

2.7 MACHINE SPECIFICATIONS

2.7.1 Injection Specifications- The following tables outline standard measure injection unit specifications. These specifications apply to the outlined injection units for HR-40, HS-40, HCR-40 and HCS-40.

INJECTION UNIT SPECIFICATIONS 22mm FRAME

	A' STYLE	A STYLE	B STYLE	C STYLE
Screw diameter mm	18	22	24	28
Injection capacity, max(oz.GPstyrene)	.73	1.08	1.29	1.76
Theoretical disp. in ³	1.32	1.97	2.35	3.19
Injection pressure, max. psi	37000	30000	25215	18528
Injection rate in ³ /sec	2.08	3.10	3.69	5.03
Injection screw stroke in	3.35	3.35	3.35	3.35
Screw L/D ratio	27:1	21.9:1	20:1	17:1
Screw speed, max. rpm	400	400	400	400
Torque at screw in-lb @psi	540 690	1080 1380	1560 2000	1560 2000
Barrel heaters-#Pyrom. (Barrel/Noz)	3/1	3/1	3/1	3/1
Total heat capacity KW	4.22	4.22	4.22	4.22