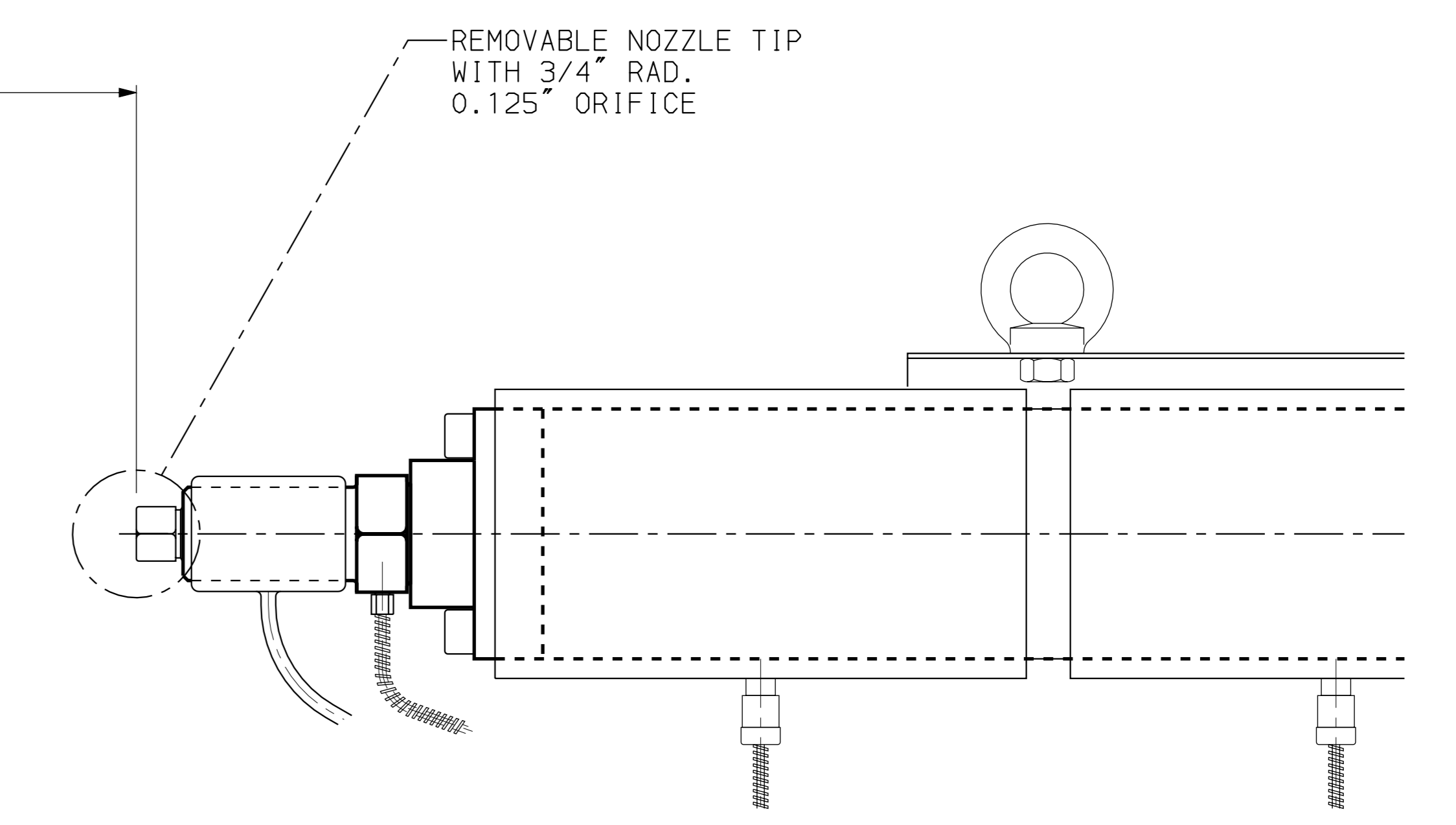
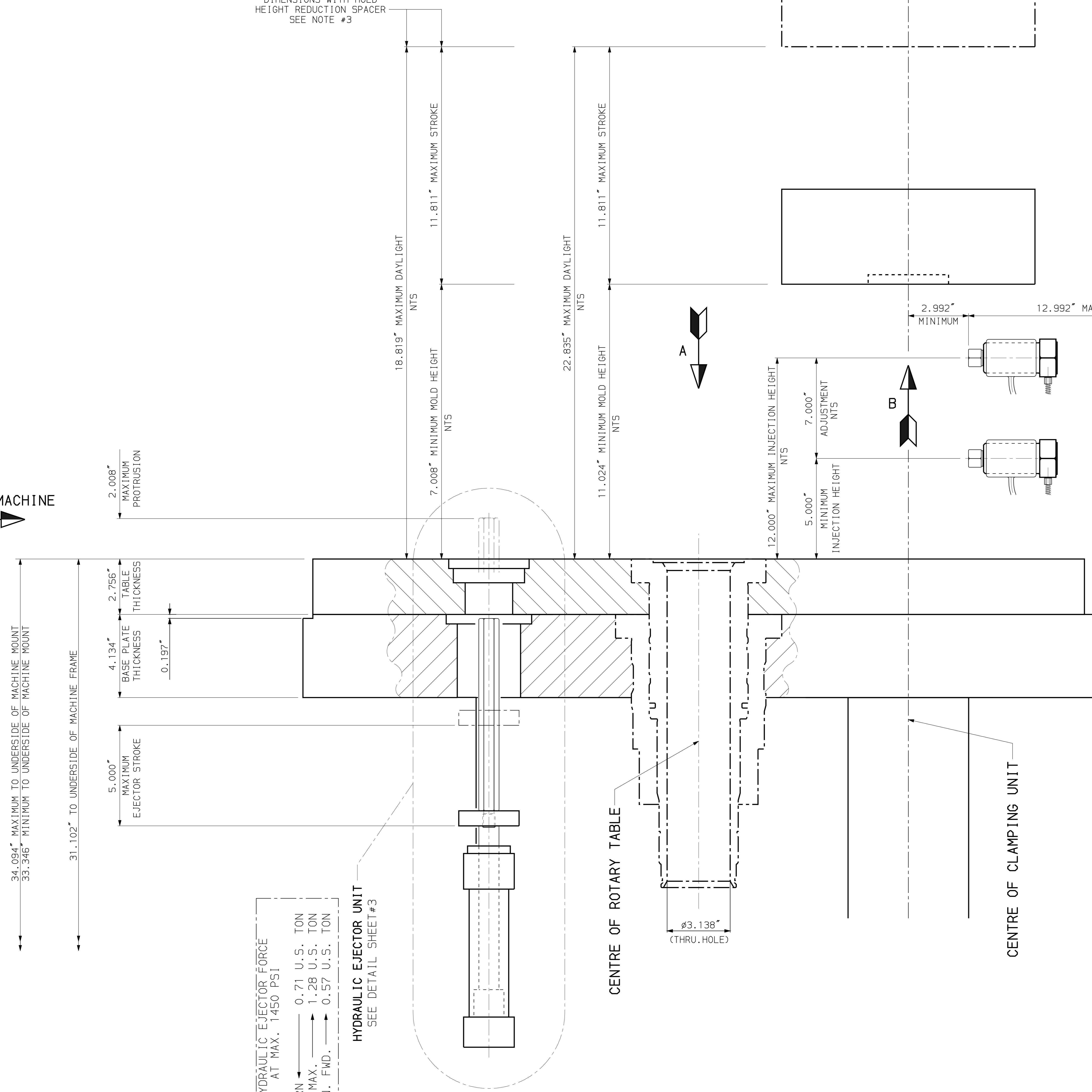


