

# CARAT 400 compact

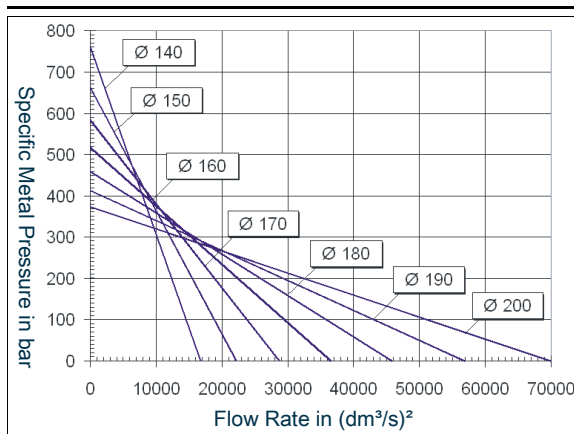
## Injection Unit

Injection Force dynamic	kN	1165
Injection Force Intensified	kN	2792
Plunger Stroke	mm	1400
Maximum plunger Velocity	m/s	8.42
Injection Height	mm	0/-600

## Closing Unit

Maximum Locking Force	kN	40000
Ejector Force	kN	1000
Ejector Stroke	mm	280
Die Height	mm	1044 - 2100
Die opening Stroke	mm	1800
Smallest permissible Die Dimensions	mm	1370 x 1370
Maximum permissible Surface Pressure	N/mm <sup>2</sup>	100

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



## Production Data

	mm	140	150	160	170	180	190	200
Plunger Diameter	mm	140	150	160	170	180	190	200
Maximum Casting Volume	cm <sup>3</sup>	14360	16485	18756	21174	23738	26449	29307
Maximum Casting Weight Al	kg	35.9	41.21	46.89	52.93	59.34	66.1	73.3
Maximum Metal Pressure	bar	1815	1580	1389	1230	1097	985	889
Maximum Projected Area	cm <sup>2</sup>	2204	2530	2879	3250	3643	4060	4499

Casting Weight =  $\frac{1}{3} \times$  Plunger Stroke x Plunger Surface x Density (Al: 2,5 kg/dm<sup>3</sup>)

## Hydraulic System

Installed Load	kW	170
Maximum System Pressure	bar	210
Filling Quantity	dm <sup>3</sup>	4650
Water Cooling	m <sup>3</sup> /h	4.8

## 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>	520

## Nitrogen/Intensifier

Maximum idle Pressure	bar	140
Filling Quantity	dm <sup>3</sup>	140

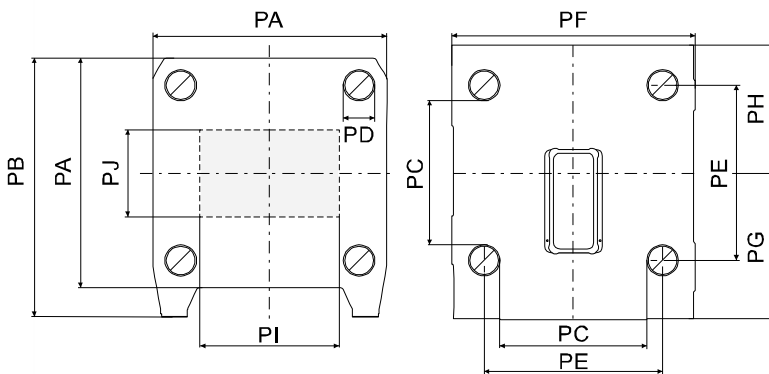
## Simultaneous hydraulic unit

Usable volume	dm <sup>3</sup>	88
Available accumulator pressure	bar max	200



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## Platen

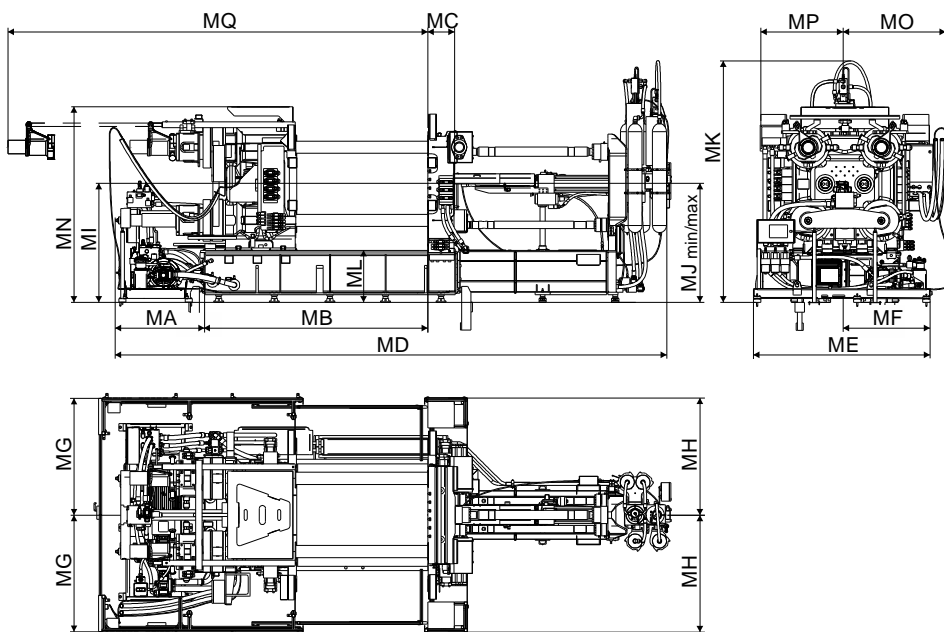


■ Ejector Plate

PA	2970
PB	3557
PC	1800
PD	390
PE	2190
PF	2970
PG	2032
PH	1525
PI	1540
PJ	1200
mm	

## Dimension/Weight

Weight of machine ready for production = 273000 kg



MA	2405
MB	6595
MC	790
MD	15110
ME	3359
MF	1226
MG	2870
MH	2870
MI	2876
MJmin	2276
MJmax	2876
MK	5219
ML	910
MN	5033
MO	2436
MP	2180
MQ	12470
mm	

## Control

Installed Load at 400V / 50 Hz = 170 kW

P) Option 670

