



Hacoplast B.V.

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Injection unit	Unit	JM88-MK6			JM128-MK6			JM168-MK6			JM208-MK6			JM258-MK6		
Swept Volume	cm ³	136	183	238	209	271	341	304	382	488	432	552	735	432	552	735
Injection Weight (PS)	g	124	167	216	190	246	310	276	348	444	393	502	669	393	502	669
Screw Diameter	mm	31	36	41	36	41	46	41	46	52	46	52	60	46	52	60
Screw L/D Ratio	L/D	24,4	21,0	18,4	23,9	21,0	18,7	23,6	21,0	18,6	23,7	21,0	18,2	23,7	21,0	18,2
Injection Pressure (Max.)	kgf/cm ²	2,549	1,890	1,457	2,451	1,890	1,501	2,368	1,881	1,472	2,419	1,893	1,422	2,419	1,893	1,422
Injection Pressure (Max.)	MPa	250	185	143	240	185	147	232	185	144	237	186	140	237	187	140
Injection Rate (PS)	g/s	80	108	140	104	135	170	138	174	222	169	216	287	169	216	287
Plasticizing rate (PS)	g/s		10			14			20			31			31	
Screw Rotation Speed (Max.)	rpm		245			245			224			200			200	
Screw Stroke	mm		180			205			230			260			260	
Nozzle contact force	t		4,2			4,2			6,2			6,2			6,2	
Nozzle stroke	mm		275			290			330			380			380	
Clamping unit																
Clamping Force (Max.)	t		88			128			168			208			258	
Opening Stroke	mm		340			380			450			510			560	
Maximum Daylight	mm		720			830			970			1060			1140	
Platen size	mm		540 x 540			600x 600			680 x 680			780 x 780			840 x 840	
Space between Tie Bars (HxV)	mm		360 x 360			410 x 410			470 x 470			530 x 530			580 x 580	
Max. Mould Thickness	mm		380			450			520			550			580	
Min. Mould Thickness	mm		125			150			170			180			190	
Ejector Stroke	mm		120			120			140			150			150	
Ejector Force	t		3,4			3,4			4,2			6,7			6,7	
Mould centerring diameter	mm		100			125			125			160			160	
Dry cycle time	s		1,7			1,8			1,9			2,1			2,4	
Others																
Sound level	dBA		75,4			75,4			75,4			75,4			75,4	
System Pressure	MPa		17,5			17,5			17,5			17,5			17,5	
Pump Motor	kW		14			17			22			30			30	
Electrical Heating	kW		8			10,3			12,9			16,6			16,6	
Temperature Control Zones	Zones		3 + Nozzle			3 + Nozzle			3 + Nozzle			3 + Nozzle			3 + Nozzle	
Oil Tank Capacity	L		160			200			250			330			330	
Machine dimensions (LxWxH)	m		4,5 x 1,2 x 1,8			4,95 x 1,3 x 1,85			5,5 x 1,3 x 1,9			6,1 x 1,5 x 2,0			6,3 x 1,6 x 2,05	
Machine weight	t		3,3			4			4,9			6,8			7,8	

All technical data and features are subjected to change without notice.

Plasticizing rates of all screws A & C are estimated



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Injection unit	Unit	JM328-MK6			JM398-MK6			JM468-MK6			JM568-MK6			JM668-MK6		
Swept Volume	cm ³	947	1.181	1.480	1.322	1.657	2.029	1.833	2.245	2.640	1.833	2.245	2.640	2.300	2.704	3.206
Injection Weight (PS)	g	862	1.075	1.347	1.203	1.508	1.846	1.668	2.043	2.403	1.668	2.043	2.403	2.093	2.460	2.917
Screw Diameter	mm	60	67	75	67	75	83	75	83	90	75	83	90	83	90	98
Screw L/D Ratio	L/D	23,5	21,0	18,8	23,5	21,0	19,0	23,2	21,0	19,4	23,2	21,0	19,4	23,9	22,0	20,2
Injection Pressure (Max.)	kgf/cm ²	2,355	1,889	1,507	2,333	1,862	1,520	2,253	1,840	1,564	2,253	1,840	1,564	2,163	1,840	1,552
Injection Pressure (Max.)	MPa	231	185	148	229	183	149	221	180	153	221	180	153	212	180	152
Injection Rate (PS)	g/s	302	376	472	351	440	539	442	541	636	442	541	636	540	635	753
Plasticizing rate (PS)	g/s		50,1			70			96			96			118,1	
Injection Rate (PS)	g/s	302	376	472	351	440	539	442	541	636	442	541	636	540	635	753
Screw Rotation Speed (Max.)	rpm		200			190			180			180			170	
Screw Stroke	mm		335			375			415			415			425	
Nozzle contact force	t		9,1			11,1			11,1			11,1			11,1	
Nozzle stroke	mm		440			470			540			540			540	
Clamping unit																
Clamping Force (Max.)	t		328			398			468			568			668	
Opening Stroke	mm		660			720			820			870			920	
Maximum Daylight	mm		1340			1450			1670			1750			1840	
Platen size	mm		970 x 970			1060 x 1060			1160 x 1160			1190 x 1190			1250 x 1250	
Space between Tie Bars (HxV)	mm		680 x 680			730 x 730			830 x 830			860 x 860			920 x 920	
Max. Mould Thickness	mm		680			730			850			880			920	
Min. Mould Thickness	mm		225			250			300			350			380	
Ejector Stroke	mm		180			215			220			250			265	
Ejector Force	t		11,1			11,1			16,6			16,6			18,2	
Mould centerring diameter	mm		160			160			200			200			200	
Dry cycle time	s		2,7			3,2			3,6			3,7			4	
Others																
Noise level	dBA		75,4			75,4			77			79			79	
System Pressure	MPa		17,5			17,5			17,5			17,5			17,5	
Pump Motor	kW		48			60			72			96			96	
Electrical Heating	kW		26			31,1			35,5			35,5			35,5	
Temperature Control Zones	Zones		4 + Nozzle			5 + Nozzle			5 + Nozzle			5 + Nozzle			5 + Nozzle	
Oil Tank Capacity	L		580			760			850			850			950	
Machine dimensions (LxWxH)	m		7,4 x 1,8 x 2,1			8,0 x 1,95 x 2,3			8,8 x 2,0 x 2,3			9,5 x 2,0 x 2,1			9,9 x 2,1 x 2,2	
Machine weight	ton		13,2			16,7			19,8			21,5			23	

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