

**610MMJ-110**

**CLAMP UNIT**

ITEM		UNIT	SPECIFICATION		NOTES	
			Inch	( Metric )		
Max. Mold Clamping Force		US. ton	606	(550)		
Mold Opening Force		( Metric ton)	30.3	(27.5)		
Mold Closing Speed	High Speed	ft/min ( m/min )	164.1	(50)		
	Low Speed		6.56	(2.0)		
Mold Opening Speed	Detaching Speed		6.56	(2.0)		
	High Speed		164.1	(50)		
	Low Speed		6.56	(2.0)		
Platen Size	( H )		inch ( mm )	49.21	(1250)	
	( V )	49.21		(1250)		
Clearance between Tie Bars	( H )	33.86		(860)		
	( V )	33.86		(860)		
Maximum Clamp Stroke				47.24	(1200)	
Maximum Daylight				62.99	(1600)	
Mold Thickness	Minimum			15.75	(400)	
	Maximum			31.5	(800)	
Hydraulic ejector	Force	US ton (Metric ton )	14.3	(13.0)		
	Stroke	inch (mm)	5.9	(150)		
Maximum Mold Size	Hor. load	( H )	49.21	(1250)		
		( V )	33.46	(850)		
	Ver. Load	( H )	33.46	(850)		
		( V )	49.21	(1250)		
Minimum Mold Size	( H )		.		Full clamp tonnage	
	( V )		.			

**610MMJ-110**

**INJECTION UNIT**

ITEM		UNIT	SPECIFICATION		NOTES
			Inch	( Metric )	
Theoretical Injection Volume		cu.in ( cm <sup>3</sup> )	191.6	(3140)	
Inj. Shot Weight	PS	oz	101.94	(2890)	
	PE	( g )	81.83	(2320)	
Plasticizing Capacity	PS	lbs/hr	1015	(460)	
		( kg/hr )			
Max. Injection Pressure		psi ( kg/cm <sup>2</sup> )	25880	(1820)	
Injection Rate	Standard	cu.in /sec	35.4	(580)	
	Option	(cm3/sec)	52.2	(855)	
Injection Horse Power		HP ( PS )	142		
Screw Diameter		in ( mm )	3.54	(90)	
Screw L/D		---		22	
Screw Stroke		in ( mm )	19.49	(495)	
Screw Speed	High speed	rpm	~ 157		
	Mid. speed		~		
	Low speed		~ 108		
Nozzle protrusion		in ( mm )	1.18	(30)	

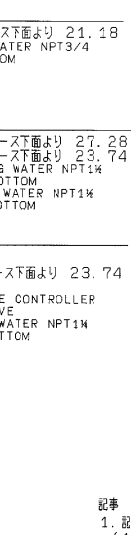
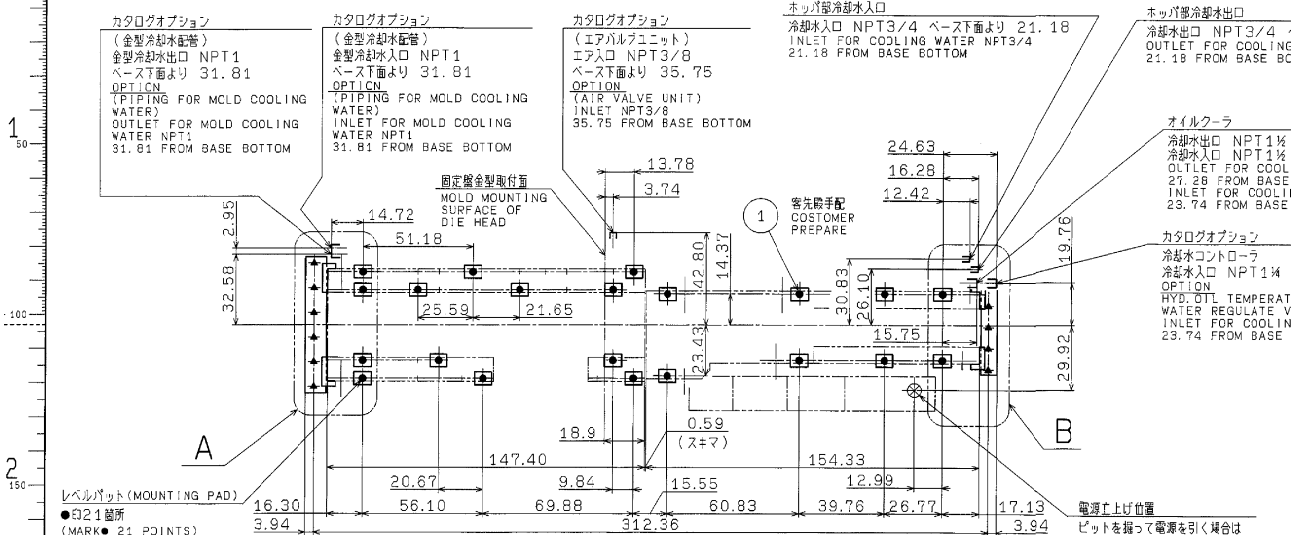
**610MMJ-110****GENERAL**

