

Energy Measurements

Machine:	55 A	
Manufacturer:	BOY	
Year of production:	2006	
Machine No.:	59332	
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

Date of trial:	13.08.2009
Responsible:	H.Hirte/H.Bräuer
Meas. Instrument:	Amprobe DM II

Motor / Pump	15 KW	80 cm ³
Heaters:	4 Zones	KW
Control:	Procan CT	
Screw dia.:	38 mm	
Nozzle:	open R35	
Part-/ Shotweight:	1,9 g	20,9 g
Mould temp. Ctrl.:	16 °C	16 °C
Melt temperature:	225 °C	

Injection time:	1,8 s
Holding pres. Time:	5 s
Cooling time:	9,0 s
Cycle time:	23,9 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	1282 w/h	1169 w/h	1235 w/h	1250 w/h

Material throughput p.h.:	3,16 kg
Produktionoutput p.h.:	1205 pieces
Pump idle capacity:	KW/h
Pump capacity:	KW/h
Heating capacity:	KW/h

Total consumption:	4,936 KW/h
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