FRONT OF MACHINE

DIMENSIONS WITH MOLD HEIGHT REDUCTION SPACER SEE NOTE #3



HYDRAULIC EJECTOR FORCE AT MAX. 1450 PSI
 RETURN ← 0.71 U.S. TON
 FWD. MAX. → 1.28 U.S. TON
 REGEN. FWD. → 0.57 U.S. TON

HYDRAULIC EJECTOR UNIT SEE DETAIL SHEET #3

CENTRE OF ROTARY TABLE

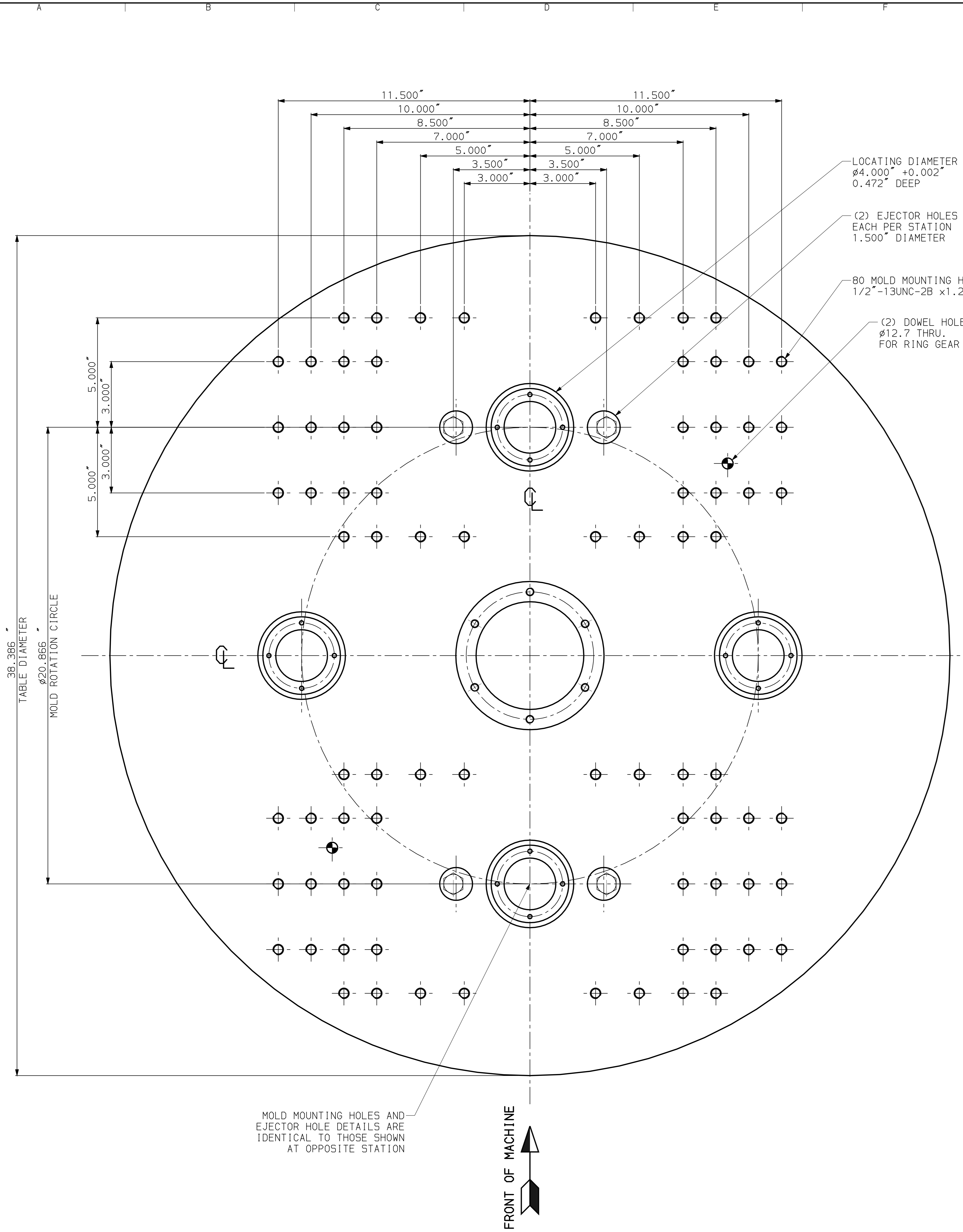
CENTRE OF CLAMPING UNIT

NOTES:

1. ALL DIMENSIONS ARE IN INCHES UNLESS SPECIFIED OTHERWISE.
 2. TECHNICAL DATA SUBJECT TO CHANGE WITHOUT NOTICE.
 3. MACHINE IS AVAILABLE WITH OPTIONAL MOLD HEIGHT REDUCTION SPACER.
- CAUTION:** WITH MOLD HEIGHT REDUCTION SPACER INSTALLED, EXERCISE EXTREME CAUTION WHEN ADJUSTING INJECTION HEIGHT, IN ORDER TO PREVENT A COLLISION BETWEEN THE MOVING PLATEN AND PLASTICIZING CYLINDER.

RELEASED
 MICROFILM
 REV. # 10

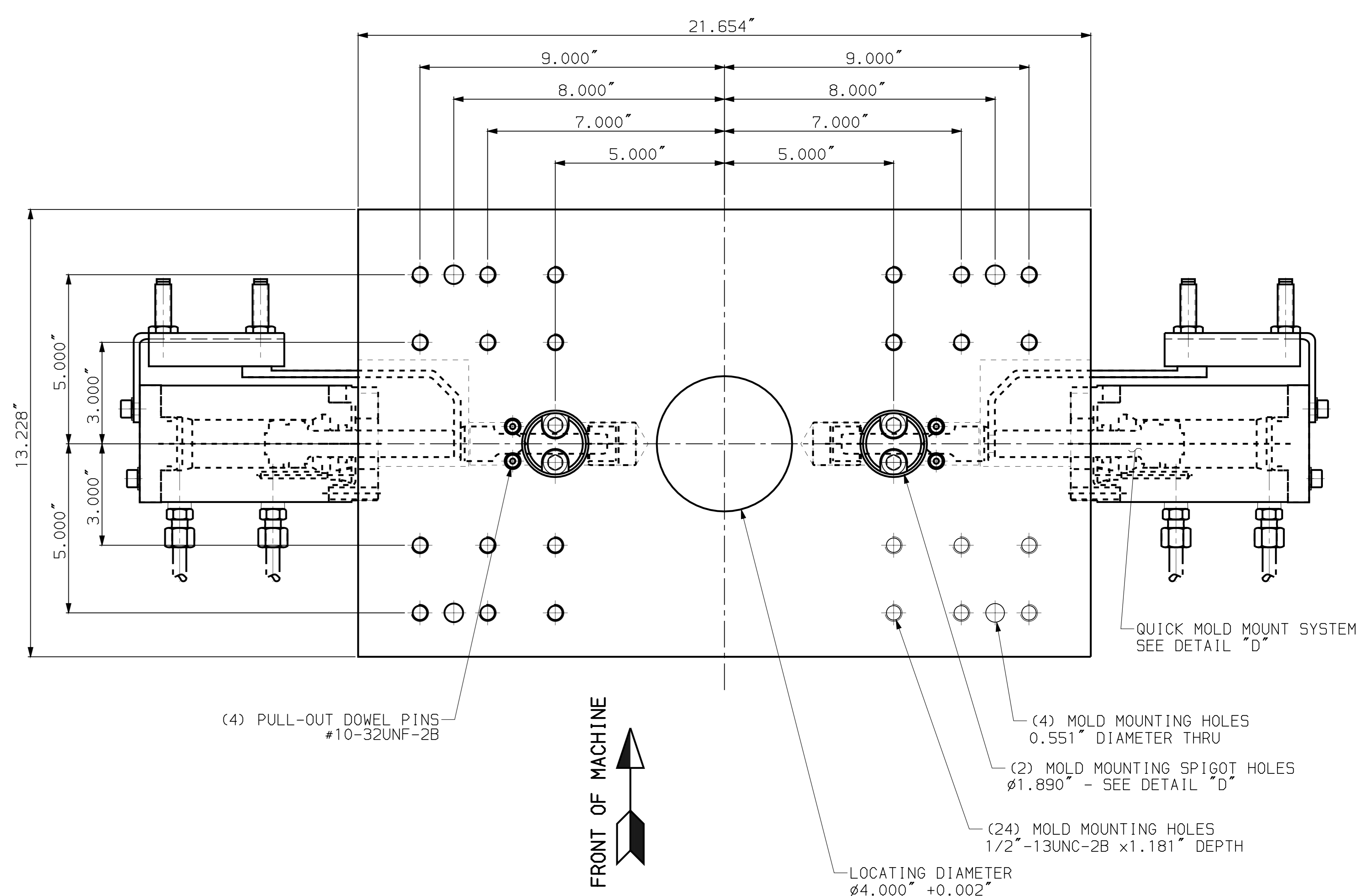
REV#	ECO#	DATE	NAME
10	SOS	NEW	
SCALE		DESCRIPTION	
1: 2		PLATEN LAYOUT-2 STN. PCD 530 ES85VHRB	
MATERIAL		NAME	
OUTDOCK CODE		DATE	
BREAK SHARP CORNERS		DR. N.	
FROM	TO	DATE	REPLACES
0.5	6	30	1000
1.0	8.0	30	1000
2.0	120	315	1000
3.0	1500	2000	2000
4.0	2000	2000	2000
FINE #		COPY FROM	
0.05	0.1	0.15	0.2
0.3	0.5	0.8	1.2
2.0	3.0	4.0	5.0
MEDIUM #		DRAWING NO.	
0.1	0.2	0.3	0.5
0.8	1.2	2.0	3.0
4.0	6.0	10.0	15.0
COARSE #		SHEET	
0.2	0.5	0.8	1.2
2.0	3.0	4.0	5.0
DIM. MICRONS		PART WEIGHT IN Kg.	
METERS		5785.002.3932E	
THIS DRAWING AND THE INFORMATION HEREIN IS CONFIDENTIAL AND MUST NOT BE REPRODUCED OR USED IN ANY WAY WITHOUT WRITTEN PERMISSION OF ENGEL CANADA INC.		SHEET 1 OF 3	



