-7000			7000-10500		
Clamping unit		700/1120								
Clamping force	[kN]	7000								
Locking force	[kN]	7700								
Max. mould opening stroke	[mm]	1030								
Min. mould height	[mm]	500								
Max./enlarged mould height	[mm]	1050/1350								
Overall size of platens/enlarged	[mm]	2080/2380								
Mould platen (h x v)	[mm]	1620x1620								
Distance between tie bars (h x v)	[mm]	1120x1120								
Max. mould weight	[kg]	14000 ⁵⁾								
Max. mould weight on movable platen	[kg]	7200								
Max. mould weight on fixed platen	[kg]	10800								
Ejection stroke	[mm]	230								
Ejection force	[kN]	106								
Retraction force	[kN]	45								
Injection unit		3600			7000			10500		
Screw diameter	[mm]	70	80	95	80	95	110	95	110	130
Screw geometry		standard	standard	standard	standard	standard	standard	standard	standard	standard
L/D ratio		23	24	20	24	23	20	23	24	20
Injection pressure (up to 400 °C)	[bar]	2423	2051	1454	2391	2094	1562	2434	2006	1436
Cylinder head volume, max.	[cm ³]	1362	1779	2509	2388	3367	4514	3899	5227	7300
Max. shot weight (PS)	[g]	1240	1620	2280	2170	3060	4110	3550	4760	6640
Rate of injection										
> with accumulator	[cm ³ /s]	2694	3519	4253	3519	4253	4752	4253	4752	6637
Plasticising rate (PS)										
Max. screw stroke	[mm]	105	129	155	132	176	187	182	223	212
Max. screw stroke	[mm]	354	354	354	475	475	475	550	550	550
Distance of nozzle retraction, SVO/SVP	[mm]	800/563			800/563			800/563		
Max. nozzle dipping depth (SVO)	[mm]	30			30			30		
Nozzle sealing force	[kN]	110			110			110		
Hopper capacity	[ltr.]	110			110			110		
General data		700/1120-3600			700/1120-7000			700/1120-10500		
Oil tank capacity	[ltr.]	730			730			730		
Installed electrical rating										
> pump unit ¹⁾	[kW]	55			55			55		
> electric screw drive ¹⁾	[≈ kW]	80			90			115		
> capacity clamp unit ¹⁾	[≈ kW]	90			90			90		
> heating capacity of screw cylinder	[≈ kW]	32	44	44	44	59	61	61	81	81
> total capacity	[≈ kW]	257	269	269	279	296	296	321	341	341
Dry cycles (Euromap 6a, 01/07)	[s-mm]	2,0-784			2,0-784			2,0-784		
Net weight (without oil) ²⁾	[≈ kg]	35000/9800/44800			35000/10900/45900			35000/12900/47900		
Machine dimensions (l x w x h) ³⁾	[≈ m]	10,6x2,7x3			11,3x2,7x3			12x2,7x3		
Electric drive projection (H) ⁴⁾	[mm]	0/0	0/469	0/469	0/0	0/243	0/243	0/0	0/325	0/325

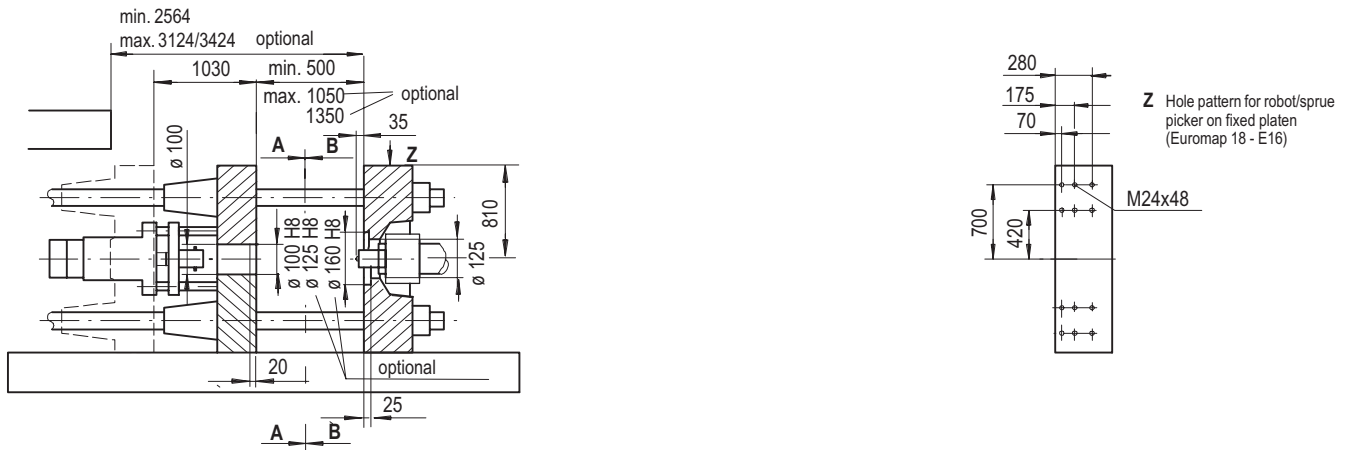
We reserve the right to make changes as a result of further technical advantages

