

# CARAT 220 compact

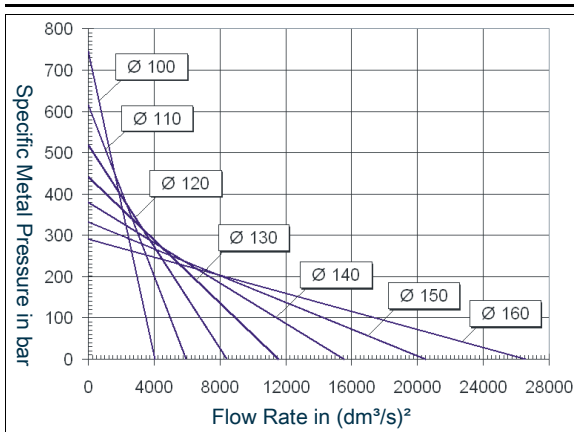
## Injection Unit

Injection Force dynamic	kN	583
Injection Force Intensified	kN	1530
Plunger Stroke	mm	1050
Maximum plunger Velocity	m/s	8.11
Injection Height	mm	0/-420

## Closing Unit

Maximum Locking Force	kN	22000
Ejector Force	kN	500
Ejector Stroke	mm	240
Die Height	mm	772 - 1600
Die opening Stroke	mm	1400
Smallest permissible Die Dimensions	mm	1160 x 1160
Maximum permissible Surface Pressure	N/mm <sup>2</sup>	100

## p/Q<sup>2</sup> Diagram



## Production Data

Plunger Diameter	mm	100	110	120	130	140	150	160
Maximum Casting Volume	cm <sup>3</sup>	5495	6648	7912	9286	10770	12364	14067
Maximum Casting Weight Al	kg	13.7	16.62	19.78	23.21	26.92	30.9	35.2
Maximum Metal Pressure	bar	1949	1610	1353	1153	994	866	761
Maximum Projected Area	cm <sup>2</sup>	1129	1365	1625	1907	2212	2540	2890

Casting Weight =  $\frac{2}{3}$  x Plunger Stroke x Plunger Surface x Density (Al: 2,5 kg/dm<sup>3</sup>)

## Hydraulic System

Installed Load	kW	115
Maximum System Pressure	bar	210
Filling Quantity	dm <sup>3</sup>	2700
Water Cooling	m <sup>3</sup> /h	3.6

## Central Lubrication

Installed Load	kW	0.1
Filling Quantity	dm <sup>3</sup>	10

## Nitrogen/Piston Accumulator

Maximum idle Pressure	bar	160
Filling Quantity	dm <sup>3</sup>	325

## Nitrogen/Intensifier

Maximum idle Pressure	bar	160
Filling Quantity	dm <sup>3</sup>	65

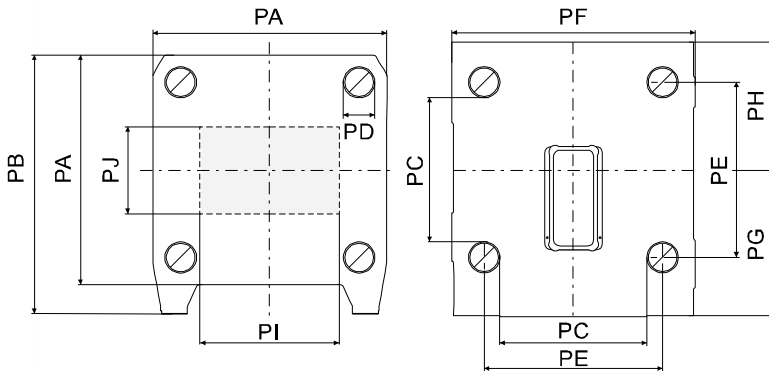
## Simultaneous hydraulic unit

Usable volume	dm <sup>3</sup>	36
Available accumulator pressure	bar max	200



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## Platen

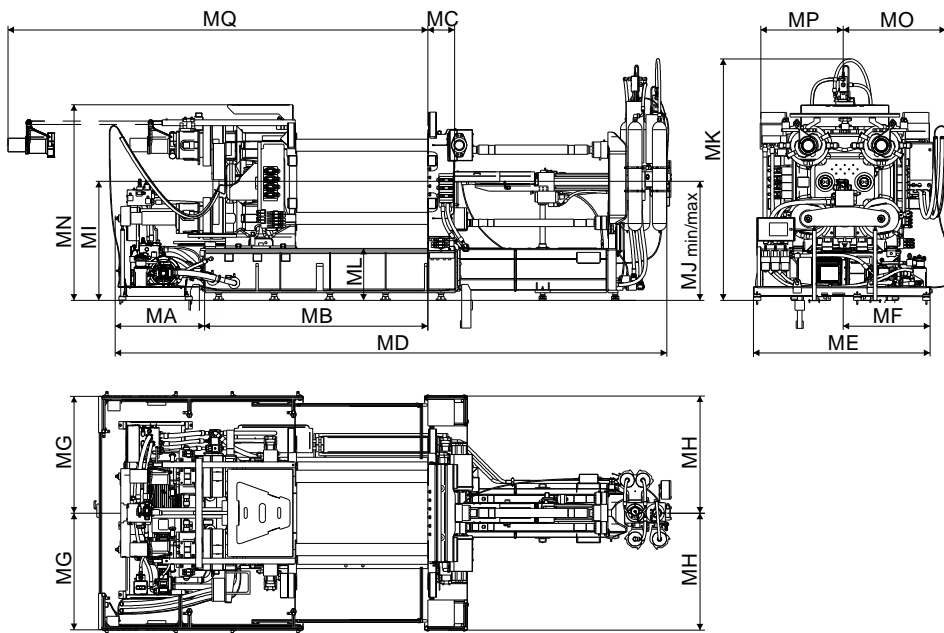


■ Ejector Plate

PA	2240
PB	2698
PC	1400
PD	280
PE	1680
PF	2240
PG	1528
PH	1170
PI	1330
PJ	1040
mm	

## Dimension/Weight

Weight of machine ready for production = 130000 kg



MA	2030
MB	4845
MC	580
MD	11657
ME	3035
MF	1302
MG	2270
MH	2270
MI	2340
MJmin	1920
MJmax	2340
MK	4696
ML	856
MN	3975
MO	1999
MP	1945
MQ	9418
mm	

## Control

Installed Load at 400V / 50 Hz = 115 kW

P) Option 670

