

victory, e-victory US		Clamping unit		
		200	220	240
Clamp force	US tons / kN	200 / 1800	220 / 2000	240 / 2200
Opening force	US tons	10.8	10.8	10.8
Opening stroke max.	inches	29.53	29.53	29.53
Mold height min.	inches	11.81	11.81	11.81
Daylight max.	inches	41.34	41.34	41.34
Mold fixing platens standard h x v	inches	34.65 x 32.68	34.65 x 32.68	34.65 x 32.68
Larger mold fixing platen / wide platen h x v	inches	38.58 x 32.68	38.58 x 32.68	38.58 x 32.68
Standard discharge chute width	inches	25.59	25.59	25.59
Wide-Platen discharge chute width	inches	29.53	29.53	29.53
Ejector stroke	inches	7.09	7.09	7.09
Ejector force forward / return	US tons	9.0 / 3.7	9.0 / 3.7	9.0 / 3.7
mold weight, max on moving platen/center of gravity ¹	lbs / inches	3307 / 9.06	3307 / 9.06	3307 / 9.06
Dry operation time	sec@inches	2.0 @ 9.84	2.0 @ 9.84	2.0 @ 9.84

1. Without additional guide block

victory 200, 220, 240 US		Injection unit						
		330	500	650	750	1050	1350	1800
Weight Standard / Wide-Platen	to US tons	11.7 / 12.2 12.8 / 13.4	11.7 / 12.2 12.8 / 13.4	11.9 / 12.4 13.1 / 13.7	12.2 / 12.7 13.4 / 14.0	12.2 / 12.7 13.4 / 14.0	12.6 / 13.1 13.9 / 14.4	12.6 / 13.1 13.9 / 14.4
Oil reservoir capacity ¹	l gal	540 142.7	540 142.7	540 142.7	540 142.7	540 142.7	610 161.1	610 161.1
Drive power HV1 / HV2	kW hp	30 / 30 40.8 / 40.8	30 / 30 40.8 / 40.8	30 / 30 40.8 / 40.8	30 / 30 40.8 / 40.8	30 / 30 40.8 / 40.8	37 / 37 50.3 / 50.3	45 / 45 61.2 / 61.2
Drive power SHV1 / SHV2 / SHV3	kW hp	25 / 31 / 40 34 / 42 / 54	25 / 31 / 40 34 / 42 / 54	25 / 31 / 40 34 / 42 / 54	28 / 34 / 49 38 / 46 / 66	28 / 34 / 49 38 / 46 / 66	39 / 44 / 54 52 / 60 / 73	39 / 44 / 54 52 / 60 / 73
Injection unit heating capacity (max.capacity / max.zones)	kW / n	6.44 / 4	8.54 / 5	9.35 / 5	10.75 / 5	11.45 / 5	14.95 / 5	20.58 / 5
Total power HV1 / HV2	kW	39 / 39	41 / 41	42 / 42	43 / 43	44 / 44	54 / 54	68 / 68
Total power SHV1 / SHV2	kW	33 / 39	35 / 41	36 / 42	40 / 46	41 / 47	56 / 61	62 / 67
Connected current HV1 / HV2 ²	A	71 / 71	80 / 80	77 / 77	83 / 83	80 / 80	97 / 97	117 / 117
Connected current SHV1 / SHV2 ²	A	49 / 58	57 / 66	54 / 63	65 / 73	62 / 70	84 / 91	92 / 100
Cooling water consumption HVx / SHVx ³	m ³ /h gal/h	1 / 0.5 264/132	1 / 0.5 264/132	1 / 0.5 264/132	1 / 0.5 264/132	1 / 0.5 264/132	1.3 / 0.65 343/171	1.3 / 0.65 343/171

