

victory, e-victory US		Clamping unit	
		290	340
Clamp force	US tons / kN	290 / 2600	340 / 3000
Opening force	US tons	22.0	22.0
Opening stroke max.	inches	35.43	35.43
Mold height min.	inches	15.75	15.75
Daylight max.	inches	51.18	51.18
Mold fixing platens standard h x v	inches	43.31 x 39.37	43.31 x 39.37
Larger mold fixing platen / wide platen h x v	inches	47.24 x 39.37	47.24 x 39.37
Standard discharge chute width	inches	29.53	29.53
Wide-Platen discharge chute width	inches	33.46	33.46
Ejector stroke	inches	7.87	7.87
Ejector force forward / return	US tons	10.1 / 4.9	10.1 / 4.9
mold weight, max on moving platen/center of gravity ¹	lbs / inches	4850 / 9.25	4850 / 9.25
Dry operation time	sec@inches	2.2 @ 11.81	2.2 @ 11.81

1. Without additional guide block

victory 290, 340 US		Injection unit					
		750	1050	1350	1800	2050	2550
Weight Standard / Wide-Platen	to US tons	19.4 / 19.9 21.4 / 21.9	19.4 / 19.9 21.4 / 21.9	20.1 / 20.6 22.2 / 22.7	20.1 / 20.6 22.2 / 22.7	21.0 / 21.5 23.1 / 23.7	21.0 / 21.5 23.1 / 23.7
Transport measure (l x h x b)	mm in	7220 x 2300 x 2170 284.3 x 90.6 x 85.4					
Oil reservoir capacity ¹	l gal	670 177.0	670 177.0	670 177.0	670 177.0	710 187.6	710 187.6
Drive power HV1	kW hp	37 50.3	37 50.3	37 50.3	45 61.2	45 61.2	45 61.2
Drive power SHV1 / SHV2 / SHV3	kW hp	40 / 46 / 59 54.4/62.5/80.2	40 / 46 / 59 54.4/62.5/80.2	46 / 53 / 60.5 62.5/72.1/82.3	46 / 53 / 60.5 62.5/72.1/82.3	51 / 55 / 76.6 69.3/74.8/104	51 / 55 / 76.6 69.3/74.8/104
Injection unit heating capacity (max.capacity / max.zones)	kW / n	10.75 / 5	11.45 / 5	14.95 / 5	20.58 / 5	20.58 / 5	20.58 / 5
Total power HV1	kW	50	51	54	68	68	68
Total power SHV1 / SHV2	kW	53 / 59	54 / 61	63 / 71	69 / 77	74 / 79	74 / 79
Connected current HV1 ²	A	96	93	97	117	117	117
Connected current SHV1 / SHV2 ²	A	84 / 93	81 / 91	94 / 106	103 / 114	110 / 117	110 / 117
Cooling water consumption HVx / SHVx ³	m ³ /h gal/h	1.3 / 0.65 343 / 172	1.3 / 0.65 343 / 172	1.3 / 0.65 343 / 172	1.3 / 0.65 343 / 172	1.5 / 0.75 396 / 198	1.5 / 0.75 396 / 198

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 290, 340 US		Injection unit				
		740	940	1340	1640	2440
Weight Standard / Wide-Platen	to US tons	20.4 / 20.9 22.5 / 23.0	20.4 / 20.9 22.5 / 23.0	21.8 / 22.3 24.0 / 24.6	21.8 / 22.3 24.0 / 24.6	24.3 / 24.8 26.8 / 27.3
Oil reservoir capacity ¹	l gal	670 177.0	670 177.0	710 187.6	710 187.6	970 256.2
Drive power SHV1 / SHV2	kW hp	33.41 / 38.92 45.42 / 52.92	36.62 / 42.35 49.79 / 57.58	47.57 / 58.43 64.68 / 79.44	47.57 / 58.43 64.68 / 79.44	46.62 / 57.36 63.39 / 77.99
Injection unit heating capacity (max.capacity / max.zones)	kW / n	10.75 / 5	11.45 / 5	14.95 / 5	20.58 / 5	20.58 / 5
Total power SHV1 / SHV2 ²	kW	47 / 52	51 / 55	65 / 74	71 / 80	70 / 81
Connected current SHV1 / SHV2 ^{2 3}	A	75 / 83	76 / 85	97 / 112	105 / 121	105 / 121
Cooling water consumption SHVx ⁴	m ³ /h gal/h	0.4 105.7	0.4 105.7	0.4 105.7	0.4 105.7	0.4 105.7

