



60... 420 EL-EXISS

TECHNICAL DESCRIPTION ERGOTECH

Demag ergotech

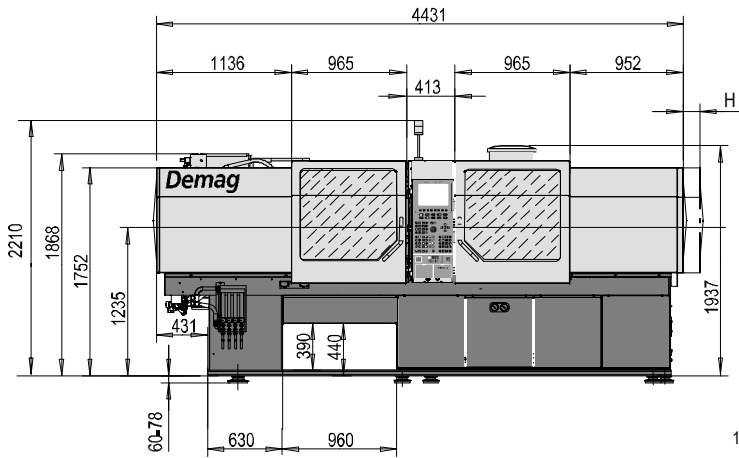
Technical Data Ergotech 60/370 EL-EXIS S

Demag Ergotech	Ergotech 60/370 EL-EXIS S												
	Ergotech 60/370-120 EL-EXIS S				Ergotech 60/370-200 EL-EXIS S				Ergotech 60/370-310 EL-EXIS S				
	600-120				600-200				600-310				
Model description													
International size description													
Clamping unit	60												
Clamping force [kN]	600												
Locking force [kN]	660												
Max. mould opening stroke [mm]	350												
Min. mould height [mm]	160												
Max./enlarged mould height [mm]	360/460												
Overall size of platens/enlarged [mm]	710/810												
Mould platen (h x v) [mm]	600 x 600												
Distance between tie bars (h x v) [mm]	370 x 370												
Ejection stroke [mm]	100												
Ejection force [kN]	34												
Retraction force [kN]	16												
Injection unit	120				200				310				
Screw diameter [mm]	22	25	30	25	30	35	30	30	35	40	30	35	
Screw geometry	standard	standard	standard	standard	standard	standard	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	
L/D ratio	20	20	20	20	20	20	25	20	20	20	25	25	
Injection pressure (up to 400 °C) [bar]	2400	2000	1390	2400	1990	1460	1990	2400	2024	1550	2400	2024	
Cylinder head volume [cm ³]	42	61	88	61	106	144	106	106	168	220	106	168	
Max. shot weight (PS, PE*) [g]	40	60	80	60	100	130	80*	100	150	200	80*	120*	
Rate of injection													
> with accumulator [cm ³ /s]	380	490	710	490	710	910	710	710	910	1130	710	910	
Plasticising rate (PS, PE*) [g/s]	6,8	11,3	18,8	11,3	18,8	25,5	15,8*	18,8	25,5	37,5	15,8*	21,8*	
Max. screw stroke [mm]	110	125	125	125	150	150	150	150	175	175	150	175	
Max. distance of nozzle retraction [mm]	200			200				250					
Max. nozzle dipping depth (SVO) [mm]	20			20				20					
Nozzle sealing force [kN]	60			60				60					
Hopper capacity [ltr.]	35			35				35					
General data	60/370-120				60/370-200				60/370-310				
Oil tank capacity [ltr.]	105				105				105				
Installed electrical rating													
> pump unit ³⁾ [kW]	15				15				15				
> electric screw drive ³⁾ [≈ kW]	11,3				11,3				18				
> capacity clamp unit ³⁾ [≈ kW]	10,4				10,4				10,4				
> heating capacity of screw cylinder [≈ kW]	5,1	5,7	8,3	5,7	8,3	9,4	11,3	8,3	9,4	11,1	11,3	13,0	
> total capacity [≈ kW]	41,8	42,4	45,0	42,4	45,0	46,1	48,0	51,7	52,8	54,5	54,7	56,4	
Dry cycles (EUROMAP 6) [s-mm]	1,3 - 259				1,3 - 259				1,3 - 259				
Net weight (without oil) [≈ kg]	5200				5300				5400				
Machine dimensions (l x w x h) ⁴⁾ [≈ m]	4,6 x 1,4 x 2,2				4,6 x 1,4 x 2,2				4,6 x 1,4 x 2,2				
Electric drive projection (H) ⁵⁾ [mm]	0/206	0/206	0/206	0/70	0/70	0/70	0/70	0/70	0/70	0/70	0/70	0/70	

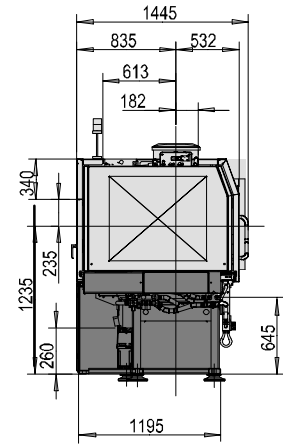
We reserve the right to make changes as a result of further technical advantages

- 1) homogenisation screw
- 2) at maximum torque
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact/retraction

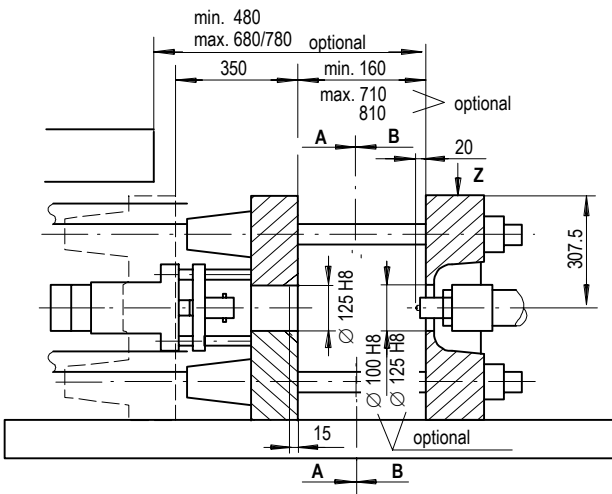
Machine dimensions Ergotech 60/370 EL-EXIS S



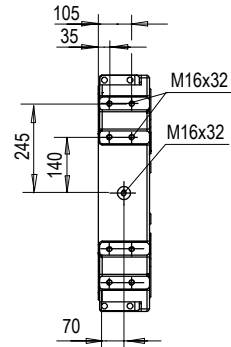
1) valid for injection unit 120



Platen dimensions Ergotech 60/370 EL-EXIS S

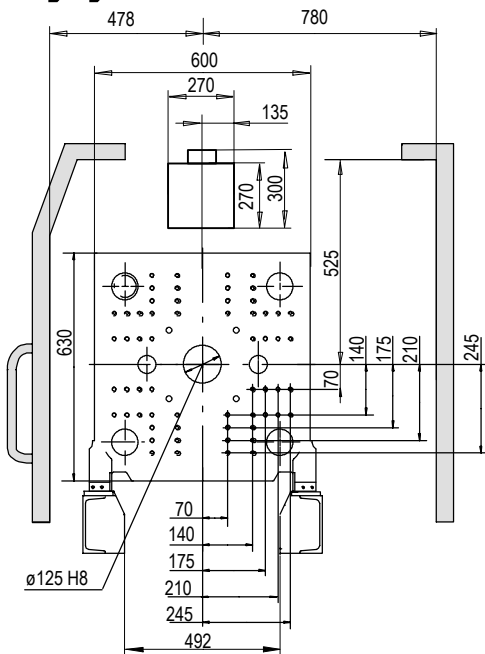


Z Hole pattern for robot/sprue picker on fixed platen



Moving platen

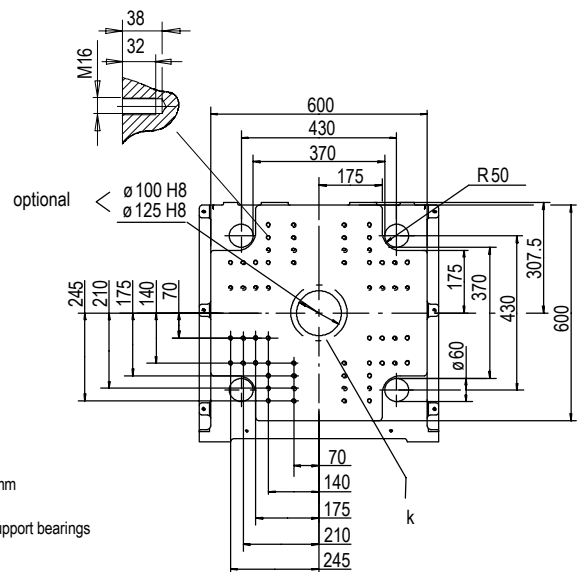
B - B



Hole pattern according EUROMAP
 k = minimum permissible mould \varnothing 215 mm
 Max. permissible mould weight 700 kg,
 max. 450 kg of it on the moving platen support bearings
 \oplus bore diameter \varnothing 27 through holes

Fixed platen

A - A



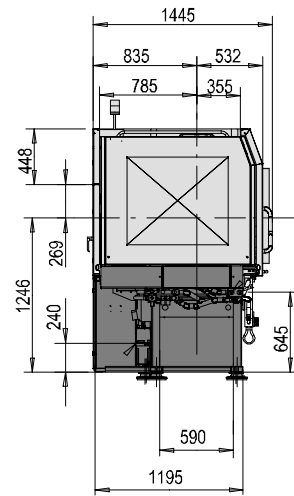
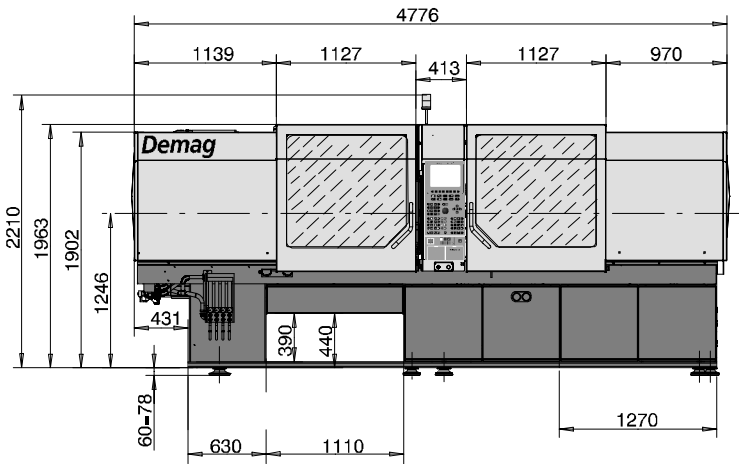
Technical Data Ergotech 100/420 EL-EXIS S

