

victory, e-victory US		Clamping unit		
		100	120	130
Clamp force	US tons / kN	100 / 900	120 / 1100	130 / 1200
Opening force	US tons	4.3	4.3	4.3
Opening stroke max.	inches	19.69	19.69	19.69
Mold height min.	inches	11.81	11.81	11.81
Daylight max.	inches	31.50	31.50	31.50
Mold fixing platens standard h x v	inches	29.13 x 26.77	29.13 x 26.77	29.13 x 26.77
Larger mold fixing platen / wide platen h x v	inches	31.10 x 26.77	31.10 x 26.77	31.10 x 26.77
Standard discharge chute width	inches	19.69	19.69	19.69
Wide-Platen discharge chute width	inches	21.65	21.65	21.65
Ejector stroke	inches	5.12	5.12	5.12
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	1764 / 7.20	1764 / 7.20	1764 / 7.20
Dry operation time	sec@inches	1.6 @ 7.87	1.6 @ 7.87	1.6 @ 7.87

1. Without additional guide block

victory 100, 120, 130 US		Injection unit			
		200	330	500	650
Weight Standard / Wide-Platen	to US tons	6.6 / 7.0 7.3 / 7.7	6.7 / 7.1 7.4 / 7.8	6.8 / 7.2 7.5 / 7.9	7.0 / 7.4 7.7 / 8.2
Oil reservoir capacity ¹	l gal	300 79.3	300 79.3	300 79.3	300 79.3
Drive power HV1 / HV2	kW hp	15 / 18.5 20.4 / 25.2	15 / 18.5 20.4 / 25.2	18.5 / 18.5 25.2 / 25.2	22 / 22 29.9 / 29.9
Drive power SHV1 / SHV2 / SHV3	kW hp	17.5 / 22.3 / 27.5 23.79 / 30.32 / 37.39	17.5 / 22.3 / 27.5 23.79 / 30.32 / 37.39	20.3 / 22.3 / 27.5 27.60 / 30.32 / 37.39	20.3 / 22.3 / 27.5 27.60 / 30.32 / 37.39
Injection unit heating capacity (max.capacity / max.zones)	kW / n	4.76 / 4	6.44 / 4	8.54 / 5	9.35 / 5
Total power HV1 / HV2	kW	21 / 24	22 / 26	28 / 28	32 / 32
Total power SHV1 / SHV2	kW	23 / 28	25 / 30	30 / 32	31 / 33
Connected current HV1 / HV2 ²	A	38 / 44	40 / 47	55 / 55	58 / 58
Connected current SHV1 / SHV2 ²	A	35 / 41	37 / 44	50 / 52	47 / 49
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	0.6 / 0.3 158 / 79

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 100, 120, 130 US		Injection unit		
		170	310	440
Weight Standard / Wide-Platen	to US tons	6.9 / 7.3 7.6 / 8.0	7.1 / 7.5 7.8 / 8.3	7.5 / 7.9 8.3 / 8.7
Oil reservoir capacity ¹	l gal	300 79.3	300 79.3	300 79.3
Drive power SHV1 / SHV2	kW hp	18.57 / 23.04 25.25 / 31.33	21.29 / 26.32 28.95 / 35.79	22.56 / 27.93 30.67 / 37.97
Injection unit heating capacity (max.capacity / max.zones)	kW / n	4.76 / 4	6.44 / 4	8.54 / 5
Total power SHV1 / SHV2 ²	kW	24 / 29	29 / 34	32 / 37
Connected current SHV1 / SHV2 ^{2 3}	A	36 / 43	42 / 50	53 / 61
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 500 - EHV								
		HV1 / HV2			HV3			HV3-HSI		
Screw diameter	mm in	35 1.38	40 1.57	45 1.77	35 1.38	40 1.57	45 1.77	35 1.38	40 1.57	45 1.77
Screw stroke	mm in	200 7.87	200 7.87	200 7.87	200 7.87	200 7.87	200 7.87	200 7.87	200 7.87	200 7.87
Injection capacity	cm ³ in ³	192 11.71	251 15.31	318 19.40	192 11.71	251 15.31	318 19.40	192 11.71	251 15.31	318 19.40
Screw speed	min ⁻¹ rpm	400	400	320	455	455	455	455	455	455
Peripheral screw speed max.	m/s ft/s	0.73 2.40	0.84 2.76	0.75 2.46	0.83 2.72	0.95 3.12	1.07 3.51	0.83 2.72	0.95 3.12	1.07 3.51
Screw torque max.	Nm lbf-ft	520 383.53	520 383.53	650 4749.42	520 383.53	520 383.53	650 4749.42	520 383.53	520 383.53	650 4749.42
L/D ratio (3-zone screw)	L/D	20	20	20	20	20	20	20	20	20
Recovery rate (3-zone screw) ¹	g/s oz/s	20.9 0.74	31.7 1.12	33.7 1.19	23.8 0.84	36.1 1.27	47.9 1.69	23.8 0.84	36.1 1.27	47.9 1.69
L/D ratio (barrier screw)	L/D	24	24	24	24	24	24	24	24	24
Recovery rate (barrier screw) ²	g/s oz/s	27.6 0.97	38.4 1.35	41.8 1.47	31.0 1.09	43.1 1.52	59.4 2.10	31.0 1.09	43.1 1.52	59.4 2.10
Injection speed	mm/s in/s	157 6.18	157 6.18	157 6.18	201 7.91	201 7.91	201 7.91	-	-	-
Injection speed (inj. pressure increased)	mm/s in/s	102 4.02	102 4.02	102 4.02	130 5.12	130 5.12	130 5.12	600 23.62	600 23.62	600 23.62
Injection rate ³	cm ³ /s in ³ /s	151 9.21	198 12.08	250 15.26	194 11.84	253 15.44	320 19.52	-	-	-
Injection rate (inj. pressure increased) ³	cm ³ /s in ³ /s	98 5.98	129 7.87	163 9.94	125 7.63	164 10.01	207 12.63	579 35.33	756 46.13	957 58.40
Spec. injection pressure	bar psi	1700 24650	1300 18850	1030 14939	1700 24650	1300 18850	1030 14939	1700 24650	1300 18850	1030 14939
Injection pressure (max.)	bar psi	2390 34664	2020 29298	1595 23134	2390 34664	2020 29298	1595 23134	2390 34664	2020 29298	1595 23134
Nozzle stroke	mm in	300 / 500 ⁴ 11.81 / 19.69 ⁴			300 / 500 ⁴ 11.81 / 19.69 ⁴			300 / 500 ⁴ 11.81 / 19.69 ⁴		
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	52 5.85	52 5.85	52 5.85	52 5.85	52 5.85	52 5.85	52 5.85	52 5.85	52 5.85
Heating wattage	kW	9.2	9.2	12.2	9.2	9.2	12.2	9.2	9.2	12.2
Number of heating zones incl. nozzle		4	4	5	4	4	5	4	4	5

