

victory, e-victory US		Clamping unit		
		65	75	85
Clamp force	US tons / kN	65 / 600	65 / 700	85 / 800
Opening force	US tons	3.2	3.2	3.2
Opening stroke max.	inches	17.72	17.72	17.72
Mold height min.	inches	9.84	9.84	9.84
Daylight max.	inches	27.56	27.56	27.56
Mold fixing platens standard h x v	inches	26.38 x 23.62	26.38 x 23.62	26.38 x 23.62
Larger mold fixing platen / wide platen h x v	inches	28.35 x 23.62	28.35 x 23.62	28.35 x 23.62
Standard discharge chute width	inches	17.72	17.72	17.72
Wide-Platen discharge chute width	inches	19.69	19.69	19.69
Ejector stroke	inches	3.94	3.94	3.94
Ejector force forward / return	US tons	4.5 / 1.6	4.5 / 1.6	4.5 / 1.6
mold weight, max on moving platen/center of gravity ¹	lbs / inches	992 / 6.50	992 / 6.50	992 / 6.50
Dry operation time	sec@inches	1.5 @ 5.91	1.5 @ 5.91	1.5 @ 5.91

1. Without additional guide block

victory 65, 75, 85 US		Injection unit		
		60	200	330
Weight Standard / Wide-Platen	to US tons	5.1 / 5.4 5.6 / 6.0	5.2 / 5.5 5.7 / 6.1	5.3 / 5.6 5.8 / 6.2
Oil reservoir capacity ¹	l gal	170 44.9	170 44.9	170 44.9
Drive power HV1/ HV2	kW hp	15 / 15 20.4 / 20.4	15 / 15 20.4 / 20.4	15 / 18.5 20.4 / 25.2
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	17.5 / 19.3 / 27.5 23.79 / 26.24 / 37.39
Injection unit heating capacity (max.capacity / max.zones)	kW / n	3.54 / 4	4.76 / 4	6.44 / 4
Total power HV1 / HV2	kW	20 / 20	21 / 21	22 / 26
Total power SHV1 / SHV2	kW	18 / 21	19 / 22	25 / 27
Connected current HV1 / HV2 ²	A	36 / 36	38 / 38	40 / 47
Connected current SHV1 / SHV2 ²	A	27 / 31	29 / 33	37 / 40
Cooling water consumption HVx / SHVx ³	m ³ /h gal/h	0.5 / 0.25 132 / 66	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 65, 75, 85 US		Injection unit	
		170	310
Weight Standard / Wide-Platen	to US tons	5.5 / 5.8 6.1 / 6.4	5.7 / 6.0 6.3 / 6.6
Oil reservoir capacity ¹	l gal	170 44.9	170 44.9
Drive power SHV1 / SHV2	kW hp	13.92 / 18.09 18.93 / 24.60	17.33 / 21.87 23.56 / 29.73
Injection unit heating capacity (max.capacity / max.zones)	kW / n	4.76 / 4	6.44 / 5
Total power SHV1 / SHV2 ²	kW	20 / 24	25 / 29
Connected current SHV1 / SHV2 ^{2 3}	A	29 / 35	37 / 43
Cooling water consumption SHVx ⁴	m ³ /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 330 - EHV								
		HV1 / HV2			HV3			HV3-HSI		