- 1) parallel movement of all axis possible
- 2) Clamping unit/Injection unit/General
- 3) without extension of the drive over the machine base
- 4) at nozzle contact / max. distance of nozzle retraction
- 5) increased mould weights for stack moulds on demand

Machine dimensions EL-EXIS S 700/1120

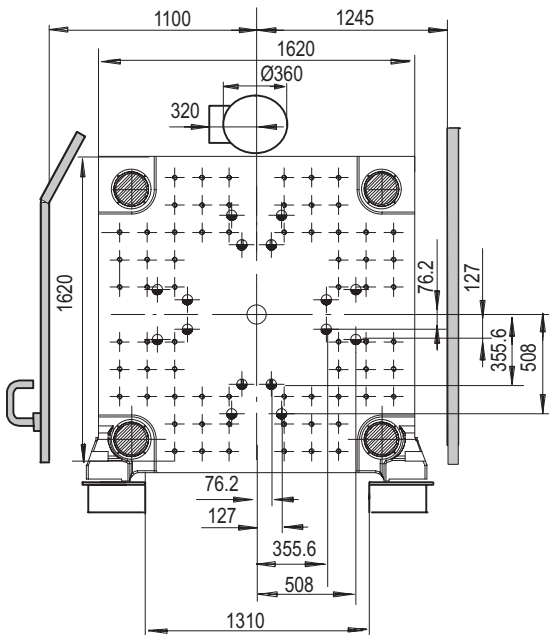


Platen dimensions EL-EXIS S 700/1120



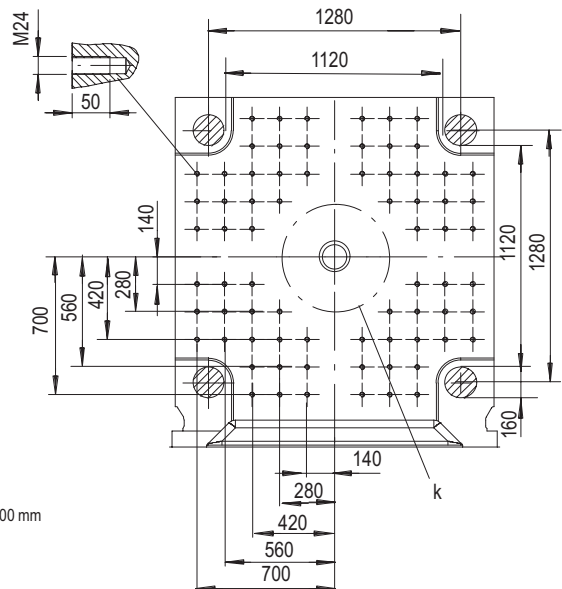
Moving platen

B - B



Fixed platen

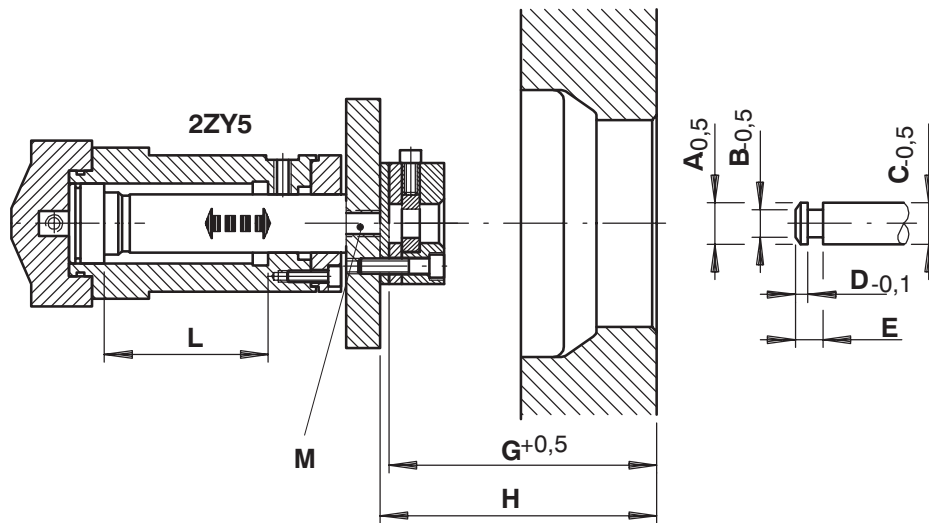
A - A



Hole pattern according Euromap
 k = minimum permissible mould \varnothing 700 mm
 \varnothing bore diameter \varnothing 52 through holes

Hydraulic Ejector EL-EXIS S

Hydraulic Ejector



Machine Type	Dimensions (mm)								
	A	B	C	D	E	G	H	L	M
EL-EXIS S 100/475	24.5	17.5	24.5	7.8	20	294	302	140	M16 - 30
EL-EXIS S 125/475	24.5	17.5	24.5	7.8	20	294	302	140	M16 - 30
EL-EXIS S 150/500	24.5	17.5	24.5	7.8	20	327	335	160	M16 - 30
EL-EXIS S 200/560	44.5	29.5	44.5	9.5	26	390	400	180	M20 - 35
EL-EXIS S 250/630 (ZE)	44.5	29.5	44.5	9.5	26	430	440	200 (180)	M20 - 35
EL-EXIS S 300/720	44.5	29.5	44.5	9.5	26	490	500	200	M20 - 35
EL-EXIS S 350/810 (ZE)	44.5	29.5	44.5	9.0	26	485	495	230 (200)	M24 - 50
EL-EXIS S 420/810 (ZE)	44.5	29.5	44.5	9.0	26	485	495	230 (200)	M24 - 50
EL-EXIS S 550/1020	44.5	29.5	44.5	9.0	26	575	585	230	M24 - 50
EL-EXIS S 700/1120	44.5	29.5	44.5	9.0	26	575	585	230	M24 - 50

Clamping unit	
> Compact 5-point twin toggle with Compact units with fully hydraulic clamping system with two clamp cylinders and a volume multiplier for fast machine cycles and low energy consumption	●
> Clamping unit with AC servo-drive and hydrostatic transmission for dynamic acceleration	●
> Moving platen supported by linear guides on machine base	●
> Clamp force adjustable on Ergocontrol panel, with actual value display	●
> Clamp force control with display	●
> Sensitive mould protection using high-resolution force transducer	●