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 200, 220, 240 US		Injection unit				
		440	740	940	1340	1640
Weight Standard / Wide-Platen	to US tons	12.4 / 12.9 13.7 / 14.2	12.9 / 13.4 14.2 / 14.8	12.9 / 13.4 14.2 / 14.8	14.1 / 14.6 15.5 / 16.1	14.1 / 14.6 15.5 / 16.1
Oil reservoir capacity ¹	l gal	610 161.1	610 161.1	610 161.1	610 161.1	610 161.1
Drive power SHV1 / SHV2	kW hp	23.57 / 29.27 32.05 / 39.80	25.03 / 30.71 34.03 / 41.75	29.95 / 35.71 40.72 / 48.55	47.82 / 58.03 65.02 / 78.90	47.82 / 58.03 65.02 / 78.90
Injection unit heating capacity (max.capacity / max.zones)	kW / n	8.54 / 5	10.75 / 5	11.45 / 5	14.95 / 5	20.58 / 5
Total power SHV1 / SHV2 ²	kW	33 / 39	37 / 42	42 / 48	64 / 74	70 / 80
Connected current SHV1 / SHV2 ^{2 3}	A	56 / 64	61 / 69	64 / 73	95 / 110	103 / 118
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 1050 - EHV								
		HV1 / HV2			HV3			HV3-HSI		
Screw diameter	mm in	50 1.97	55 2.17	60 2.36	50 1.97	55 2.17	60 2.36	50 1.97	55 2.17	60 2.36
Screw stroke	mm in	215 8.46	215 8.46	215 8.46	215 8.46	215 8.46	215 8.46	215 8.46	215 8.46	215 8.46
Injection capacity	cm ³ in ³	422 25.75	510 31.12	607 37.03	422 25.75	510 31.12	607 37.03	422 25.75	510 31.12	607 37.03
Screw speed	min ⁻¹ rpm	230	230	230	320	320	320	320	320	320
Peripheral screw speed max.	m/s ft/s	0.60 1.97	0.66 2.17	0.72 2.36	0.84 2.76	0.92 3.02	1.01 3.31	0.84 2.76	0.92 3.02	1.01 3.31
Screw torque max.	Nm lbf-ft	1290 951.46	1290 951.46	1290 951.46	1290 951.46	1290 951.46	1290 951.46	1290 951.46	1290 951.46	1290 951.46
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	32.1 1.13	41.3 1.46	51.1 1.80	45.4 1.60	57.5 2.03	71.1 2.51	45.4 1.60	57.5 2.03	71.1 2.51
L/D ratio (barrier screw)	L/D	24	24	24	24	24	-	24	24	-
Recovery rate (barrier screw) ²	g/s oz/s	39.2 1.38	50 1.76	62.4 2.20	54.4 1.92	69.2 2.44	-	54.4 1.92	69.2 2.44	-
Injection speed	mm/s in/s	107 4.21	107 4.21	107 4.21	147 5.79	147 5.79	147 5.79	-	-	-
Injection speed (inj. pressure increased)	mm/s in/s	84 3.31	84 3.31	84 3.31	116 4.57	116 4.57	116 4.57	600 23.62	600 23.62	600 23.62
Injection rate ³	cm ³ /s in ³ /s	211 12.87	255 15.56	303 18.49	289 17.63	350 21.35	417 25.44	1181 72.07	1429 87.20	1701 103.80
Injection rate (inj. pressure increased) ³	cm ³ /s in ³ /s	165 10.07	200 12.20	238 14.52	228 13.91	276 18.84	329 20.07	-	-	-
Spec. injection pressure	bar psi	1955 28355	1615 23424	1360 19725	1955 28355	1615 23424	1360 19725	1955 28355	1615 23424	1360 19725
Injection pressure (max.)	bar psi	2330 33794	2050 29733	1725 25019	2330 33794	2050 29733	1725 25019	2330 33794	2050 29733	1725 25019
Nozzle stroke	mm in	350 13.78	350 13.78	350 13.78	350 13.78	350 13.78	350 13.78	350 13.78	350 13.78	350 13.78
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	67 7.50	67 7.50	67 7.50	67 7.50	67 7.50	67 7.50	67 7.50	67 7.50	67 7.50
Heating wattage	kW	15.3	16.3	18.3	15.3	16.3	18.3	15.3	16.3	18.3
Number of heating zones incl. nozzle		5	5	5	5	5	5	5	5	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

