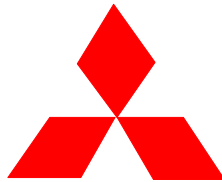


MITSUBISHI INJECTION MOLDING MACHINE
SPECIFICATIONS

1200MGV-240



MHI Injection Molding Machinery, Inc.

Ref: MHI-PT document # ED-1D33-4407

1200MGV-240

CLAMP UNIT

ITEM		UNIT	SPECIFICATION		NOTES	
			Inch	(Metric)		
Max. Mold Clamping Force		US. ton	1157	(1050)		
Mold Opening Force		(Metric ton)	68.3	(62.0)		
Mold Closing Speed	High Speed	ft/min (m/min)	121.4	(37)		
	Low Speed		6.56	(2.0)		
Mold Opening Speed	Detaching Speed		6.56	(2.0)		
	High Speed		121.4	(37)		
	Low Speed		6.56	(2.0)		
Platen Size	(H)		inch (mm)	70.87	(1800)	
	(V)			66.93	(1700)	
Clearance between Tie Bars	(H)			51.18	(1300)	
	(V)	47.24		(1200)		
Maximum Clamp Stroke				68.9	(1750)	
Maximum Daylight				89.76	(2280)	
Mold Thickness	Minimum			20.87	(530)	
	Maximum			43.31	(1100)	
Hydraulic ejector	Force	US ton (Metric ton)		22.3	(20.2)	
	Stroke	inch (mm)		7.9	(200)	
	Forward Speed	ft/min	15.1	(4.6)		
	Retract Speed	(m/min)	19.7	(6.0)		
Maximum Mold Size	Hor. load	(H)	70.87	(1800)		
		(V)	50.79	(1290)		
	Ver. Load	(H)	46.85	(1190)		
		(V)	66.93	(1700)		
Minimum Mold Size	(H)		29.92	(760)	Full clamp tonnage	
	(V)		29.92	(760)		
Maximum Mold weight		lbs (kg)	31	(14)	Moving side is half of this weight	

1200MGV-240

INJECTION UNIT

ITEM		UNIT	SPECIFICATION		NOTES
			Inch	(Metric)	
Theoretical Injection Volume		cu.in (cm ³)	413.7	(6780)	
Inj. Shot Weight	PS	oz	220.11	(6240)	
	PE	(g)	177.07	(5020)	
Plasticizing Capacity	PS	lbs/hr	1623	(735)	
		(kg/hr)			
Max. Injection Pressure		psi (kg/cm ²)	25667	(1805)	
Injection Rate	Standard	cu.in /sec	58.9	(965)	
	Option	(cm3/sec)	76.0	(1245)	
Injection Horse Power		HP (PS)	233		
Screw Diameter		in (mm)	4.72	(120)	
Screw L/D		---		22	
Screw Stroke		in (mm)	23.62	(600)	
Screw Speed	High speed	rpm	~ 125		
	Mid. speed		~ 83		
	Low speed		~ 62		
Nozzle protrusion		in (mm)	1.18	(30)	
Nozzle Touch Force		US ton (metric ton)	6.83	(6.2)	

