

### 1.3 TECHNICAL FEATURES

The technical features of SANDRETTO SERIE SETTE presses are summarized in Table 1-1.

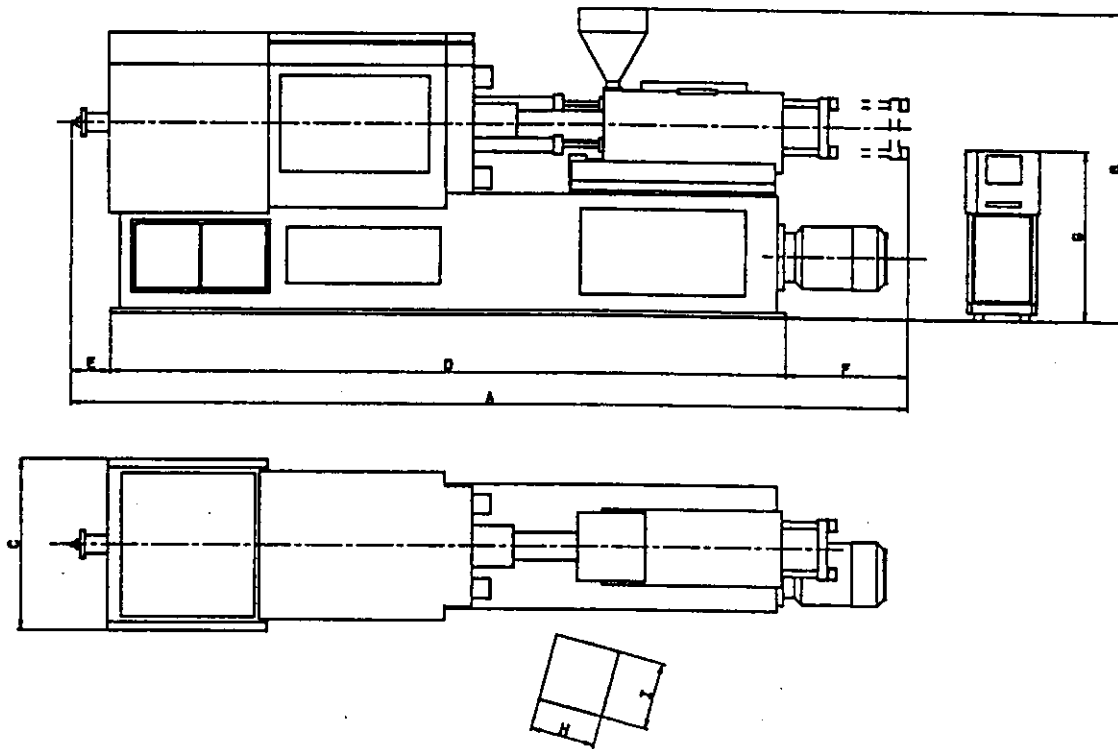
Table 1-1 Technical Features of SERIE SETTE Presses