> Mould mounting dimensions in accordance to Euromap, without side ejector plate	●
> Mould mounting dimensions in accordance to Euromap standard, with side ejector plate	○
> Mould mounting dimensions similar to DIN	○
> Mould mounting dimensions similar to SPI	○
> Reduced centering diameter on fixed platen with DIN or Euromap	○
> Automatic central oil lubrication for toggle	●
> Chromed tie-bars; upper tiebar on non-operator side retractable	●
> Manual clamping mechanism for tiebar retraction	●
> Automatic tiebar retraction, upper tiebar on operator side (from 1.250 kN)	○
> Extended mould height	○
> Automatic mould height adjustment	○
> Hydraulic central ejector with multi-stroke and mechanical quick coupling	●
> Short/long stroke ejector	●
> Programmable ejector stroke, pressure and speed	●
> Ejector pressure and speed programmable for simultaneous operation with mould movement, including positioning control	●
> Mould and ejector movements only when safety gate closed	●
> Stroke measuring system (ultrasonic) via CAN-Bus for injection operation and movement of the injection unit, clamp- and ejector movement	●
> Sequence matrix for free programming of ejectors and core pullers (simultaneous to mould movement)	●
> Flexible sequence of the clamp unit with or without multiple movement of the ejector and core pullers	○
> Core puller with 1, 2 or 4 circuits, independent speed (simultaneous with mould movement) set via sequence matrix	○
> Additional ports for 2 core pullers on fixed mould platen (from 1.250 kN)	○
> Manual pressure relief for 1, 2 or 4 core pullers	○
> 1 or 2 pneumatic 5/2 directional valves, mounted to moving platen and freely programmable	○
> 1 or 2 pneumatic 5/2 directional valves, mounted to fixed platen and freely programmable	○
> 4-way cooling water volume controller	●
> 4 additional cooling water volume controllers	○
> 8 additional cooling water flow controllers	○
> Time-programmable switch-off of mould cooling	●

