

UN1850D1 Specifications

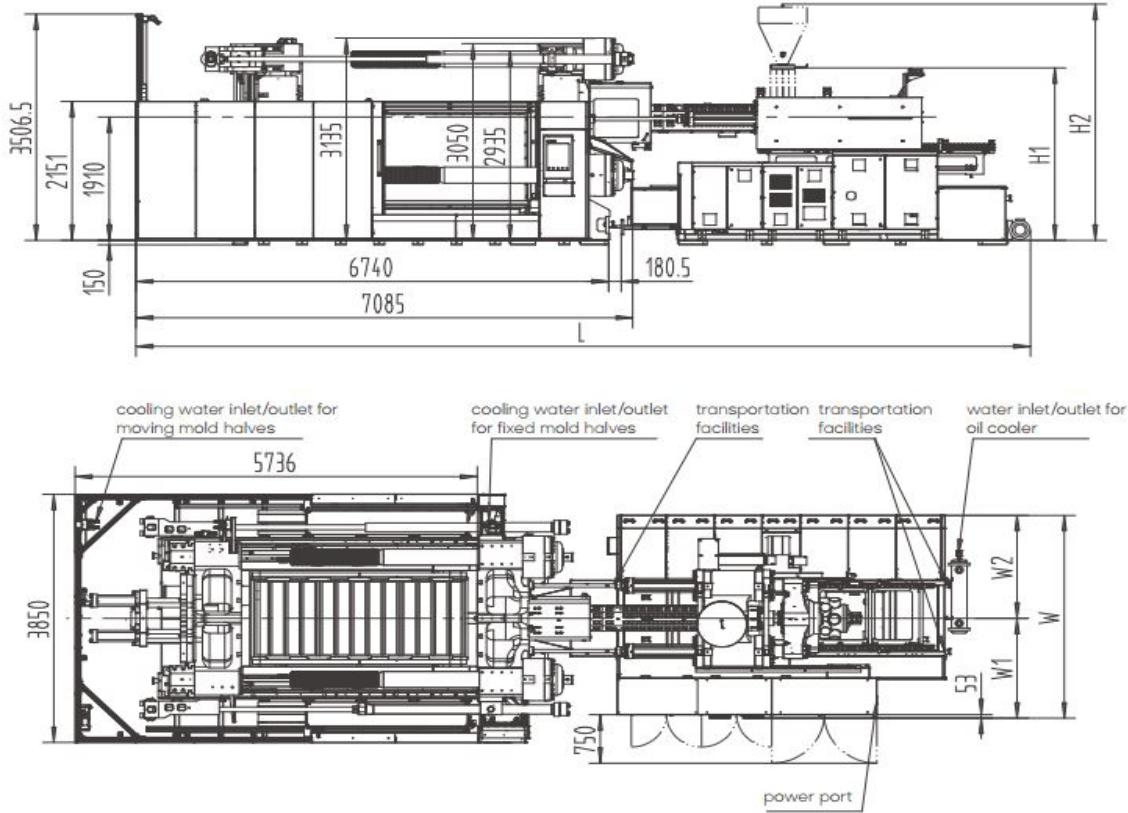
FEATURES

- › European, oil-cooled, two-headed motor-driven servo drive delivers fast response and maximise energy efficiency
- › Austrian KEBA control with dual CPU is stable, fast & accurate with 12" TFT colour touch screen display
- › Based on European design technology
- › High rigidity clamping unit delivers stability & accuracy, combined with uniform stress distribution on the tie bars
- › Rexroth highly responsive dual proportional valves on clamping unit offers accurate repeatability
- › L-shape guide rails deliver platen movement accuracy up to 0.05mm
- › Mould open position accurate to $\pm 0.2\text{mm}$
- › Tie bars independent of moving platen offers precision & speed
- › Dry cycle times faster than toggle lock machines
- › Small footprint compared to traditional three platen design
- › Low pressure & highly sensitive mould protection
- › Integrated linear guide rails on injection unit offer low resistance and accuracy
- › Repeatability of part weight $\leq 3\%$
- › Durable ceramic heater bands
- › Time, position or pressure switchover for holding phase start
- › Ultrasonic displacement sensor
- › Central lubrication for injection unit
- › European oil seals & guide rings
- › Double core pull
- › Double air blast circuit
- › Euromap robot interface & Euromap mounting
- › Hydraulic ejector
- › T-Slot platen
- › Auto mould height adjustment
- › Oil pre-heating
- › IP54 electrical enclosure
- › Precise filtration and independent cooling system
- › Service, warranty & parts supported by our in-house engineers