1200MGV-240**GENERAL**

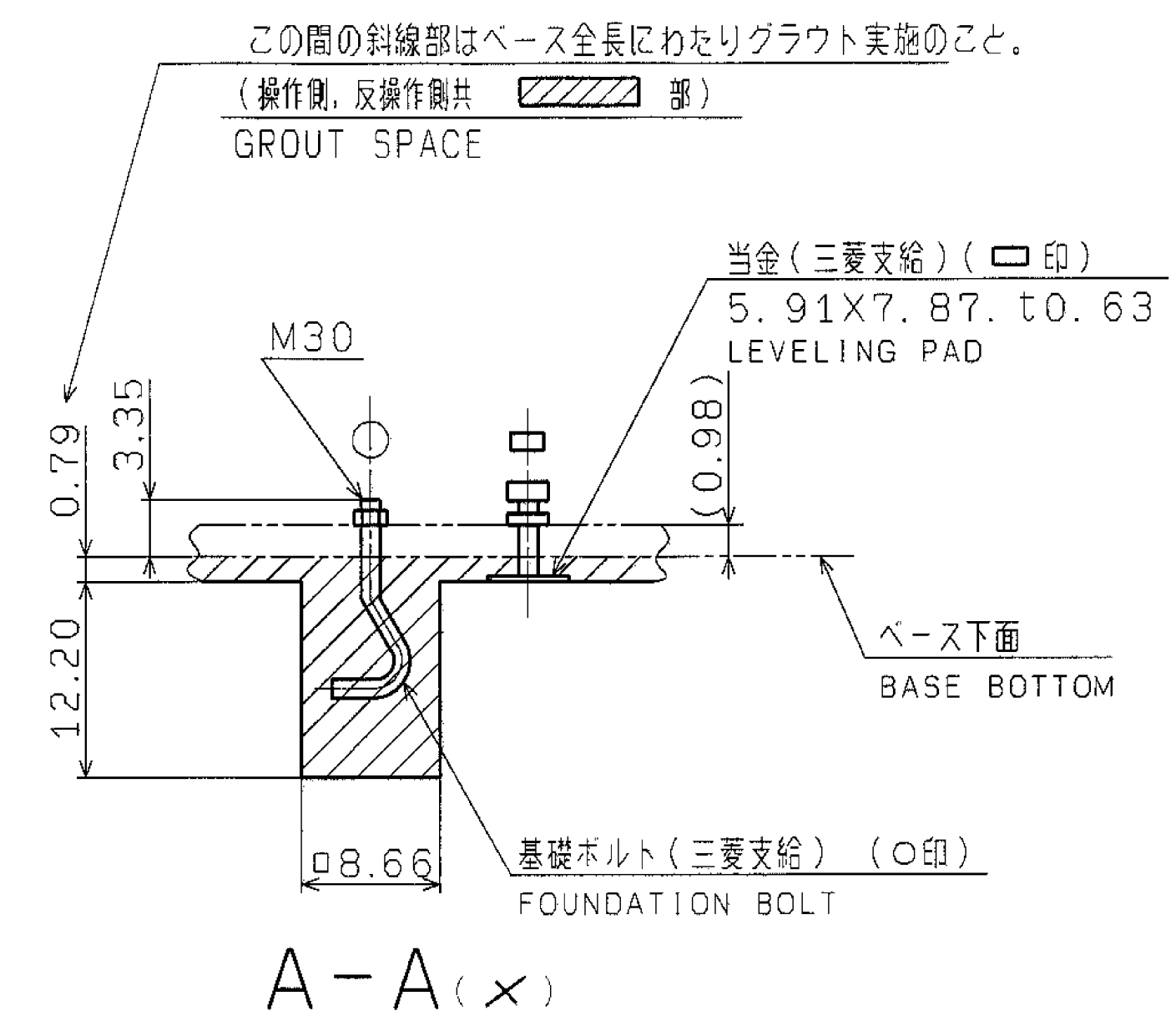
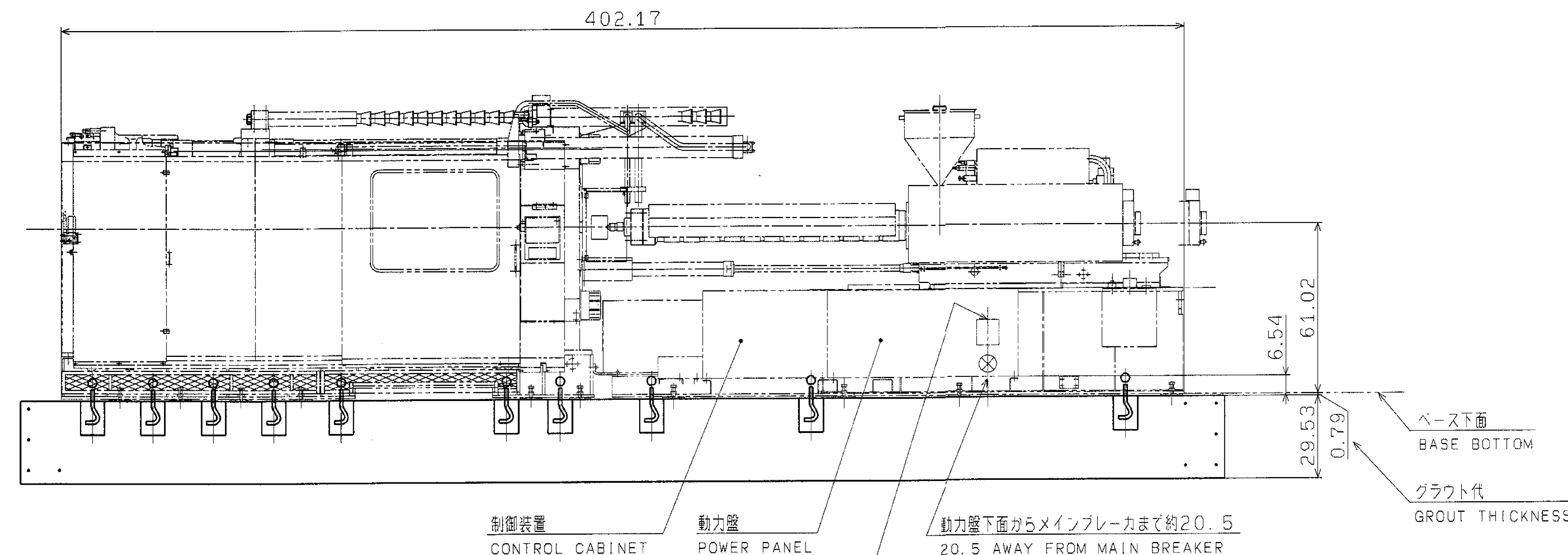
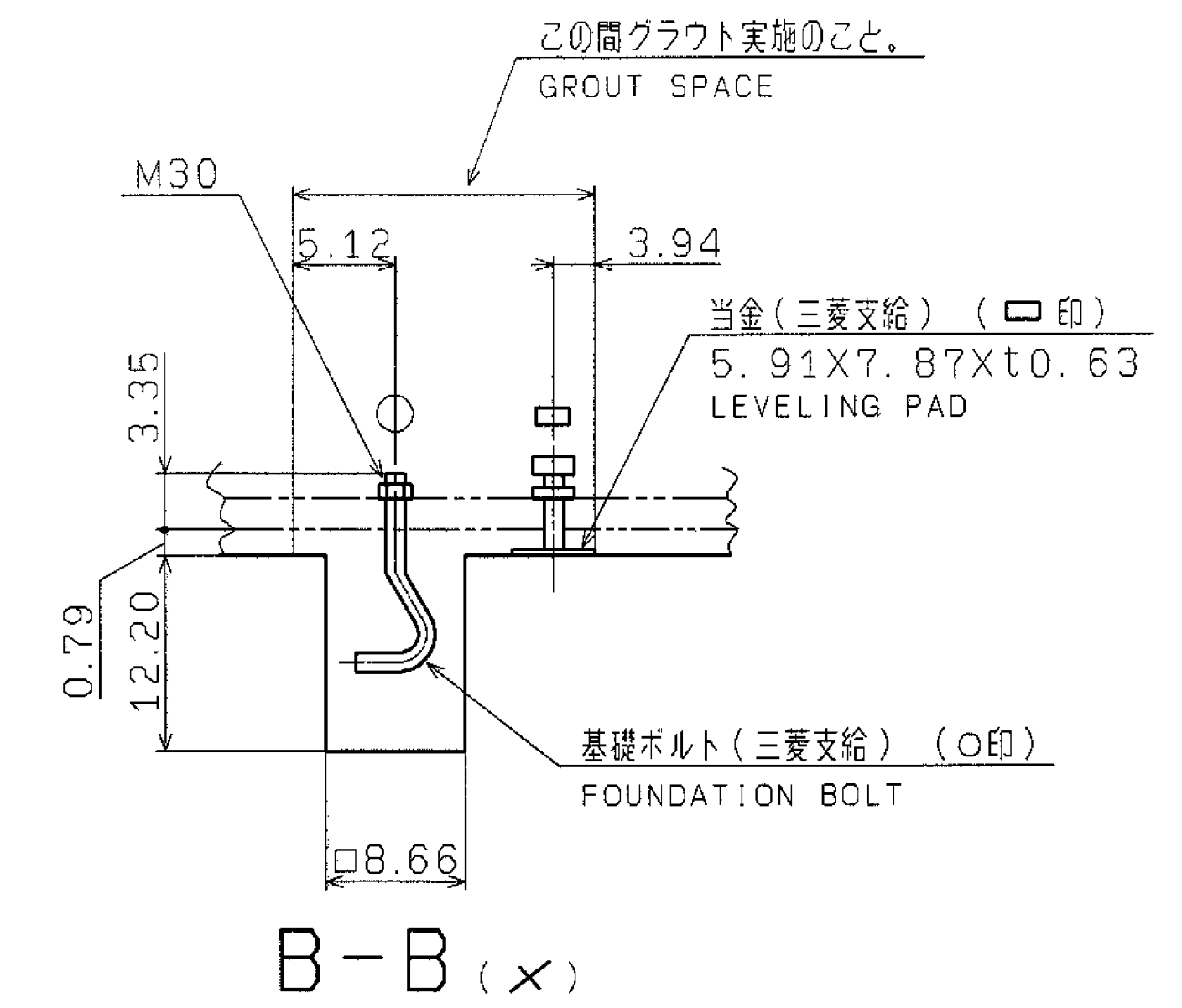
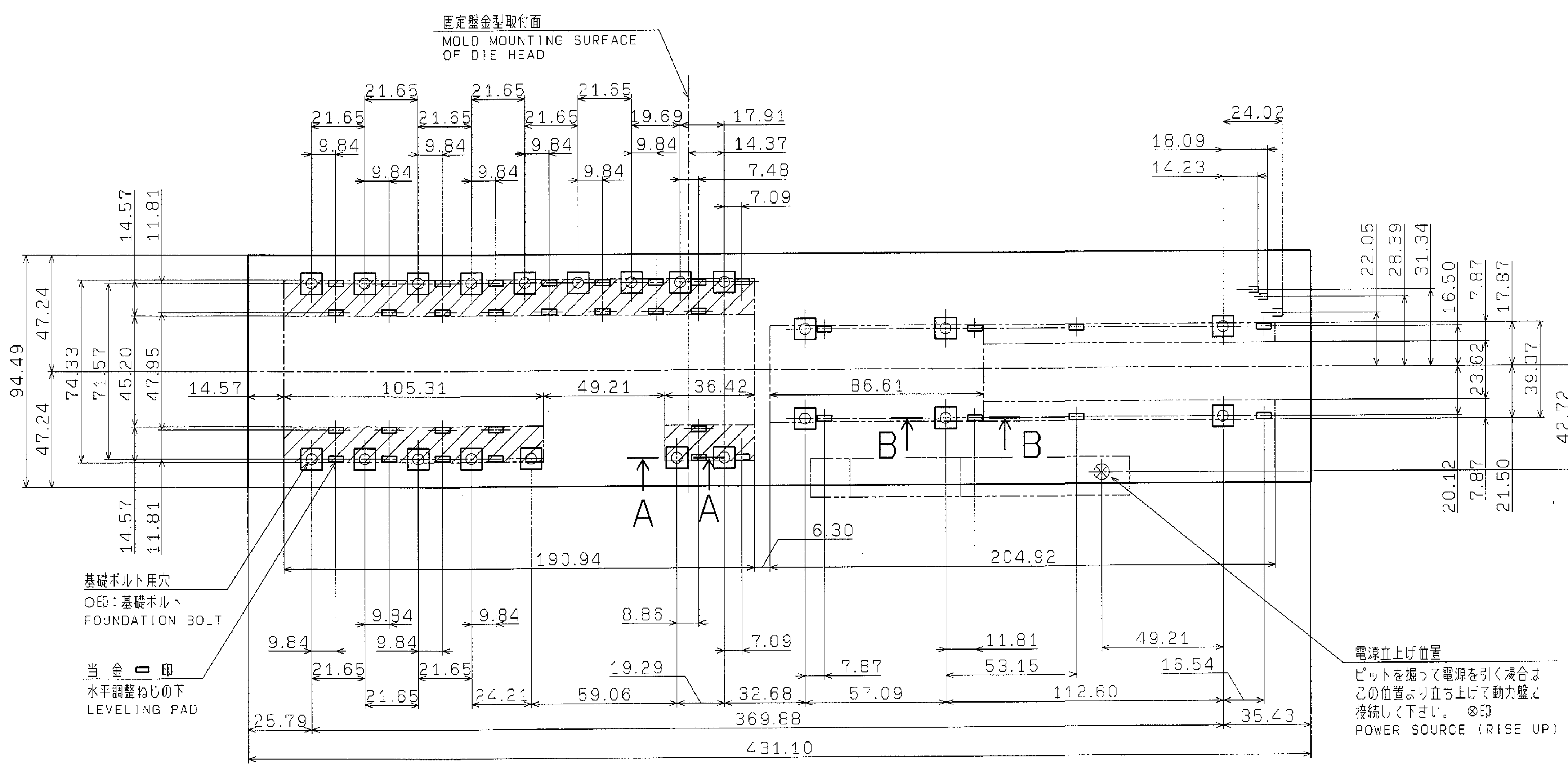
ITEM	UNIT	SPECIFICATION		NOTES
		Inch	(Metric)	
Electric Motor Capacity	HP (kw)	147	(110)	2 x 55kw
Electric Heater Capacity for Screw Barrel	kw	53.2		
Electric Heater Capacity for standard Nozzle		0.3		
Oil reservoir Capacity	US gal (ltr)	462.4	(1750)	
Lub. Oil Capacity for Bearing Housing	US gal (lit)	2.51	(9.5)	
Overall Dimension	(L)	ft	34.78	(10.6)
	(W)	(m)	9.84	(3.00)
	(H)		8.53	(2.60)
Machine Weight	US ton (metric ton)	51.8	(47.0)	