Demag Ergotech		Ergotech 100/420 EL-EXIS S														
Model description		Ergotech 100/420-200 EL-EXIS S					Ergotech 100/420-310 EL-EXIS S					Ergotech 100/420-430 EL-EXIS S				
International size description		1000-200					1000-310					1000-430				
Clamping unit		100/420														
Clamping force	[kN]	1000														
Locking force	[kN]	1100														
Max. mould opening stroke	[mm]	380														
Min. mould height	[mm]	200														
Max./enlarged mould height	[mm]	430 / 495														
Overall size of platens/enlarged	[mm]	810 / 875														
Mould platen (h x v)	[mm]	600 x 600														
Distance between tie bars (h x v)	[mm]	420 x 420														
Ejection stroke	[mm]	140														
Ejection force	[kN]	59														
Retraction force	[kN]	29														
Injection unit		200					310					430				
Screw diameter	[mm]	25	30	35	30	30	35	40	30	35	35	40	45	35	40	
Screw geometry		standard	standard	standard	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	
L/D ratio		20	20	20	25	20	20	20	25	25	20	20	20	25	25	
Injection pressure (up to 400 °C)	[bar]	2400	1990	1460	1990	2400	2024	1550	2400	2024	2400	2020	1600	2400	2020	
Cylinder head volume	[cm ³]	61	106	144	106	106	168	220	106	168	168	231	293	168	231	
Max. shot weight (PS, PE*)	[g]	60	100	130	80*	100	150	200	80*	120*	150	210	260	120*	160*	
Rate of injection																
> with accumulator	[cm ³ /s]	490	710	910	710	710	910	1130	710	910	910	1130	1350	910	1130	
Plasticising rate (PS, PE*)	[g/s]	11,3	18,8	25,5 ²⁾	15,8*	18,8	25,5	37,5 ²⁾	15,8*	21,8*	25,5	37,5	47,3 ²⁾	21,8*	32,3*	
Max. screw stroke	[mm]	125	150	150	150	150	175	175	150	175	175	184	184	175	184	
Max. distance of nozzle retraction	[mm]	200					250					300				
Max. nozzle dipping depth (SVO)	[mm]	20					20					20				
Nozzle sealing force	[kN]	60					60					60				
Hopper capacity	[ltr.]	35					35					35				
General data		100/420-200					100/420-310					100/420-430				
Oil tank capacity	[ltr.]	105					105					105				
Installed electrical rating																
> pump unit ³⁾	[kW]	15					15					15				
> electric screw drive ³⁾	[≈ kW]	11,3					18					25,1				
> capacity clamp unit ³⁾	[≈ kW]	12					12					12				
> heating capacity of screw cylinder	[≈ kW]	5,7	8,3	9,4	11,3	8,3	9,4	11,1	11,3	13,0	9,4	11,1	11,3	13,0	14,0	
> total capacity	[≈ kW]	44,0	46,6	47,7	49,6	53,3	54,4	56,1	56,3	58,0	61,5	63,2	63,4	65,1	66,1	
Dry cycles (EUROMAP 6)	[s-mm]	1,5 - 294					1,5 - 294					1,5 - 294				
Net weight (without oil)	[≈ kg]	5800					5900					6000				
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	4,8 x 1,4 x 1,9					4,8 x 1,4 x 1,9					4,8 x 1,4 x 1,9				
Electric drive projection (H) ⁵⁾	[mm]	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	0/0	

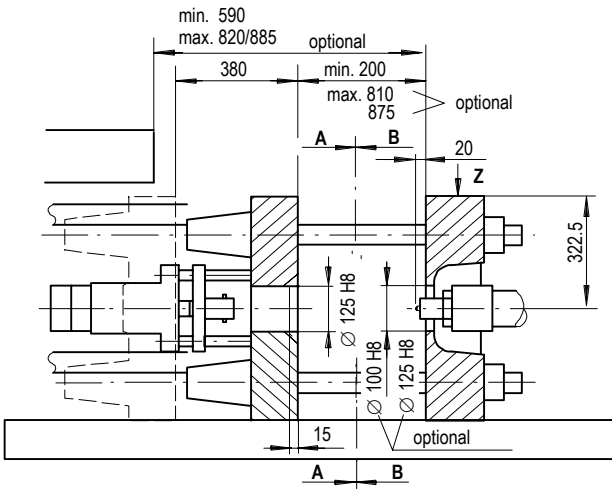
We reserve the right to make changes as a result of further technical advantages

- 1) homogenisation screw
- 2) at maximum torque
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact/retraction

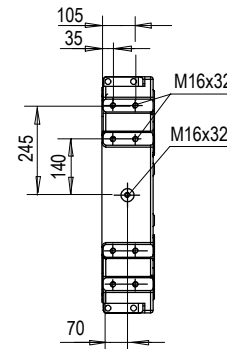
Machine dimensions Ergotech 100/420 EL-EXIS S



Platen dimensions Ergotech 100/420 EL-EXIS S

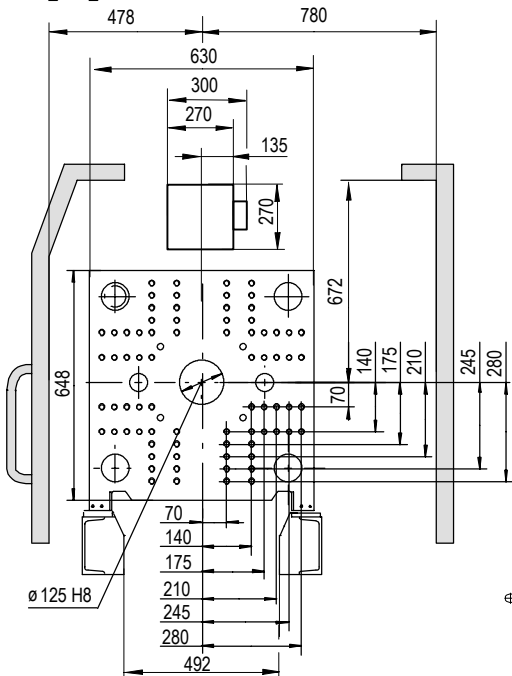


Z Hole pattern for robot/sprue picker on fixed platen



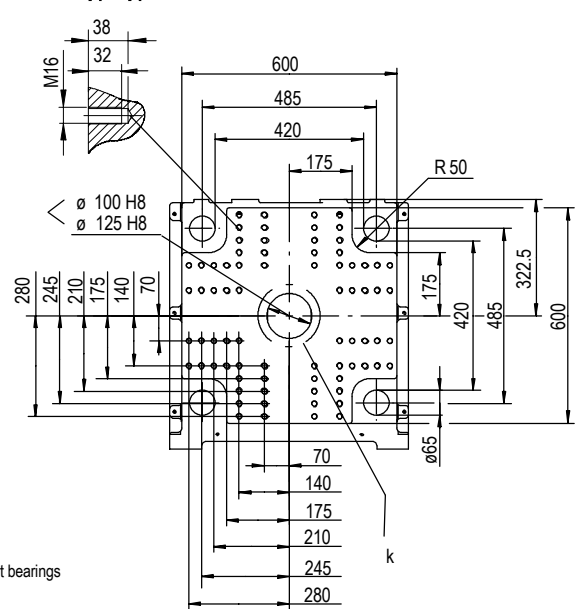
Moving platen

B - B



Fixed platen

A - A



Hole pattern according EUROMAP

k = minimum permissible mould \varnothing 215 mm

Max. permissible mould weight 700 kg,

max. 450 kg of it on the moving platen support bearings

⊕ bore diameter \varnothing 27 through holes

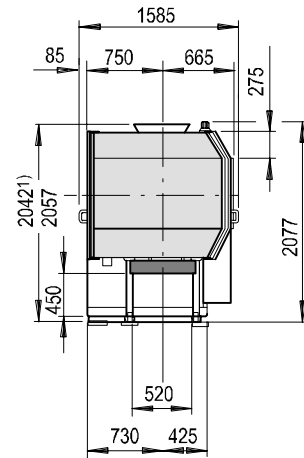
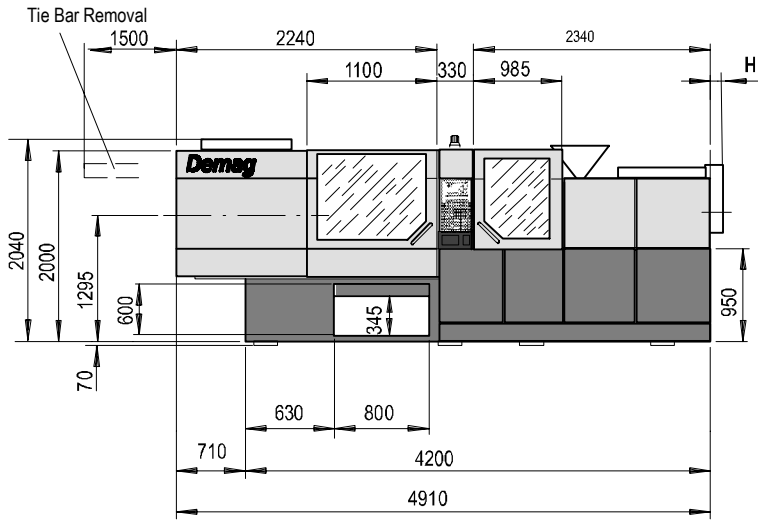
Technical Data Ergotech 125/475 EL-EXIS S

Demag Ergotech	Ergotech 125/475 EL-EXIS S														
Model description	Ergotech 125/475-320 EL-EXIS S					Ergotech 125/475-440 EL-EXIS S					Ergotech 125/475-610 EL-EXIS S				
International size description	1250-320					1250-440					1250-610				
Clamping unit	125														
Clamping force [kN]	1250														
Locking force [kN]	1375														
Max. mould opening stroke [mm]	450														
Min. mould height [mm]	230														
Max./enlarged mould height [mm]	460/560														
Overall size of platens/enlarged [mm]	910/1010														
Mould platen (h x v) [mm]	690 x 660														
Distance between tie bars (h x v) [mm]	475 x 450														
Ejection stroke [mm]	140														
Ejection force [kN]	59														
Retraction force [kN]	29														
Injection unit	320					440					610				
Screw diameter [mm]	30	35	40	30	35	35	40	45	35	40	40	45	50	40	45
Screw geometry	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio	20	20	20	25	25	20	20	20	25	25	20	20	20	25	25
Injection pressure (up to 400 °C) [bar]	2420	1877	1437	2420	1877	2423	1855	1466	2423	1855	2418	1973	1598	2418	1973
Cylinder head volume [cm ³]	124	168	220	124	168	177	231	293	177	231	255	323	399	255	323
Max. shot weight (PS, PE*) [g]	110	150	200	90*	120*	160	210	260	130*	160*	230	290	360	180*	230*
Rate of injection															
> with accumulator [cm ³ /s]	710	910	1130	710	910	910	1130	1350	910	1130	1130	1350	1570	1130	1350
Plasticising rate (PS, PE*) [g/s]	23	32	32	20*	27*	34	44	40	29*	38*	41	52	57	37*	47*
Max. screw stroke [mm]	175					184					203				
Max. distance of nozzle retraction [mm]	350					350					350				
Max. nozzle dipping depth (SVO) [mm]	20					20					20				
Nozzle sealing force [kN]	80					80					80				
Hopper capacity [ltr.]	70					70					70				
General data	125/475-320					125/475-440					125/475-610				
Oil tank capacity [ltr.]	400					400					400				
Installed electrical rating															
> pump unit ³⁾ [kW]	15					15					15				
> electric screw drive ³⁾ [≈ kW]	15					22					27				
> capacity clamp unit ³⁾ [≈ kW]	22					22					22				
> heating capacity of screw cylinder [≈ kW]	8	8	12	12	13	8	12	13	13	16	12	13	15	16	19
> total capacity [≈ kW]	60	60	64	64	65	67	71	72	72	75	76	77	79	80	83
Dry cycles (EUROMAP 6) [s-mm]	1,48 - 392					1,48 - 392					1,48 - 392				
Net weight (without oil) [≈ kg]	6550					6850					6850				
Machine dimensions (l x w x h) ⁴⁾ [≈ m]	4,9 x 1,6 x 2,1					4,9 x 1,6 x 2,1					4,9 x 1,6 x 2,1				
Electric drive projection (H) ⁵⁾ [mm]	0/0	0/0	0/64	0/0	0/116	0/0	0/122	0/278	0/174	0/322	0/143	0/299	108/458	0/343	174/524

We reserve the right to make changes as a result of further technical advantages

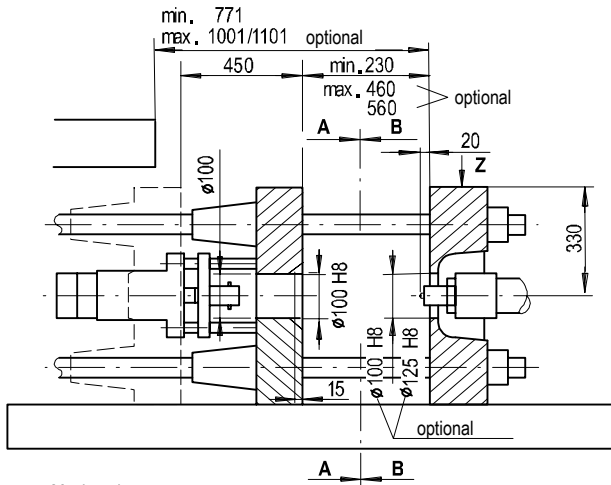
- 1) homogenisation screw
- 2) at maximum torque
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact/retraction

