

## Energy Measurements

Machine:	55 E	
Manufacturer:	BOY	
Year of production:	2009	
Machine No.:	59501	
Mould:	Textilhanger	
No. Of cavities:	4	
Sprue system:	Sprue	
Material:	HDPE	
Drying:	yes	no
Machine Data Sheet:	yes	no
	yes	no
Setting Data:	yes	no

Date of trial:	05.05.2009
Responsible:	H.Hirte
Meas. Instrument:	Amprobe DM II

Motor / Pump	11 KW	32 cm <sup>3</sup>
Heaters:	5 Zones	7,7 KW
Control:	Procan ALPHA	
Screw dia.:	32 mm	
Nozzle:	offen R35	
Part-/ Shotweight:	5,75 g	26 g
Mould temp. Ctrl.:	cold °C	cold °C
Melt temperature:	180 °C	

Injection time:	1,3 s
Houlding pres. Time:	6 s
Cooling time:	7,7 s
Cycle time:	19,2 s

				15 min	30 min	45 min	60 min
Pump / engine	Y	△	calculated	480 w/h	490 w/h	485 w/h	495 w/h
Heating + control	Y	△	<b>calculated</b>	466 w/h	462 w/h	463 w/h	461 w/h
<b>Machine total</b>	<b>Y</b>	<b>△</b>	<b>calculated</b>	<b>946 w/h</b>	<b>952 w/h</b>	<b>948 w/h</b>	<b>956 w/h</b>

Material throughput p.h.:	4,88 kg
Produktionoutput p.h.:	750 pieces
Pump idle capacity:	0 KW/h
Pump capacity:	1,950 KW/h
Heating capcity:	1,852 KW/h

<b>Total consumption:</b>	<b>3,802 KW/h</b>
---------------------------	-------------------