ITEM	UNIT	SPECIFICATION		NOTES
		Inch	( Metric )	
Electric Motor Capacity	HP ( kw)	90	(67)	45kw + 22kw
Electric Heater Capacity for Screw Barrel	kw	33.4		
Electric Heater Capacity for standard Nozzle		0.3		
Oil reservoir Capacity	us gal (ltr)	369.9	(1400)	
Overall Dimension	( L )	ft	26.25	(8.0)
	( W )	( m )	7.87	(2.4)
	( H )		7.22	(2.2)
Machine Weight	us ton (metric ton)	30.9	(28.0)	

**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.



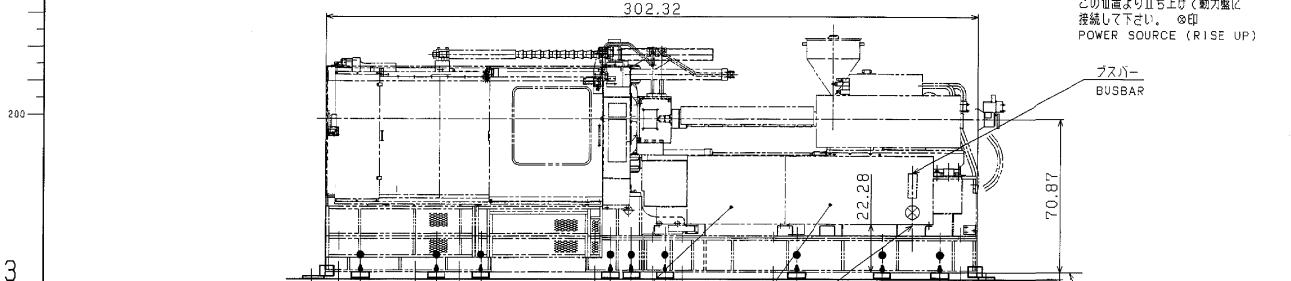
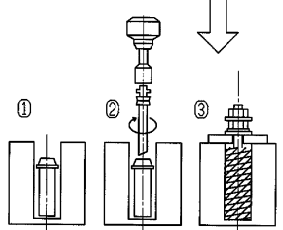


**ケミカルアンカ施工方法**

① 母材に穴をあけ、清浄後レジン'カプ'セルを挿入する。  
 ② ハンマーで'リル、さく'若しくは'インパクト'ドリルを使って回轉衝擊させて打ち込む。  
 ③ 取付け

**HOW TO CHEMICAL ANCHOR WORKING**

① DRILL AND INSERT RESIN CAPSULE.  
 ② STRIKE BOLT WITH REVOLVE AND INPAKUT, USING HAMMER DRILL ETC.  
 ③ FIX TIGHTEN.