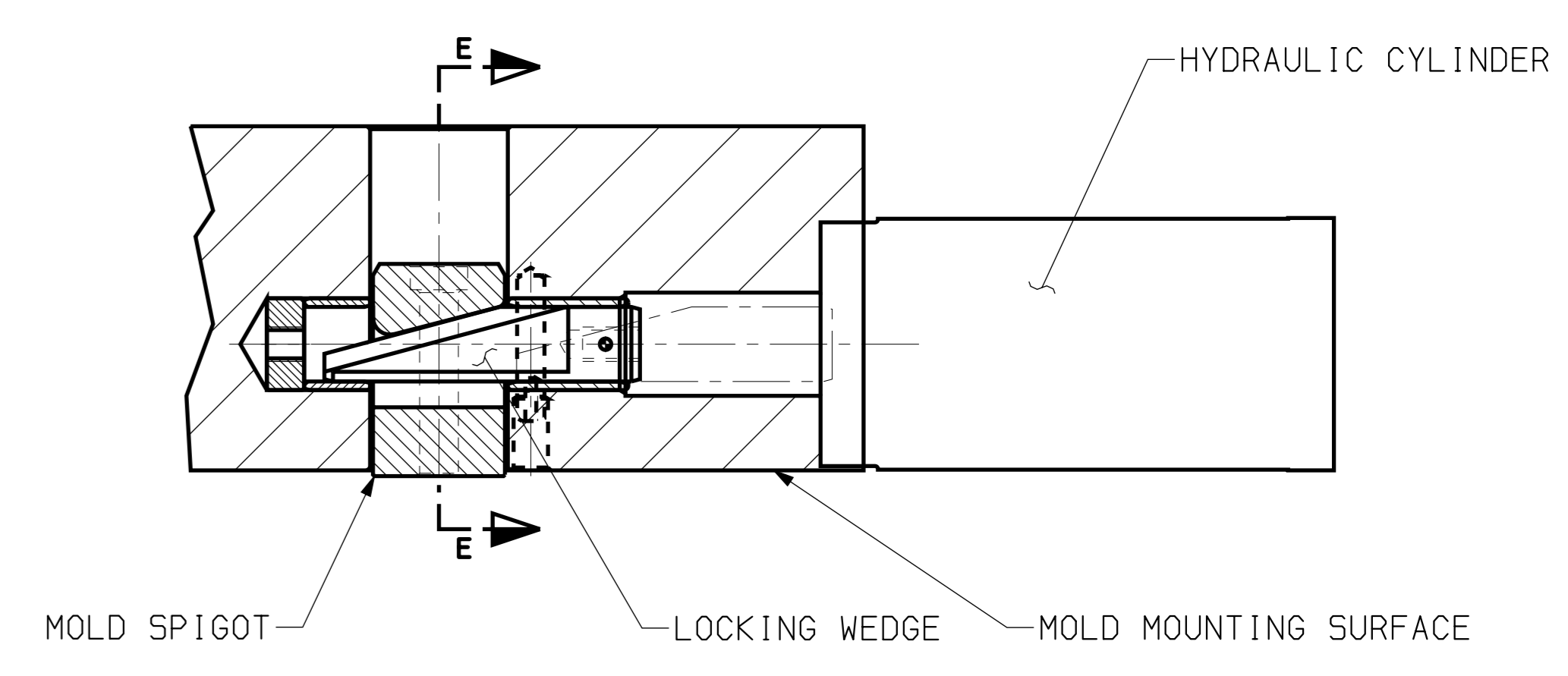
"A" VIEW
VIEW AT TOP OF FOUR STATION TABLE

MOLD MOUNTING HOLES AND
EJECTOR HOLE DETAILS ARE
IDENTICAL TO THOSE SHOWN
AT OPPOSITE STATION

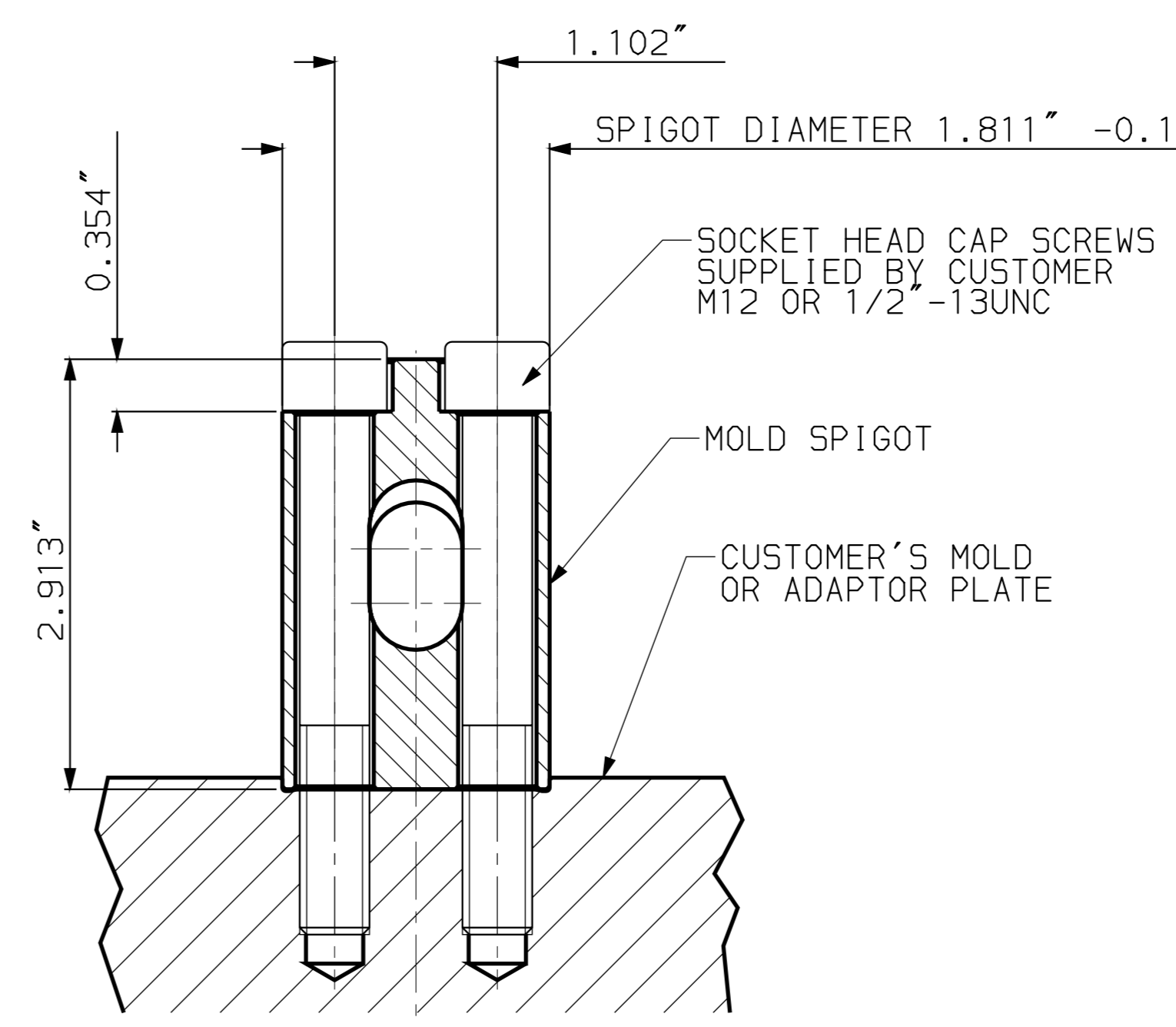
- NOTES:**
1. ALL DIMENSIONS ARE IN INCHES UNLESS SPECIFIED OTHERWISE.
 2. TECHNICAL DATA SUBJECT TO CHANGE WITHOUT NOTICE.
 3. 3.5" FOR STANDARD SPI EJECTOR HOLE PATTERN
OPTIONAL ON REQUEST 3.25".



