K-TEC 400 *servo* / K-TEC 450 *servo*										
Clamping unit										
Clamping force	kN	4000 / 4500								
Distance between strain rods H x V	mm	825 x 825 (900 x 900, 1000 x 1000)[4]								
Mould clamping platens h x v	mm	1195 x 1267 (1270 x 1345, 1370 x 1445)[4]								
Mould opening stroke	mm	1000								
Max. distance between platens	mm	1420								
Min. mould installation height	mm	420								
Opening force	kN	181 / 205								
Ejector force	kN	85								
Ejector stroke	mm	200								
Dry running time (EUROMAP 6) [1]	s-mm	3 - 578								
Injection unit										
International size		**1650**			**2650**			**4400**		
Screw diameter	mm	60	70		70	80		80	90	100
Injection pressure	bar	2144	1575		2175	1665		2431	1921	1556
Stroke volume	cm³	763	1039		1213	1583		1810	2290	2825
Screw stroke	mm	270			315			360		
Max. injected weight (PS)	g	694	946		1104	1441		1647	2084	2571
Injection rate	cm³/s	1480	2000		1550	2000		2250	2850	3550
Plasticizing volume [2]	g/s	60	67		73	85		80	103	128
Screw length [3]	L/D	22	18,6		22	19,3		22,5	20	18
Screw revolutions, max.	min⁻¹	275			240			190		
Installed heating capacity	kW	22,7	22,7		30,7	30,7		48,4	48,4	48,4
Number of heating zones		5			5			5		
Nozzle holding pressure	kN	115			115			115		
Unit stroke	mm	525			525			525		
General data										
Electrical connection	kW	see electric circuit diagram								
Machine dimensions L x W x H	m	see installation plan								
Net weight (without oil)	kg	26000			27000			30000		
Oil tank capacity	l	1180			1180			1180		
Max. processing temperature	°C	350 450 (option)			350 450 (option)			350 450 (option)		

Fig. 99: Technical data K-TEC 400, K-TEC 450

[1] Stroke = 70% distance between strain rods, 70% clamping force
[2] determined for PS at: 10s cycle time, 1.5D screw stroke
[3] Screws with other L/D on request
[4] Variants