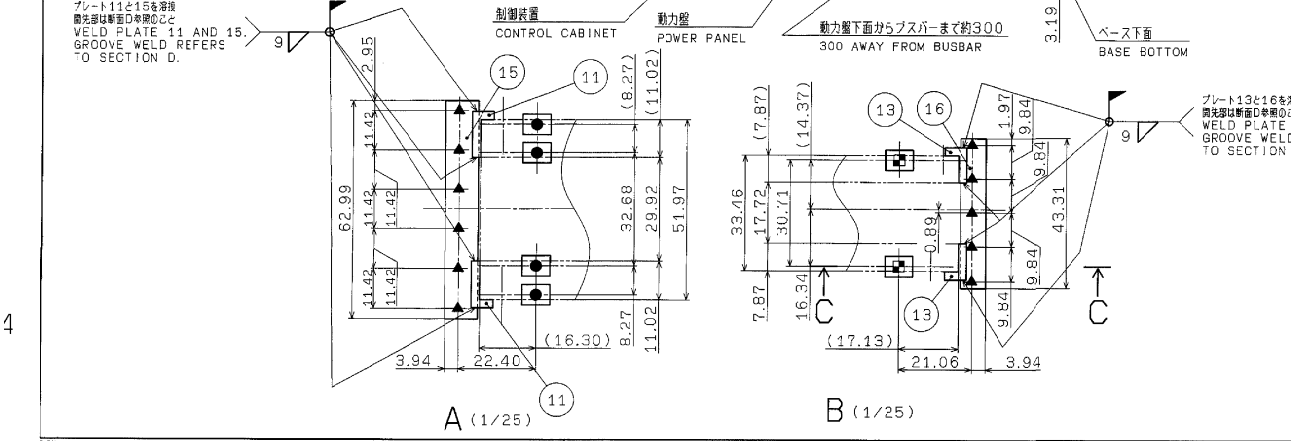
**記事**

1. 記号1 (レベルパッド) は等先除却手配で寸法が適中 (※付) で施工願います。(C-C参照)  
 (1) 床面とベース下面の寸法が 4.92 inch 以内になるよう選付のこと。  
 (2) 記号1 (レベルパッド) の外形は  $\phi 10.63$  inch 以内の物を使用のこと。  
 (3) 記号1 (レベルパッド) のレベルングボルトはM18~M26の純田の物を使用のこと。  
 尚、記号1 (レベルパッド) は●印21箇所取付のこと。  
 (4) プレート15及び16を図示位置に置き、プレート11, 13を溶接後、アンカーで確実に固定のこと。  
 但し、プレート11, 13は機械本体と溶接せぬこと。

2. 最大金型取付時、各ユニットのレベルパッドに加わる最大荷重は下記の通り  
 型線ユニット: 4000lbs (1785kg)  
 射出ユニット: 3500lbs (1575kg)

3. 質量 (内訳) 機械本体: 30.6t  
 金型(最大): 4.5t  
 作動油: 0.7t  
 (全質量) 35.6t

4. 単位: inch



1. ITEM 1 (MOUNTING PAD) ARE PROVIDED BY CUSTOMER. PLEASE SET KEEPING MARK\* COMMENTS AS SHOWN. (REFER TO C-C)

(1) MAX LEVELING HEIGHT IS 4.92INCH.  
 (2) MOUNTING PAD  $\phi$  D. SHOULD BE LESS THAN  $\phi 10.63$ INCH.  
 (3) ITEM 1 LEVELING BOLT SIZE SHOULD BE M18~M26.  
 (4) SET PLATE 11 AND 16 AS SHOWN. AFTER WELDING PLATE 11, 13 FIX TIGHTEN BY ANCHOR. DONT WELD PLATE 11, 13 AND MACHINE.

