

Energy Measurements

Machine:	55 E	
Manufacturer:	BOY	
Year of production:	2009	
Machine No.:	59501	
Mould:	Restraining grid	
No. Of cavities:	4	
Sprue system:	Sprue	
Material:	Polyfort FPP 20 T Nature	
Drying:	yes	no
Machine Data Sheet:	yes	no
Setting Data:	yes	no

Date of trial:	04.05.2009
Responsible:	H.Hirte
Meas. Instrument:	Amprobe DM II

Motor / Pump	11 KW	32 cm ³
Heaters:	5 Zones	7,7 KW
Control:	Procan ALPHA	
Screw dia.:	32 mm	
Nozzle:	offen R35	
Part-/ Shotweight:	7,2 g	31,5 g
Mould temp. Ctrl.:	cold °C	45 °C
Melt temperature:	250 °C	

Injection time:	1,17 s
Holding pres. Time:	1 s
Cooling time:	7,7 s
Cycle time:	14,6 s

				15 min	30 min	45 min	60 min
Pump / engine	Y	△	calculated	400 w/h	400 w/h	400 w/h	400 w/h
Heating + control	Y	△	calculated	389,1 w/h	364,0 w/h	372,4 w/h	380,0 w/h
Machine total	Y	△	calculated	789 w/h	764 w/h	772 w/h	780 w/h

Material throughput p.h.:	7,77 kg
Produktionoutput p.h.:	986 pieces
Pump idle capacity:	0 KW/h
Pump capacity:	1,600 KW/h
Heating capacity:	1,506 KW/h

Total consumption:	3,106 KW/h
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