

victory, e-victory US		Clamping unit	
		45	55
Clamp force	US tons / kN	45 / 400	55 / 500
Opening force	US tons	1.8	1.8
Opening stroke max.	inches	15.74	15.74
Mold height min.	inches	7.87	7.87
Daylight max.	inches	23.62	23.62
Mold fixing platens standard h x v	inches	19.69 x 17.72	19.69 x 17.72
Larger mold fixing platen / wide platen h x v	inches	-	-
Standard discharge chute width	inches	15.75	15.75
Wide-Platen discharge chute width	inches	-	-
Ejector stroke	inches	3.94	3.94
Ejector force forward / return	US tons	4.5 / 1.6	4.5 / 1.6
mold weight, max on moving platen/center of gravity <sup>1</sup>	lbs / inches	661 / 5.24	661 / 5.24
Dry operation time	sec@inches	1.6 @ 5.91	1.6 @ 5.91

1. Without additional guide block

victory 45, 55 US		Injection unit		
		60	200	330
Weight Standard / Wide-Platen	to US tons	2.7 / - 3.0 / -	2.9 / - 3.1 / -	3.1 / - 3.4 / -
Oil reservoir capacity <sup>1</sup>	l gal	135 35.7	135 35.7	135 35.7
Drive power HV1/ HV2	kW hp	7.5 / 11 10.2 / 15.0	15 / 15 20.4 / 20.4	15 / 15 20.4 / 20.4
Drive power SHV1 / SHV2 / SHV3	kW hp	13.4 / 16.3 / 20.2 18.22 / 22.16 / 27.46	13.4 / 16.3 / 20.2 18.22 / 22.16 / 27.46	13.4 / 16.3 / 20.2 18.22 / 22.16 / 27.46
Injection unit heating capacity (max.capacity / max.zones)	kW / n	3.54 / 4	4.76 / 4	6.44 / 4
Total power HV1 / HV2	kW	12 / 16	21 / 21	22 / 22
Total power SHV1 / SHV2	kW	18 / 21	19 / 22	21 / 24
Connected current HV1 / HV2 <sup>2</sup>	A	22 / 29	38 / 38	40 / 40
Connected current SHV1 / SHV2 <sup>2</sup>	A	27 / 31	29 / 33	31 / 35
Cooling water consumption HVx / SHVx <sup>3</sup>	m <sup>3</sup> /h gal/h	0.25 / 0.125 66 / 33	0.5 / 0.25 132 / 66	0.5 / 0.25 132 / 66

1. In case of oil supply when commissioning carried out at ENGEL +15%
2. With voltage 3 x 380V - 400V + N + PE, 50/60Hz
3. With an ambient temperature of maximum 35° C / 95° F

e-victory 45, 55 US		Injection unit	
		50	170
Weight Standard / Wide-Platen	to US tons	4.0 / - 4.4 / -	4.0 / - 4.4 / -
Oil reservoir capacity <sup>1</sup>	l gal	135 35.7	135 35.7
Drive power SHV1 / SHV2	kW hp	9.66 / 12.68 13.13 / 17.24	13.92 / 18.09 18.93 / 24.60
Injection unit heating capacity (max.capacity / max.zones)	kW / n	3.54 / 4	4.76 / 4
Total power SHV1 / SHV2 <sup>2</sup>	kW	14 / 17	20 / 24
Connected current SHV1 / SHV2 <sup>2 3</sup>	A	22 / 26	29 / 35
Cooling water consumption SHVx <sup>4</sup>	m <sup>3</sup> /h gal/h	-	-

