

## 1.2 TECHNICAL CHARACTERISTICS

The technical characteristics of the SERIE SETTE presses are summarized in this section.

The main data of the various models can be found in table 1-1.

Table 1-1 SERIE SETTE Press Technical Characteristics

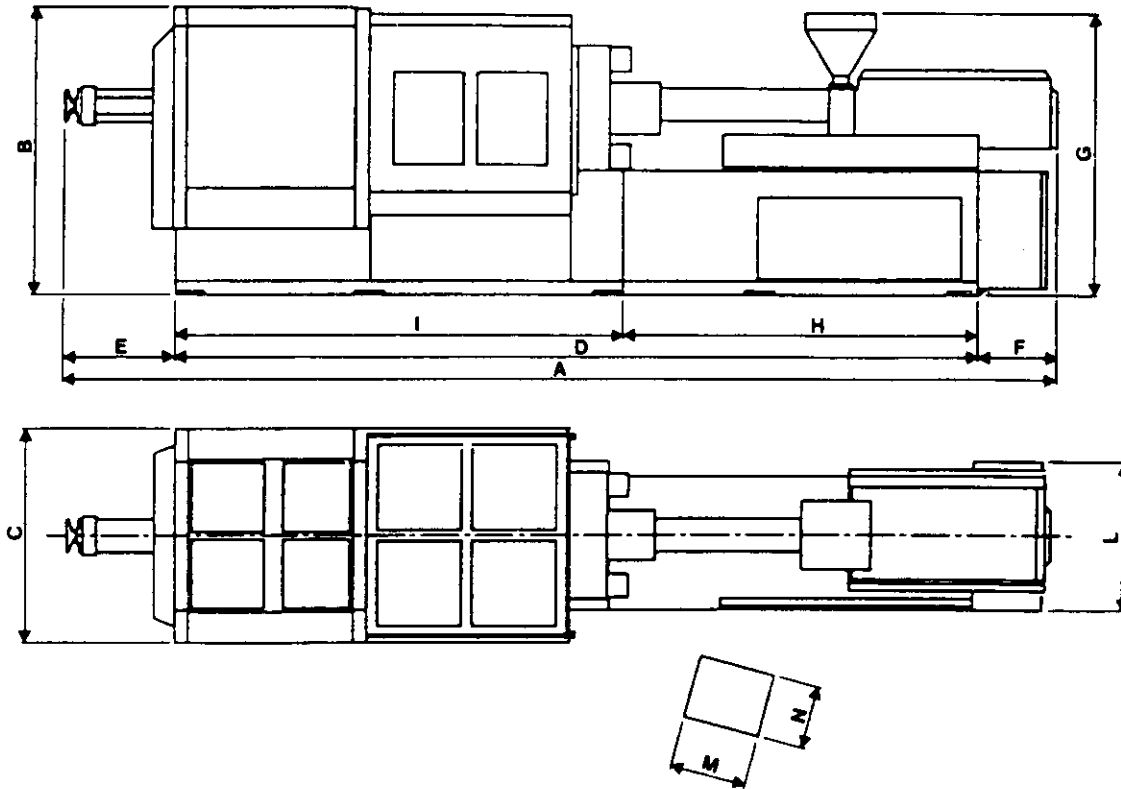
CHARACTERISTICS		SERIE SETTE 500			SERIE SETTE 650		
Euromap classification	cm <sup>3</sup> /MP	3270/500			4300/650		
Screw diameter	mm	70	80	90	80	90	105
Calculated shot volume	cm <sup>3</sup>	1616	2110	2680	2260	2860	3895
Approx. shot weight (polystyrene)	g	1570	2050	2550	2190	2775	3780
Pressure on material	bar	1950	1500	1200	1945	1540	1130
Max. injection speed	cm <sup>3</sup> /s	460	605	770	580	752	996
Screw length	L/D	23	20	18	23	20	17
Plasticizing capacity (cont. rot. polystyrene)	g/s	80.5	100	122.2	83.3	108.3	127.7
Screw hydraulic motor power	Hp	100			125		
Screw speed	rpm/1'	0-200			0-200		
Torque on screw	N x m	3960			4550		
Heating zones (+ nozzle)	N°	4			4		
Total heating power	kW	31			36		
Mould clamping force	kN	5000			6500		
Fixed platen travel	mm	830			920		
Mold min. + max. thickness	mm	250-800			250-900		
Passage between tie bars (O x V)	mm	720x720			820x820		
Ejection force with plate hydraulic ejector	kN	115			115		
Hydraulic plate ejector stroke	mm	290			290		
Electric motors power	kW	75			90		
Total installed power	kW	105			128		
Idle cycle	N°/1	20			16		
Oleodynamic circuit pressure	bar	135			135		
Oil quantity (approx.)	litres	500			670		
Refrigeration units required for oil cooling	refr./h	19200			24000		
15° H <sub>2</sub> O a 15° required for oil cooling	m <sup>3</sup> /h	1.9			2.4		
Injector net weight	kg	-			-		
Mould clamping net weight	kg	-			-		
Net weight	kg	25000			33000		

