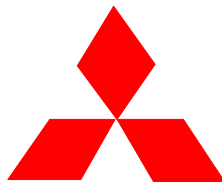


MITSUBISHI INJECTION MOLDING MACHINE
SPECIFICATIONS

950MGV-240



MHI Injection Molding Machinery, Inc.

Ref: MHI-PT document # ED-1D33-4402

950MGV-240

CLAMP UNIT

ITEM		UNIT	SPECIFICATION		NOTES	
			Inch	(Metric)		
Max. Mold Clamping Force		US. ton	937	(850)		
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)	60.24	(1530)	
	(V)			60.24	(1530)	
Clearance between Tie Bars	(H)			41.73	(1060)	
	(V)	41.73		(1060)		
Maximum Clamp Stroke				68.9	(1750)	
Maximum Daylight				88.58	(2250)	
Mold Thickness	Minimum			19.69	(500)	
	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	or	(H)	60.24	(1530)		
		(V)	41.34	(1050)		
		(H)	41.34	(1050)		
		(V)	60.24	(1530)		
Minimum Mold Size		(H)	26.77	(680)	Full clamp tonnage	
		(V)	26.77	(680)		
Maximum Mold weight		lbs (kg)	20	(9)	Moving side is half of this weight	

950MGV-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)	

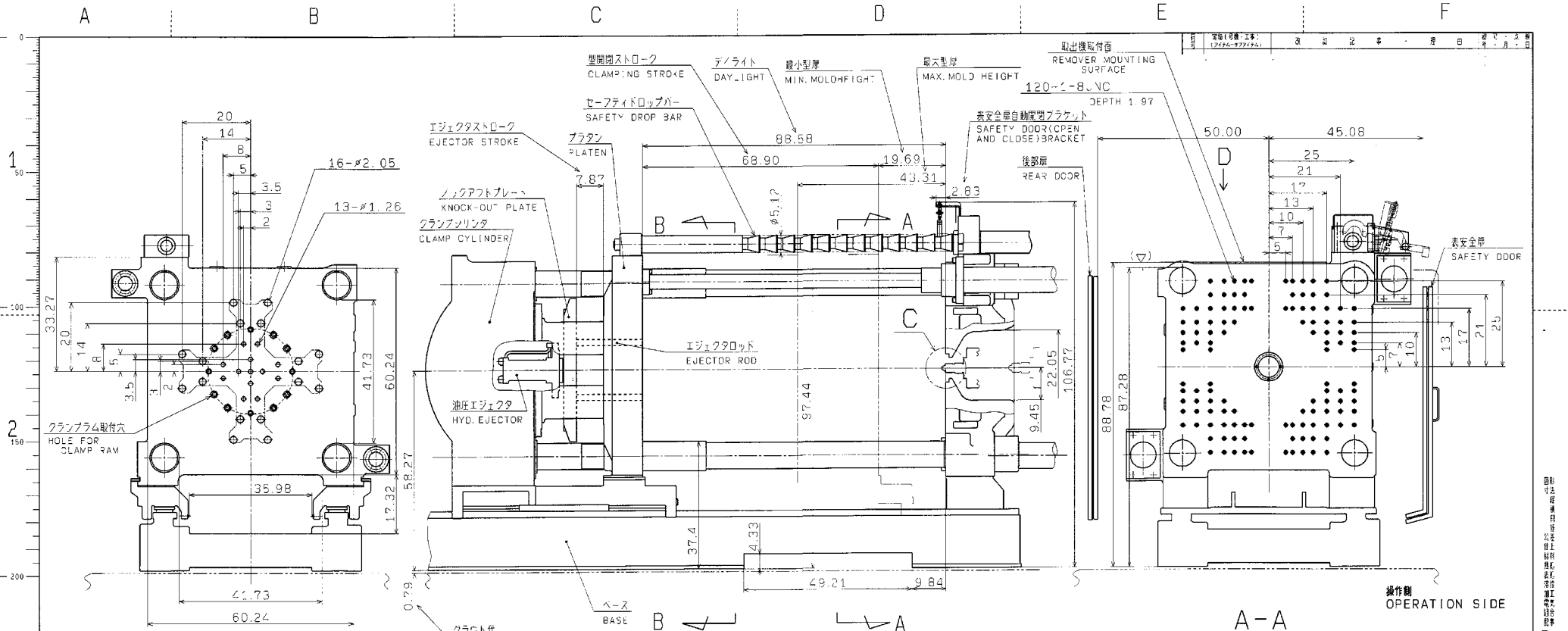
950MGV-240**GENERAL**

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 (ltr)	2.51	(9.5)	
Overall Dimension	(L)	ft	32.81	(10.0)
	(W)	(m)	8.5	(2.60)
	(H)		8.2	(2.50)
Machine Weight	us ton (metric ton)	44.4	(40.3)	

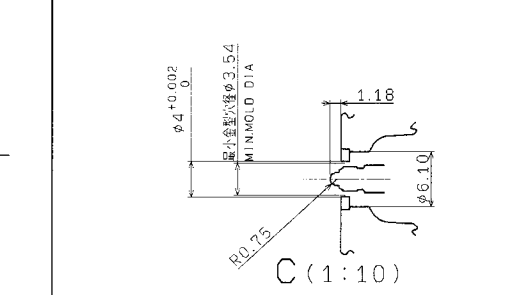
Electric Capacity		KVA	202.0	460 V , 60 Hz
Full Load Current		A	254.0	460 V , 60 Hz
Cooling Water supply for Heat exchanger	us gpm (lit/min)	18.5	(70)	Soft water, 90 °F or below
Cooling Water supply for Feed Throat		7.9	(30)	

Remarks

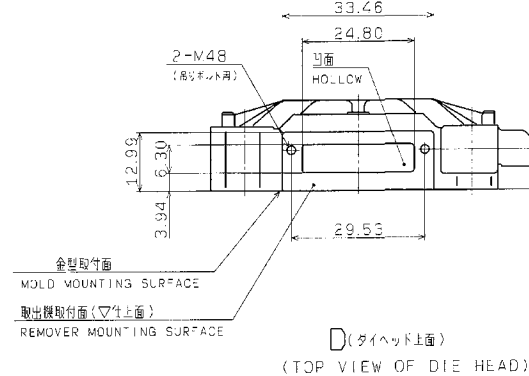
1. Injection weight, injection rate and plasticizing capacity are dependent upon molding conditions and resin used.
2. Specifications are subject to change without notice.