victory		Injection unit 1050 - ecodrive								
		SHV1 / SHV1-HSI			SHV2 / SHV5			SHV3 / SHV3-HSI		
Screw diameter	mm	50	55	60	50	55	60	50	55	60
	in	1.97	2.17	2.36	1.97	2.17	2.36	1.97	2.17	2.36
Screw stroke	mm	215	215	215	215	215	215	215	215	215
	in	8.46	8.46	8.46	8.46	8.46	8.46	8.46	8.46	8.46
Injection capacity	cm ³	422	510	607	422	510	607	422	510	607
	in ³	25.75	31.12	37.03	25.75	31.12	37.03	25.75	31.12	37.03
Screw speed	min-1 rpm	230	230	230	230	230	230	320	320	320
Peripheral screw speed max.	m/s	0.60	0.66	0.72	0.60	0.66	0.72	0.84	0.92	1.01
	ft/s	1.97	2.17	2.36	1.97	2.17	2.36	2.76	3.02	3.31
Screw torque max.	Nm	1290	1290	1290	1290	1290	1290	1290	1290	1290
	lbf-ft	951.46	951.46	951.46	951.46	951.46	951.46	951.46	951.46	951.46
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	32.1	41.3	51.1	32.1	41.3	51.1	45.4	57.5	71.1
	oz/s	1.13	1.46	1.80	1.13	1.46	1.80	1.60	2.03	2.51
L/D ratio (barrier screw)	L/D	24	24	24	24	24	24	24	24	-
Recovery rate (barrier screw) ²	g/s	39.2	50	62.4	39.2	50	62.4	54.4	69.2	-
	oz/s	1.38	1.76	2.20	1.38	1.76	2.20	1.92	2.44	-
Injection speed	mm/s	107/ -	107/ -	107/ -	107	107	107	147/ -	147/ -	147/ -
	in/s	4.21/ -	4.21/ -	4.21/ -	4.21	4.21	4.21	5.79/ -	5.79/ -	5.79/ -
Injection speed (inj. pressure increased)	mm/s	84 / 600	84 / 600	84 / 600	84	84	84	116 / 600	116 / 600	116 / 600
	in/s	3.3 / 23.6	3.3 / 23.6	3.3 / 23.6	3.3	3.3	3.3	4.6 / 23.6	4.6 / 23.6	4.6 / 23.6
Injection rate ³	cm ³ /s	211/ -	255/ -	303/ -	211	255	303	289/ -	350/ -	417/ -
	in ³ /s	12.87/ -	15.56/ -	18.49/ -	12.87	15.56	18.49	17.64/ -	21.36/ -	25.45/ -
Injection rate (inj. pressure increased) ³	cm ³ /s	165/ 1181	200/ 1429	238/ 1701	165	200	238	228/ 1181	276/ 1429	329/ 1701
	in ³ /s	10.1/ 72.1	12.2/ 87.2	14.5/ 103.8	10.1	12.2	14.5	13.9/ 72.1	16.8/ 87.2	20.1/ 103.8
Spec. injection pressure	bar	1955	1615	1360	1955	1615	1360	1955	1615	1360
	psi	28355	23424	19725	28355	23424	19725	28355	23424	19725
Injection pressure (max.)	bar	2330	2050	1725	2330	2050	1725	2330	2050	1725
	psi	33794	29733	25019	33794	29733	25019	33794	29733	25019
Nozzle stroke	mm	350	350	350	350	350	350	350	350	350
	in	13.78	13.78	13.78	13.78	13.78	13.78	13.78	13.78	13.78
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	67	67	67	67	67	67	67	67	67
	US tons	7.50	7.50	7.50	7.50	7.50	7.50	7.50	7.50	7.50
Heating wattage	kW	15.3	16.3	18.3	15.3	16.3	18.3	15.3	16.3	18.3
Number of heating zones incl. nozzle		5	5	5	5	5	5	5	5	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