

# CARAT 320 compact

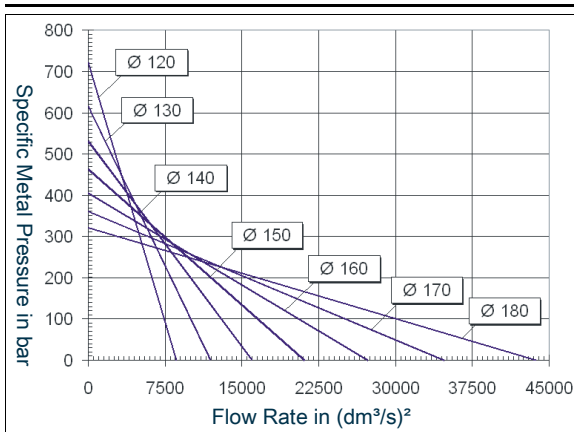
## Injection Unit

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	32000
Ejector Force	kN	680
Ejector Stroke	mm	280
Die Height	mm	988 - 2000
Die opening Stroke	mm	1700
Smallest permissible Die Dimensions	mm	1280 x 1280
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>	1742	2044	2371	2722	3097	3497	3920

Casting Weight =  $\frac{2}{3} \times \text{Plunger Stroke} \times \text{Plunger Surface} \times \text{Density (Al: 2,5 kg/dm}^3\text{)}$

## 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

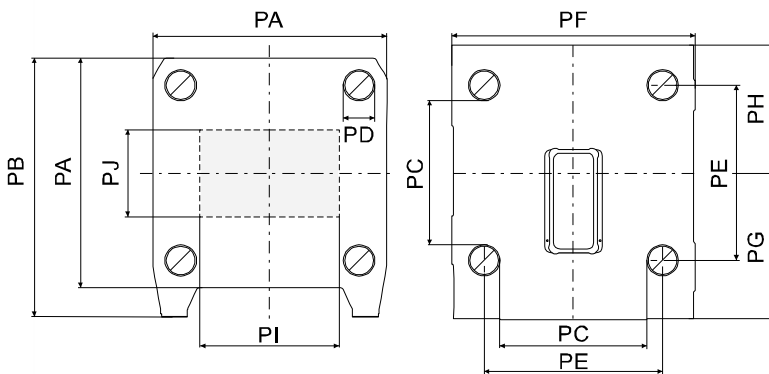
## Simultaneous hydraulic unit

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



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## Platen

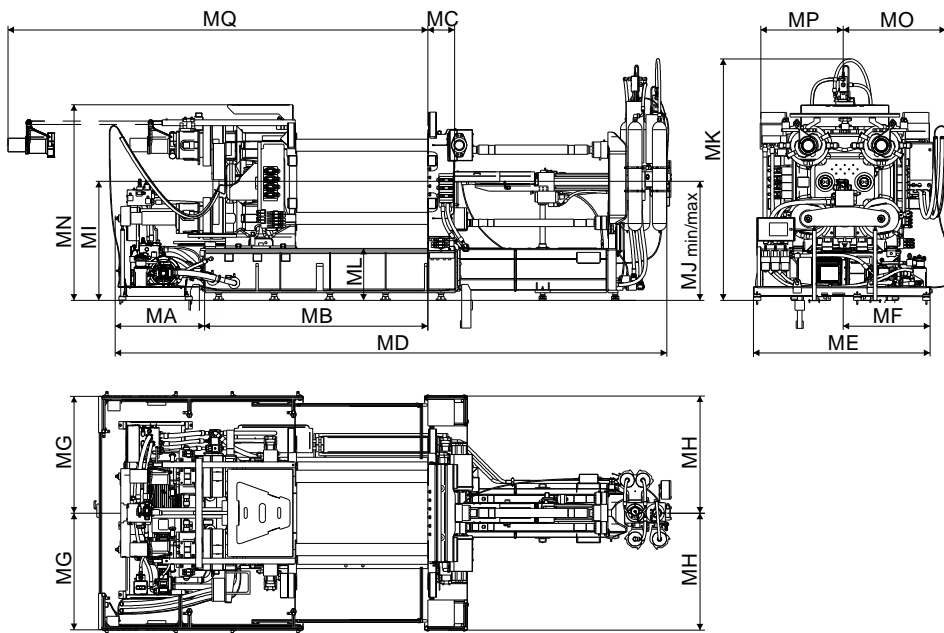


■ Ejector Plate

PA	2750
PB	3283
PC	1700
PD	350
PE	2050
PF	2750
PG	1868
PH	1415
PI	1510
PJ	1180
mm	

## Dimension/Weight

Weight of machine ready for production = 209000 kg



MA	2405
MB	6005
MC	725
MD	14178
ME	3191
MF	1260
MG	2670
MH	2670
MI	2696
MJmin	2136
MJmax	2696
MK	5002
ML	882
MN	4718
MO	2302
MP	2045
MQ	11619
mm	

## Control

Installed Load at 400V / 50 Hz = 140 kW

P) Option 670

