

# CARAT 250 compact

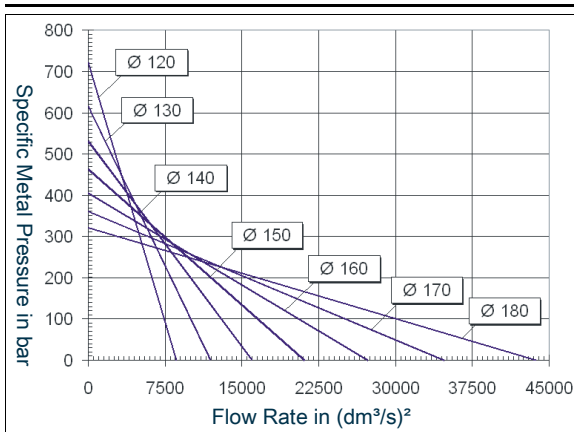
## Injection Unit

Injection Force dynamic	kN	814
Injection Force Intensified	kN	2076
Plunger Stroke	mm	1300
Maximum plunger Velocity	m/s	8.22
Injection Height	mm	0/-560

## Closing Unit

Maximum Locking Force	kN	25000
Ejector Force	kN	680
Ejector Stroke	mm	280
Die Height	mm	880 - 1800
Die opening Stroke	mm	1550
Smallest permissible Die Dimensions	mm	1160 x 1160
Maximum permissible Surface Pressure	N/mm <sup>2</sup>	100

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



## Production Data

	mm	120	130	140	150	160	170	180
Plunger Diameter	mm	120	130	140	150	160	170	180
Maximum Casting Volume	cm <sup>3</sup>	9797	11497	13334	15307	17416	19662	22043
Maximum Casting Weight Al	kg	24.5	28.74	33.33	38.26	43.54	49.2	55.1
Maximum Metal Pressure	bar	1837	1564	1349	1175	1033	915	816
Maximum Projected Area	cm <sup>2</sup>	1361	1597	1852	2126	2420	2732	3063

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	140
Maximum System Pressure	bar	210
Filling Quantity	dm <sup>3</sup>	3800
Water Cooling	m <sup>3</sup> /h	4

## 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>	520

## Nitrogen/Intensifier

Maximum idle Pressure	bar	140
Filling Quantity	dm <sup>3</sup>	70

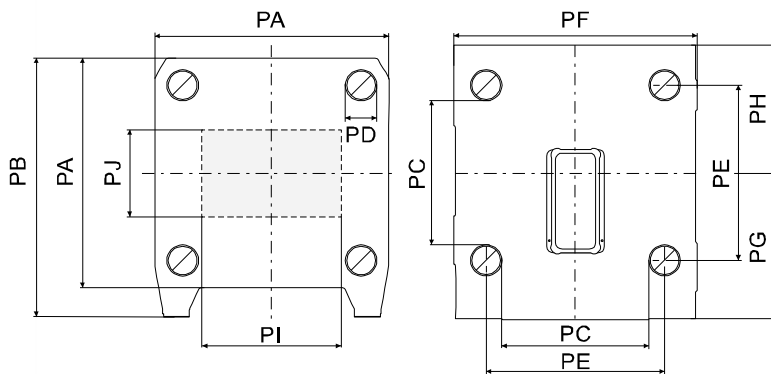
## Simultaneous hydraulic unit

Usable volume	dm <sup>3</sup>	72
Available accumulator pressure	bar max	200



# CARAT 250 compact

## Platen

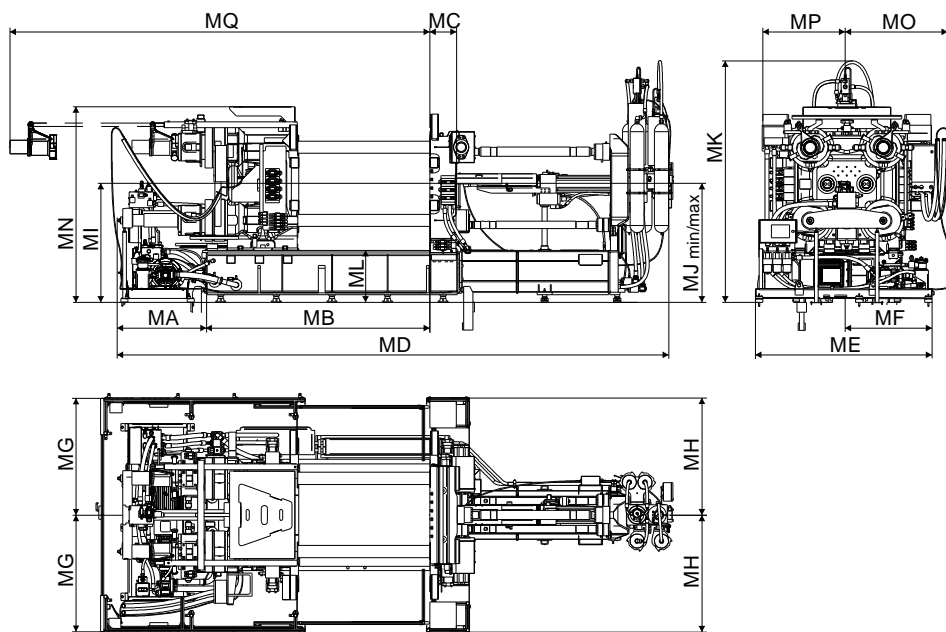


■ Ejector Plate

PA	2480
PB	2993
PC	1550
PD	310
PE	1860
PF	2480
PG	1698
PH	1295
PI	1430
PJ	1100
	mm

## Dimension/Weight

Weight of machine ready for production = 158000 kg



MA	1725
MB	6005
MC	640
MD	13498
ME	3191
MF	1260
MG	2470
MH	2470
MI	2526
MJmin	1966
MJmax	2526
MK	4872
ML	882
MN	4386
MO	2139
MP	1910
MQ	10603
	mm

## Control

Installed Load at 400V / 50 Hz = 140 kW

P) Option 670