Clamping unit	
> Blow-through for mould cooling lines	○
> Unscrewing module with positioning function	○
> Unscrewing module without positioning function	○
> Automatic safety gate on operator side (from 1.250 kN)	○
> Safety gate prepared for handling device	●

Injection unit	
> Barrels for up to 3 injection units, L/D ratio 20:1 for all diameters	●
> Barrel for high performance applications, L/D ratio 25:1	○
> Barrels with barrier screw, L/D ratio 25:1	○
> Wear and corrosion resistant universal thermoplastic screw, nitrided barrel	●
> Special screws for processing various materials, with screws and non-return valves in wear and corrosion resistant or heavy duty design (powder metal)	○
> Barrel with bi-metallic lining	○
> Open nozzle with M 40x3 thread; M 60x3 from 30 mm screw diameter	●
> Open nozzle with M 24x1,5 connection thread, incl. adapter	○
> Extended open nozzle	○
> Pneumatic shut off nozzle incl. control	○
> Needle shut off nozzle	○
> Melt temperature measuring (only for open nozzles)	○
> Controlled barrel heating zones (ceramic heaters), number dependent on injection unit, and one controlled nozzle heating zone	●
> Each temperature control circuit with setpoint deviation control and thermocouple break protection; barrel operating temperatures up to 450°C, with pressure limitation above 400°C (from injection unit 3300 up to 400°C)	●
> Central connector for barrel heaters and thermocouples	●
> Integrated hot runner control, 1 to 16 zones	○
> Hydraulic control for hot runner nozzles	○
> Pneumatic hot runner shut off control	○
> Frequency controlled electric screw drive with AC servo motor	●
> Stainless steel hopper	○
> Drilled for hopper loader	●
> Closed-loop control for throat temperature	●
> Barrel quick change with central plugs for heaters and thermocouples, and automatic barrel recognition	●
> Programmable profiles for closed-loop control of injection speed, holding pressure, back pressure and screw speed parameters	●
> Injection, holding pressure and back-pressure regulated by servovalve; regulated screw speed	●
> Accumulator for fast injection cycles and movement of injection unit, cores and ejector	●
> Back pressure programmable in six stages of screw stroke	●

● Basic equipment

○ Additional price

We reserve the right to make changes as a result of further technical advances

Equipment EL-EXIS S 100...700

Injection unit	
> Switch-over to follow-up pressure by hydraulic pressure, with acquisition of maximum value and pressure recording	●
> Switch-over to holding pressure by cavity pressure, with pressure recording for 1 or 2 pressure transducers	○
> Programmable nozzle contact pressure	●
> Residual nozzle sealing force programmable	●
> Two-stage injection unit movement	●
> Injection unit movement parallel to mould movement	●
Hydraulics	
> Separate circuits for oil and mould cooling	○
> Closed-loop oil temperature control with display	●
> Oil cooler with increased cooling capacity	○
> Pre-heating circuit for hydraulic oil	●
> Automatic two stage control and display of oil filter contamination	●
> Ports for external oil cleaning during production (bypass filtration)	●
> Additional integrated oil cleaning unit for microfine bypass filtration	●
Electronics	
> Ergocontrol: Operator-friendly NC4 microprocessor-based operating panel with large LCD colour monitor, alphanumeric keyboard, and disk drive option for data downloads	●
> Setpoint entry switch-over to physical values (bar, ccm, mm/s)	●
> Fault log with trouble shooting hints	●
> Quality control with reject parts recognition	●
> Integrated disk drive for software downloads and saving machine and ancillary settings	●
> Universal printer port	●
> Printer program for external printer for automatic printout of error log, alarms, messages and changes	○
> Integrated printer including driver software	○
> Smart card reader for controlled access	●
> Additional Ergocontrol operating language	●
Functions	
> Process data acquisition with 100% monitoring and statistics with graphics for of process parameters	●
> Integrated Statistical Process Control (SPC) with display of process control charts	○
> Saving of statistical data in ASCII format on disk	○
> Integrated production data acquisition	○
> Change log	○
> Help disk for operator support	○
> Additional operating language on disk	○
> Mould stroke dependent injection start; nozzle contact pressure remains over the whole cycle	○
> Three-stage start-up program	○
> On/off program with one purging cycle	○
> 1, 2, 3, 5, or 6 freely programmable inputs/outputs	○
> Ergostart: integrated basic setting program	●
> Ergosupport: program for faster fault recognition on basic setting / process optimisation and for extended monitoring of process sequence and deviations	○
> Mould-dependent machine optimisation	○
> Econ 2000 energy consumption metering with graphic display	○