Table 1-1 SERIE SETTE Press Technical Characteristics

CHARACTERISTICS		SERIE SETTE 1300		
Euromap classification	cm <sup>3</sup> /MP	15028/1300		
Screw diameter	mm	120	135	155
Calculated shot volume	cm <sup>3</sup>	7970	10090	13300
Approx. shot weight (polystyrene)	g	7570	9600	12640
Pressure on material	bar	1900	1500	1140
Max. injection speed	cm /s	880	1150	1480
Screw lenght	L/D	25	22	19.5
Plasticizing capacity (cont. rot. polystyrene)	g/s	169.5	194.5	216.6
Screw hydraulic motor power	Hp	200		
Screw speed	turn/1'	0-85		
Torque on screw	N x m	17000		
Heating zones (+ nozzle)	N°	6		
Total heating power	kW	66.3		
Mould clamping force	kN	13000		
Fixed platen travel	mm	1350		
Mold min. + max. thickness	mm	450-1350		
Passage between tie bars (O x V)	mm	1200x1200		
Ejection force with plate hydraulic ejector	kN	225		
Hydraulic plate ejector stroke	mm	350		
Electric motors power	kW	145		
Total installed power	kW	219		
Idle cycle	N°/1	7		
Oleodynamic circuit pressure	bar	135		
Oil quantity (approx.)	litres	1300		
Refrigeration units required for oil cooling	refr./h	33000		
15 C° H <sub>2</sub> O required for oil cooling	m <sup>3</sup> /h	3.3		
Injector net weight	kg	29000		
Mold clamping net weight	kg	76000		
Net weight	kg	105000		

### 1.2.1 OVERALL DIMENSIONS

Figure 1-2 shows the overall dimension of the SANDRETTO SERIE SETTE presses.



TYPE	A	B	C	D	E	F	G	H	I	L	M	N
500	9080	2520	1875	7120	1280	680	2510	-	-	-	620	530
650	9710	2650	2075	7880	1100	730	2720	-	-	-	620	530
800	10970	2860	2245	8870	1300	800	2825	4090	4780	1900	620	530
1000	14800	2710	2690	12700	1500	600	2850	7200	5500	1075	620	530
1300	16350	2990	2690	14050	1700	800	3010	7550	6300	1140	620	530