Machine dimensions Ergotech 125/475 EL-EXIS S



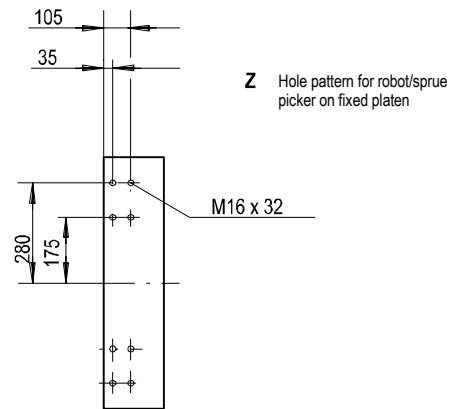
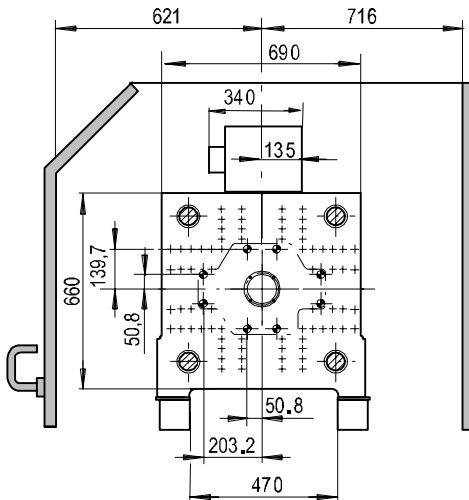
1) valid for injection unit 320

Platen dimensions Ergotech 125/475 EL-EXIS S



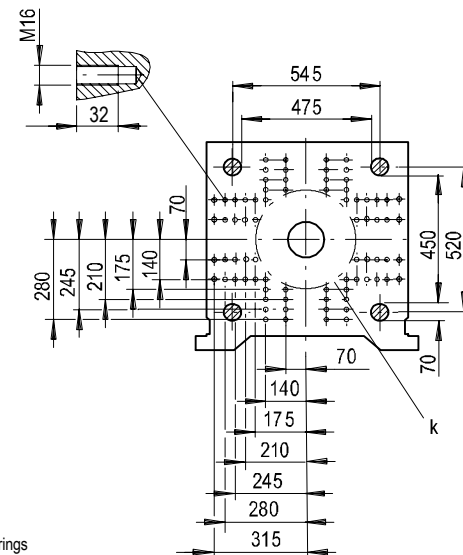
Moving platen

B - B



Fixed platen

A - A



Hole pattern according EUROMAP
 k = minimum permissible mould \varnothing 285 mm
 Max. permissible mould weight 1100 kg,
 max. 730 kg of it on the moving platen support bearings
 \varnothing bore diameter \varnothing 27 through holes

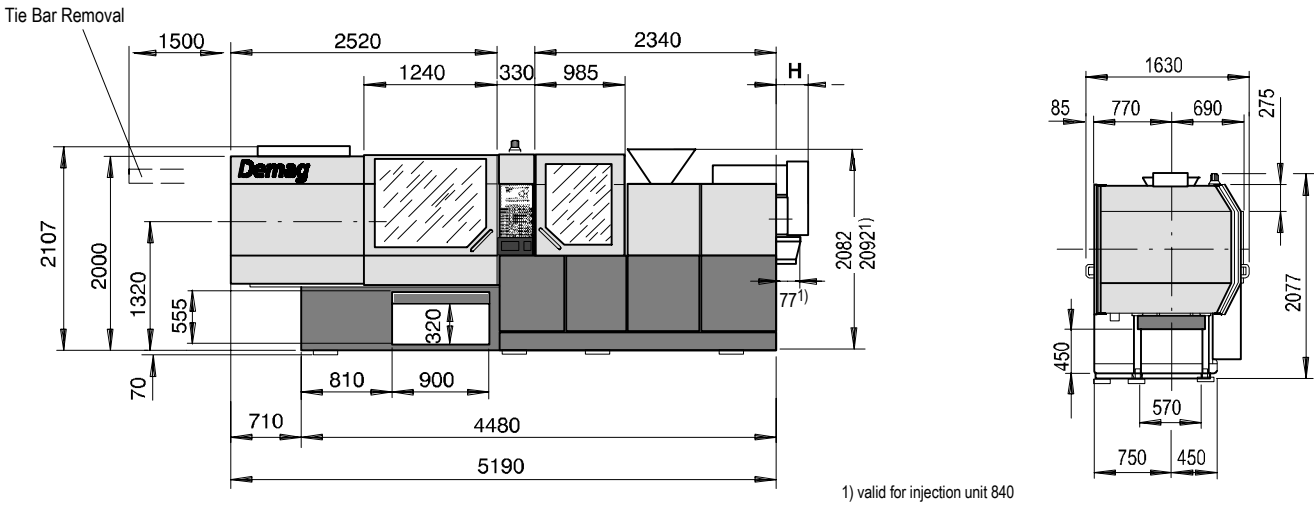
Technical Data Ergotech 150/500 EL-EXIS S

Demag Ergotech	Ergotech 150/500 EL-EXIS S															
	Ergotech 150/500-440 EL-EXIS S					Ergotech 150/500-610 EL-EXIS S					Ergotech 150/500-840 EL-EXIS S					
	1500-440					1500-610					1500-840					
Model description																
International size description																
Clamping unit	150															
Clamping force	[kN] 1500															
Locking force	[kN] 1650															
Max. mould opening stroke	[mm] 500															
Min. mould height	[mm] 250															
Max./enlarged mould height	[mm] 560/660															
Overall size of platens/enlarged	[mm] 1060/1160															
Mould platen (h x v)	[mm] 750 x 750															
Distance between tie bars (h x v)	[mm] 500 x 500															
Ejection stroke	[mm] 160															
Ejection force	[kN] 59															
Retraction force	[kN] 29															
Injection unit	440					610					840					
Screw diameter	[mm] 35	40	45	35	40	40	45	50	40	45	45	50	60	45	50	
Screw geometry	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	
L/D ratio	20	20	20	25	25	20	20	20	25	25	20	20	20	25	25	
Injection pressure (up to 400 °C)	[bar] 2423	1855	1466	2423	1855	2418	1973	1598	2418	1973	2402	1946	1351	2402	1946	
Cylinder head volume	[cm ³] 177	231	293	177	231	255	323	399	255	323	358	442	636	358	442	
Max. shot weight (PS, PE*)	[g] 160	210	260	130*	160*	230	290	360	180*	230*	320	400	570	250*	310*	
Rate of injection																
> with accumulator	[cm ³ /s] 910	1130	1350	910	1130	1130	1350	1570	1130	1350	1350	1570	1970	1350	1570	
Plasticising rate (PS, PE*)	[g/s] 34	44	40	29*	38*	41	52	57	37*	47*	42	60	67	38*	50*	
Max. screw stroke	[mm]		184					203					225			
Max. distance of nozzle retraction	[mm]		350					350					350			
Max. nozzle dipping depth (SVO)	[mm]		20					20					20			
Nozzle sealing force	[kN]		80					80					80			
Hopper capacity	[ltr.]		70					70					70			
General data	150/500-440					150/500-610					150/500-840					
Oil tank capacity	[ltr.]	400					400					400				
Installed electrical rating																
> pump unit ³⁾	[kW]	15					15					15				
> electric screw drive ³⁾	[≈ kW]	22					27					32				
> capacity clamp unit ³⁾	[≈ kW]	22					22					22				
> heating capacity of screw cylinder	[≈ kW]	8	12	13	13	16	12	13	15	16	19	13	15	23	19	22
> total capacity	[≈ kW]	67	71	72	72	75	76	77	79	80	83	82	84	92	88	91
Dry cycles (EUROMAP 6)	[s-mm]	1,62 - 350					1,62 - 350					1,62 - 350				
Net weight (without oil)	[≈ kg]	7900					7900					8200				
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	5,2 x 1,7 x 2,1					5,2 x 1,7 x 2,1					5,2 x 1,7 x 2,1				
Electric drive projection (H) ⁵⁾	[mm]	0/0	0/122	0/278	0/174	0/322	0/143	0/299	108/458	0/343	174/524	101/451	260/610	551/901	326/676	510/860

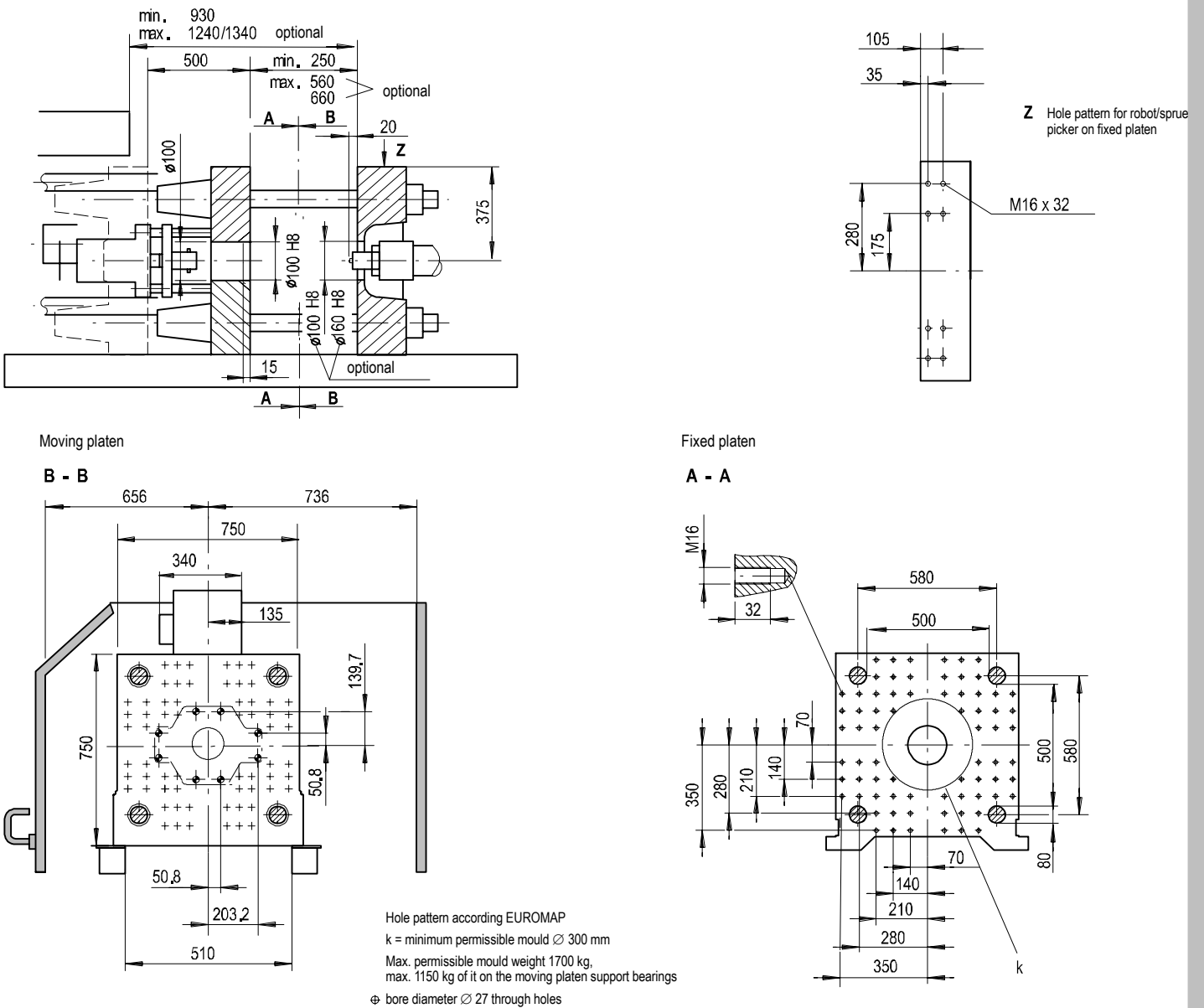
We reserve the right to make changes as a result of further technical advantages