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



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

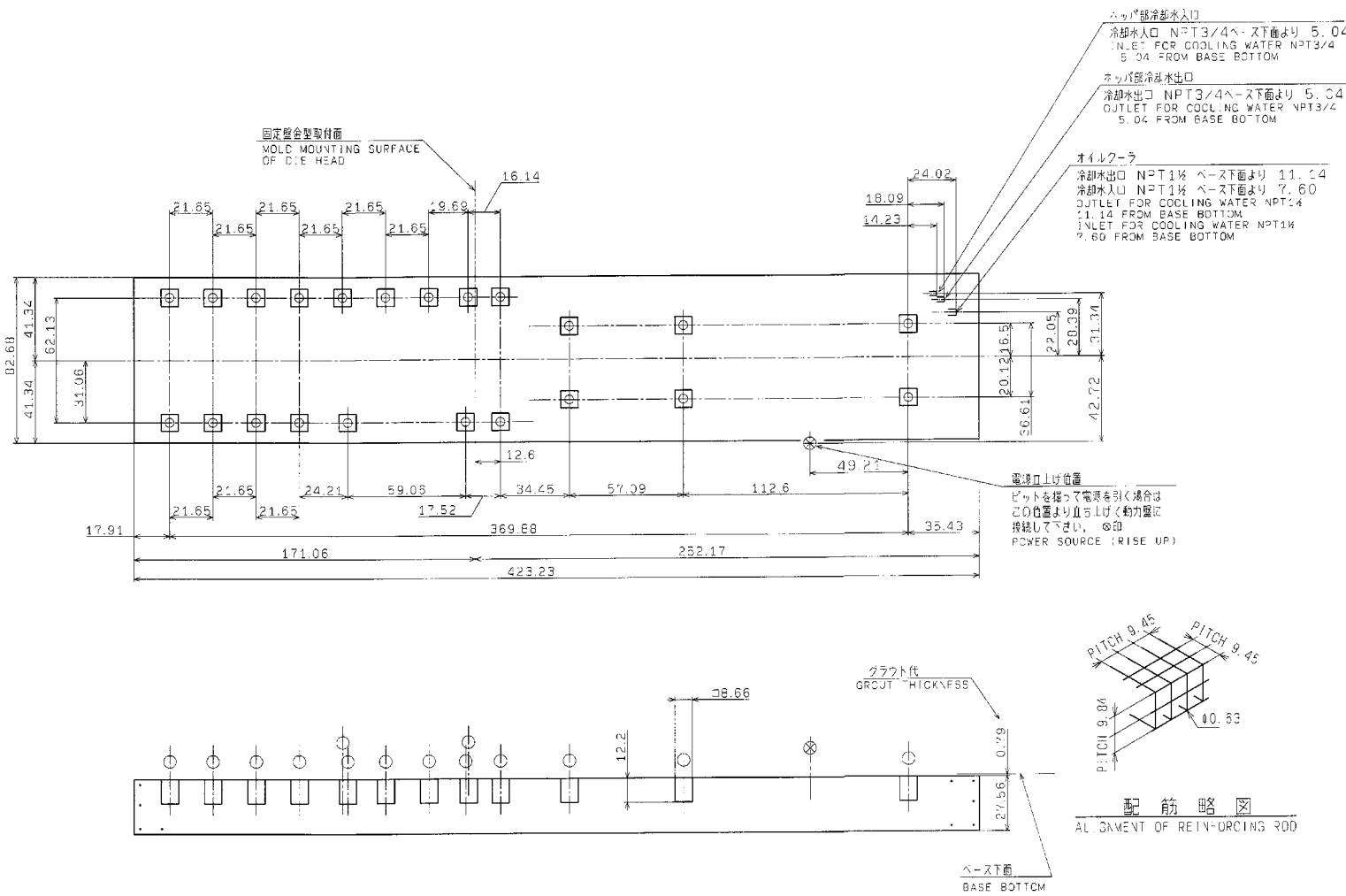


- MIN. MOLD SIZE: 26.77x26.77 (WHEN CLAMPING FORCE IS 937J5.10T)
 - HEX0.95x19.25x4-PIECES, HEX1.61x19.25x4-PIECES, EJECTOR RODS ARE SUPPLIED WITH MACHINE (EJECTOR ROD WITH MALE SCREW 3/4-1UNC; HEX0.95 & 1-8UNC; HEX1.61) WHEN OTHER EJECTOR RODS ARE REQUIRED THEY SHALL BE PREPARED BY CUSTOMER
 - ALL DIMENTION ARE SHOWN IN INCH.
- 最小金型は、680x680mm (型締力5336kN (850tf) の時)
 - 対辺24mm六角x489/4本、対辺21mm六角x489/4本のエジェクタロッド (別-1UNC仕込み式: 対辺24、1-8UNC仕込み式: 対辺21) 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。
 - 区中の単位は1/16INCH表示です。

BK MODEL 3FK93869 BK APPROVED 船木	BK CHECKED 船木	BK DRAWN 船木	BK NAME 金型取付寸法図 BK SCALE 1/20 BK ANGLE PROJECTION 1/20 BK DATE 18.9.18	BK PART NO. 3FK93869 BK SUPPLY MARK 船木	BK PAGE 1/1 BK TOTAL PAGE 1/1
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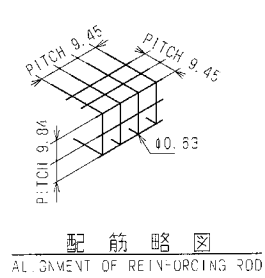
FOR REFERENCE ONLY