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 1800 - EHV								
		HV1 / HV2			HV3			HV3-HSI		
		60	70	80	60	70	80	60	70	80
		mm	mm	mm	mm	mm	mm	mm	mm	mm
		in	in	in	in	in	in	in	in	in
Screw diameter		60	70	80	60	70	80	60	70	80
		2.36	2.76	3.15	2.36	2.76	3.15	2.36	2.76	3.15
Screw stroke	mm	270	270	270	270	270	270	270	270	270
	in	10.63	10.63	10.63	10.63	10.63	10.63	10.63	10.63	10.63
Injection capacity	cm ³	763	1039	1357	763	1039	1357	763	1039	1357
	in ³	46.55	63.39	82.79	46.55	63.39	82.79	46.55	63.39	82.79
Screw speed	min ⁻¹	226	226	226	254	254	254	254	254	254
	rpm									
Peripheral screw speed max.	m/s	0.71	0.83	0.95	0.80	0.93	1.06	0.80	0.93	1.06
	ft/s	2.33	2.72	3.12	2.62	3.05	3.48	2.62	3.05	3.48
Screw torque max.	Nm	2000	2000	2000	2000	2000	2000	2000	2000	2000
	lbf-ft	1475.12	1475.12	1475.12	1475.12	1475.12	1475.12	1475.12	1475.12	1475.12
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	50.2	73.8	103	56.5	82.9	115	56.5	82.9	115
	oz/s	1.77	2.60	3.63	1.99	2.92	4.06	1.99	2.92	4.06
L/D ratio (barrier screw)	L/D	24	24	-	24	-	-	24	-	-
Recovery rate (barrier screw) ²	g/s	61.3	90.8	-	68.8	-	-	68.8	-	-
	oz/s	2.16	3.20	-	2.43	-	-	2.43	-	-
Injection speed	mm/s	100	100	100	112	112	112	-	-	-
	in/s	3.94	3.94	3.94	4.41	4.41	4.41	-	-	-
Injection speed (inj. pressure increased)	mm/s	83	83	83	93	93	93	600	600	600
	in/s	3.27	3.27	3.27	3.66	3.66	3.66	23.62	23.62	23.62
Injection rate ³	cm ³ /s	283	386	504	317	432	564	-	-	-
	in ³ /s	17.27	23.55	30.75	19.34	26.36	34.42	-	-	-
Injection rate (inj. pressure increased) ³	cm ³ /s	235	320	418	264	359	469	1701	2315	3024
	in ³ /s	14.34	19.52	25.50	16.11	21.91	28.62	103.80	141.27	184.54
Spec. injection pressure	bar	1960	1441	1105	1960	1441	1105	1960	1441	1105
	psi	28430	20900	16030	28430	20900	16030	28430	20900	16030
Injection pressure (max.)	bar	2360	1735	1330	2360	1735	1330	2360	1735	1330
	psi	34230	25165	19290	34230	25165	19290	34230	25165	19290
Nozzle stroke	mm	500	500	500	500	500	500	500	500	500
	in	19.69	19.69	19.69	19.69	19.69	19.69	19.69	19.69	19.69
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	110	110	110	110	110	110	110	110	110
	US tons	12.32	12.32	12.32	12.32	12.32	12.32	12.32	12.32	12.32
Heating wattage	kW	25.3	29.4	33.5	25.3	29.4	33.5	25.3	29.4	33.5
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 1800 - ecodrive								
		SHV1 / SHV1-HSI			SHV2 / SHV5			SHV3 / SHV3-HSI		
Screw diameter	mm in	60 2.36	70 2.76	80 3.15	60 2.36	70 2.76	80 3.15	60 2.36	70 2.76	80 3.15