- 1) homogenisation screw
- 2) at maximum torque
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact/retraction

Machine dimensions Ergotech 150/500 EL-EXIS S



Platen dimensions Ergotech 150/500 EL-EXIS S



Technical Data Ergotech 200/560 EL-EXIS S

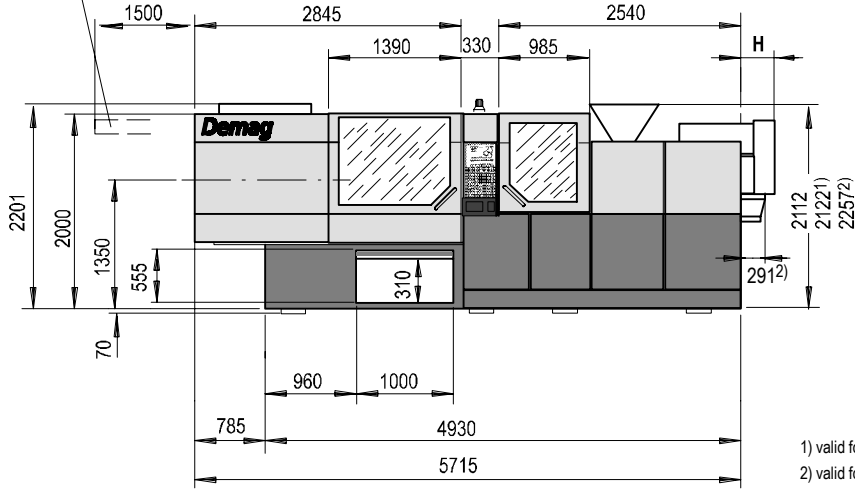
Demag Ergotech	Ergotech 200/560 EL-EXIS S														
Model description	Ergotech 200/560-610 EL-EXIS S					Ergotech 200/560-840 EL-EXIS S					Ergotech 200/560-1450 EL-EXIS S				
International size description	2000-610					2000-840					2000-1450				
Clamping unit	200														
Clamping force [kN]	2000														
Locking force [kN]	2200														
Max. mould opening stroke [mm]	575														
Min. mould height [mm]	310														
Max./enlarged mould height [mm]	660/760														
Overall size of platens/enlarged [mm]	1235/1335														
Mould platen (h x v) [mm]	830 x 830														
Distance between tie bars (h x v) [mm]	560 x 560														
Ejection stroke [mm]	180														
Ejection force [kN]	69														
Retraction force [kN]	31														
Injection unit	610					840					1450				
Screw diameter [mm]	40	45	50	40	45	45	50	60	45	50	50	60	70	50	60
Screw geometry	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio	20	20	20	25	25	20	20	20	25	25	20	20	20	25	25
Injection pressure (up to 400 °C) [bar]	2418	1973	1598	2418	1973	2402	1946	1351	2402	1946	2426	1905	1400	2426	1905
Cylinder head volume [cm ³]	255	323	399	255	323	358	442	636	358	442	530	763	1039	530	763
Max. shot weight (PS, PE*) [g]	230	290	360	180*	230*	320	400	570	250*	310*	480	690	940	380*	540*
Rate of injection															
> with accumulator [cm ³ /s]	1130	1350	1570	1130	1350	1350	1570	1970	1350	1570	1570	1970	2290	1570	1970
Plasticising rate (PS, PE*) [g/s]	41	52	57	37*	47*	42	60	67	38*	50*	49	76	78	41*	68*
Max. screw stroke [mm]	203					225					270				
Max. distance of nozzle retraction [mm]	400					400					400				
Max. nozzle dipping depth (SVO) [mm]	20					20					20				
Nozzle sealing force [kN]	80					80					110				
Hopper capacity [ltr.]	70					70					110				
General data	200/560- 610					200/560- 840					200/560-1450				
Oil tank capacity [ltr.]	500					500					500				
Installed electrical rating															
> pump unit ³⁾ [kW]	15					15					22				
> electric screw drive ³⁾ [≈ kW]	27					32					37				
> capacity clamp unit ³⁾ [≈ kW]	32					32					32				
> heating capacity of screw cylinder [≈ kW]	12	13	15	16	19	13	15	23	19	22	15	23	27	22	31
> total capacity [≈ kW]	86	87	89	90	93	92	94	102	98	101	106	114	118	113	122
Dry cycles (EUROMAP 6) [s-mm]	1,8 - 392					1,8 - 392					1,8 - 392				
Net weight (without oil) [≈ kg]	10650					10950					11450				
Machine dimensions (l x w x h) ⁴⁾ [≈ m]	5,7 x 1,7 x 2,2					5,7 x 1,7 x 2,2					5,7 x 1,7 x 2,2				
Electric drive projection (H) ⁵⁾ [mm]	0/0	0/149	0/308	0/393	0/374	101/501	260/660	551/951	326/726	510/910	402/802	693/1093	997/1397	852/1052	993/1393

We reserve the right to make changes as a result of further technical advantages

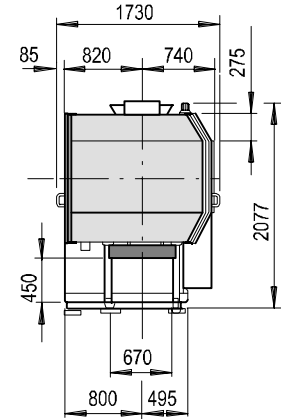
- 1) homogenisation screw
- 2) at maximum torque
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact/retraction

Machine dimensions Ergotech 200/560 EL-EXIS S

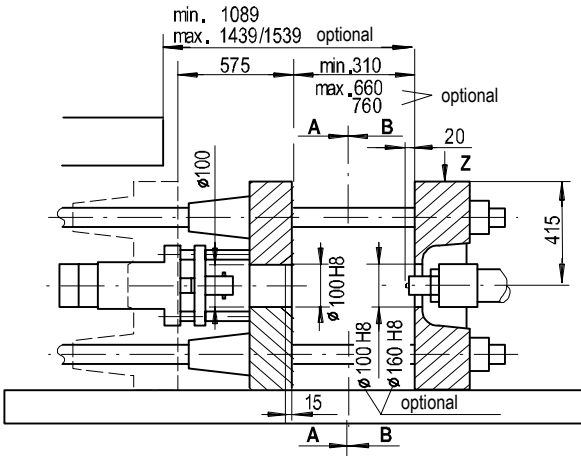
Tie Bar Removal



- 1) valid for injection unit 840
- 2) valid for injection unit 1450

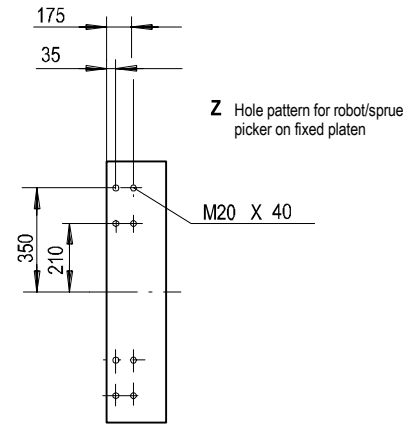


Platen dimensions Ergotech 200/560 EL-EXIS S



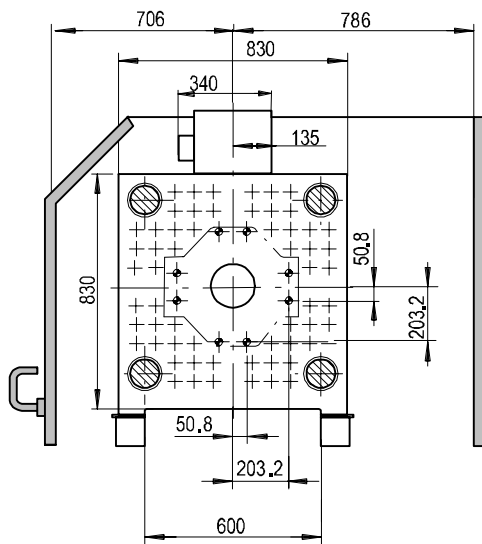
Moving platen

B - B

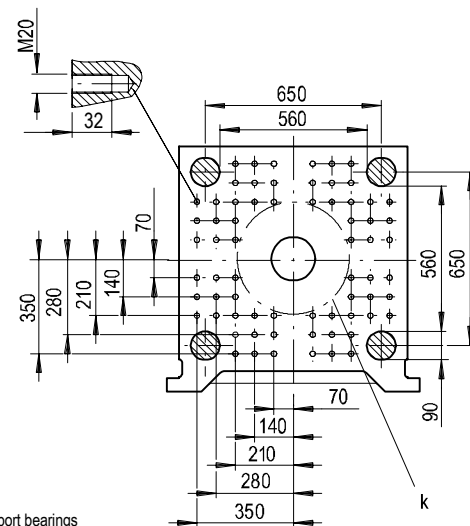


Fixed platen

A - A



Hole pattern according EUROMAP
 k = minimum permissible mould \varnothing 350 mm
 Max. permissible mould weight 2500 kg,
 max. 1700 kg of it on the moving platen support bearings
 \varnothing bore diameter \varnothing 27 through holes



Technical Data Ergotech 250/630 EL-EXIS S

Demag Ergotech		Ergotech 250/630 EL-EXIS S														
Model description		Ergotech 250/630-840 EL-EXIS S					Ergotech 250/630-1450 EL-EXIS S					Ergotech 250/630-2300 EL-EXIS S				
International size description																
Clamping unit		250														
Clamping force	[kN]	2500														
Locking force	[kN]	2750														
Max. mould opening stroke	[mm]	675														
Min. mould height	[mm]	330														
Max./enlarged mould height	[mm]	710/830														
Overall size of platens/enlarged	[mm]	1385/1505														
Mould platen (h x v)	[mm]	950 x 950														
Distance between tie bars (h x v)	[mm]	630 x 630														
Ejection stroke	[mm]	200														
Ejection force	[kN]	69														
Retraction force	[kN]	31														
Injection unit		840					1450					2300				
Screw diameter	[mm]	45	50	60	45	50	50	60	70	50	60	60	70	80	60	70
Screw geometry		standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio		20	20	20	25	25	20	20	20	25	25	20	20	20	25	25
Injection pressure (up to 400 °C)	[bar]	2402	1946	1351	2402	1946	2426	1905	1400	2426	1905	2420	1877	1437	2420	1877
Cylinder head volume	[cm ³]	358	442	636	358	442	530	763	1039	530	763	891	1212	1583	891	1212
Max. shot weight (PS, PE*)	[g]	320	400	570	250*	310*	480	690	940	380*	540*	800	1090	1430	630*	860*
Rate of injection																
> with accumulator	[cm ³ /s]	1350	1570	1970	1350	1570	1570	1970	2290	1570	1970	1970	2290	2480	1970	2290
Plasticising rate (PS, PE*)	[g/s]	42	60	67	38*	50*	49	76	78	41*	68*	61	87	87	55*	79*
Max. screw stroke	[mm]						270					315				
Max. distance of nozzle retraction	[mm]						440					440				
Max. nozzle dipping depth (SVO)	[mm]	20					20					20				
Nozzle sealing force	[kN]	80					110					110				
Hopper capacity	[ltr.]	70					110					110				
General data		250/630-840					250/630-1450					250/630-2300				
Oil tank capacity	[ltr.]	700					700					700				
Installed electrical rating																
> pump unit ³⁾	[kW]	22					22					22				
> electric screw drive ³⁾	[≈ kW]	32					37					46				
> capacity clamp unit ³⁾	[≈ kW]	32					32					32				
> heating capacity of screw cylinder	[≈ kW]	13	15	23	19	22	15	23	27	22	31	23	27	31	31	37
> total capacity	[≈ kW]	99	101	109	105	108	106	114	118	113	122	123	127	131	131	137
Dry cycles (EUROMAP 6)	[s-mm]	2,03 - 441					2,03 - 441					2,03 - 441				
Net weight (without oil)	[≈ kg]	13700					14200					14900				
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	6,5 x 1,9 x 2,3					6,5 x 1,9 x 2,3					6,5 x 1,9 x 2,3				
Electric drive projection (H) ⁵⁾	[mm]	0/171	0/330	181/621	0/396	140/580	32/472	323/763	627/1067	852/1092	623/1063	454/894	758/1198	1064/1504	712/1152	1108/1548