1
50
100
2
150
200
3
300
4



- 本図は、基礎ボルト穴位置、各種冷却水及びエア供給口を示します。
- 2/2葉は、レベルボルト位置及び基礎ボルト埋込の要領等を示します。
- 従用コンクリートは全コンクリートの機械基礎用を用いて下さい。
- 地耐力が78.5kPa(B. Q.T/ノ)以上かつ下の場合は、状況に応じて杭打地盤を行ったりは、基礎底面荷を増加する等の対策を実施して下さい。
- 薬石地盤は適宜に決定し施工して下さい。
- ベース据付面全面(鉛線地盤所)で重量を受ける様、埋付して下さい。(葉別2/2を参照して下さい。)
- 質量 (内訳)
 - 機械全体 : 39.8t
 - 全型(最大) : 9.0t
 - 作動油 : 1.5t
 - (全質量) : 50.3t
 - 基礎質量 : 約 37.9t
- 機械据付後の基礎ボルト穴、ベース下面のモルタルの充填(クラフト)も先取で施工して下さい。
- 全くの箱板部のモルタルは下記のものを使用下さい。
 - (1) 早強性無収縮モルタルを使用下さい。(デナカスコン又はノッシュリンクを含有して下さい) 箱板部全容積: 0.33m³
 - (2) 強度は20.6MPa(210kgf/cm²)以上
- 全ての箱板部の隅辺は補強鉄を入れて下さい。
- 基礎ボルトと当金は、機械に付属されています。
- 単位 : inch

- THIS PAGE SHOWS FOUNDATION-BOLT HOLES AND WATER AND AIR.
- NEXT PAGE SHOWS POSITION OF LEVELING-BOLT AND RESUME OF FILLING FOUNDATION-BOLT.
- PLEASE ADOPT THE REINFORCED CONCRETE TO THE FOUNDATIONS.
- BEARING CAPACITY OF SOIL SHOULD BE OVER 11.4tcf/in² AND IN CASE UNDER 11.4tcf/in² IT IS NECESSARY TO BE REINFORCED WITH CONCRETE PILES.
- GROUTING OF BASE FEET IS RECOMMENDED.
- APPROX FLOOR LOAD IS 19.9tbf/in² WHEN BASE IS GROUTED.
- MASS
 - MACHINE : 43.9 US-ton
 - DIE(MAX) : 9.9 US-ton
 - DIL : 1.7 US-ton
 - TOTAL : 55.5 US-ton
- FOUNDATION MASS : 41.9 US-ton
- AFTER MACHINE INSTALLATION AND LEVELING FILL FOUNDATION BOLT HOLES AND THE BOTTOM OF THE BASE WITH MORTAR (CUSTOMER IS RESPONSIBLE FOR MORTAR PROCUREMENT)
- PLEASE ADOPT THE QUICKLY STRENG AND NO-SHRINKING MORTAR
 - CAPACITY : 20137.7in³(0.33m³)
 - DENSITY : 2984.1tcf/in³(210kg/cm³)
- PLEASE INSERT THE ARMATURE AROUND THE DROWN BOX.
- FOUNDATION BOLTS AND LEVELING PADS ARE SUPPLIED WITH MACHINE.
- ALL DIMENSIONS ARE SHOWN IN INCH.



MODEL	3FK91298	三角法	SCALE	1/20	基礎図
PRODUCTION	000009	三日月	PRODUCTION	1/20	FOUNDATION
APPROVED	CHECKED	DRAWN	CHKD	CHKD	SUFFIX MAP/PAGE
3FK91298	3FK91298	3FK91298	3FK91298	3FK91298	1/2

1φ=1ボルト
1φ=0.4539kg
1kgf/cm²=14.226bf/in²

MIMM 標準
(E-PAC 92対応)

3FK91298

MITSUBISHI HEAVY INDUSTRIES
PLASTIC TECHNOLOGY CO., LTD. (電報局番 3FK91081)

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