

# CARAT 180 compact

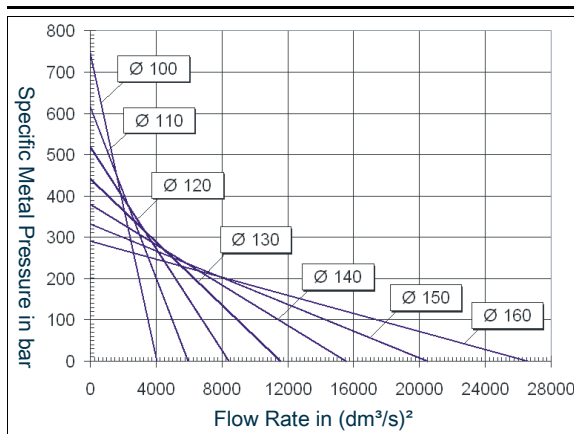
## Injection Unit

Injection Force dynamic	kN	583
Injection Force Intensified	kN	1530
Plunger Stroke	mm	1050
Maximum plunger Velocity	m/s	8.11
Injection Height	mm	0/-420

## Closing Unit

Maximum Locking Force	kN	17600
Ejector Force	kN	500
Ejector Stroke	mm	240
Die Height	mm	724 - 1450
Die opening Stroke	mm	1250
Smallest permissible Die Dimensions	mm	1060 x 1060
Maximum permissible Surface Pressure	N/mm <sup>2</sup>	100

## p/Q<sup>2</sup> Diagram



## Production Data

Plunger Diameter	mm	100	110	120	130	140	150	160
Maximum Casting Volume	cm <sup>3</sup>	5495	6648	7912	9286	10770	12364	14067
Maximum Casting Weight Al	kg	13.7	16.62	19.78	23.21	26.92	30.9	35.2
Maximum Metal Pressure	bar	1949	1610	1353	1153	994	866	761
Maximum Projected Area	cm <sup>2</sup>	924	1117	1329	1560	1810	2078	2364

Casting Weight =  $\frac{2}{3}$  x Plunger Stroke x Plunger Surface x Density (Al: 2,5 kg/dm<sup>3</sup>)

## Hydraulic System

Installed Load	kW	115
Maximum System Pressure	bar	210
Filling Quantity	dm <sup>3</sup>	2700
Water Cooling	m <sup>3</sup> /h	3.6

## Central Lubrication

Installed Load	kW	0.1
Filling Quantity	dm <sup>3</sup>	10

## Nitrogen/Piston Accumulator

Maximum idle Pressure	bar	160
Filling Quantity	dm <sup>3</sup>	325

## Nitrogen/Intensifier

Maximum idle Pressure	bar	160
Filling Quantity	dm <sup>3</sup>	65

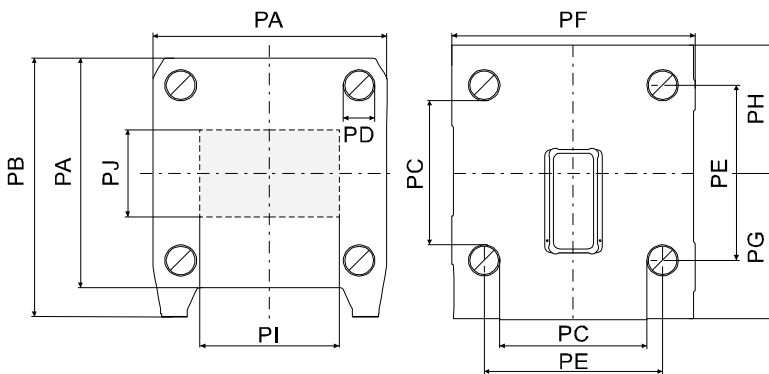
## Simultaneous hydraulic unit

Usable volume	dm <sup>3</sup>	36
Available accumulator pressure	bar max	200



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## Platen

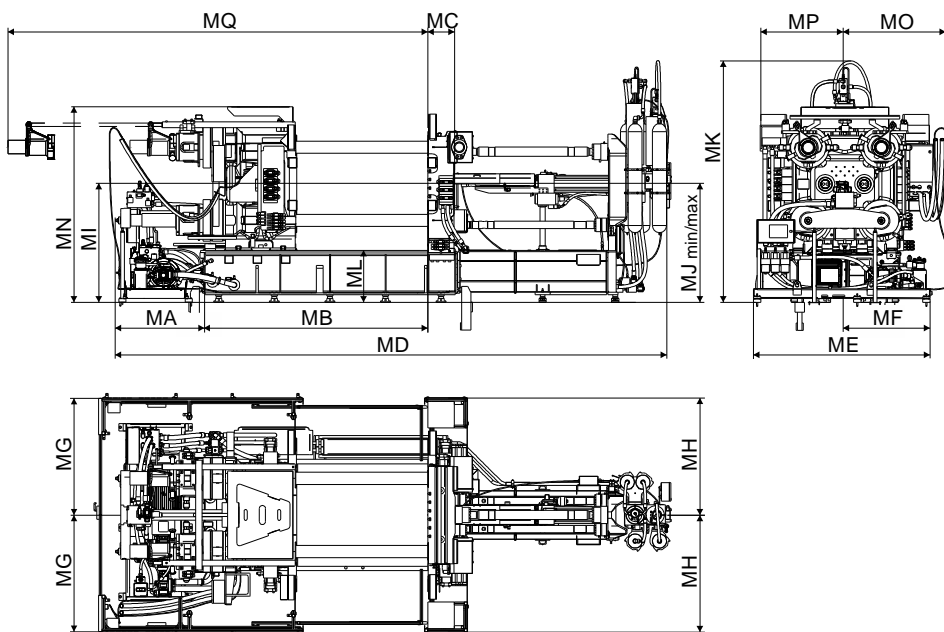


■ Ejector Plate

PA	2000
PB	2448
PC	1250
PD	250
PE	1500
PF	2000
PG	1388
PH	1060
PI	1230
PJ	930
	mm

## Dimension/Weight

Weight of machine ready for production = 87000 kg



MA	1410
MB	4845
MC	525
MD	11037
ME	3035
MF	1302
MG	2170
MH	2172
MI	2200
MJmin	1780
MJmax	2200
MK	4556
ML	856
MN	3696
MO	1861
MP	1815
MQ	8576
	mm

## Control

Installed Load at 400V / 50 Hz = 115 kW

P) Option 670