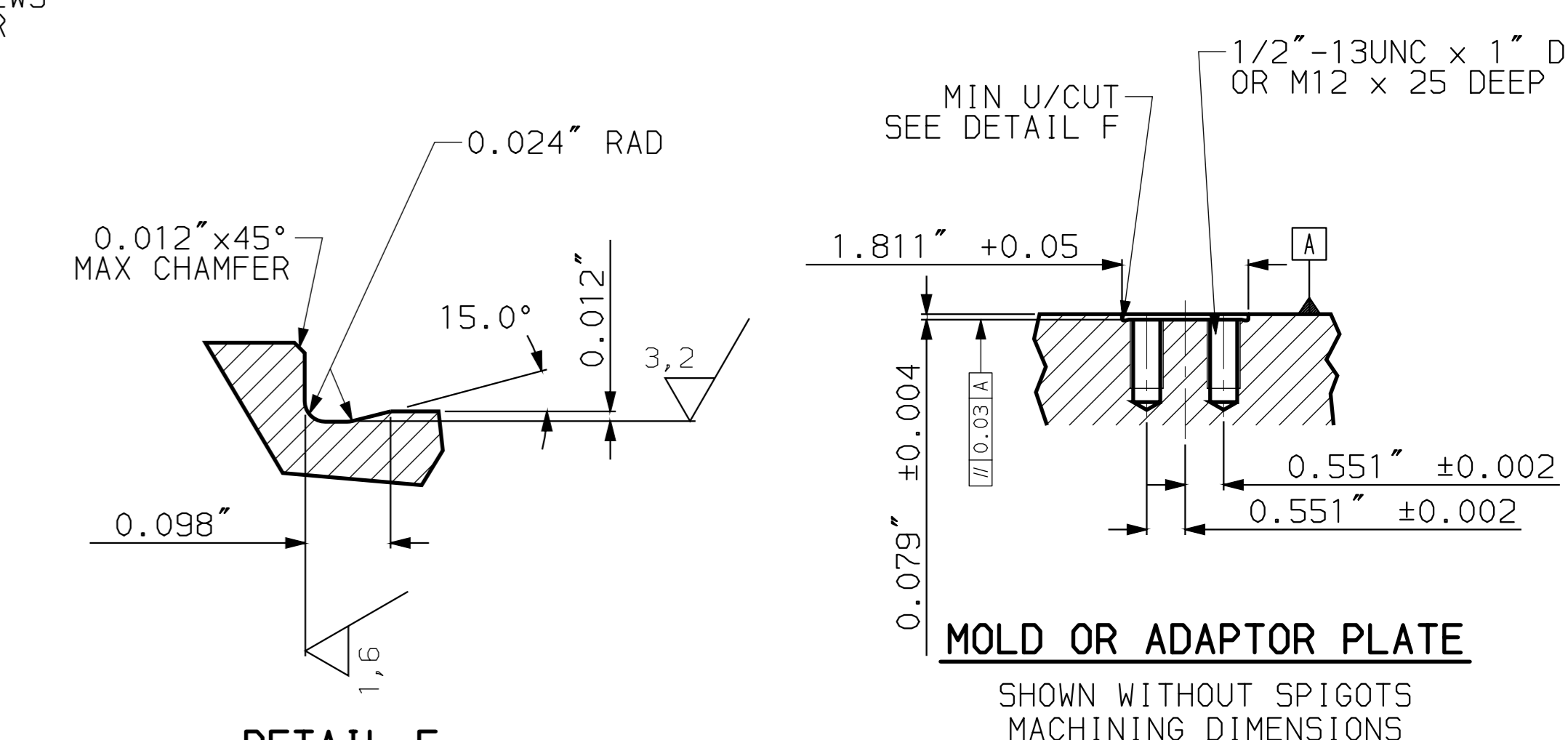
"B" VIEW
VIEW AT MOLD MOUNTING SURFACE OF MOVING PLATEN
OPTIONAL QUICK MOLD MOUNT SYSTEM