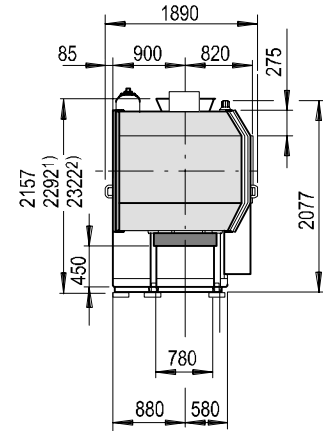
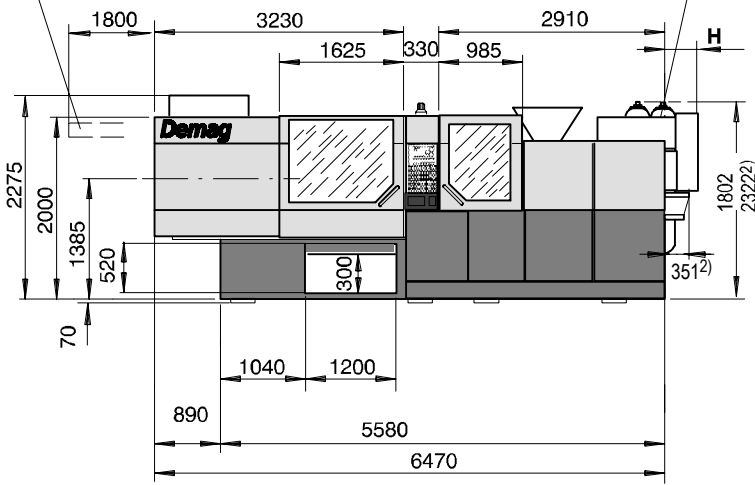
We reserve the right to make changes as a result of further technical advantages

- 1) homogenisation screw
- 2) at maximum torque
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact/retraction

Machine dimensions Ergotech 250/630 EL-EXIS S

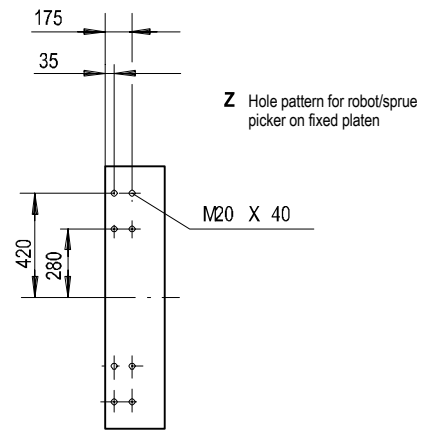
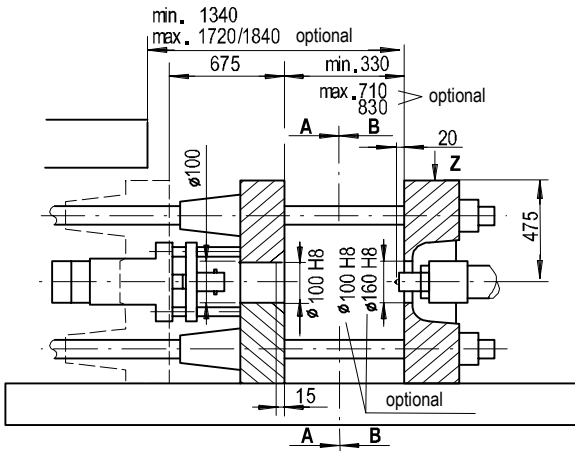
Tie Bar Removal

only EE 1450 and EE 2300



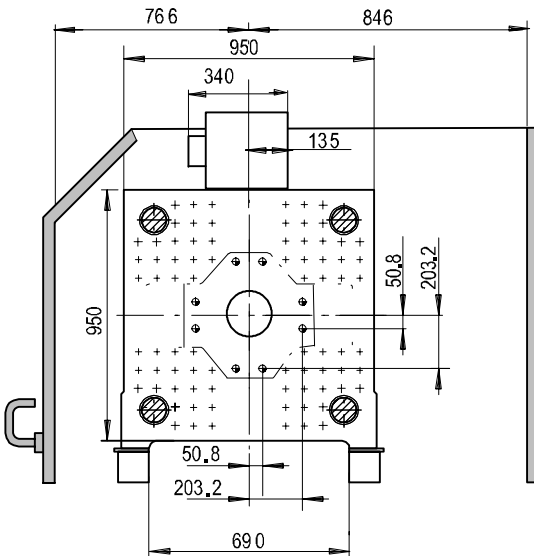
- 1) valid for injection unit 1450
- 2) valid for injection unit 2300

Platen dimensions Ergotech 250/630 EL-EXIS S



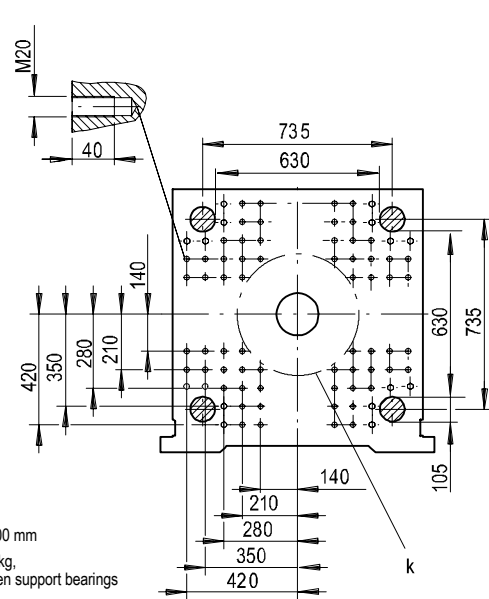
Moving platen

B - B



Fixed platen

A - A



Hole pattern according EUROMAP

k = minimum permissible mould \varnothing 400 mm

Max. permissible mould weight 3300 kg,
max. 2200 kg of it on the moving platen support bearings

⊕ bore diameter \varnothing 27 through holes

Technical Data Ergotech 300/720 EL-EXIS S

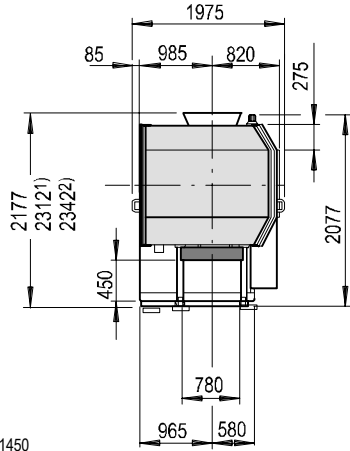
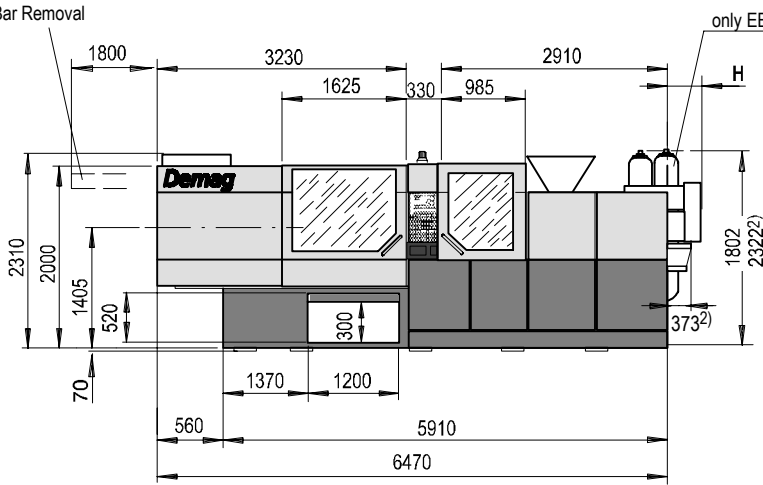
Demag Ergotech		Ergotech 300/720 EL-EXIS S														
Model description		Ergotech 300/720-840 EL-EXIS S					Ergotech 300/720-1450 EL-EXIS S					Ergotech 300/720-2300 EL-EXIS S				
International size description		3000-840					3000-1450					3000-2300				
Clamping unit		300														
Clamping force	[kN]	3000														
Locking force	[kN]	3300														
Max. mould opening stroke	[mm]	675														
Min. mould height	[mm]	330														
Max./enlarged mould height	[mm]	710/830														
Overall size of platens/enlarged	[mm]	1385/1505														
Mould platen (h x v)	[mm]	1040 x 950														
Distance between tie bars (h x v)	[mm]	720 x 650														
Ejection stroke	[mm]	200														
Ejection force	[kN]	69														
Retraction force	[kN]	31														
Injection unit		840					1450					2300				
Screw diameter	[mm]	45	50	60	45	50	50	60	70	50	60	60	70	80	60	70
Screw geometry		standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio		20	20	20	25	25	20	20	20	25	25	20	20	20	25	25
Injection pressure (up to 400 °C)	[bar]	2402	1946	1351	2402	1946	2426	1905	1400	2426	1905	2420	1877	1437	2420	1877
Cylinder head volume	[cm ³]	358	442	636	358	442	530	763	1039	530	763	891	1212	1583	891	1212
Max. shot weight (PS, PE*)	[g]	320	400	570	250*	310*	480	690	940	380*	540*	800	1090	1430	630*	860*
Rate of injection																
> with accumulator	[cm ³ /s]	1350	1570	1970	1350	1570	1570	1970	2290	1570	1970	1970	2290	2480	1970	2290
Plasticising rate (PS, PE*)	[g/s]	42	60	67	38*	50*	49	76	78	41*	68*	61	87	87	55*	79*
Max. screw stroke	[mm]						270					315				
Max. distance of nozzle retraction	[mm]						470					470				
Max. nozzle dipping depth (SVO)	[mm]	20					20					20				
Nozzle sealing force	[kN]	80					110					110				
Hopper capacity	[ltr.]	70					110					110				
General data		300/720-840					300/720-1450					300/720-2300				
Oil tank capacity	[ltr.]	700					700					700				
Installed electrical rating																
> pump unit ³⁾	[kW]	22					22					22				
> electric screw drive ³⁾	[≈ kW]	32					37					46				
> capacity clamp unit ³⁾	[≈ kW]	37					37					37				
> heating capacity of screw cylinder	[≈ kW]	13	15	23	19	22	15	23	27	22	31	23	27	31	31	37
> total capacity	[≈ kW]	104	106	114	110	113	111	119	123	118	127	128	132	136	136	142
Dry cycles (EUROMAP 6)	[s-mm]	2,22-441					2,22-441					2,22-441				
Net weight (without oil)	[≈ kg]	15200					15700					16400				
Machine dimensions (l x w x h) ⁴⁾	[≈ m]	6,5 x 2,0 x 2,3					6,5 x 2,0 x 2,3					6,5 x 2,0 x 2,3				
Electric drive projection (H) ⁵⁾	[mm]	0/201	0/360	181/651	0/426	140/610	454/894	758/1198	627/1097	852/1122	623/1093	454/924	758/1228	1064/1534	712/1182	1108/1578