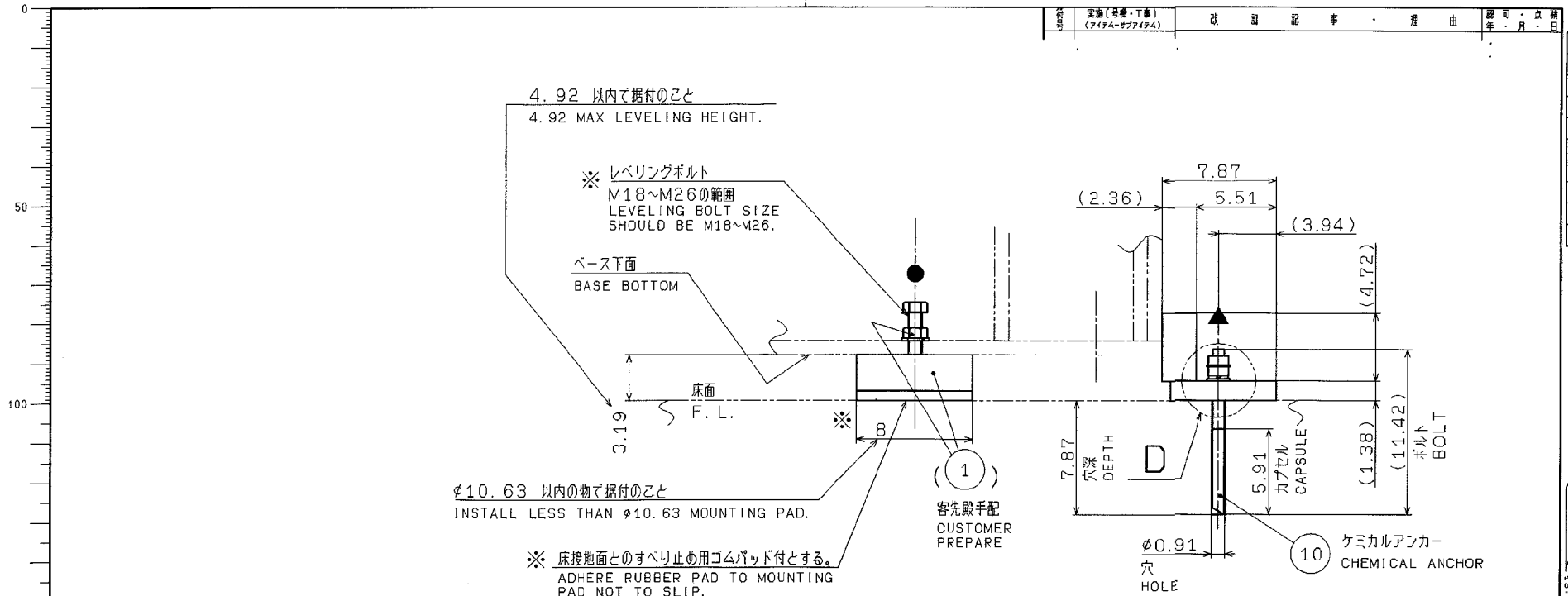
2. THE MAXIMUM LOAD OF WEIGHT FOR EACH MOUNTING PAD IS AS FOLLOWS. (IN CASE OF SETTING-UP MAX. MOLD WEIGHT)

CLAMP UNIT SIDE: 4000lbs (1785kg)  
 INJECTION UNIT SIDE: 3500lbs (1575kg)

3. WEIGHT MACHINE: 33.7 us ton  
 DIE(MAX): 5.0 us ton  
 OIL: 0.8 us ton  
 TOTAL: 39.4 us ton

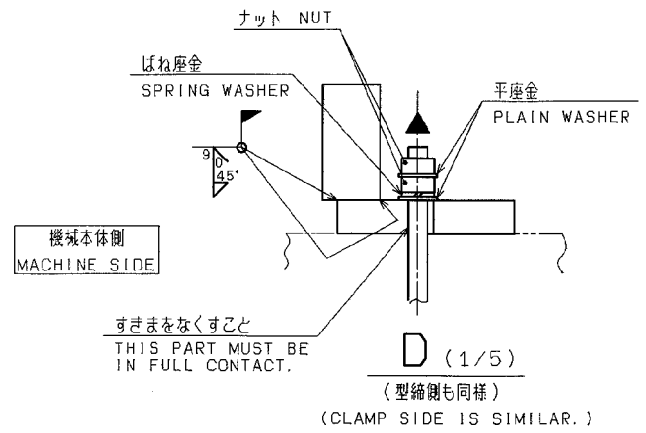
4. ALL DIMENSIONS ARE SHOWN IN INCH.