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 500/180, 200, 220, VC 500/200, 220, 240 US, VC 500/180, 200, 220 PRO

victory		Injection unit 500 - ecodrive								
		SHV1 / SHV1-HSI			SHV2 / SHV5			SHV3 / SHV3-HSI		
Screw diameter	mm in	35 1.38	40 1.57	45 1.77	35 1.38	40 1.57	45 1.77	35 1.38	40 1.57	45 1.77
Screw stroke	mm in	200 7.87	200 7.87	200 7.87	200 7.87	200 7.87	200 7.87	200 7.87	200 7.87	200 7.87
Injection capacity	cm ³ in ³	192 11.71	251 15.31	318 19.40	192 11.71	251 15.31	318 19.40	192 11.71	251 15.31	318 19.40
Screw speed	min-1 rpm	400	400	320	400	400	320	455	455	440
Peripheral screw speed max.	m/s ft/s	0.73 2.40	0.84 2.76	0.75 2.46	0.73 2.40	0.84 2.76	0.75 2.46	0.83 2.72	0.95 3.12	1.04 3.41
Screw torque max.	Nm lbf-ft	520 383.5	520 383.5	650 4749.4	520 383.5	520 383.5	650 4749.4	520 383.5	520 383.5	650 4749.4
L/D ratio (3-zone screw)	L/D	20	20	20	20	20	20	20	20	20
Recovery rate (3-zone screw) ¹	g/s oz/s	20.9 0.74	31.7 1.12	33.7 1.19	20.9 0.74	31.7 1.12	33.7 1.19	23.8 0.84	36.1 1.27	47.9 1.69
L/D ratio (barrier screw)	L/D	24	24	24	24	24	24	24	24	24
Recovery rate (barrier screw) ²	g/s oz/s	27.6 0.97	38.4 1.35	41.8 1.47	27.6 0.97	38.4 1.35	41.8 1.47	31.0 1.09	43.1 1.52	59.4 2.10
Injection speed	mm/s in/s	157 / - 6.18 / -	157 / - 6.18 / -	157 / - 6.18 / -	157 6.18	157 6.18	157 6.18	194 / - 7.64 / -	194 / - 7.64 / -	194 / - 7.64 / -
Injection speed (inj. pressure increased)	mm/s in/s	102 / 600 4.0 / 23.6	102 / 600 4.0 / 23.6	102 / 600 4.0 / 23.6	102 4.0	102 4.0	102 4.0	130 / 600 5.1 / 23.6	130 / 600 5.1 / 23.6	130 / 600 5.1 / 23.6
Injection rate ³	cm ³ /s in ³ /s	151 9.21	198 12.08	250 15.26	151 9.21	198 12.08	250 15.26	187 11.41	244 14.89	309 18.86
Injection rate (inj. pressure increased) ³	cm ³ /s in ³ /s	98 / 579 6.0 / 35.3	129 / 756 7.9 / 46.1	163 / 957 9.9 / 58.4	98 6.0	129 7.9	163 9.9	125 / 579 7.6 / 35.3	164 / 756 10.0 / 46.1	207 / 957 12.6 / 58.4
Spec. injection pressure	bar psi	1700 24650	1300 18850	1030 14939	1700 24650	1300 18850	1030 14939	1700 24650	1300 18850	1030 14939
Injection pressure (max.)	bar psi	2390 34664	2020 29298	1595 23134	2390 34664	2020 29298	1595 23134	2390 34664	2020 29298	1595 23134
Nozzle stroke	mm in	300 / 500 ⁴ 11.81 / 19.69 ⁴			300 / 500 ⁴ 11.81 / 19.69 ⁴			300 / 500 ⁴ 11.81 / 19.69 ⁴		
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	52 5.85	52 5.85	52 5.85	52 5.85	52 5.85	52 5.85	52 5.85	52 5.85	52 5.85
Heating wattage	kW	9.2	9.2	12.2	9.2	9.2	12.2	9.2	9.2	12.2
Number of heating zones incl. nozzle		4	4	5	4	4	5	4	4	5

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 500/180, 200, 220, VC 500/200, 220, 240 US, VC 500/180, 200, 220 PRO