Electric Capacity		KVA	202.0	
Full Load Current		A	254.0	460 V , 60 Hz
Cooling Water supply for Heat exchanger	us gpm (lit/min)	18.5	(70)	Soft water, 90 °F or below
Cooling Water supply for Feed Throat		7.9	(30)	

Remarks

1. Injection weight, injection rate and plasticizing capacity are dependent upon molding conditions and resin used.
2. Specifications are subject to change without notice.
3. The "electric capacity" is the rated capacity of the standard machine and any increase in capacity (i.e. additional outlets, etc.) is not included.

1 50
2 150
3
4



図形
寸法
標準
公称
公差
表示
加工
条件
等
事項

3FK91302
CADAM
A9/07/06
18:32

03FTH

[CAD区分]
A: 全CAD
B: 半CAD
C: フラック: 手書き

[図種区分]
A: 加工品
B: 鋳物
C: 購入品
D: 組立品
P: 電加工品
R: 電鍍品
S: 電ソド品
T: 電鍍品

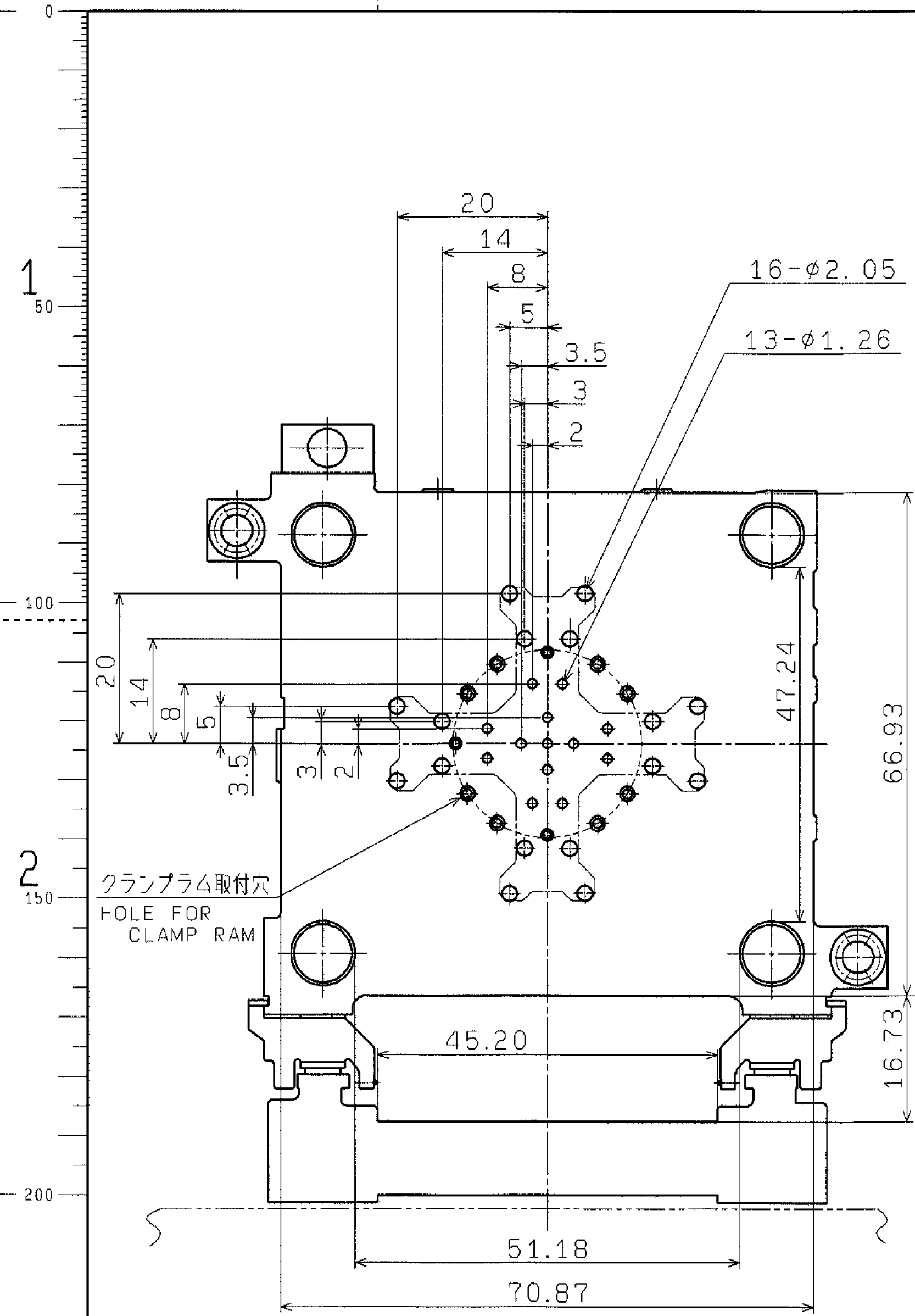
CAD	M	A
図種	AD	
部		
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MODEL 1200MG5-240	三角法 3RD ANGLE PROJECTION	SCALE 1/40	図名 基礎図
APPROVED	CHECKED	DRAWN 江川	DWG. NO. 3FK91302
MITSUBISHI HEAVY INDUSTRIES PLASTIC TECHNOLOGY CO., LTD.			REF. DWG. NO. 3FK91086