DETAIL "D"
QUICK MOLD MOUNT SYSTEM



SECTION E-E
SCALE 1:1
QUICK MOLD MOUNT SPIGOT



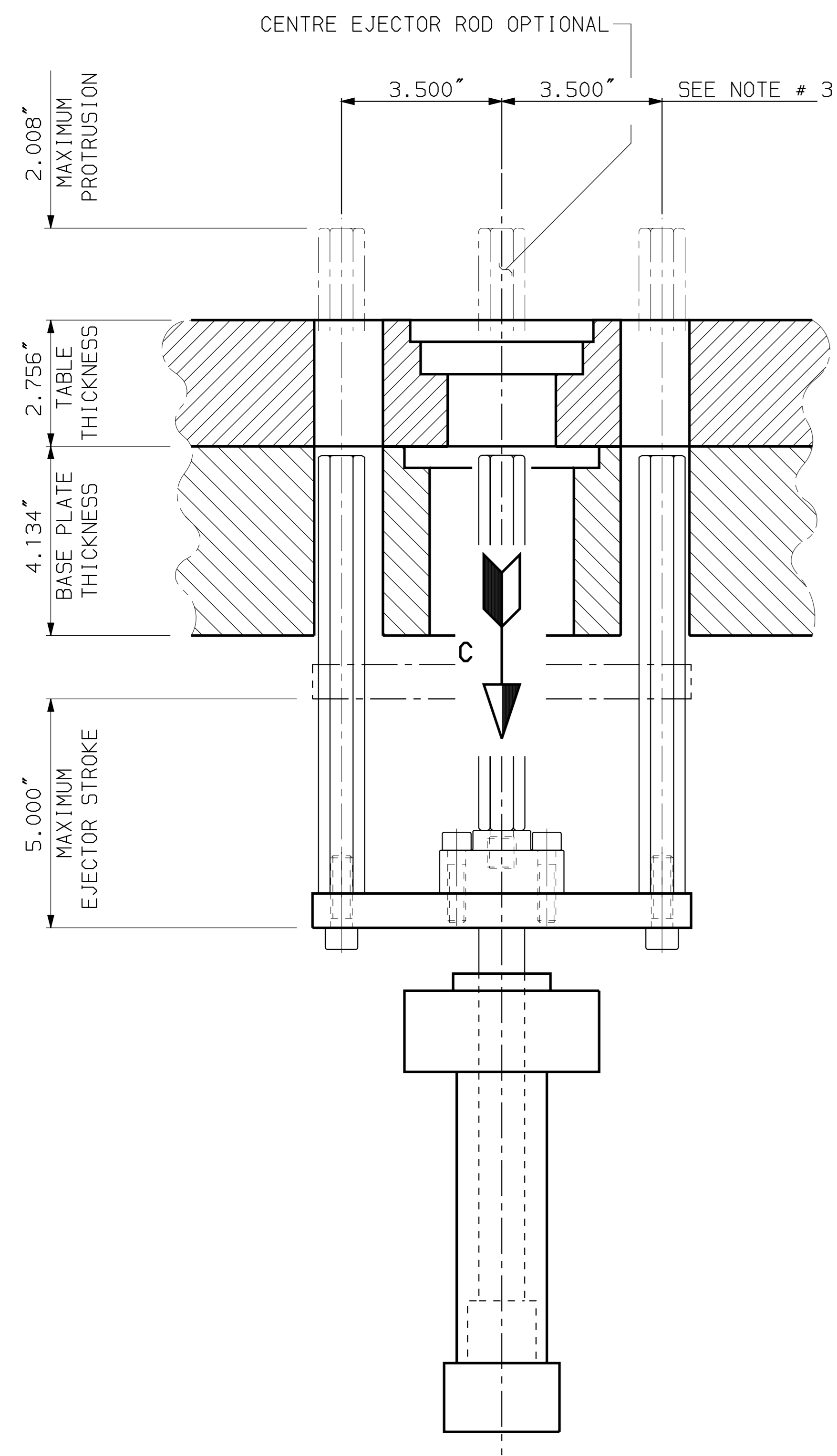
DETAIL F
UNDERCUT
DIN 509-E0, 6x0,3

MOLD OR ADAPTOR PLATE
SHOWN WITHOUT SPIGOTS
MACHINING DIMENSIONS

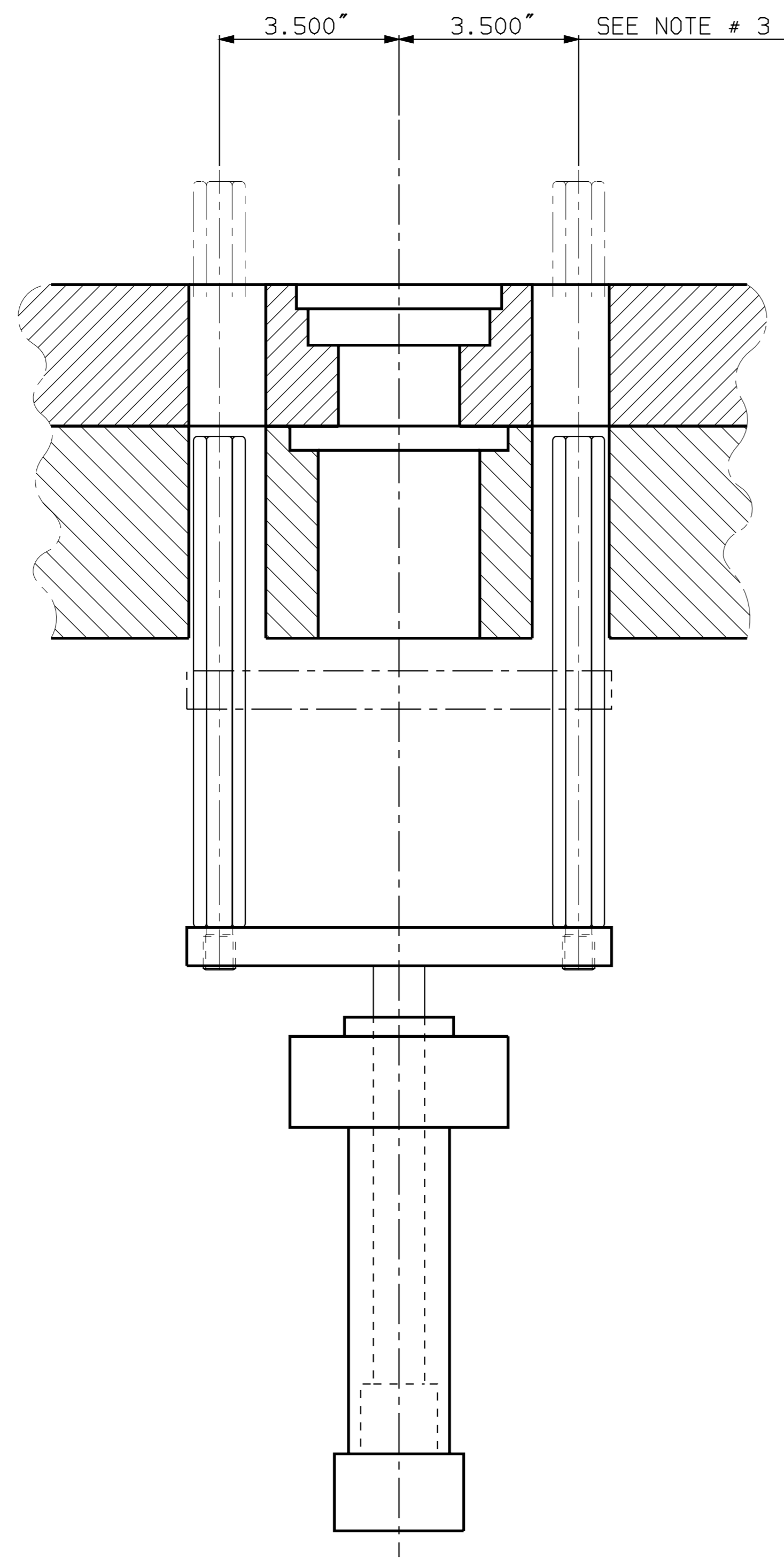
RELEASED
MICROFILM
REV. # 10

PART WEIGHT IN Kg.
-

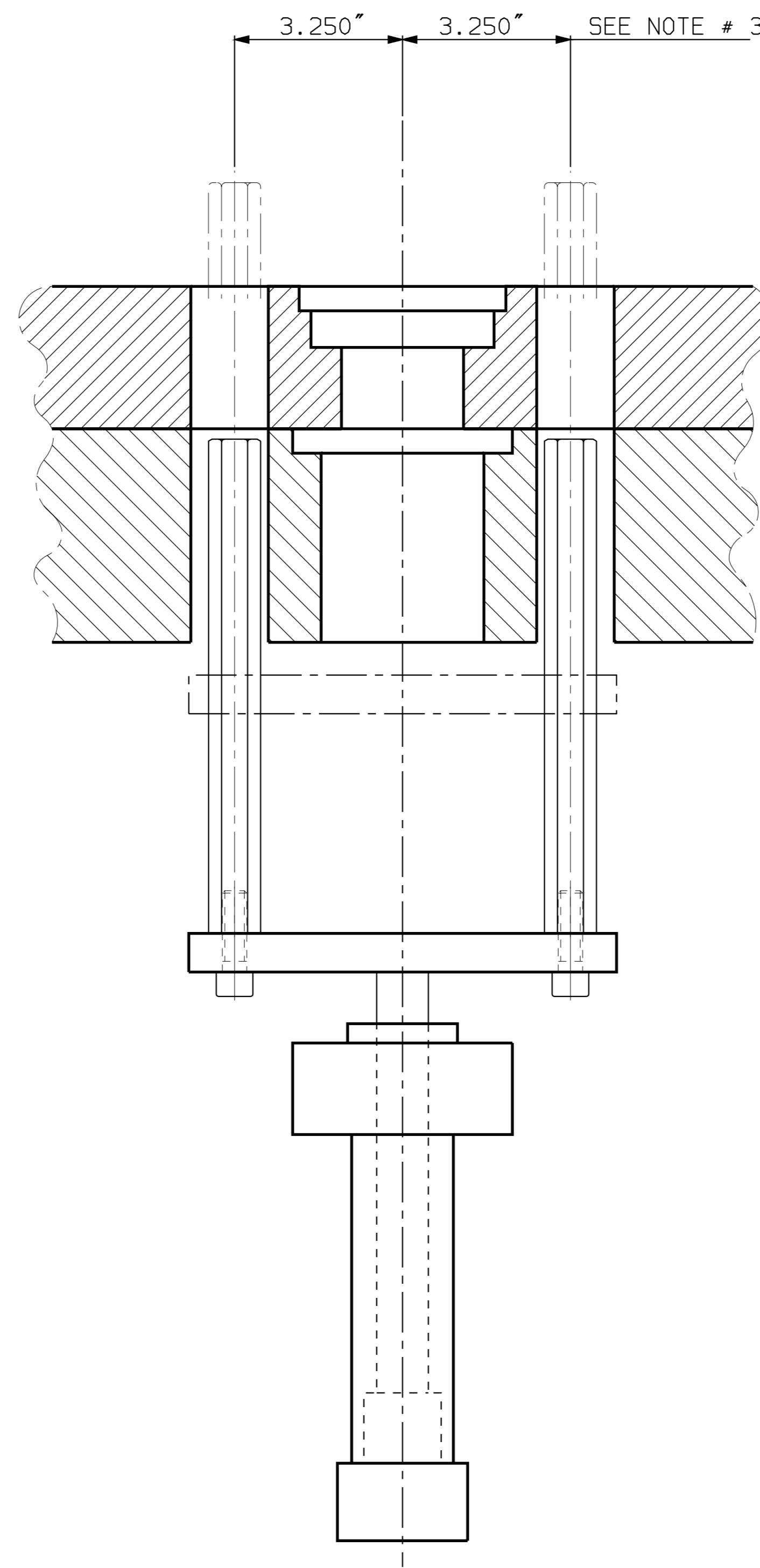
10	SAS	NEW	22-JAN-97	I.S.
REV#	ECOM	REVISION	DATE	NAME
1: 2		DESCRIPTION		
PLATEN LAYOUT-2 STN.		ENGEL		
PCD 530 E585VHRB		GUELPH - CANADA		
MATERIAL		NAME	DATE	
STOCK CODE		DR. N.	22-JAN-97	
BREAK SHARP CORNERS		CHK. D.	22-JAN-97	
FROM	0.5 6 30 120 315 1000 2000	REPLACES		
SIZE	10 8.0 30 120 315 1000 2000	COPY FROM	7964-450-234E	REV. 11
FINE #	0.05 0.1 0.15 0.2 0.3 0.5 0.8			
MEDIUM #	0.1 0.2 0.3 0.5 0.8 1.2 2.0	DRAGTING NO.		
DIM. MICR.	COARSE # 0.2 0.5 0.8 1.2 2.0 3.0 4.0	5785.002.3932E		
THIS DRAWING AND THE INFORMATION HEREIN IS CONFIDENTIAL AND MUST NOT BE REPRODUCED OR USED IN ANY WAY WITHOUT WRITTEN PERMISSION OF ENGEL CANADA INC.				SHEET 2 OF 3