図名 MODEL	610MMU-80	三角法	RE SCALE	1	図名	基礎図
図番	B3FK91139	3/0 ANGLE PROJECTION	40	図番	基礎図	
承認	14.7.24	図番	B3FK91139	図番	B3FK91139	



C-C

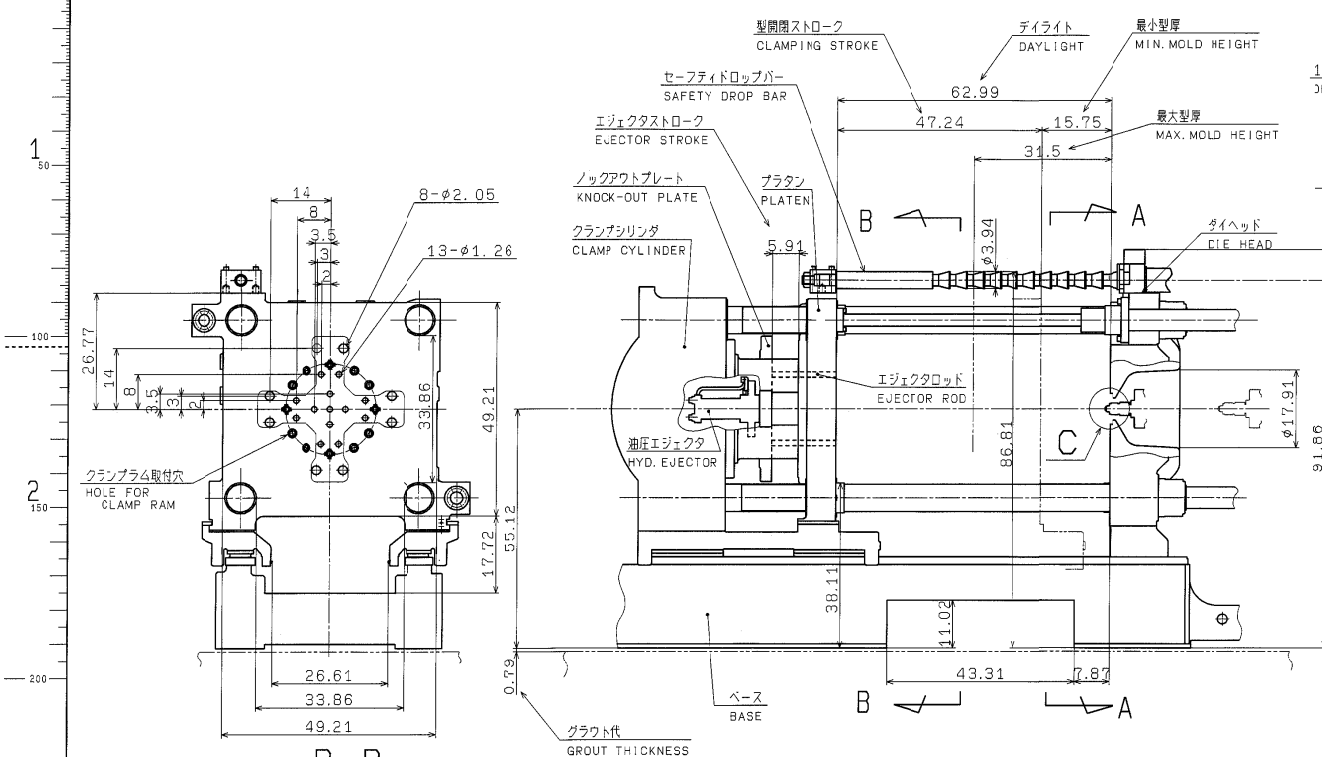
(●印21箇所、▲印11箇所)  
 (MARK ● 21 POINTS, MARK ▲ 11 POINTS)