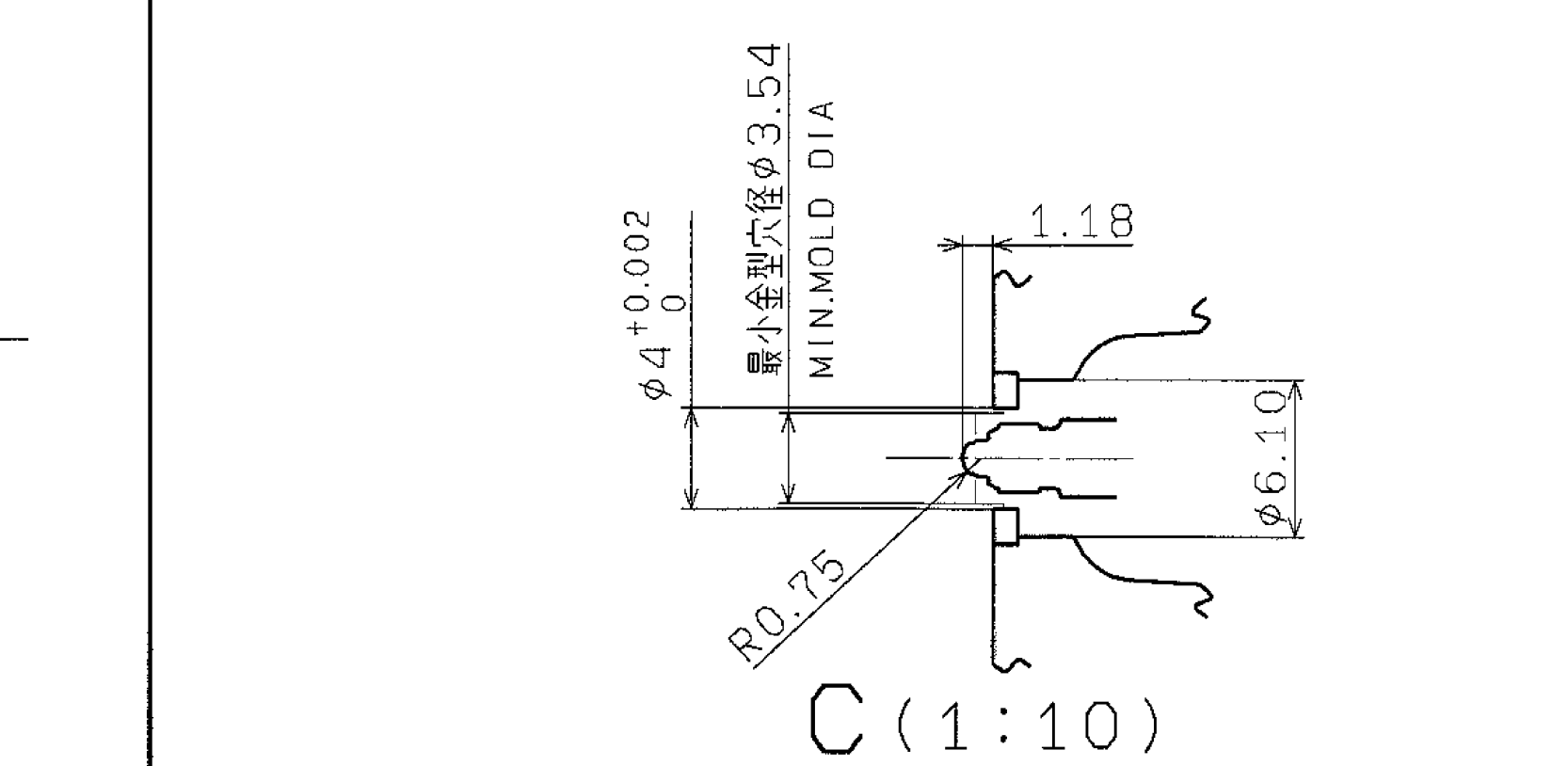
MIMM 標準
(E PACT' 92対応)