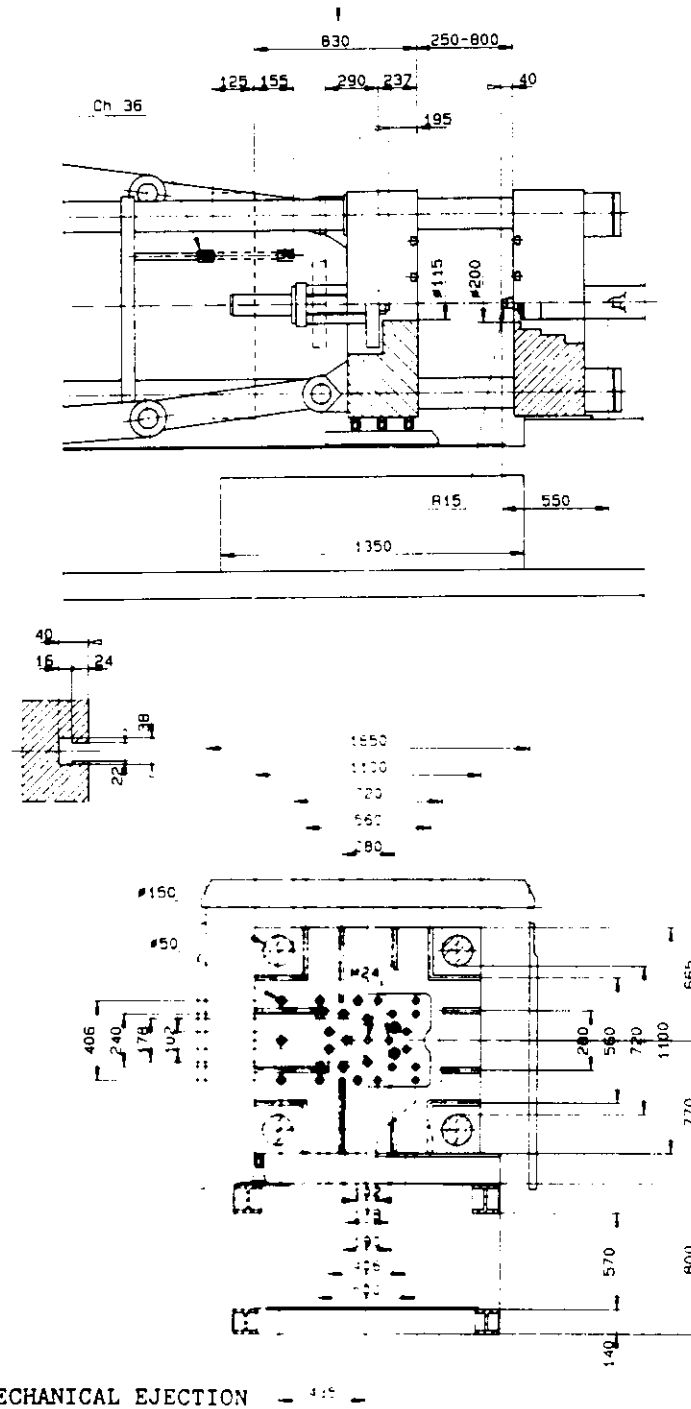
ALL DIMENSIONS ARE IN MILLIMETERS

Fig. 1-2 Overall Dimensions

### 1.2.2 PLATEN DIMENSIONS AND TRAVEL

Platen dimensions and travel are shown in figures 1-3 to 1-7.

ADJUSTABLE STROKE ABOUT 40%

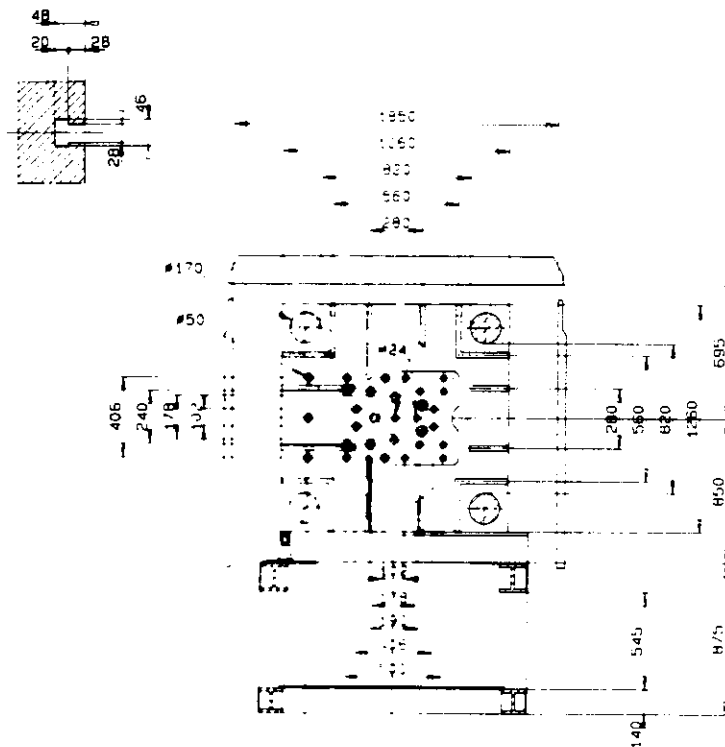
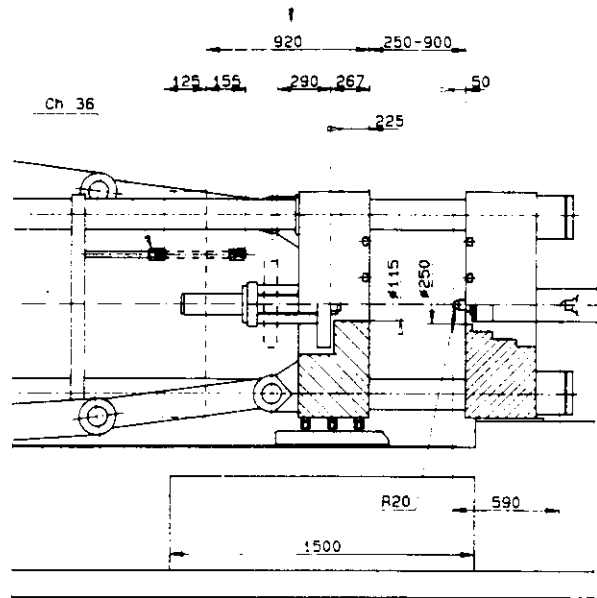