FEATURES		SERIE SETTE 40			SERIE SETTE 60			SERIE SETTE 95			SERIE SETTE 135			SERIE SETTE 190			SERIE SETTE 250			SERIE SETTE 350		
Euromap classification	cm <sup>3</sup> MP	164/40			177/60			310/95			515/135			790/190			1250/250			1960/350		
Screw diameter	mm	28	32	35	35	40	45	40	45	50	45	50	55	50	55	60	55	60	70	60	70	80
Calculated injection volume	cm <sup>3</sup>	80	105	125	96	125	159	175	222	274	286	353	427	451	546	650	700	835	1135	990	1347	1760
Approx injected weight in polystyrene	g	77	100	120	90	120	150	168	210	260	275	339	410	435	525	625	670	802	1090	950	1290	1690
Pressure on material	bar	1970	1500	1260	1840	1408	1112	1775	1400	1135	1800	1464	1210	1750	1450	1215	1785	1500	1100	1980	1450	1110
Maximum injection speed	cm <sup>3</sup> /s	78	102	115	115	150	190	125	160	195	146	180	217	230	280	335	230	270	370	270	360	470
Screw length	L/D	23	20	18	21,5	19	16,5	24	22	20	22	20	18	22	20	18,5	22	20	17	23	20	17,5
Plasticizing per hour (in cont. rotation polystyrene)	kg/h	50	55	60	90	110	125	105	120	135	120	140	150	130	160	180	160	180	210	160	200	235
Hydraulic motor power (variable displacement)	HP	15*			25			25			30			40			40			60		
Screw speed	r.p.m.	0-270			0-300 300-670			0-170 170-450			0-200 200-520			0-150 150-440			0-160 160-490			0-120 120-300		
Torque on screw	N x m	380			490 490-220			1100 1100-430			1100 1100-430			2100 2100-720			2100 2100-720			3860 3860-1540		
Thermoregulated zones (+ nozzle)	N	3			3			3			3			3			3			3		
Total heaters power	kW	4,2			6			7,2			9			13,8			16,2			23		
Mold clamping force	kN	400			590			930			1325			1870			2460			3440		
Mobile plane stroke	mm	270			300			350			400			460			530			600		
Mold minimum and maximum thickness	mm	100-350			80-350			100-400			150-500			200-550			200-650			200-650		
Clearance between columns	mm	266x266			300x300			353x353			400x400			460x460			530x530			600x600		
Approx. ejection force with mechanical ejector	kN	15			10,4			18			21			30			44			52		
Ejection force with plate hydraulic ejector	kN	22**			34			34			50			50			50			85		
Plate hydraulic ejector stroke	mm	85**			90			115			150			150			150			190		
Electrical motor power	kW	11			18,5			18,5			22			30			30			45		
Total installed power	kW	15,2			24			25,7			31			43			53,2			68		
Idle cycles	r.p.m.	48			70			55			45			35			30			22		
Oleodynamic circuit pressure	bar	135			115			135			135			135			135			135		
Oil quantity (approx.)	kg	120			170			215			245			315			400			500		
Net weight	kg	2300			2900			4200			5700			8100			9900			14500		

\* Constant Displacement \*\* Central Hydraulic Ejector

## 1.4 OVERALL DIMENSIONS

Fig. 1-3 shows SANDRETTO SERIE SETTE presses' overall dimensions.



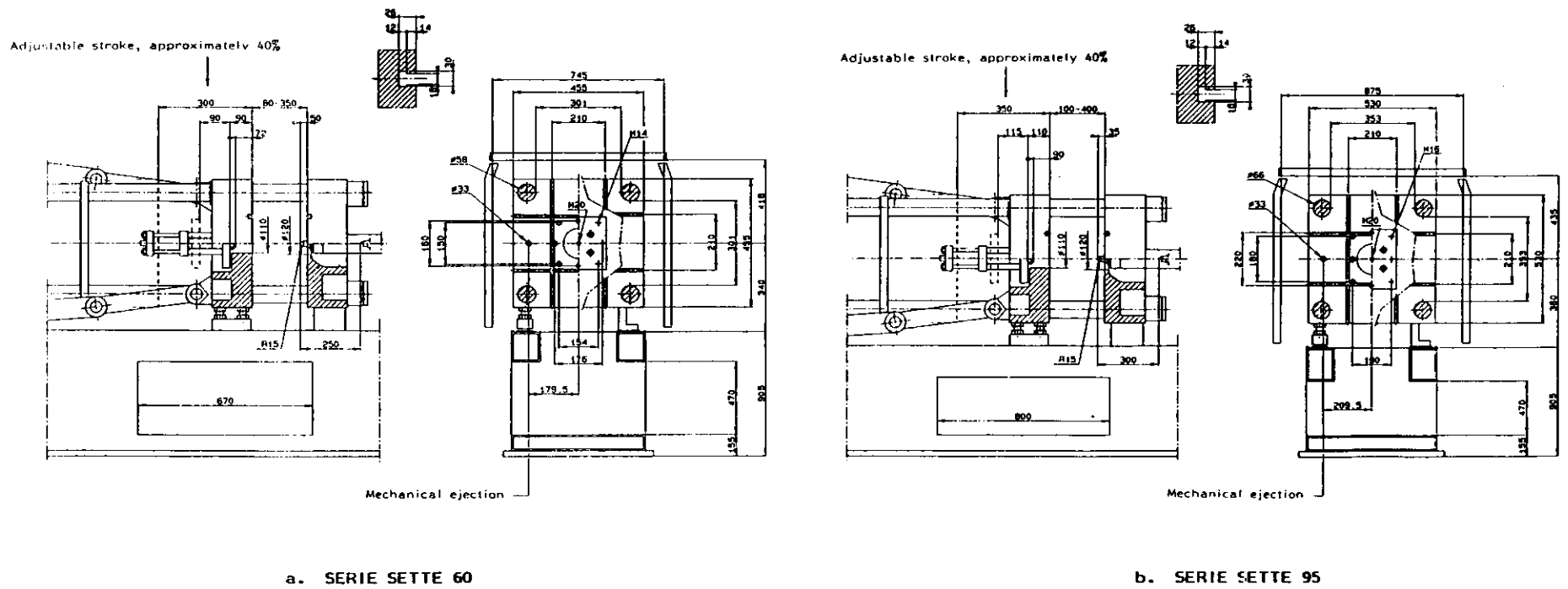
TYPE	A	B	C	D	E	F	G	H	I
60	4350	1860	920	3455	295	600	1240	530	530
95	5027	1920	960	3970	520	650	1240	530	530
135	5720	1980	1140	4405	540	770	1240	530	530
190	6330	2250	1180	4780	620	930	1240	530	530
250	6715	2340	1260	5205	680	830	1240	530	530
350	8015	2480	1400	5865	1050	1100	1240	530	530