3FK91302
ON DWG

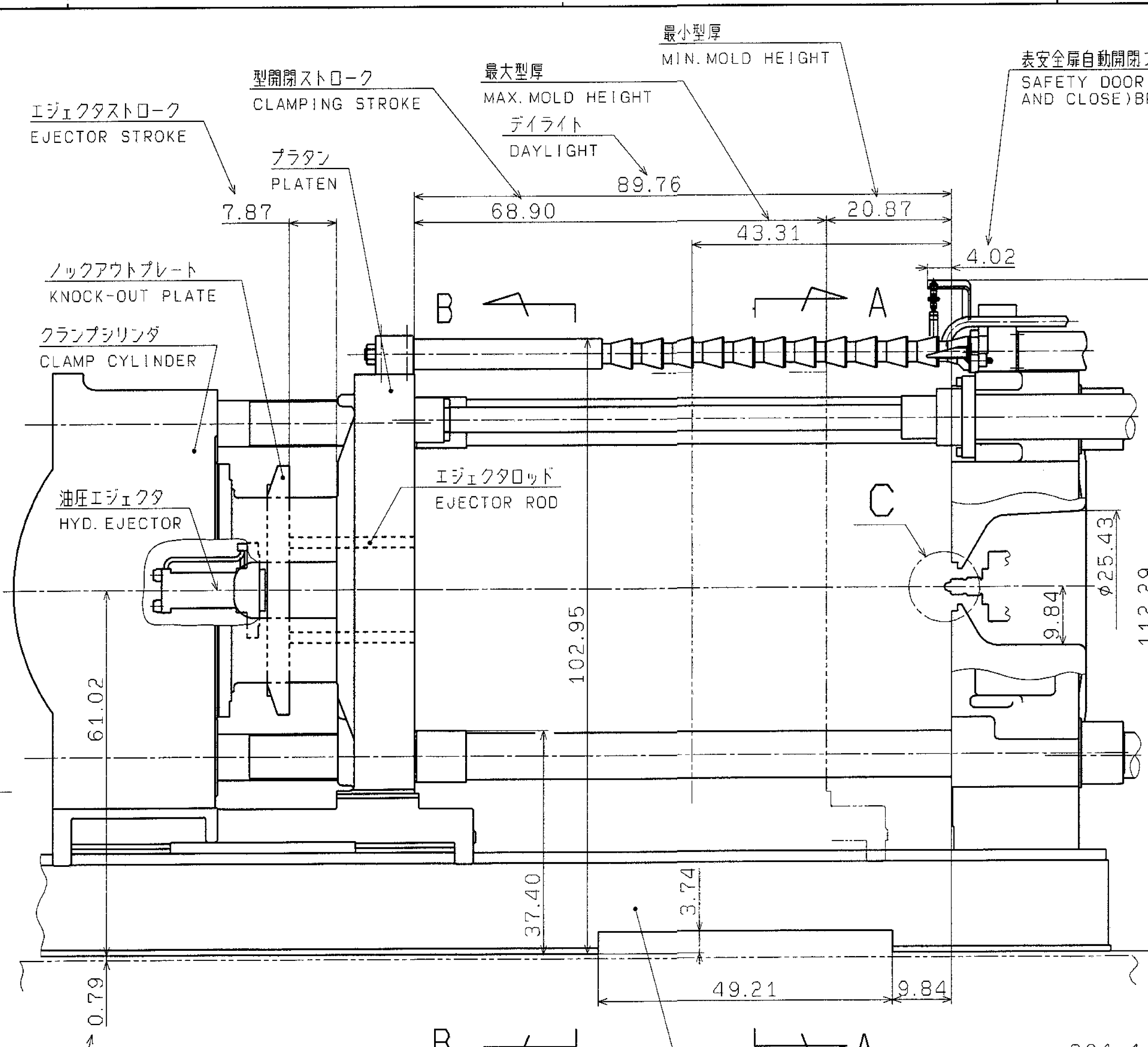
図番	3FK93871	改訂	09/06/06	理由	標準
製図	09/06/06	承認			



