

Energy Measurements

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| Machine: | 30 A | |
| Manufacturer: | BOY | |
| Year of production: | 2003 | |
| Machine No.: | 69163 | |
| Mould: | pouring spout | |
| No. Of cavities: | 8 | |
| Sprue system: | Sprue | |
| Material: | DOW PELD 410 E | |
| Drying: | yes | no |
| Machine Data Sheet: | yes | no |
| | yes | no |
| Setting Data: | yes | no |

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| Date of trial: | 12.08.2009 |
| Responsible: | H.Hirte/H.Bräuer |
| Meas. Instrument: | Amprobe DM II |

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|--------------------|-----------|--------------------|
| Motor / Pump | 7,5 KW | 28 cm ³ |
| Heaters: | 4 Zones | 8,2 KW |
| Control: | Procan CT | |
| Screw dia...: | 28 mm | |
| Nozzle: | open R35 | |
| Part-/ Shotweight: | 1,9 g | 20,9 g |
| Mould temp. Ctrl.: | 16 °C | 16 °C |
| Melt temperature: | 225 °C | |

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| Injection time: | 2,4 s |
| Houlding pres. Time: | 5 s |
| Cooling time: | 8,0 s |
| Cycle time: | 23,8 s |

| | | | | 15 min | 30 min | 45 min | 60 min |
|----------------------|----------|----------|-------------------|----------------|----------------|----------------|----------------|
| Pump / engine | Y | △ | calculated | w/h | w/h | w/h | w/h |
| Heating + control | Y | △ | calculated | w/h | w/h | w/h | w/h |
| Machine total | Y | △ | calculated | 923 w/h | 939 w/h | 922 w/h | 935 w/h |

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|---------------------------|-------------|
| Material throughput p.h.: | 3,16 kg |
| Produktionoutput p.h.: | 1210 pieces |
| Pump idle capacity: | KW/h |
| Pump capacity: | KW/h |
| Heating capcity: | KW/h |

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|---------------------------|-------------------|
| Total consumption: | 3,719 KW/h |
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