ALL DIMENSIONS ARE IN MILLIMETERS

Fig. 1-3 Overall Dimensions

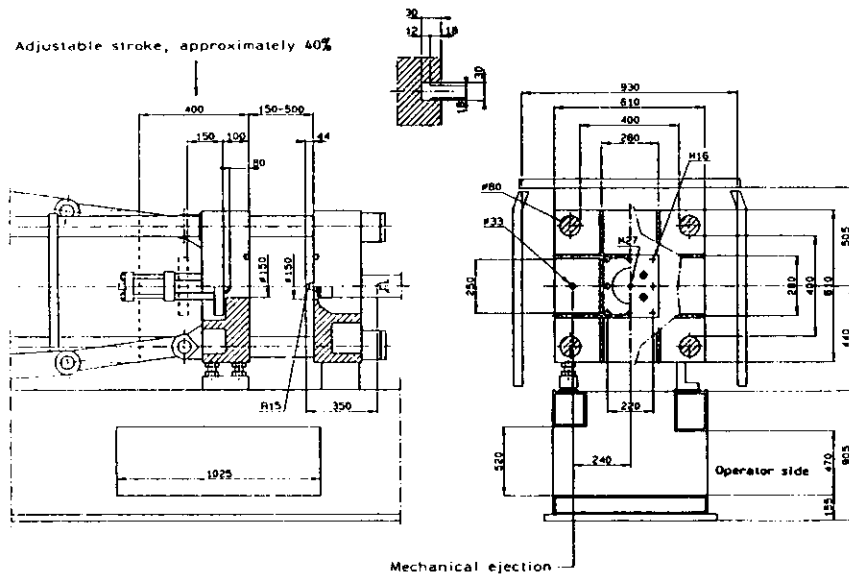
1.4.1 PLANES DIMENSIONS AND STROKES

Planes dimensions and strokes are shown in Fig. 1-4.

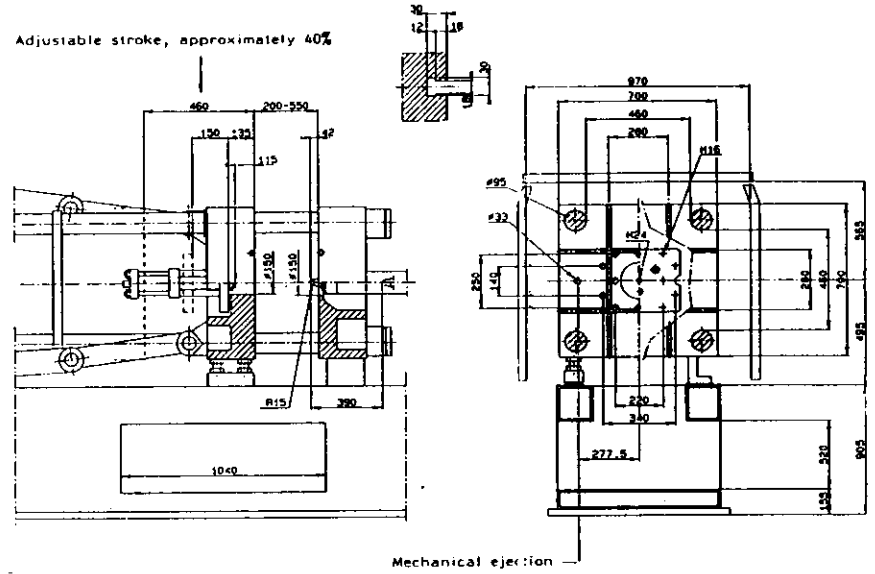


ALL DIMENSIONS ARE IN MILLIMETERS

Fig. 1-4 SERIE SETTE Presses Planes Dimensions and Strokes (Sheet 1 of 3)