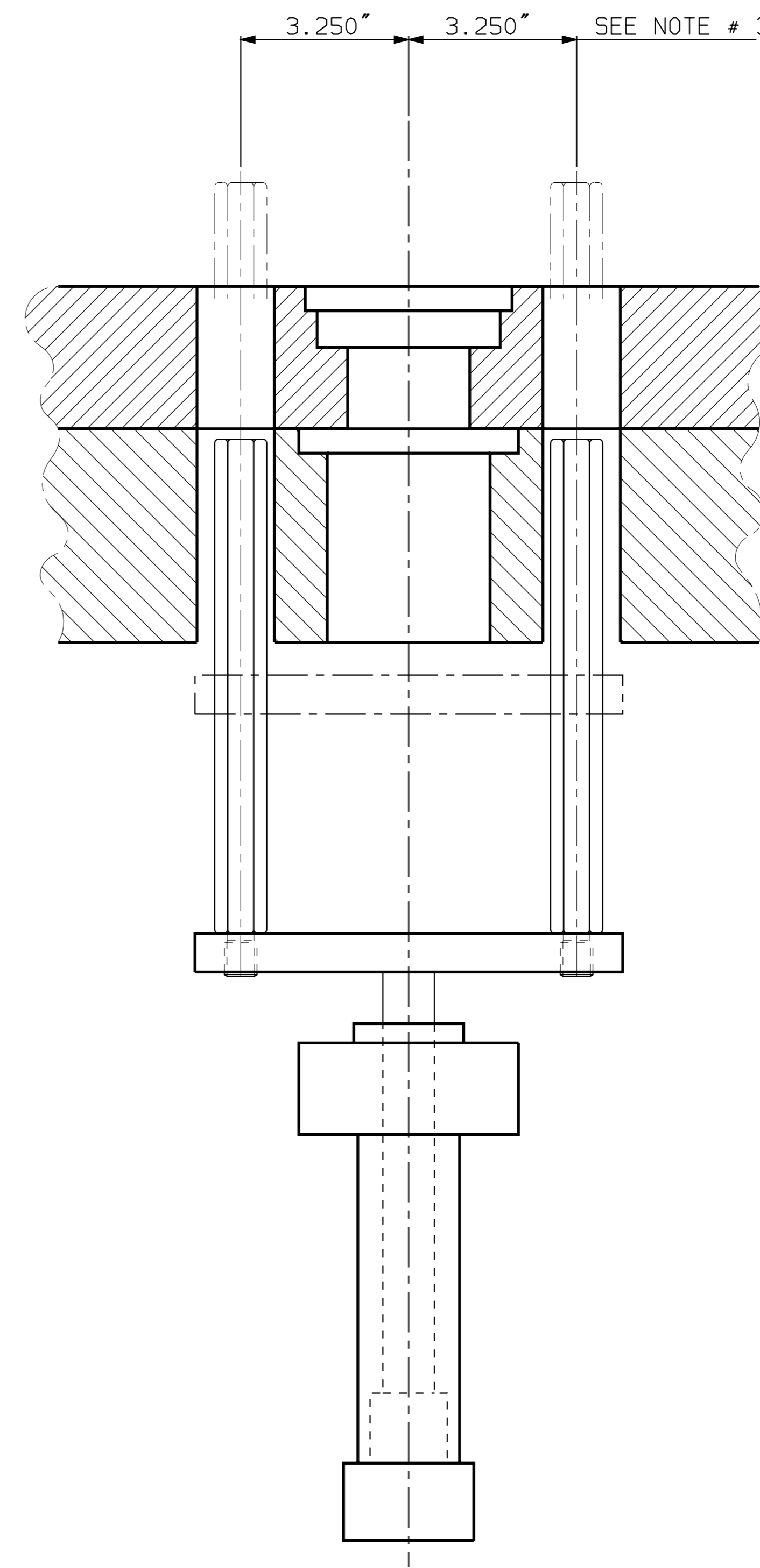
STANDARD HYDRAULIC EJECTOR UNIT
3.5" EJECTOR CENTRES AS PER SPI