Screw diameter	mm in	30 1.18	35 1.38	40 1.57	30 1.18	35 1.38	40 1.57	30 1.18	35 1.38	40 1.57
Screw stroke	mm in	160 6.30	160 6.30	160 6.30	160 6.30	160 6.30	160 6.30	160 6.30	160 6.30	160 6.30
Injection capacity	cm ³ in ³	113 6.89	154 9.40	201 12.26	113 6.89	154 9.40	201 12.26	113 6.89	154 9.40	201 12.26
Screw speed	min ⁻¹ rpm	400	400	320	440	440	350	440	440	350
Peripheral screw speed max.	m/s ft/s	0.63 2.07	0.73 2.40	0.67 2.20	0.69 2.26	0.81 2.66	0.73 2.40	0.69 2.26	0.81 2.66	0.73 2.40
Screw torque max.	Nm lbf-ft	380 280.3	380 280.3	450 331.9	380 280.3	380 280.3	450 331.9	380 280.3	380 280.3	450 331.9
L/D ratio (3-zone screw)	L/D	23.6	20	17.5	23.6	20	17.5	23.6	20	17.5
Recovery rate (3-zone screw) ¹	g/s oz/s	14.3 0.50	20.9 0.74	24.8 0.87	15.7 0.55	23.0 0.81	27.1 0.96	15.7 0.55	23.0 0.81	27.1 0.96
L/D ratio (barrier screw)	L/D	-	24	-	-	24	-	-	24	-
Recovery rate (barrier screw) ²	g/s oz/s	-	27.6 0.97	-	-	30.1 1.06	-	-	30.1 1.06	-
Injection speed	mm/s in/s	113 ⁴ / 157 4.5 ⁴ / 6.2	113 ⁴ / 157 4.5 ⁴ / 6.2	113 ⁴ / 157 4.5 ⁴ / 6.2	201 7.91	201 7.91	201 7.91	-	-	-
Injection speed (inj. pressure increased)	mm/s in/s	83 ⁴ / 116 3.3 ⁴ / 4.6	83 ⁴ / 116 3.3 ⁴ / 4.6	83 ⁴ / 116 3.3 ⁴ / 4.6	148 5.83	148 5.83	148 5.83	600 23.62	600 23.62	600 23.62
Injection rate ³	cm ³ /s in ³ /s	80 ⁴ / 111 4.9 ⁴ / 6.8	109 ⁴ / 151 6.7 ⁴ / 9.2	142 ⁴ / 198 8.7 ⁴ / 12.1	142 8.67	194 11.84	253 15.44	-	-	-
Injection rate (inj. pressure increased) ³	cm ³ /s in ³ /s	59 ⁴ / 82 3.6 ⁴ / 5.0	80 ⁴ / 112 4.9 ⁴ / 6.8	105 ⁴ / 146 6.4 ⁴ / 8.9	105 6.41	143 8.73	186 11.35	425 25.94	579 35.33	756 46.13
Spec. injection pressure	bar psi	2180 31610	1600 23200	1225 17767	2180 31610	1600 23200	1225 17767	2180 31610	1600 23200	1225 17767
Injection pressure (max.)	bar psi	2390 34664	2175 31546	1670 24215	2390 34664	2175 31546	1670 24215	2390 34664	2175 31546	1670 24215
Nozzle stroke	mm in	300 / 500 ⁵ 11.81 / 19.69 ⁵			300 / 500 ⁵ 11.81 / 19.69 ⁵			300 / 500 ⁵ 11.81 / 19.69 ⁵		
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	49 5.51	49 5.51	49 5.51	49 5.51	49 5.51	49 5.51	49 5.51	49 5.51	49 5.51
Heating wattage	kW	9.2	9.2	9.2	9.2	9.2	9.2	9.2	9.2	9.2
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
4. VC 330/ 40, 50, VC 330/ 45, 55 US, VC 330/ 40, 50 PRO
5. VC 330/ 180, 200, 220, VC 330/ 200, 220, 240 US, VC 330/ 180, 200, 220 PRO