shot weight = melt correction factor x swept volume

The melt correction factor takes into account the change in volume at process temperature and also includes a factor for the flow characteristics of the shut off device on the end of the screw

Interfaces	
> VGA interface and interface for AT keyboard (MF-II standard)	○
> Interface for mould protection (ejector with LS)	●
> Interfaces for ejector limit switch in mould, side action with LS and product detection	○
> CAN-Bus interface for temperature controllers (2 circuits), Demag-specific signal	○
> Mould temperature display with monitoring for 1 or 2 circuits	○
> Interface with three-point controllers for 2 temperature controllers	○
> Interface with three-point controllers for 4 temperature controllers	○
> 20 mA interface (TTY-V24) for up to 6 units integrated temperature controllers	○
> Additional 2 point temperature control for nozzle, 1 circuit	○
> Socket for second nozzle heater band	○
> Drilled for handling device to VDMA 24466	●
> 32-pin handling interface to Euromap 12 (VDMA)	○
> Data interface for three signals: drycycling, automatic, and semi-automatic operation	○
> Data interface for main computer systems to Euromap 63	○
> Ergolink modem interface	●
> Portable Ergolink modem	○

Automation	
> Quality reject feature in chute; either for 2 or 3 directions (up to 3,000 kN)	○
> Integrated temperature controllers (2 circuits)	○
> Integrated handling device with separate control cabinet	○
> Ergorob sprue picker with integrated control	○
> Interface and control for gas injection process, 1 to 4 circuits integrated	○

General	
> Separate power supply for both drive and heating	●
> Single-phase 230V/50Hz/10A socket in specific national version	●
> Set of sockets in separate cabinet on non-operator side, switched through main isolator and switch-off matrix, 2x 16A three-phase IECIEE and 2x 10A AC shockproof plugs in specific national versions	○
> Supply voltage 400V, 3/N/PE, 50 Hz	●
> Specific national supply voltage	○
> Full guarding on injection unit operator side	●
> "Supply voltage I/O" switch	○
> Basic equipment to European safety standard (EN 201)	●
> Basic equipment in compliance with national safety standards	○
> Fault indication by flashing lamp	●
> Fault indication by acoustic alarm	○
> Freely assignable output for fault indication	●
> Anti-vibration mounts	●
> Three-colour paint trim: machine bed and injection unit light grey RAL 7035, clamping unit dark grey RAL 7016; cladding light grey RAL 7035, red RAL 3003, ultramarine RAL 5002 or light blue 571C MD	●

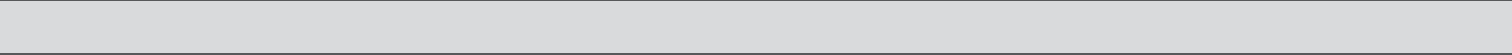
Practical values of melt correction factor for use in calculation of shot weight for some common plastics

Notes



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Notes



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Practical values of melt correction factor for use in calculation of shot weight for some common plastics

Material	Melt correction factor
HD-PE	0,75
LD-PE	0,73
PP	0,73
PS	0,91
SB	0,91
ABS	0,91
SAN	0,91
PA	0,93
PA 6 +30 % GF	1,14
PC	0,97
PC / ABS	0,94
PMMA	0,97
POM	1,15
PET	1,08
PBT	1,08
CA	1,03
CAB	0,98
PVC-w	1,05
PVC-h	1,15

shot weight = melt correction factor x swept volume

The melt correction factor takes into account the change in volume at process temperature and also includes a factor for the flow characteristics of the shut off device on the end of the screw

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