We reserve the right to make changes as a result of further technical advantages

- 1) homogenisation screw
- 2) at maximum torque
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machinebase
- 5) at nozzle contact/retraction

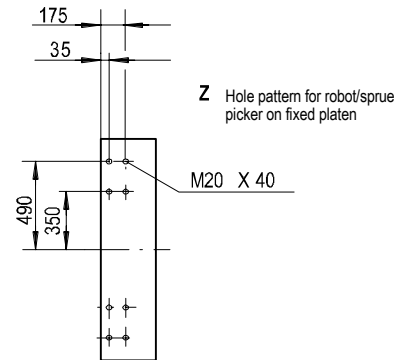
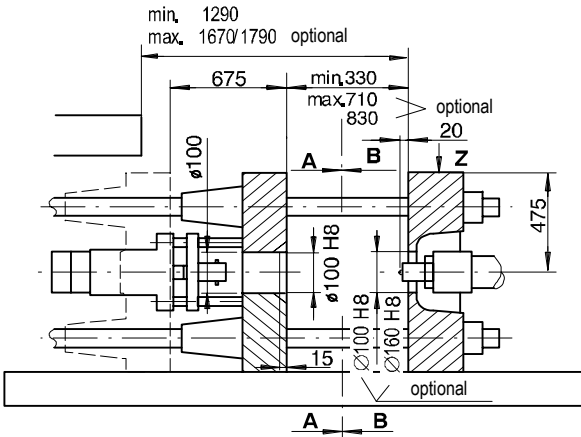
Machine dimensions Ergotech 300/720 EL-EXIS S

Tie Bar Removal



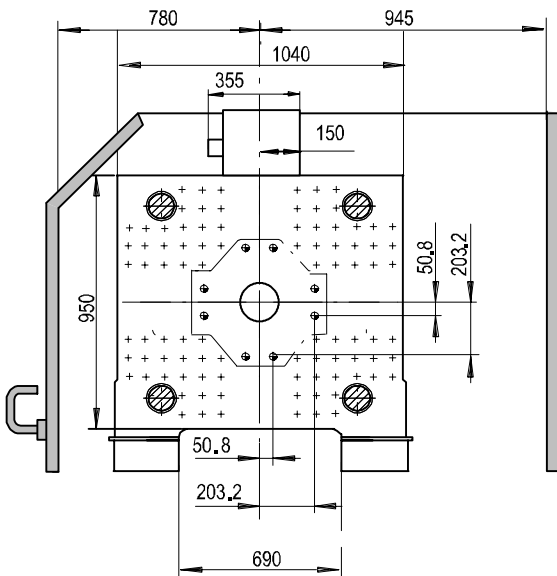
- 1) valid for injection unit 1450
- 2) valid for injection unit 2300

Platen dimensions Ergotech 300/720 EL-EXIS S



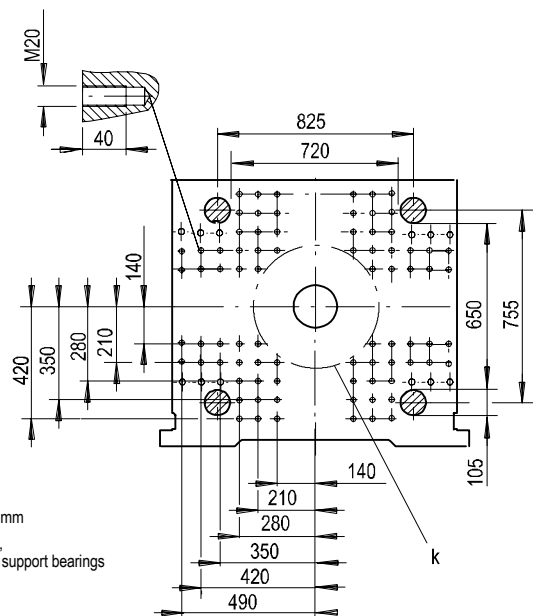
Moving platen

B - B



Fixed platen

A - A



Hole pattern according EUROMAP
 k = minimum permissible mould \varnothing 400 mm
 Max. permissible mould weight 3600 kg,
 max. 2400 kg of it on the moving platen support bearings
 ⊕ bore diameter \varnothing 27 through holes

Technical Data Ergotech 350/810 EL-EXIS S

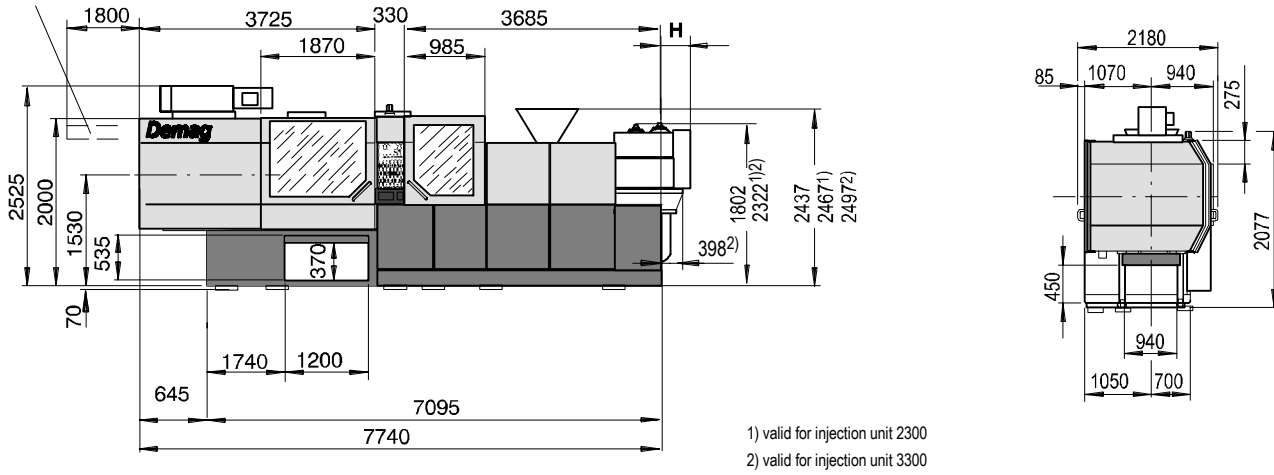
Demag Ergotech	Ergotech 350/810 EL-EXIS S														
Model description	Ergotech 350/810-1450 EL-EXIS S					Ergotech 350/810-2300 EL-EXIS S					Ergotech 350/810-3300 EL-EXIS S				
International size description	3500-1450					3500-2300					3500-3300				
Clamping unit	350														
Clamping force [kN]	3500														
Locking force [kN]	3850														
Max. mould opening stroke [mm]	710														
Min. mould height [mm]	380														
Max./enlarged mould height [mm]	820/940														
Overall size of platens/enlarged [mm]	1530/1650														
Mould platen (h x v) [mm]	1200 x 1100														
Distance between tie bars (h x v) [mm]	810 x 710														
Ejection stroke [mm]	230														
Ejection force [kN]	96														
Retraction force [kN]	41														
Injection unit	1450					2300					3300				
Screw diameter [mm]	50	60	70	50	60	60	70	80	60	70	70	80	95	70	80
Screw geometry	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio	20	20	20	25	25	20	20	20	25	25	23	20	20	23	24
Injection pressure (up to 400 °C) [bar]	2426	1905	1400	2426	1905	2420	1877	1437	2420	1877	2423	1855	1316	2423	1855
Cylinder head volume [cm ³]	530	763	1039	530	763	891	1212	1583	891	1212	1362	1779	2509	1362	1779
Max. shot weight (PS, PE*) [g]	480	690	940	380*	540*	800	1090	1430	630*	860*	1230	1600	2260	970*	1260*
Rate of injection															
> with accumulator [cm ³ /s]	1570	1970	2290	1570	1970	1970	2290	2480	1970	2290	2290	2480	3060	2290	2480
Plasticising rate (PS, PE*) [g/s]	49	76	78	41*	68*	61	87	87	55*	79*	71	100	109	64*	89*
Max. screw stroke [mm]	270					315					354				
Max. distance of nozzle retraction [mm]	620					620					620				
Max. nozzle dipping depth (SVO) [mm]	20					20					20				
Nozzle sealing force [kN]	110					110					110				
Hopper capacity [ltr.]	110					110					110				
General data	350/810-1450					350/810-2300					350/810-3300				
Oil tank capacity [ltr.]	730					730					730				
Installed electrical rating															
> pump unit ³⁾ [kW]	22					22					30				
> electric screw drive ³⁾ [≈ kW]	37					46					52				
> capacity clamp unit ³⁾ [≈ kW]	47					47					47				
> heating capacity of screw cylinder [≈ kW]	15	23	27	22	31	23	27	31	31	37	31	31	43	31	43
> total capacity ³⁾ [≈ kW]	121	129	133	128	137	138	142	146	146	152	160	160	172	160	172
Dry cycles (EUROMAP 6) [s-mm]	2,44-574					2,44-574					2,44-574				
Net weight (without oil) [≈ kg]	20700					21000					22000				
Machine dimensions (l x w x h) ⁴⁾ [≈ m]	7,8 x 2,2 x 2,6					7,8 x 2,2 x 2,6					7,8 x 2,2 x 2,6				
Electric drive projection (H) ⁵⁾ [mm]	0/0	0/168	0/472	0/127	0/468	0/299	0/603	289/909	0/599	333/953	702/1322	702/1322	1069/1689	702/1322	1069/1689

We reserve the right to make changes as a result of further technical advantages

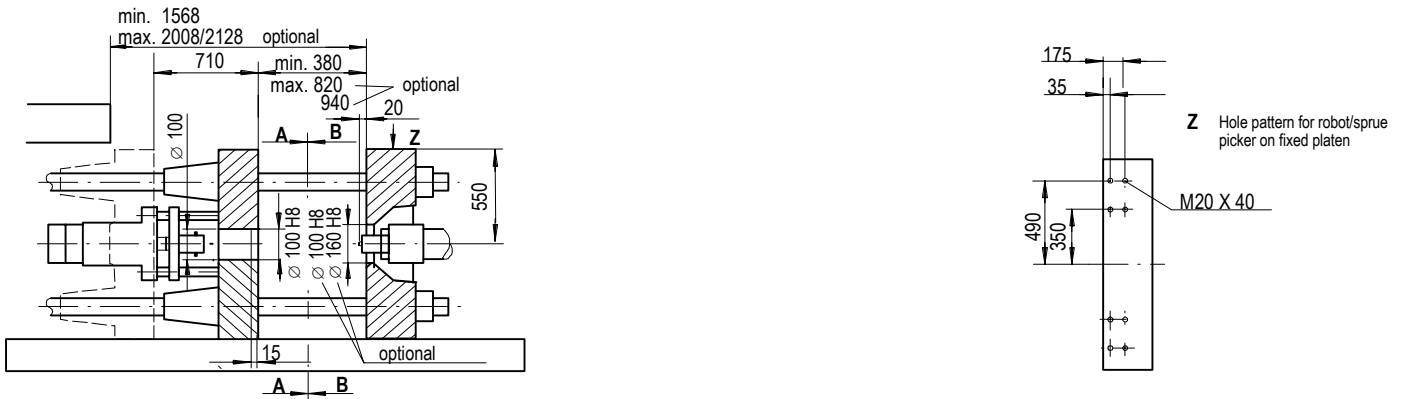
- 1) homogenisation screw
- 2) at maximum torque
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact/retraction