victory		Injection unit 330 - ecodrive								
		SHV1 / SHV1-HSI			SHV2 / SHV5			SHV3 / SHV3-HSI		
Screw diameter	mm	30	35	40	30	35	40	30	35	40
	in	1.18	1.38	1.57	1.18	1.38	1.57	1.18	1.38	1.57
Screw stroke	mm	160	160	160	160	160	160	160	160	160
	in	6.30	6.30	6.30	6.30	6.30	6.30	6.30	6.30	6.30
Injection capacity	cm ³	113	154	201	113	154	201	113	154	201
	in ³	6.89	9.40	12.26	6.89	9.40	12.26	6.89	9.40	12.26
Screw speed	min-1 rpm	400	400	320	400	400	320	440	440	350
Peripheral screw speed max.	m/s	0.63	0.73	0.67	0.63	0.73	0.67	0.69	0.81	0.73
	ft/s	2.07	2.40	2.20	2.07	2.40	2.20	2.26	2.66	2.40
Screw torque max.	Nm	380	380	450	380	380	450	380	380	450
	lbf-ft	280.27	280.27	331.90	280.27	280.27	331.90	280.27	280.27	331.90
L/D ratio (3-zone screw)	L/D	23.6	20	17.5	23.6	20	17.5	23.6	20	17.5
Recovery rate (3-zone screw) ¹	g/s	14.3	20.9	24.8	14.3	20.9	24.8	15.7	23.0	27.1
	oz/s	0.50	0.74	0.87	0.50	0.74	0.87	0.55	0.81	0.96
L/D ratio (barrier screw)	L/D	-	-	-	-	-	-	-	-	-
Recovery rate (barrier screw) ²	g/s	-	27.6	-	-	27.6	-	-	30.1	-
	oz/s	-	0.97	-	-	0.97	-	-	1.06	-
Injection speed	mm/s	137/ -	137/ -	137/ -	157 / 194	157 / 194	157 / 194	194/ -	194/ -	194/ -
	in/s	5.39/ -	5.39/ -	5.39/ -	6.2 / 7.6	6.2 / 7.6	6.2 / 7.6	7.64/ -	7.64/ -	7.64/ -
Injection speed (inj. pressure increased)	mm/s	101 / 600	101 / 600	101 / 600	116	116	116	143 / 600	143 / 600	143 / 600
	in/s	4.0 / 23.6	4.0 / 23.6	4.0 / 23.6	4.6	4.6	4.6	5.6 / 23.6	5.6 / 23.6	5.6 / 23.6
Injection rate ³	cm ³ /s	97/ -	132/ -	173/ -	111 / 137	151 / 187	198 / 244	137/ -	187/ -	244/ -
	in ³ /s	5.92/ -	8.06/ -	10.56/ -	6.8 / 8.3	9.2 / 11.4	12.1 / 14.9	8.36/ -	11.41/ -	14.89/ -
Injection rate (inj. pressure increased) ³	cm ³ /s	72 / 425	97 / 579	127 / 756	82	112	146	101 / 425	138 / 579	180 / 756
	in ³ /s	4.4 / 25.9	5.9 / 35.3	7.8 / 46.1	5.0	6.8	8.9	6.1 / 25.9	8.4 / 35.3	11.0 / 46.1
Spec. injection pressure	bar	2180	1600	1225	2180	1600	1225	2180	1600	1225
	psi	31610	23200	17767	31610	23200	17767	31610	23200	17767
Injection pressure (max.)	bar	2390	2175	1670	2390	2175	1670	2390	2175	1670
	psi	34664	31546	24215	34664	31546	24215	34664	31546	24215
Nozzle stroke	mm	300/ 500 ⁴			300/ 500 ⁴			300/ 500 ⁴		
	in	11.81/ 19.69 ⁴			11.81/ 19.69 ⁴			11.81/ 19.69 ⁴		
Nozzle penetration	mm	30	30	30	30	30	30	30	30	30
	in	1.18	1.18	1.18	1.18	1.18	1.18	1.18	1.18	1.18
Nozzle contact pressure	kN	49	49	49	49	49	49	49	49	49
	US tons	5.51	5.51	5.51	5.51	5.51	5.51	5.51	5.51	5.51
Heating wattage	kW	9.2	9.2	9.2	9.2	9.2	9.2	9.2	9.2	9.2
Number of heating zones incl. nozzle		4	4	4	4	4	4	4	4	4

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