

PLASTAR Si-250IV SPECIFICATIONS

		In-line screw												
		F				G				H				
Injection system	—													
Injection unit type	—													
Injection stroke	in	5.03	5.66	6.29		6.29	7.24	7.87		7.87	8.66			
Screw diameter	in (mm)	1.25(32)	1.41(36)	1.57(40)	1.81(46)	1.57(40)	1.81(46)	1.96(50)	2.16(55)	1.96(50)	2.16(55)	2.36(60)		
Theoretical injection capacity	in ³	6.28	8.97	12.26	16.23	12.26	18.67	23.98	28.99	23.98	31.85	37.96		
Injection capacity(PS)	oz	3.45	4.92	6.73	8.91	6.73	10.25	13.16	15.91	13.16	17.49	20.84		
Injection	Standard	Injection unit	—											
		Injection rate	in ³ /s											
		Max. injection speed	in/s											
		Max. injection pressure	psi											
	High speed	Injection unit	F200BU				G300BU				H370BU			
		Injection rate	10.31	13.06	16.11	21.30	16.11	21.30	25.14	30.45	23.98	28.99	34.48	
		Max. injection speed	8.26				8.26				7.87			
		Max. injection pressure	38290	36259	31270	24163	35389	31270	27006	22741	34083	28427	24163	
	Superhigh speed	Injection unit	F400BU				G450BU				—			
		Injection rate	19.65	24.84	30.69	40.58	23.00	30.45	35.94	43.51				
		Max. injection speed	15.74				11.81							
		Max. injection pressure	38290	36259	31270	24163	35389	31270	27006	22741				
Max. injection holding pressure	psi	38290	36259	27006	21320	35389	28427	24163	19899					
Recovery rate(PS)	oz/s	0.60	0.87	1.10	1.68	0.95	1.53	1.95	2.22	1.95	2.22	2.37		
Screw revolution speed	min ⁻¹	350				300				300				
Nozzle pressing force	U.Ston	2.7				2.7				3.3				

Clamping system	—	Double toggle										
Clamping force	U.Ston	250										
Clamping stroke	in	21.65										
Min. mold height	in	9.84										
Max. mold height	in	26.77										
Tie bar clearance (H×V)	in	24.01×24.01										
Die plate size (H×V)	in	32.28×32.28										
Ejector force	U.Ston	5.82										
Ejector stroke	in	5.90										

Heater capacity	kW	5.85	6.50	7.95	11.20	7.95	11.20	13.50	16.70	13.50	16.70	19.50	
Mold height motor output	kW	0.4											
Nozzle touch motor output	kW	0.2											
Machine dimension <L>	in	225.47	227.67	234.48	232.87	239.68	242.44	251.10	244.05	250.86	257.63		
Machine dimensions <W×H>	in	54.84×71.92											
Power source	—	Three-phase AC200V/200, 230V±10% 50Hz/60Hz											
Main breaker capacity	A	200 (F400BU, G450BU : 225)											
Total electric capacity	kVA	F400BU : 49				G300BU : 43				52			
Cable size	in ²	0.09【0.03】											
230V Class【460V Class ※1】													
Machine weight	U.Ston	12.1				12.4				13.2			

NOTES

- The figures are subject to change without any legal obligation on the part of the manufacture.
- 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.