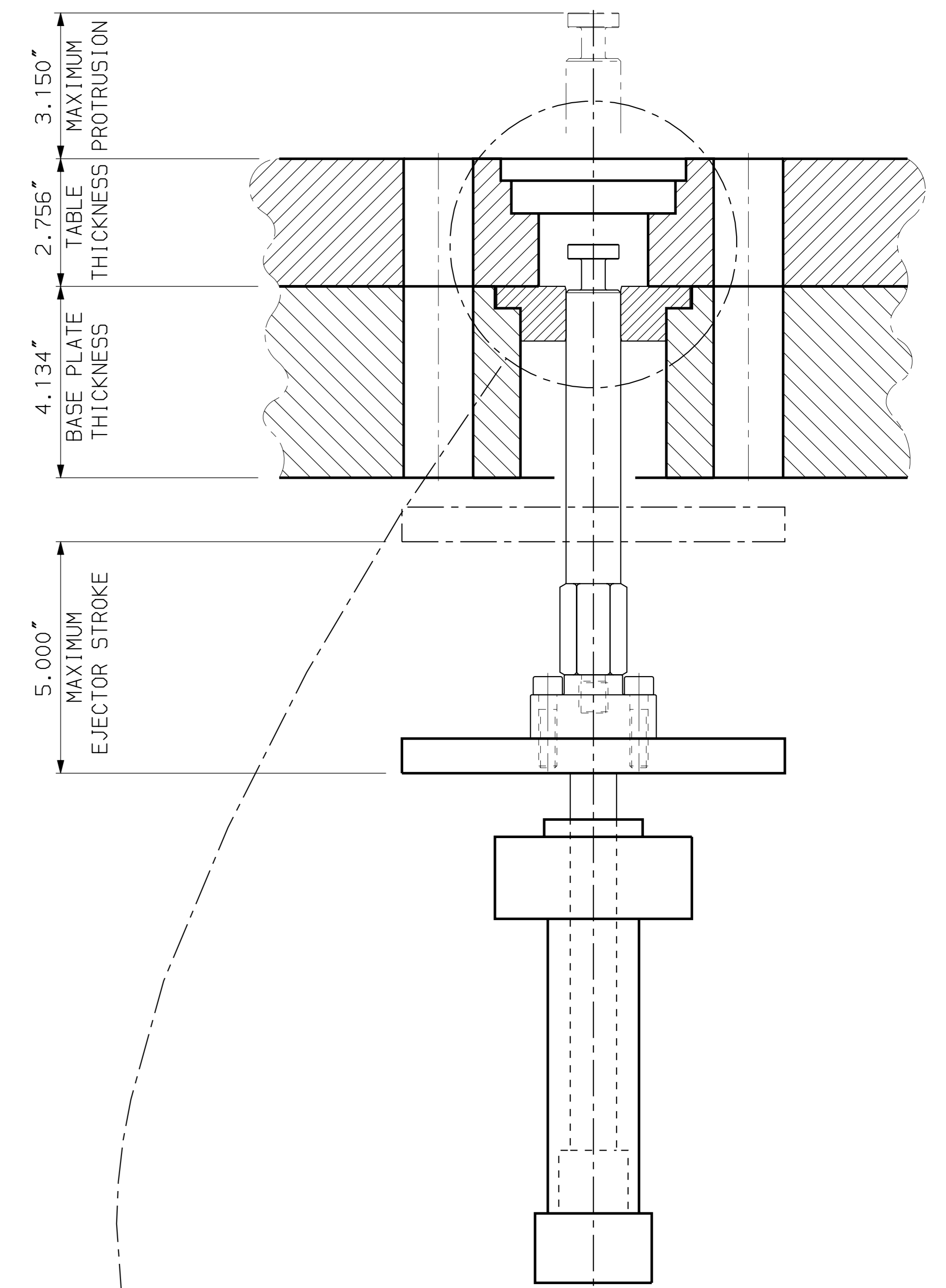
OPTIONAL HYDRAULIC EJECTOR UNIT
3.5" EJECTOR CENTRES
5/8"-11UNC EJECTOR RODS



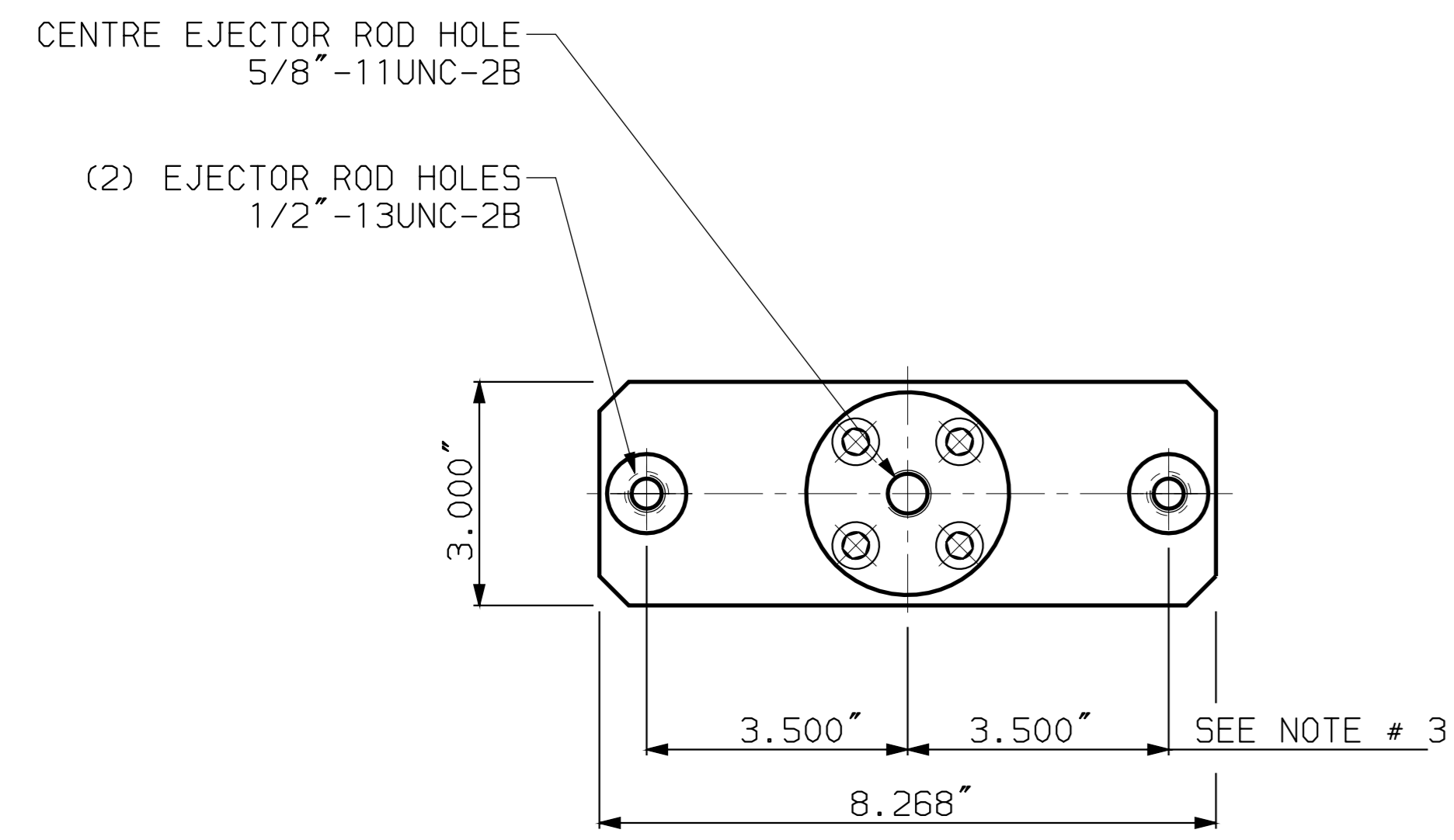
SPECIAL HYDRAULIC EJECTOR UNIT
3.25" EJECTOR CENTRES