Machine dimensions Ergotech 350/810 EL-EXIS S

Tie Bar Removal

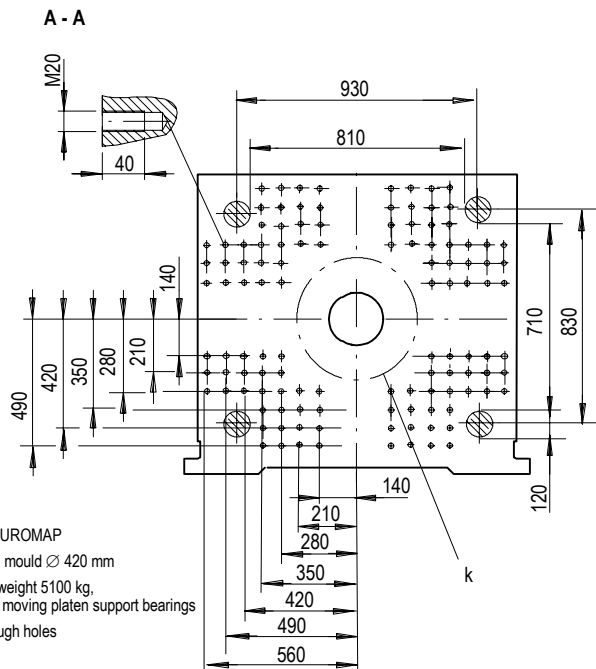
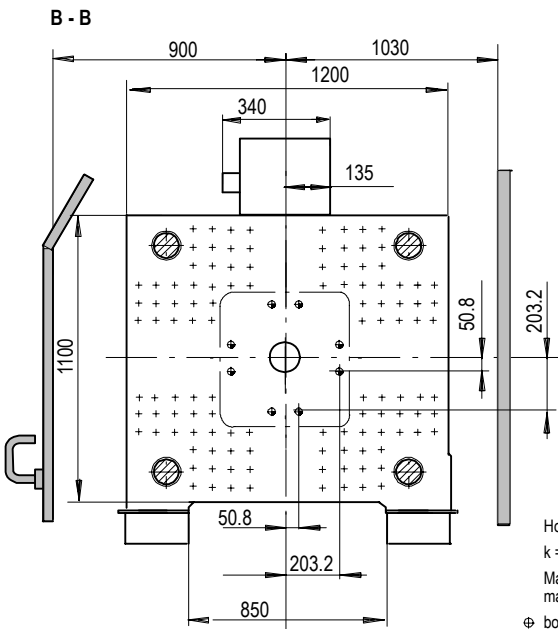


Platen dimensions Ergotech 350/810 EL-EXIS S



Fixed platen

Moving platen



Hole pattern according EUROMAP
k = minimum permissible mould \varnothing 420 mm
Max. permissible mould weight 5100 kg,
max. 3400 kg of it on the moving platen support bearings
 \varnothing bore diameter \varnothing 27 through holes

Technical Data Ergotech 420/810 EL-EXIS S

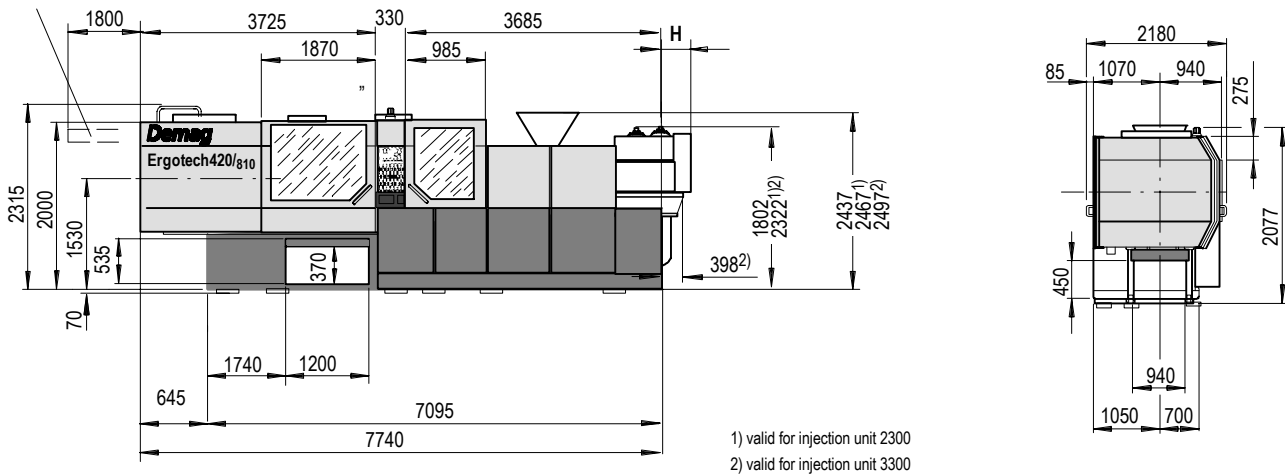
Demag Ergotech	Ergotech 420/810 EL-EXIS S														
Model description	Ergotech 420/810-1450 EL-EXIS S					Ergotech 420/810-2300 EL-EXIS S					Ergotech 420/810-3300 EL-EXIS S				
International size description	4200-1450					4200-2300					4200-3300				
Clamping unit	420														
Clamping force [kN]	4200														
Locking force [kN]	4620														
Max. mould opening stroke [mm]	710														
Min. mould height [mm]	380														
Max./enlarged mould height [mm]	820/940														
Overall size of platens/enlarged [mm]	1530/1650														
Mould platen (h x v) [mm]	1200 x 1100														
Distance between tie bars (h x v) [mm]	810 x 710														
Ejection stroke [mm]	230														
Ejection force [kN]	96														
Retraction force [kN]	41														
Injection unit	1450					2300					3300				
Screw diameter [mm]	50	60	70	50	60	60	70	80	60	70	70	80	95	70	80
Screw geometry	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾	standard	standard	standard	special ¹⁾	special ¹⁾
L/D ratio	20	20	20	25	25	20	20	20	25	25	23	20	20	23	24
Injection pressure (up to 400 °C) [bar]	2426	1905	1400	2426	1905	2420	1877	1437	2420	1877	2423	1855	1316	2423	1855
Cylinder head volume [cm ³]	530	763	1039	530	763	891	1212	1583	891	1212	1362	1779	2509	1362	1779
Max. shot weight (PS, PE*) [g]	480	690	940	380*	540*	800	1090	1430	630*	860*	1230	1600	2260	970*	1260*
Rate of injection															
> with accumulator [cm ³ /s]	1570	1970	2290	1570	1970	1970	2290	2480	1970	2290	2290	2480	3060	2290	2480
Plasticising rate (PS, PE*) [g/s]	49	76	78	41*	68*	61	87	87	55*	79*	71	100	109	64*	89*
Max. screw stroke [mm]	270					315					354				
Max. distance of nozzle retraction [mm]	620					620					620				
Max. nozzle dipping depth (SVO) [mm]	20					20					20				
Nozzle sealing force [kN]	110					110					110				
Hopper capacity [ltr.]	110					110					110				
General data	420/810-1450					420/810-2300					420/810-3300				
Oil tank capacity [ltr.]	730					730					730				
Installed electrical rating															
> pump unit ³⁾ [kW]	22					22					30				
> electric screw drive ³⁾ [≈ kW]	37					46					52				
> capacity clamp unit ³⁾ [≈ kW]	47					47					47				
> heating capacity of screw cylinder [≈ kW]	15	23	27	22	31	23	27	31	31	37	31	31	43	31	43
> total capacity ³⁾ [≈ kW]	121	129	133	128	137	138	142	146	146	152	160	160	172	160	172
Dry cycles (EUROMAP 6) [s-mm]															
Net weight (without oil) [≈ kg]	20700					21000					22000				
Machine dimensions (l x w x h) ⁴⁾ [≈ m]	7,8 x 2,2 x 2,6					7,8 x 2,2 x 2,6					7,8 x 2,2 x 2,6				
Electric drive projection (H) ⁵⁾ [mm]	0/0	0/168	0/472	0/127	0/468	0/299	0/603	289/909	0/599	333/953	702/1322	702/1322	1069/1689	702/1322	1069/1689

We reserve the right to make changes as a result of further technical advantages

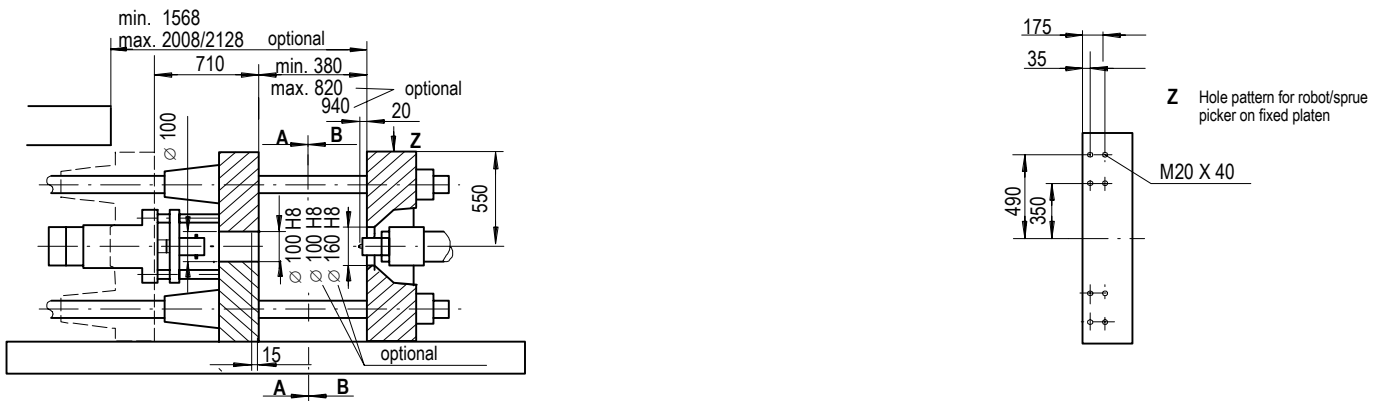
- 1) homogenisation screw
- 2) at maximum torque
- 3) parallel movement of all axis possible
- 4) without extension of the drive over the machine base
- 5) at nozzle contact/retraction

Machine dimensions Ergotech 420/810 EL-EXIS S

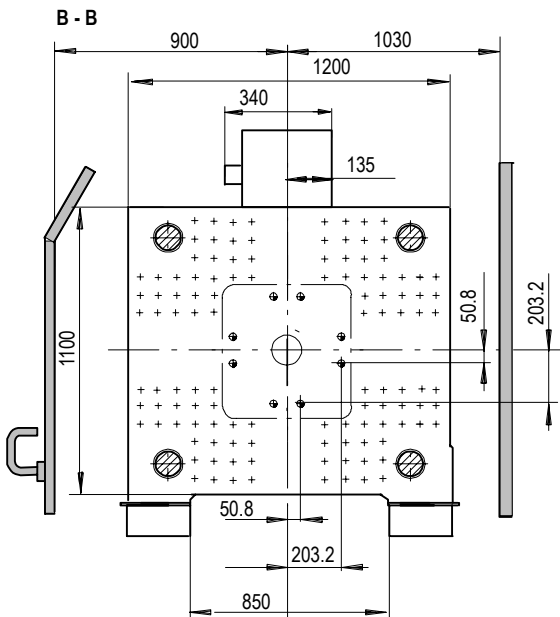
Tie Bar Removal



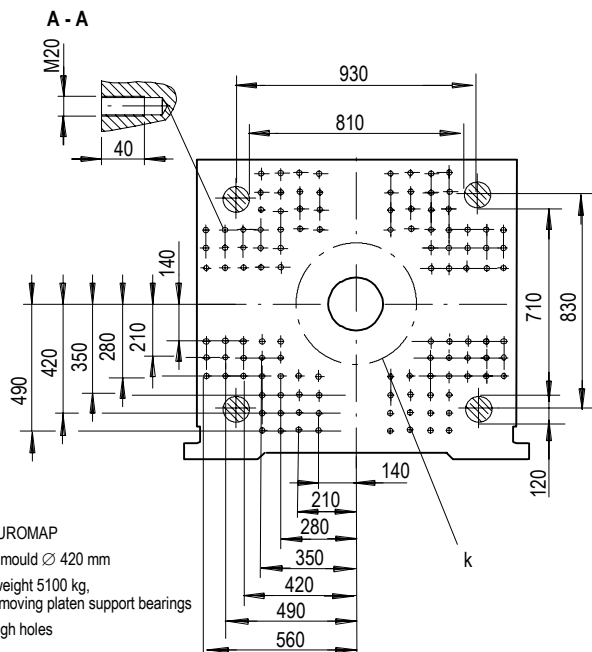
Platen dimensions Ergotech 420/810 EL-EXIS S