MECHANICAL EJECTION - 1-3 -

ALL DIMENSIONS ARE IN MILLIMETERS

Fig. 1-3 SERIE SETTE 500 Platen Dimensions and Travel

ADJUSTABLE STROKE ABOUT 40%



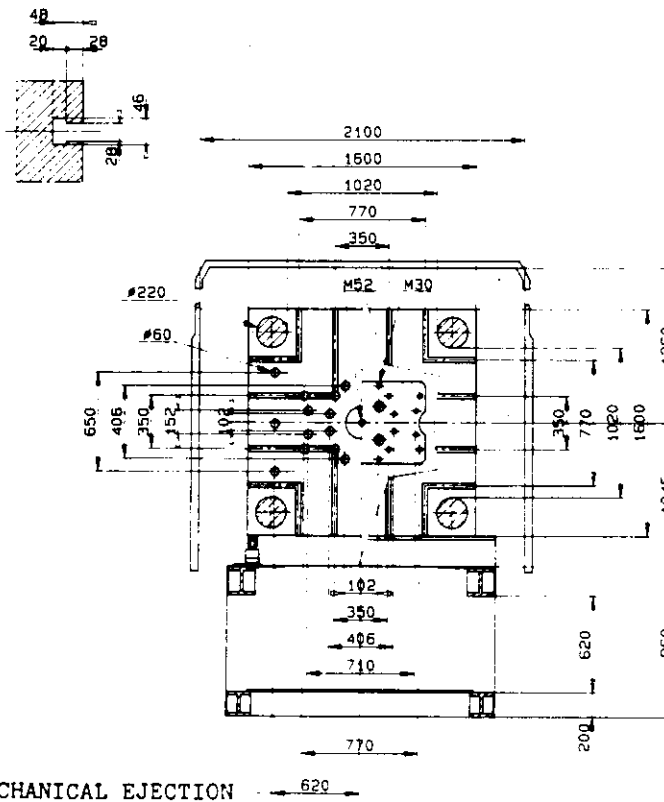
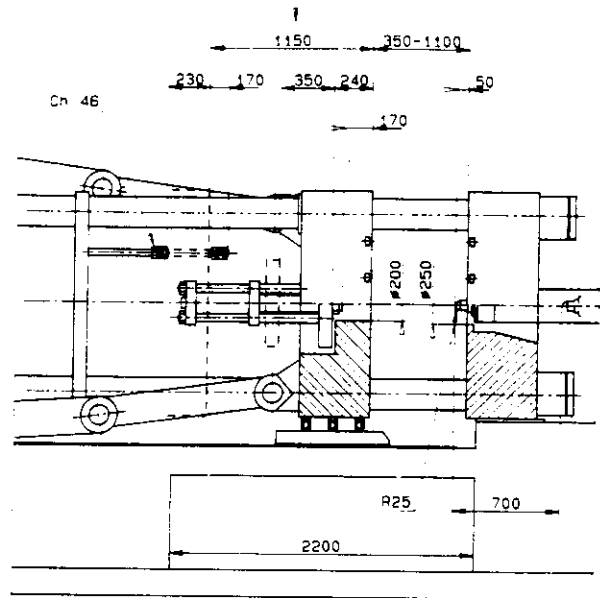
MECHANICAL EJECTION - 345 -

ALL DIMENSIONS ARE IN MILLIMETERS

Fig. 1-4 SERIE SETTE 650 Platen Dimensions and Travel



ADJUSTABLE STROKE ABOUT 40%



ALL DIMENSIONS ARE IN MILLIMETERS

Fig. 1-6 SERIE SETTE 1000 Platen Dimensions and Travel