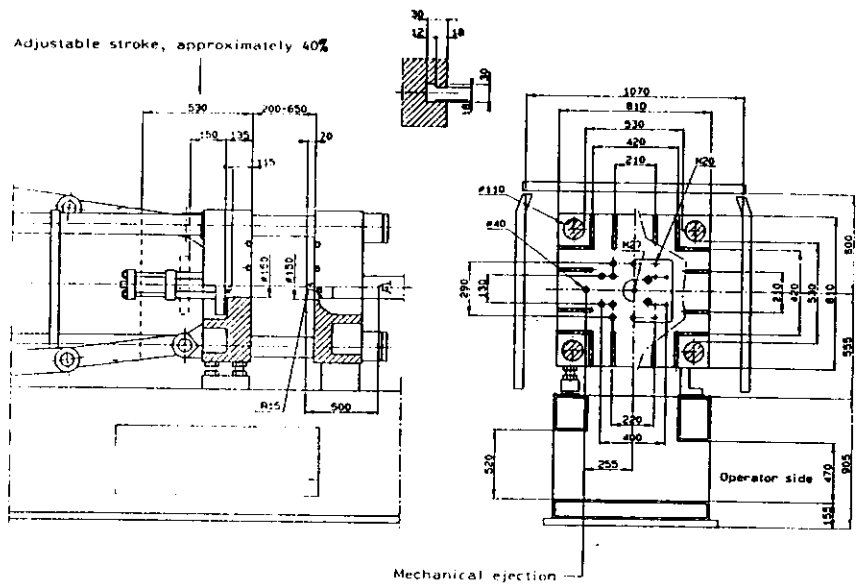
c. SERIE SETTE 135



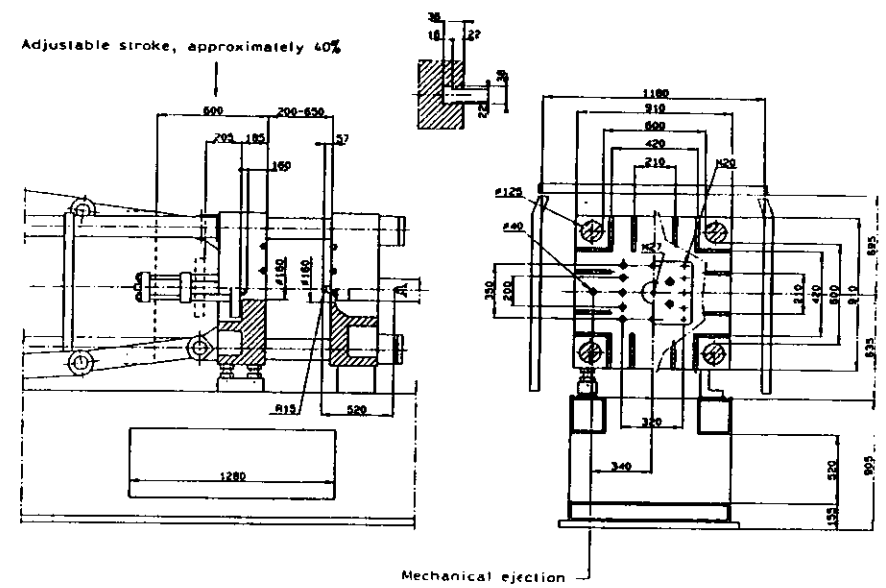
d. SERIE SETTE 190

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Fig. 1-4 SERIE SETTE Presses Planes Dimensions and Strokes (Sheet 2 of 3)



e. SERIE SETTE 250



f. SERIE SETTE 350

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Fig. 1-4 SERIE SETTE Presses Planes Dimensions and Strokes (Sheet 3 of 3)