

TF 1350 SC3.0

TWO PLATENS MACHINE WITH STEEL PLATENS

TECHNICAL DATA

DT000 0032 REV2

1.00 MACHINE OVERALL DIMENSIONS

1.01	Length	mm	9.225
1.02	Width	mm	4.060
1.03	Height	mm	3.750
1.04	MACHINE WEIGHT	kg	67.000
1.05	STANDARD MACHINE COLOUR - GREEN/WITHE	RAL	6011/9010
1.06	STANDARD SAFETY COVERS AND GATES COLOUR - YELLOW	RAL	1007
1.07	NOISE LEVEL IN WORKING CONDITIONS (WITHOUT SHOT)	dB	< 80 (A)
1.08	INLET COOLING WATER. MAX TEMPERATURE REQUIRED	°C	20
1.09	INLET COOLING WATER. MIN/MAX PRESSURE REQUIRED	bar	2÷5

2.00 CLOSING GRPOUP

2.01	MAX DIE CLOSING FORCE	kN	13.243
2.02	MAX DIE CLOSING FORCE	tonn	1.350
2.04	MAX HYDRAULINC CYLINDER DIE OPENING FORCE	kN	266
2.05	MAX MOVING PLATEN STROKE WITH MIN DIE HEIGHT	mm	1.400
2.06	MIN DIE HEIGHT	mm	600
2.07	MAX DIE HEIGHT	mm	1.040
2.08	PLATENS DIMENSIONS	mm	1785 x 1785
2.09	TIE-BARS DIAMETER	mm	240
2.10	DISTANCE BETWEEN THE TIE-BARS	mm	1050 x 1050
2.11	MIN DIE SURFACE	mm	790 x 790
2.12	CENTRAL EJECTION FORCE - forward	kN	574
2.13	CENTRAL EJECTION FORCE - backward	kN	574
2.14	CENTRAL EJECTION STROKE	mm	240
2.15	NET DISTANCE BETWEEN TIE-BARS COVERS	mm	1020 x 1020

3.00 INJECTION SYSTEM

3.01	MAX SHOT WEIGHT FOR ALUMINIUM ALLOYS (in accordance with DIN 24480)	kg	21,8
3.02	MAX PROJECTED AREA (specific pressure 400 bar)	cm ²	3.310
3.03	INJECTION PLUNGER STROKE	mm	740
3.04	INJECTION PLUNGER STROKE OVER THE FIXED PLATEN	mm	290
3.05	INJECTION PLUNGER DIAMETERS	mm	90 ÷ 150
3.06	SHOT-SLEEVE POSITIONS	mm	0-250-500
3.07	DYNAMIC INJECTION FORCE	kN	314
3.08	INJECTION FORCE WITH 0/25 bar BACKPRESSURE	kN	1150/1011
3.09	INJECTION PLUNGER BACKWARD FORCE	kN	175
3.10	INJECTION PLUNGER SPEED (without metal)	m/s	9
3.11	MULTIPLICATION TIME *	ms	< 25
3.12	MULTIPLICATION RATIO		3,66

4.00 HYDRAULIC UNIT

4.01	MAX HYDRAULIC FLUID TANK CAPACITY	l	2.500
4,02	TIE-BARS HYDRO-BLOCK PRESSURE	bar	205
4.03	LINE PRESSURE	bar	150
4.04	MULTIPLIED PRESSURE (with 0 bar backpressure)	bar	510
4.05	HYDRAULIC PUMP	g/1'	960

5.00	CONTROL CABINET DIMENSIONS		
5.01	Length	mm	2.400
5.02	Width	mm	600
5.03	Height	mm	2.000
5.04	CONTROL CABINET STANDARD SAFETY REQUIREMENTS		IP 54
5.05	CONTROL CABINET OUTSIDE COLOUR - GREY	RAL	7035
5.07	STANDARD CABLE LENGTH BETWEEN MACHINE AND CONTROL CABINET	m	4

6.00	ELECTRIC EQUIPMENT		
6.01	VOLTAGE	V	400
6.02	FREQUENCY	Hz	50
6.03	PROTECTION VOLTAGE	V	24 DC
6.04	RELAYS VOLTAGE	V	24 DC
6.05	MACHINE INPUT/OUTPUT VOLTAGE	V	24 DC
6.06	MACHINE INSTALLED POWER	kW	90
6.07	PUMP MOTOR RATING	kW	2 x 37

7.00	AIR AND WATER CONSUMPTION TABLE		
7.01	AIR CONSUMPTION (pressure: 5/6 bar)		
7.02	for the injection plunger lubrication	m ³ /h	0,24
7.03	COOLING WATER CONSUMPTION		
7.04	for machine fluid	m ³ /h	5
7.05	for injection plunger	m ³ /h	0,30
7.06	for fixed platen	m ³ /h	0,50

8.00	BEWARE!		
	IN ORDER TO COMPLY WITH THE CE STANDARDS IN FORCE, CUSTOMERS MUST		
8.01	COMPULSORILY PLACE TWO FOOTBOARDS ON BOTH SIDES OF OUR DIECASTING		
	MACHINES		
8.02	height of the footboards from the floor	mm	500

* E' indicato il tempo per raggiungere l'80% della pressione massima moltiplicata misurato con moltiplica impostata su base corsa (non inseriti i programmi di moltiplica con tempo e moltiplica con pressione) e su un ciclo macchina in bianco (senza metallo)