1. In case of oil supply when commissioning carried out at ENGEL +15%
2. When using compensation equipment for correcting the power factor of machines, plants or plant components, reactive current compensation with impedance capacitors is necessary.
3. With voltage 3 x 380V - 400V + N + PE, 50/60Hz
4. With an ambient temperature of maximum 35° C / 95° F

victory		Injection unit 200 - EHV								
		HV1 / HV2			HV3			HV3-HSI		
Screw diameter	mm in	22 0.87	25 0.98	30 1.18	22 0.87	25 0.98	30 1.18	22 0.87	25 0.98	30 1.18
Screw stroke	mm in	140 5.51	140 5.51	140 5.51	140 5.51	140 5.51	140 5.51	140 5.51	140 5.51	140 5.51
Injection capacity	cm <sup>3</sup> in <sup>3</sup>	53 3.23	69 4.21	99 6.04	53 3.23	69 4.21	99 6.04	53 3.23	69 4.21	99 6.04
Screw speed	min <sup>-1</sup> rpm	480	480	480	550	550	550	550	550	550
Peripheral screw speed max.	m/s ft/s	0.55 1.80	0.63 2.07	0.75 2.46	0.63 2.07	0.72 2.36	0.86 2.82	0.63 2.07	0.72 2.36	0.86 2.82
Screw torque max.	Nm lbf-ft	205 151.20	240 177.01	240 177.01	205 151.20	240 177.01	240 177.01	205 151.20	240 177.01	240 177.01
L/D ratio (3-zone screw)	L/D	24	24.8	20.5	24	24.8	20.5	24	24.8	20.5
Recovery rate (3-zone screw) <sup>1</sup>	g/s oz/s	6.9 0.24	11.8 0.42	16.8 0.59	7.9 0.28	13.5 0.48	19.3 0.68	7.9 0.28	13.5 0.48	19.3 0.68
L/D ratio (barrier screw)	L/D	-	-	-	-	-	-	-	-	-
Recovery rate (barrier screw) <sup>2</sup>	g/s oz/s	-	-	-	-	-	-	-	-	-
Injection speed	mm/s in/s	211 8.31	211 8.31	211 8.31	260 10.24	260 10.24	260 10.24	-	-	-
Injection speed (inj. pressure increased)	mm/s in/s	139 5.47	139 5.47	139 5.47	171 6.73	171 6.73	171 6.73	600 23.62	600 23.62	600 23.62
Injection rate <sup>3</sup>	cm <sup>3</sup> /s in <sup>3</sup> /s	80 4.88	104 6.35	150 9.15	99 6.04	128 7.81	184 11.23	-	-	-
Injection rate (inj. pressure increased) <sup>3</sup>	cm <sup>3</sup> /s in <sup>3</sup> /s	53 3.23	68 4.15	99 6.04	65 3.97	84 5.12	121 7.38	229 13.97	295 18.00	425 25.94
Spec. injection pressure	bar psi	2400 34800	2090 30305	1450 21025	2400 34800	2090 30305	1450 21025	2400 34800	2090 30305	1450 21025
Injection pressure (max.)	bar psi	2400 34800	2400 34800	2210 32045	2400 34800	2400 34800	2210 32045	2400 34800	2400 34800	2210 32045
Nozzle stroke	mm in	230 9.06	230 9.06	230 9.06	230 9.06	230 9.06	230 9.06	230 9.06	230 9.06	230 9.06
Nozzle penetration	mm in	30 1.18	30 1.18	30 1.18	30 1.18	30 1.18	30 1.18	30 1.18	30 1.18	30 1.18
Nozzle contact pressure	kN US tons	28 3.15	28 3.15	28 3.15	28 3.15	28 3.15	28 3.15	28 3.15	28 3.15	28 3.15
Heating wattage	kW	7.1	6.8	6.8	7.1	6.8	6.8	7.1	6.8	6.8
Number of heating zones incl. nozzle		4	4	4	4	4	4	4	4	4