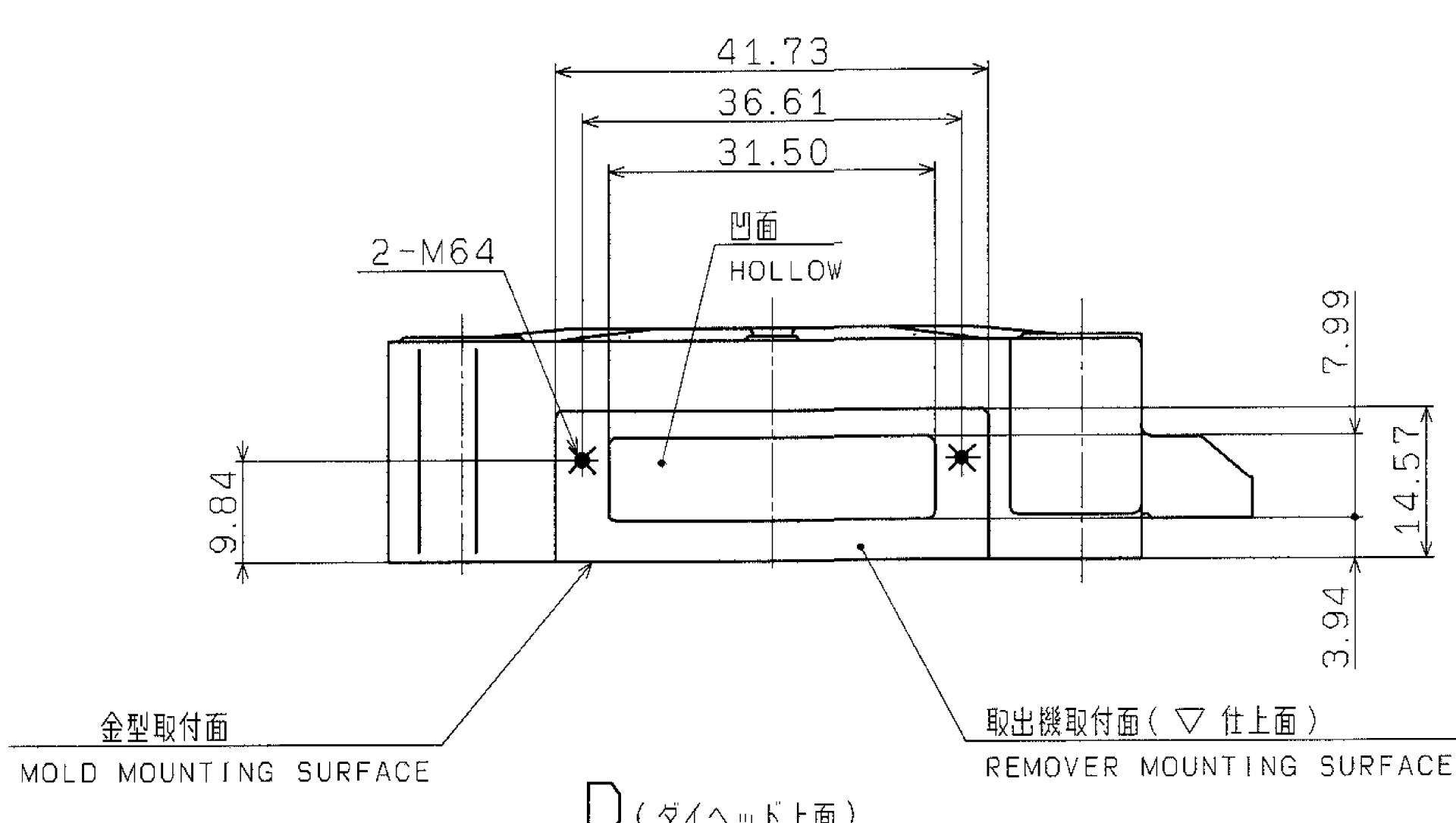
B-B
(エジェクタ穴配置)
(ARRANGEMENT OF EJECTOR HOLES)



C (1:10)



A-A
(金型取付ねじ穴の配置は
ダイヘッド、プラテン共同)
(ARRANGEMENT OF MOLD ATTACHMENT SCREW HOLES
ON DIE HEAD AND PLATEN IS SIMILAR.)



D (ダイヘッド上面)
(TOP VIEW OF DIE HEAD)

204-1-8UNC
DEPTH 1.97

- MIN. MOLD SIZE: 29.92x29.92 (WHEN CLAMPING FORCE IS 1157US ton)
- HEX0.95x20.83 λ -4PIECES, HEX1.61x20.83 λ -4PIECES, EJECTOR RODS ARE SUPPLIED WITH MACHINE (EJECTOR ROD: WITH MALE SCREW 3/4-10UNC; HEX0.95 & 1-8UNC; HEX1.61) WHEN OTHER EJECTOR RODS ARE REQUIRED THEY SHALL BE PREPARED BY CUSTOMER
- ALL DIMENTION ARE SHOWN IN INCH.

- 最小金型寸法は、760x760mm (型締力10297kN (1050tf)の時)
- 対辺24mm六角x529 λ 4本, 対辺41mm六角x529 λ 4本のエジェクタロッド (兼-10UNCねじ込み式: 対辺24, 1-8UNCねじ込み式: 対辺41) が付属します。上記以外のものが必要な場合は、事前にご準備願います。
- 図中の単位はINCH表示です。

図式 MODEL	1200MG5	三角法	3RD ANGLE PROJECTION	縮尺 SCALE	1/20	名称 NAME	金型取付寸法図
図番 NEXT ASS'Y	B					DIE SPACE	
承認 APPROVED	検査 CHECKED	製図 DRAWN	製図 B/M	製図 DWG. NO.	3FK93871		
		江川		18.9.7		SUUFFIX MARK PAGE	