Fixed platen



Moving platen



Hole pattern according EUROMAP
 k = minimum permissible mould \varnothing 420 mm
 Max. permissible mould weight 5100 kg,
 max. 3400 kg of it on the moving platen support bearings
 \varnothing bore diameter \varnothing 27 through holes

Equipment Ergotech 60...420 EL-EXIS S

Clamping unit	
> Compact 5-point twin toggle with Compact units with fully hydraulic clamping system with two clamp cylinders and a volume multiplier for fast machine cycles and low energy consumption	●
> Clamping unit with AC servo-drive and hydrostatic transmission for dynamic acceleration	●
> Moving platen supported by roller bearings on machine base	●
> Clamp force adjustable on Ergocontrol panel, with actual value display	●
> Clamp force control with display	●
> Sensitive mould protection using high-resolution force transducer	●
> Mould mounting dimensions in accordance to Euromap, without side ejector plate	●
> Mould mounting dimensions in accordance to Euromap standard, with side ejector plate	○
> Mould mounting dimensions similar to DIN	○
> Mould mounting dimensions similar to SPI	○
> Reduced centering diameter on fixed platen with DIN or EUROMAP	○
> Automatic central oil lubrication for toggle	●
> Chromed tie-bars; upper tiebar on non-operator side retractable	●
> Manual clamping mechanism for tiebar retraction	●
> Automatic tiebar retraction, upper tiebar on operator side (from 1.250 kN)	○
> Extended mould height	○
> Automatic mould height adjustment	○
> Hydraulic central ejector with multi-stroke and mechanical quick coupling	●
> Short/long stroke ejector	●
> Programmable ejector stroke, pressure and speed	●
> Ejector pressure and speed programmable for simultaneous operation with mould movement, including positioning control	●
> Mould and ejector movements only when safety gate closed	●
> Stroke measuring system (ultrasonic) via CAN-Bus for injection operation and movement of the injection unit, clamp- and ejector movement	●
> Sequence matrix for free programming of ejectors and core pullers (simultaneous to mould movement)	●
> Flexible sequence of the clamp unit with or without multiple movement of the ejector and core pullers	○
> Core puller with 1, 2 or 4 circuits, independent speed (simultaneous with mould movement) set via sequence matrix	○
> Additional ports for 2 core pullers on fixed mould platen (from 1.250 kN)	○
> Manual pressure relief for 1, 2 or 4 core pullers	○

Clamping unit	
> 1 or 2 pneumatic 5/2 directional valves, mounted to moving platen and freely programmable	○
> 1 or 2 pneumatic 5/2 directional valves, mounted to fixed platen and freely programmable	○
> 4-way cooling water volume controller	●
> 4 additional cooling water volume controllers	○
> 8 additional cooling water flow controllers	○
> Time-programmable switch-off of mould cooling	●
> Blow-through for mould cooling lines	○
> Unscrewing module with positioning function	○
> Unscrewing module without positioning function	○
> Chute for small parts (up to 1.000 kN)	○
> Automatic safety gate on operator side (from 1.250 kN)	○
> Safety gate prepared for handling device	●

Injection unit	
> Barrels for up to 3 injection units, L/D ratio 20:1 for all diameters	●
> Barrel for high performance applications, L/D ratio 25:1	○
> Barrels with barrier screw, L/D ratio 25:1	○
> Wear and corrosion resistant universal thermoplastic screw, nitrided barrel	●
> Special screws for processing various materials, with screws and non-return valves in wear and corrosion resistant or heavy duty design (powder metal)	○
> Barrel with bi-metallic lining	○
> Open nozzle with M 40x3 thread; M 60x3 from 30 mm screw diameter	●
> Open nozzle with M 24x1,5 connection thread, incl. adapter	○
> Extended open nozzle	○
> Pneumatic shut off nozzle incl. control	○
> Needle shut off nozzle	○
> Melt temperature measuring (only for open nozzles)	○
> Controlled barrel heating zones (ceramic heaters), number dependent on injection unit, and one controlled nozzle heating zone.	●
> Each temperature control circuit with setpoint deviation control and thermocouple break protection; barrel operating temperatures up to 450°C, with pressure limitation above 400°C (from injection unit 3300 up to 400 °C)	●
> Central connector for barrel heaters and thermocouples	●
> Integrated hot runner control, 1 to 16 zones	○
> Hydraulic control for hot runner nozzles	○
> Pneumatic hot runner shut off control	○
> Frequency controlled electric screw drive with AC servo motor	●

● Basic equipment

○ Additional price

We reserve the right to make changes as a result of further technical advances

Injection unit	
> Stainless steel hopper	<input type="radio"/>
> Drilled for hopper loader	<input checked="" type="radio"/>
> Closed-loop control for throat temperature	<input checked="" type="radio"/>
> Barrel quick change with central plugs for heaters and thermocouples, and automatic barrel recognition	<input checked="" type="radio"/>
> Programmable profiles for closed-loop control of injection speed, holding pressure, back pressure and screw speed parameters	<input checked="" type="radio"/>
> Injection, holding pressure and back-pressure regulated by servovalve; regulated screw speed	<input checked="" type="radio"/>
> Accumulator for fast injection cycles and movement of injection unit, cores and ejector	<input checked="" type="radio"/>
> Back pressure programmable in six stages of screw stroke	<input checked="" type="radio"/>
> Switch-over to follow-up pressure by hydraulic pressure, with acquisition of maximum value and pressure recording	<input checked="" type="radio"/>
> Switch-over to holding pressure by cavity pressure, with pressure recording for 1 or 2 pressure transducers	<input type="radio"/>
> Programmable nozzle contact pressure	<input checked="" type="radio"/>
> Residual nozzle sealing force programmable	<input checked="" type="radio"/>
> Two-stage injection unit movement	<input checked="" type="radio"/>
> Injection unit movement parallel to mould movement	<input checked="" type="radio"/>

Hydraulics	
> Separate circuits for oil and mould cooling	<input type="radio"/>
> Closed-loop oil temperature control with display	<input checked="" type="radio"/>
> Oil cooler with increased cooling capacity (from 1.250 kN)	<input type="radio"/>
> Pre-heating circuit for hydraulic oil	<input checked="" type="radio"/>
> Automatic two stage control and display of oil filter contamination	<input checked="" type="radio"/>
> Ports for external oil cleaning during production (bypass filtration)	<input checked="" type="radio"/>
> Additional integrated oil cleaning unit for microfine bypass filtration	<input checked="" type="radio"/>

Electronics	
> Operator-friendly NC4 microprocessor-based Ergocontrol with large LCD colour monitor, alphanumeric keyboard, and disk drive option for data downloads	<input checked="" type="radio"/>
> Setpoint entry switch-over to physical values (bar, ccm, mm/s)	<input checked="" type="radio"/>
> Fault log with trouble shooting hints	<input checked="" type="radio"/>
> Quality control with reject parts recognition	<input checked="" type="radio"/>
> Integrated disk drive for software downloads and saving machine and ancillary settings	<input checked="" type="radio"/>
> Universal printer port	<input checked="" type="radio"/>
> Printer program for external printer for automatic printout of error log, alarms, messages and changes	<input type="radio"/>
> Integrated printer including driver software	<input type="radio"/>
> Smart card reader for controlled access	<input checked="" type="radio"/>
> Additional Ergocontrol operating language	<input checked="" type="radio"/>

Functions	
> Process data acquisition with 100% monitoring and statistics with graphics for of process parameters	<input checked="" type="radio"/>
> Integrated Statistical Process Control (SPC) with display of process control charts	<input type="radio"/>
> Saving of statistical data in ASCII format on disk	<input type="radio"/>
> Integrated production data acquisition	<input type="radio"/>
> Change log	<input type="radio"/>
> Help disk for operator support	<input type="radio"/>
> Additional operating language on disk	<input type="radio"/>
> Mould stroke dependent injection start; nozzle contact pressure remains over the whole cycle	<input type="radio"/>
> Three-stage start-up program	<input type="radio"/>
> On/off program with one purging cycle	<input type="radio"/>
> 1, 2, 3, 5, or 6 freely programmable inputs/outputs	<input type="radio"/>
> Ergostart:integrated basic setting program	<input checked="" type="radio"/>
> Ergosupport: program for faster fault recognition on basic setting / process optimisation and for extended monitoring of process sequence and deviations	<input type="radio"/>
> Mould-dependent machine optimisation	<input type="radio"/>
> Econ 2000 energy consumption metering with graphic display	<input type="radio"/>

Interfaces	
> VGA interface and interface for AT keyboard (MF-II standard)	<input type="radio"/>
> Interface for mould protection (ejector with LS)	<input checked="" type="radio"/>
> Interfaces for ejector limit switch in mould, side action with LS and product detection	<input type="radio"/>
> CAN-Bus interface for temperature controllers (2 circuits), Demag-specific signal	<input type="radio"/>
> Mould temperature display with monitoring for 1 or 2 circuits	<input type="radio"/>
> Interface with three-point controllers for 2 temperature controllers	<input type="radio"/>
> Interface with three-point controllers for 4 temperature controllers	<input type="radio"/>
> 20 mA interface (TTY-V24) for up to 6 units integrated temperature controllers	<input type="radio"/>
> Additional 2 point temperature control for nozzle, 1 circuit	<input type="radio"/>
> Socket for second nozzle heater band	<input type="radio"/>
> Drilled for handling device to VDMA 24466	<input checked="" type="radio"/>
> 32-pin handling interface to Euromap 12 (VDMA)	<input type="radio"/>
> Data interface for three signals: drycycling, automatic, and semi-automatic operation	<input type="radio"/>
> Data interface for main computer systems to EUROMAP 63	<input type="radio"/>
> Ergolink modem interface	<input checked="" type="radio"/>
> Portable Ergolink modem	<input type="radio"/>

Automation	
> Quality reject feature in chute, either for two or three directions (up to 3,000 kN)	○
> 4, 8 or 12 quick connectors for mould cooling (up to 1,000 kN)	○
> Integrated temperature controllers (2 circuits)	○
> Integrated handling device with separate control cabinet	○
> Ergorob sprue picker with integrated control	○
> Interface and control for gas injection process, 1 to 4 circuits integrated	○

General	
> Separate power supply for both drive and heating	●
> Single-phase 230V/50Hz/10A socket in specific national version	●
> Set of sockets in separate cabinet on non-operator side, switched through main isolator and switch-off matrix, 2x 16A three-phase IEC/EE and 2x 10A AC shockproof plugs in specific national versions	○
> Supply voltage 400V, 3/N/PE, 50 Hz	●
> Specific national supply voltage	○
> Full guarding on injection unit operator side	●
> "Supply voltage I/O" switch	○
> Basic equipment to European safety standard (EN 201)	●
> Basic equipment in compliance with national safety standards	○
> Fault indication by flashing lamp	●
> Fault indication by acoustic alarm	○
> Freely assignable output for fault indication	●
> Anti-vibration mounts	●
> Two-colour paint: machine in RAL 7016 dark grey, guarding in RAL 7035 light grey, 571C MD light blue or RAL 6011 green	●

Practical values of melt correction factor for use in calculation of shot weight for some common plastics

Material	Melt correction factor
HD-PE	0,75
LD-PE	0,73
PP	0,73
PS	0,91
SB	0,91
ABS	0,91
SAN	0,91
PA	0,93
PA 6 +30 % GF	1,14
PC	0,97
PC / ABS	0,94
PMMA	0,97
POM	1,15
PET	1,08
PBT	1,08
CA	1,03
CAB	0,98
PVC-w	1,05
PVC-h	1,15

shot weight = melt correction factor x swept volume

The melt correction factor takes into account the change in volume at process temperature and also includes a factor for the flow characteristics of the shut off device on the end of the screw

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