Screw stroke	mm in	270 10.63	270 10.63	270 10.63	270 10.63	270 10.63	270 10.63	270 10.63	270 10.63	270 10.63
Injection capacity	cm ³ in ³	763 46.55	1039 63.39	1357 82.79	763 46.55	1039 63.39	1357 82.79	763 46.55	1039 63.39	1357 82.79
Screw speed	min-1 rpm	226	226	226	226	226	226	254	254	254
Peripheral screw speed max.	m/s ft/s	0.71 2.33	0.83 2.72	0.95 3.12	0.71 2.33	0.83 2.72	0.95 3.12	0.80 2.62	0.93 3.05	1.06 3.48
Screw torque max.	Nm lbf-ft	2000 1475.12	2000 1475.12	2000 1475.12	2000 1475.12	2000 1475.12	2000 1475.12	2000 1475.12	2000 1475.12	2000 1475.12
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	50.2 1.77	73.8 2.60	103 3.63	50.2 1.77	73.8 2.60	103 3.63	56.5 1.99	82.9 2.92	115 4.06
L/D ratio (barrier screw)	L/D	24	24	-	24	24	-	24	-	-
Recovery rate (barrier screw) ²	g/s oz/s	61.3 2.16	90.8 3.20	-	61.3 2.16	90.8 3.20	-	68.8 2.43	-	-
Injection speed	mm/s in/s	100 / - 3.94 / -	100 / - 3.94 / -	100 / - 3.94 / -	100 3.94	100 3.94	100 3.94	112 / - 4.41 / -	112 / - 4.41 / -	112 / - 4.41 / -
Injection speed (inj. pressure increased)	mm/s in/s	83 / 600 3.3 / 23.6	83 / 600 3.3 / 23.6	83 / 600 3.3 / 23.6	83 3.3	83 3.3	83 3.3	93 / 600 3.7 / 23.6	93 / 600 3.7 / 23.6	93 / 600 3.7 / 23.6
Injection rate ³	cm ³ /s in ³ /s	283 / - 17.27 / -	386 / - 23.55 / -	504 / - 30.75 / -	283 17.27	386 23.55	504 30.75	317 / - 19.34 / -	432 / - 26.36 / -	564 / - 34.42 / -
Injection rate (inj. pressure increased) ³	cm ³ /s in ³ /s	235 / 1701 14.3 / 103.80	320 / 2315 19.5 / 141.3	418 / 3024 25.5 / 184.5	235 14.3	320 19.5	418 25.5	264 / 1701 16.1 / 103.8	359 / 2315 21.9 / 141.3	469 / 3024 28.6 / 184.5
Spec. injection pressure	bar psi	1960 28430	1441 20900	1105 16030	1960 28430	1441 20900	1105 16030	1960 28430	1441 20900	1105 16030
Injection pressure (max.)	bar psi	2360 34230	1735 25165	1330 19290	2360 34230	1735 25165	1330 19290	2360 34230	1735 25165	1330 19290
Nozzle stroke	mm in	500 19.69	500 19.69	500 19.69	500 19.69	500 19.69	500 19.69	500 19.69	500 19.69	500 19.69
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	110 12.32	110 12.32	110 12.32	110 12.32	110 12.32	110 12.32	110 12.32	110 12.32	110 12.32
Heating wattage	kW	25.3	29.4	33.5	25.3	29.4	33.5	25.3	29.4	33.5
Number of heating zones incl. nozzle		5	5	5	5	5	5	5	5	5

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2. Values for HDPE (according to ENGEL factory standard ETR 10100)

3. Dependent on pump drive power