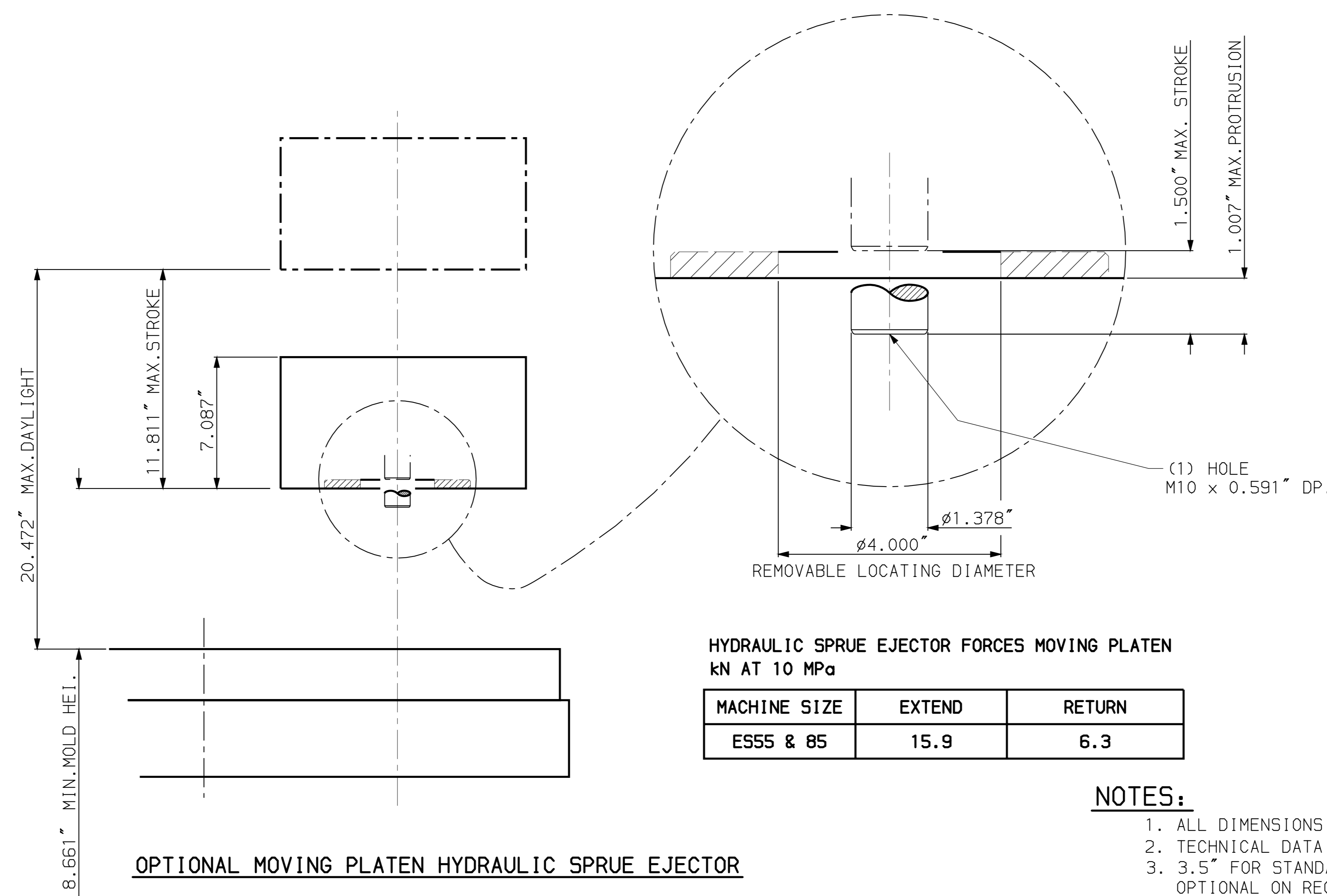
SPECIAL HYDRAULIC EJECTOR UNIT
3.25" EJECTOR CENTRES
5/8"-11UNC EJECTOR RODS



OPTIONAL EJECTOR PLATE POSITIVE RETURN UNIT
"TEE" STYLE EJECTOR ROD



"C" VIEW
VIEW AT EJECTOR PLATE

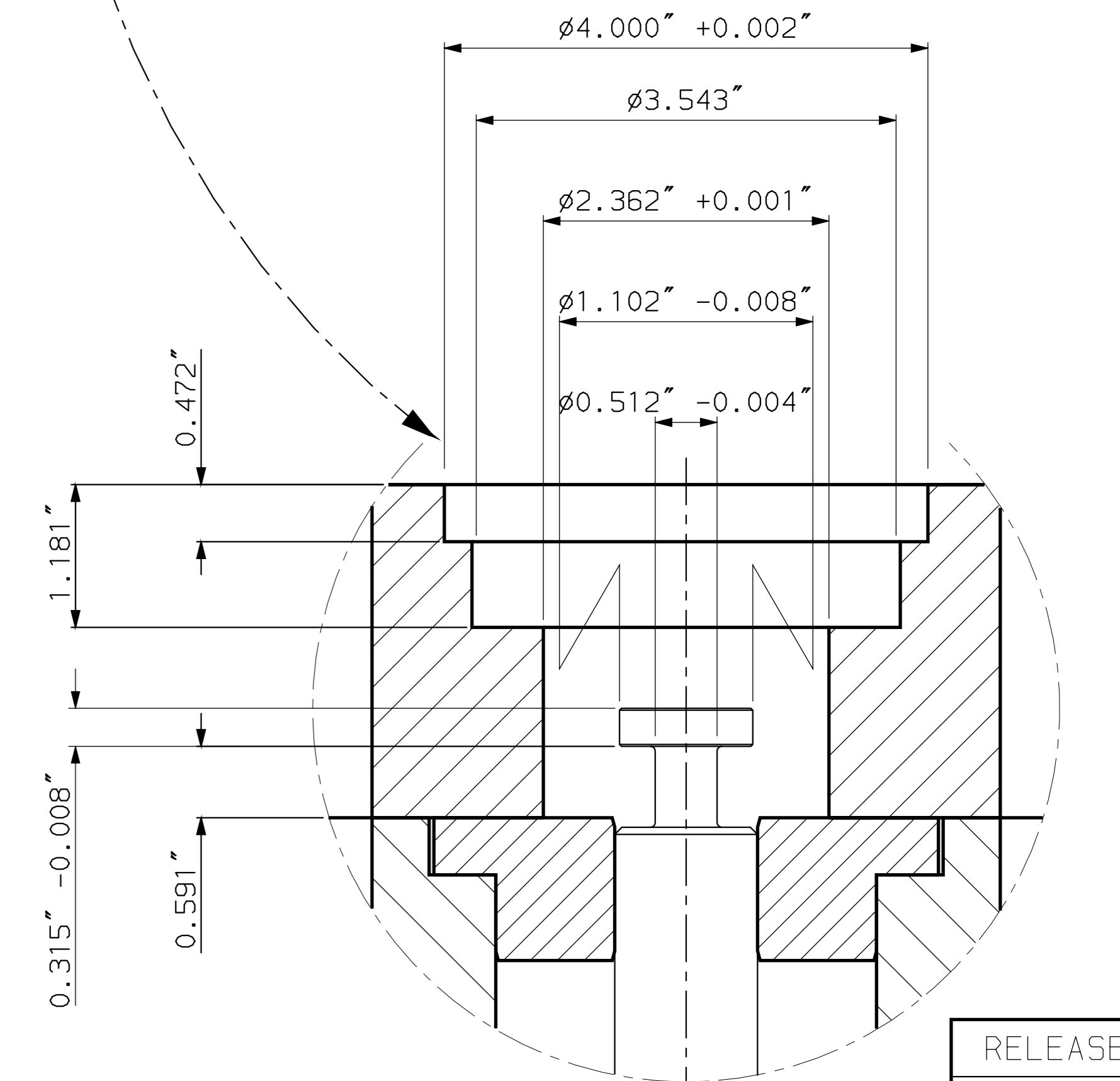


HYDRAULIC SPRUE EJECTOR FORCES MOVING PLATEN
KN AT 10 MPa

MACHINE SIZE	EXTEND	RETURN
ES55 & 85	15.9	6.3

NOTES:

1. ALL DIMENSIONS ARE IN INCHES UNLESS SPECIFIED OTHERWISE.
2. TECHNICAL DATA SUBJECT TO CHANGE WITHOUT NOTICE.
3. 3.5" FOR STANDARD SPI EJECTOR ROD SPACING
OPTIONAL ON REQUEST 3.25"



RELEASED
MICROFILM
REV. # 10

REV#	DATE	DESCRIPTION	REVISED BY	DATE	DESCRIPTION
10	22-JAN-97	NEW			
9	22-JAN-97	REVISION			
8	22-JAN-97	REVISION			
7	22-JAN-97	REVISION			
6	22-JAN-97	REVISION			
5	22-JAN-97	REVISION			
4	22-JAN-97	REVISION			
3	22-JAN-97	REVISION			
2	22-JAN-97	REVISION			
1	22-JAN-97	REVISION			

SCALE: 1:2
DESCRIPTION: PLATEN LAYOUT-2 STN.
PCD 530 ES85VHRB

MATERIAL: 1045
DIN: 1.35
DATE: 22-JAN-97

SIZE: 10
FROM: 0.5 6 30 120 315 1000 2000
TO: 0.1 30 120 315 1000 2000
REPLACES: 7964.002.294E REV.11

DIM: 10
METERS: COARSE # 0.2 0.5 0.8 1.2 2.0 3.0 4.0
FINE # 0.05 0.1 0.15 0.2 0.3 0.5 0.8 1.2 2.0 3.0 4.0
DRAFTER: JG

PART WEIGHT IN Kg. 5785.002.3932E

SHEET 3 OF 3