

K-TEC 250 S / K-TEC 275 S

Clamping Unit		250 / 275
kN	Clamping Force	2.500 / 2.750
mm	Tie Bar Clearance (H x V)	630 x 630 (750 x 750, 825 x 825) ⁵⁾
mm	Clamping Platens Size (H x V)	970 x 1035 (1.110 x 1.165, 1.110 x 1.195) ⁵⁾
mm	Mold Opening Stroke	850
mm	Distance Between Platens max.	1.195
mm	Mold Installation Height min./max.	345 / -
kg	Mold Weight max. (moving / fixed)	2.400 / 1.150
kN	Opening Force	144 / 163
kN	Ejector Force	85
mm	Ejector Stroke	200
s - mm	Dry Cyle (Euromap 6) ¹⁾	1,8 - 441

Injection Unit		1000		1650		2650	
mm	Screw Diameter	50	60	60	70	70	80
bar	Injection Pressure max.	2.268	1.575	2.144	1.575	2.175	1.665
cm ³	Stroke Volume max.	441	636	763	1.039	1.213	1.583
g	Injected Weight max. (PS)	401	579	694	946	1.104	1.441
mm	Screw Stroke	225		270		315	
mm	Unit Stroke	525		525		525	
kN	Nozzle Holding Force	63		115		115	
cm ³ /s	Injection Rate	1.480	2.000	1.480	2.000	1.550	2.000
min ⁻¹	Screw Speed	320		275		240	
g/s	Recovery Rate ²⁾	52	65	60	67	73	85
L/D	Active Screw Length ³⁾	22	18,3	22	18,6	22	19,3
qty	Number of Heating Zones	4 + 1		4 + 1		4 + 1	
kW	Total Heating Capacity	18,2	18,2	22,7	22,7	30,7	30,7

General Data		250 / 275 - 1000	250 / 275 - 1650	250 / 275 - 2650
kW	Total Connected Power ⁴⁾	68	71	77
m	Machine Dimensions (L x W x H)	7,49 x 2,16 x 2,66	7,76 x 2,16 x 2,66	8,22 x 2,16 x 2,66
kg	Net Weight	15.500	16.000	18.500
l	Oil Tank Capacity	680	680	680

- 1) Stroke = 70% Tie Bar Clearance, 70% Clamping Force
- 2) For PS: 10 s Cycle Time, 1,5 D Screw Stroke
- 3) Other L/D on Request
- 4) According to Ferromatik Milacron Specification
- 5) Option

2nd Injection Unit Optional with Position						
111 : V - H - PB - T	mm	18	25	30	mm	Screw Diameter
265 : V - H - PB - T	mm	30	35	40	mm	Screw Diameter
493 : V - H - PB - T - VM	mm	40	45	50	mm	Screw Diameter
1000 : H - HM	mm	45	50	60	mm	Screw Diameter

V = Vertical
H = Horizontal
PB = Piggy Back
T = Traversing
VM = Vertical Monosandwich
HM = Horizontal Monosandwich