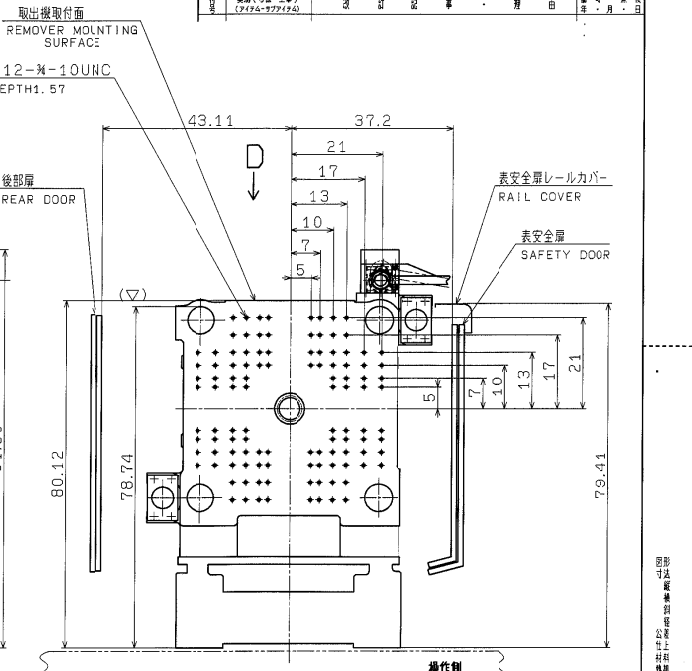
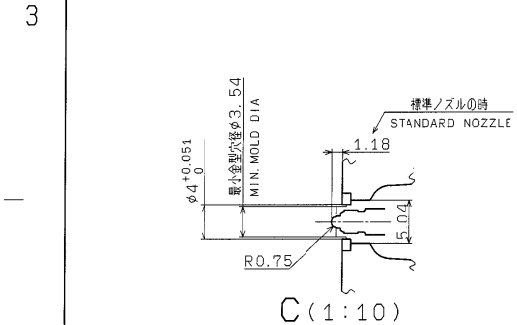
【CAD区分】  
 A: 全CAD  
 B: 半CAD  
 プラック: 手書き

【図庫区分】  
 A: 加工品  
 B: 鉄鋼品  
 C: 購入品  
 D: 組立品  
 P: 電加工品  
 R: 電鍍品  
 S: 電ソケット  
 T: 電機立品

品名 MODEL 610MMJ-80	三角法 3rd ANGLE PROJECTION	R/R SCALE 1/7	名称 NAME 基礎図 FOUNDATION
図番 NEXT ASS'Y B3FD90601	承認 APPROVED	検閲 CHECKED	製図 DRAW 佐藤 石原
基号 B/M 14.7	基番 DWG. NO. B3FK91139	SUFFIX 2	MARK/PAGE 2



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



**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.)

- MIN. MOLD SIZE: 21.65x21.65 (WHEN CLAMPING FORCE IS 608 US ton)
  - HEX0.94x14.92x4PIECES, HEX1.61x14.92x4PIECES, EJECTOR RODS ARE SUPPLIED WITH MACHINE (EJECTOR ROD WITH MALE SCREW 3/4-10UNC; HEX0.94 & 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、550x550mm (型締力5394kN (550tf) 0時)
  - 対辺24mm六角x37914本、対辺41mm六角x37914本のエジェクタロッド (※1-10UNC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1INCH表示です。

MODEL	3FK93636	三角法	SCALE	1/20	NAME	金型取付寸法図
DATE	12.6.8	BIG ANGLE PROJECTION				DIE SPACE
APPROVED	富岡	DRAWN	富岡	DWG. NO.	3FK93636	