1. Values for polystyrene (according to ENGEL factory standard ETR 10100)
2. Values for HDPE (according to ENGEL factory standard ETR 10100)
3. Dependent on pump drive power

victory		Injection unit 200 - ecodrive								
		SHV1 / SHV1-HSI			SHV2 / SHV5			SHV3 / SHV3-HSI		
Screw diameter	mm in	22 0.87	25 0.98	30 1.18	22 0.87	25 0.98	30 1.18	22 0.87	25 0.98	30 1.18
Screw stroke	mm in	140 5.51	140 5.51	140 5.51	140 5.51	140 5.51	140 5.51	140 5.51	140 5.51	140 5.51
Injection capacity	cm <sup>3</sup> in <sup>3</sup>	53 3.23	69 4.21	99 6.04	53 3.23	69 4.21	99 6.04	53 3.23	69 4.21	99 6.04
Screw speed	min-1 rpm	480	480	480	480	480	480	550	550	550
Peripheral screw speed max.	m/s ft/s	0.55 1.80	0.63 2.07	0.75 2.46	0.55 1.80	0.63 2.07	0.75 2.46	0.63 2.07	0.72 2.36	0.86 2.82
Screw torque max.	Nm lbf-ft	205 151.20	240 177.01	240 177.01	205 151.20	240 177.01	240 177.01	205 151.20	240 177.01	240 177.01
L/D ratio (3-zone screw)	L/D	24	24.8	20.5	24	24.8	20.5	24	24.8	20.5
Recovery rate (3-zone screw) <sup>1</sup>	g/s oz/s	6.9 0.24	11.8 0.42	16.8 0.59	6.9 0.24	11.8 0.42	16.8 0.59	7.9 0.28	13.5 0.48	19.3 0.68
L/D ratio (barrier screw)	L/D	-	-	-	-	-	-	-	-	-
Recovery rate (barrier screw) <sup>2</sup>	g/s oz/s	-	-	-	-	-	-	-	-	-
Injection speed	mm/s in/s	204 / - 8.03 / -	204 / - 8.03 / -	204 / - 8.03 / -	211 8.31	211 8.31	211 8.31	260 / - 10.24 / -	260 / - 10.24 / -	260 / - 10.24 / -
Injection speed (inj. pressure increased)	mm/s in/s	134 / 600 5.3 / 23.6	134 / 600 5.3 / 23.6	134 / 600 5.3 / 23.6	139 5.47	139 5.47	139 5.47	171 / 600 6.7 / 23.6	171 / 600 6.7 / 23.6	171 / 600 6.7 / 23.6
Injection rate <sup>3</sup>	cm <sup>3</sup> /s in <sup>3</sup> /s	78 / - 4.76 / -	100 / - 6.10 / -	145 / - 8.85 / -	80 4.88	104 6.35	150 9.15	99 / - 6.04 / -	128 / - 7.81 / -	184 / - 11.23 / -
Injection rate (inj. pressure increased) <sup>3</sup>	cm <sup>3</sup> /s in <sup>3</sup> /s	51 / 229 3.1 / 14.0	66 / 295 4.0 / 18.0	95 / 425 5.8 / 25.9	53 3.23	68 4.15	99 6.04	65 / 229 4.0 / 14.0	84 / 295 5.1 / 18.0	121 / 425 7.4 / 25.9
Spec. injection pressure	bar psi	2400 34800	2090 30305	1450 21025	2400 34800	2090 30305	1450 21025	2400 34800	2090 30305	1450 21025
Injection pressure (max.)	bar psi	2400 34800	2400 34800	2210 32045	2400 34800	2400 34800	2210 32045	2400 34800	2400 34800	2210 32045
Nozzle stroke	mm in	230 9.06	230 9.06	230 9.06	230 9.06	230 9.06	230 9.06	230 9.06	230 9.06	230 9.06
Nozzle penetration	mm in	30 1.18	30 1.18	30 1.18	30 1.18	30 1.18	30 1.18	30 1.18	30 1.18	30 1.18
Nozzle contact pressure	kN US tons	28 3.15	28 3.15	28 3.15	28 3.15	28 3.15	28 3.15	28 3.15	28 3.15	28 3.15
Heating wattage	kW	7.1	6.8	6.8	7.1	6.8	6.8	7.1	6.8	6.8
Number of heating zones incl. nozzle		4	4	4	4	4	4	4	4	4

1. Values for polystyrene (according to ENGEL factory standard ETR 10100)
2. Values for HDPE (according to ENGEL factory standard ETR 10100)
3. Dependent on pump drive power