

K-TEC 400 S / K-TEC 450 S

Clamping Unit		400 / 450
kN	Clamping Force	4.000 / 4.500
mm	Tie Bar Clearance (H x V)	825 x 825 (900 x 900, 1.000 x 1.000) ⁵⁾
mm	Clamping Platens Size (H x V)	1.195 x 1.267 (1.270 x 1.345, 1.370 x 1.445) ⁵⁾
mm	Mold Opening Stroke	1.000
mm	Distance Between Platens max.	1.420
mm	Mold Installation Height min./max.	420 / -
kg	Mold Weight max. (moving / fixed)	4.000 / 2.000
kN	Opening Force	181 / 205
kN	Ejector Force	85
mm	Ejector Stroke	200
s - mm	Dry Cyle (Euromap 6) ¹⁾	3 - 578

Injection Unit		1650		2650		4400		
mm	Screw Diameter	60	70	70	80	80	90	100
bar	Injection Pressure max.	2.144	1.575	2.175	1.665	2.431	1.921	1.556
cm ³	Stroke Volume max.	763	1.039	1.213	1.583	1.810	2.290	2.825
g	Injected Weight max. (PS)	694	946	1.104	1.441	1.647	2.084	2.571
mm	Screw Stroke	270		315		360		
mm	Unit Stroke	525		525		525		
kN	Nozzle Holding Force	115		115		115		
cm ³ /s	Injection Rate	1.480	2.000	1.550	2.000	2.250	2.850	3.550
min ⁻¹	Screw Speed	275		240		190		
g/s	Recovery Rate ²⁾	60	67	73	85	80	103	128
L/D	Active Screw Length ³⁾	22	18,6	22	19,3	22,5	20	18
qty	Number of Heating Zones	4 + 1		4 + 1		4 + 1		
kW	Total Heating Capacity	22,7	22,7	30,7	30,7	48,4	48,4	48,4

General Data		400 / 450 - 1650	400 / 450 - 2650	400 / 450 - 4400
kW	Total Connected Power ⁴⁾	71	77	109
m	Machine Dimensions (L x W x H)	8,38 x 2,33 x 3,03	8,86 x 2,33 x 3,03	9,56 x 2,33 x 3,03
kg	Net Weight	26.000	27.000	30.000
l	Oil Tank Capacity	1.000	1.000	1.000

- 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

2. Spritzeinheit optional mit Anordnung		2nd Injection Unit Optional with Position						
111 : V - H - PB - T								
	Schneckendurchmesser	mm	18	25	30	mm	Screw Diameter	
265 : V - H - PB - T								
	Schneckendurchmesser	mm	30	35	40	mm	Screw Diameter	
493 : V - H - PB - T								
	Schneckendurchmesser	mm	40	45	50	mm	Screw Diameter	
970 : T 1000 : H - HM								
	Schneckendurchmesser	mm	45	50	60	mm	Screw Diameter	
2650 : HM								
	Schneckendurchmesser	mm	70	80		mm	Screw Diameter	
4400 : HM								
	Schneckendurchmesser	mm	80	90	100	mm	Screw Diameter	

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