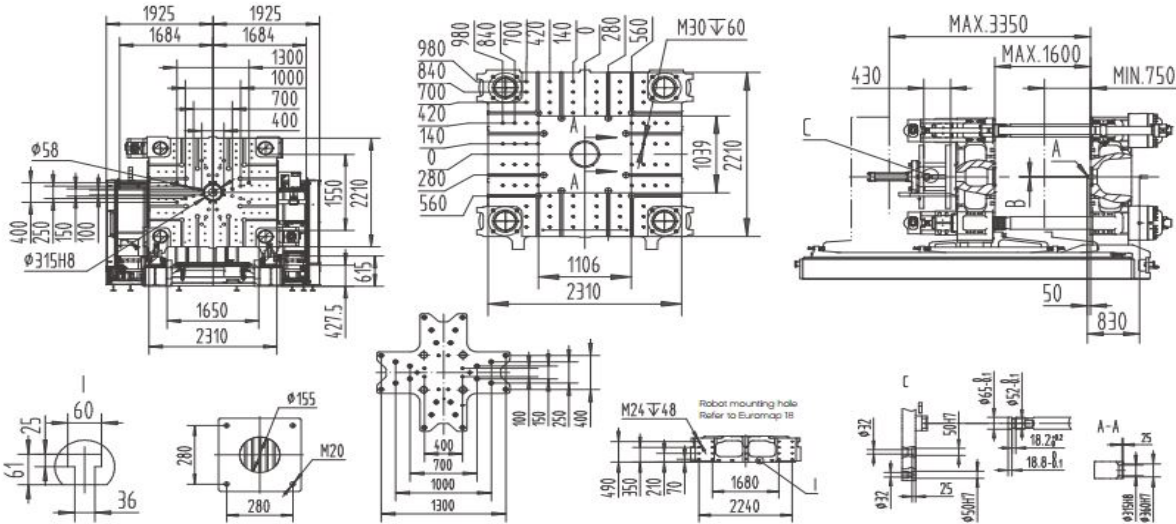


INJECTION UNIT		9000				10900				14500			18500			
		A	B	C	D	A	B	C	D	A	B	C	A	B	C	D
Screw diameter	mm	100	108	116	125	108	116	125	135	125	135	145	135	145	155	165
Shot volume	cm ³	4320	5038	5813	6748	5222	6024	6995	8159	7977	9304	10733	10020	11559	13208	14968
Shot weight	g	3974	4636	5348	6208	4804	5542	6435	7506	7339	8560	9875	9218	10634	12152	13770
Injection pressure	bar	2090	1790	1550	1340	2100	1820	1570	1350	1810	1560	1350	1840	1600	1400	1230
Screw L:D ratio		21.6	20	21.6	20	23.7	22	21.6	20	23.6	22	20	23.6	22	22	20
Injection rate	cm ³ /s	766	894	1031	1197	815	940	1092	1273	1316	1536	1772	1301	1502	1717	1946
Max. injection speed	mm/s	97.6				89				107			91			
Screw stroke	mm	550				570				650			700			
Max. screw speed	r/min	128				112				120			120			
Barrel heating zone no.	PCS	7				8				8			8			
CLAMPING UNIT																
Clamping force	kN	18500														
Opening force	kN	1230														
Platen size	mm	2310 x 2210														
Distance between tie-bars	mm	1650 x 1550														
Mould thickness (min-max)	mm	750 - 1600														
Opening stroke	mm	2600 / 1750														
Max. daylight	mm	3350														
Ejector force	kN	460														
Ejector stroke	mm	430														
Ejector number	PCS	25														
ELECTRICAL & HYDRAULIC UNITS																
System pressure	MPa	17.5 / 30				17.5 / 30				17.5 / 30			17.5 / 30			
Pump motor	kW	110 + 7.5				89 + 37 + 7.5				89 + 66 + 11			89 + 66 + 11			
Total power	kW	169.3	169.3	178.4	178.4	199.9	199.9	204.1	204.1	253.7			263.8			
Heater power	kW	51.76	51.76	60.9	60.9	66.37	66.37	70.63	70.63	87.7			97.8			
GENERAL																
Oil tank capacity	L	1400				1600				2100			2100			
Machine dimensions (LxWxH)	m	12 x 3.9 x 3.5				12.4 x 3.9 x 3.5				12.8 x 3.9 x 3.7			12.8 x 3.9 x 3.7			
Machine weight	T	50 + 11				50 + 13				50 + 16.5			50 + 18.5			
Max. mold weight	T	42				42				42			42			

MACHINE DIMENSIONS



PLATEN DRAWINGS



Model	A	B	L	H1	H2	W	W1	W2	Main power cord size	Full-load current	Bearing capacity of foundation	Mold cooling water ports	Cooling water flow (mold excluded)	Cooling water pressure	Compressed air pressure
	mm	mm	mm	mm	mm	mm	mm	mm	mm ²	A	t/m ²	n×L/min	L/min	bar	bar
UN1850D1-IU9000	SR15	$\phi 4.5$	11960	2479	3321	2906	1450.5	1455.5	95	316.71	10.5	(8+8)×11	100	3~4	5~6
UN1850D1-IU10900	SR20	$\phi 6$	12430	2514	3356	2906	1450.5	1455.5	120	370.88	10.5	(8+8)×11	100	3~4	5~6
UN1850D1-IU14500	SR20	$\phi 8$	12756	2633	3620	3146	1548	1598	150	470.42	10.5	(8+8)×11	250	3~4	5~6
UN1850D1-IU18500	SR20	$\phi 8$	12756	2649	3636	3146	1548	1598	150	491.15	10.5	(8+8)×11	250	3~4	5~6