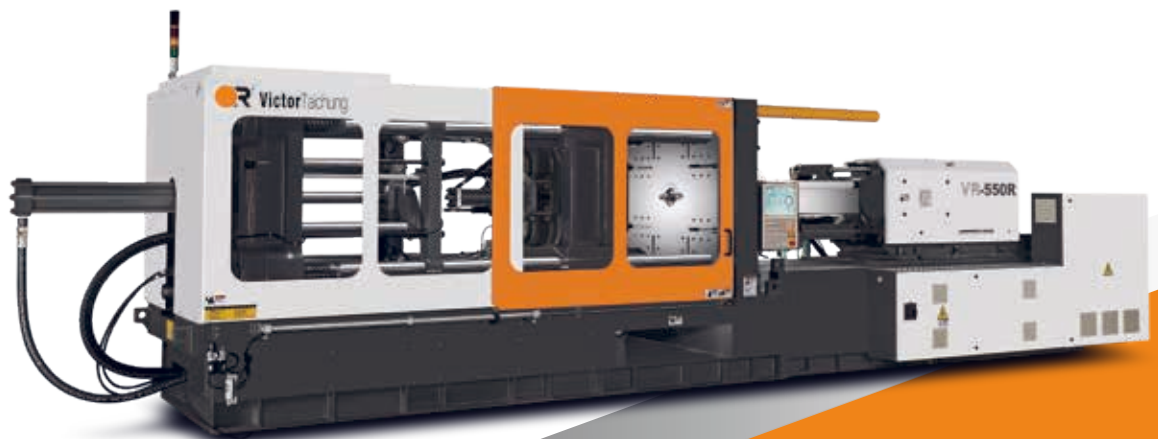


VR Series

Hybrid High-Performance Medium tonnage plastic injection molding machine to satisfy your energy saving and repeatability requirement.



VR Series

350-1300 Tons Precision built, high speed PIM machinery

Victor Taichung VR Series injection molding machine has been developed by fusing of merits of hydraulic injection machines (low maintenance-free operation, long life, and low cost) and electric molding machines (energy-saving, high-velocity injection, quick response, high repeatability, and low operation noise)

The innovative new servo motor with high-effect pump system, achieves energy-saving (Option) operation and quick response equivalent to all electric molding machines.



Management System
ISO 9001:2015
ISO 14001:2015
OHSAS 18001:2007
www.tuv.com
ID 0091003197



- Injection screw ACM2 German material
- Surface hardness: 900~1100 HV
- Processed by Nitride (500~520° C for 72hrs)
- Nitrided thickness: 0.4~0.5 mm
- Piston rod uses S45C steel which has excellent strength
- Piston seal uses German make Merkel to reduce the leakage and extend piston life.

Energy saving advantage (ES Option)

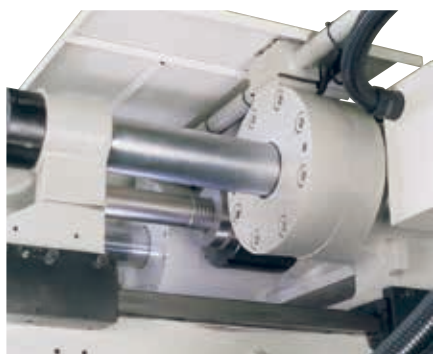
- Energy saving - Almost equivalent to all electric molding machines.
- Quick response - Injection response time (Standard mode).
- Stability in low-velocity/low-pressure & wide range - Injection velocity: From ultra-low to high velocity range.
- Linearity - Excellent linearity in both injection velocity and injection pressure.
- Excellent injection holding pressure performance - Capability in sustaining high injection holding pressure longer (as compared with all electric types).
- Reduction in the amount of hydraulic oil.
- Silent! (Low noise) Almost equivalent to all electric molding machine.

Bi-metallic material (optional) - SKD 61 base material. Excellent wear-resistant, corrosion resistant screw & barrel for the processing of materials with fiber additives and also fire retardant materials. Victor general purpose screw and barrels can process any kind of material like PE, PP, PA, ABS, AS. We also supply an optional screw & barrel for engineering materials like PC, PBT, PET, with an L/D ratio from 18, 20, 22.

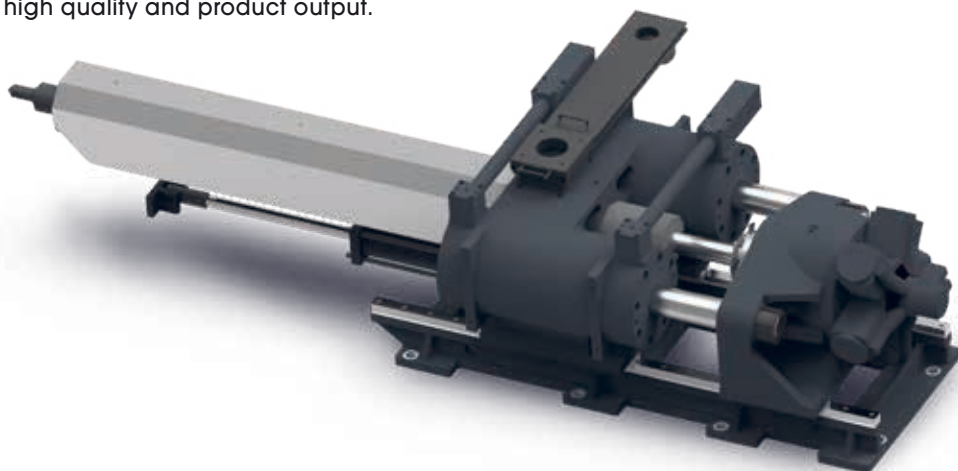


This multi-notch non-return valve offers improved reaction times and high flow rates. Also improves cycle times and increases product precision.

The VR Series injection unit, utilizing the high wear and corrosion resistant ion-nitrided screw and barrel, provides the injection volumes and plasticizing capacities necessary for the manufacture of precision products. With high injection stability and excellent mixing capabilities, this newly developed injection unit allows for the use of a wider range of materials. It all adds up to unit that will stay the course, giving consistently high quality and product output.



High precision injection unit with a screw and barrel, which is used on the Victor machines has the following properties.

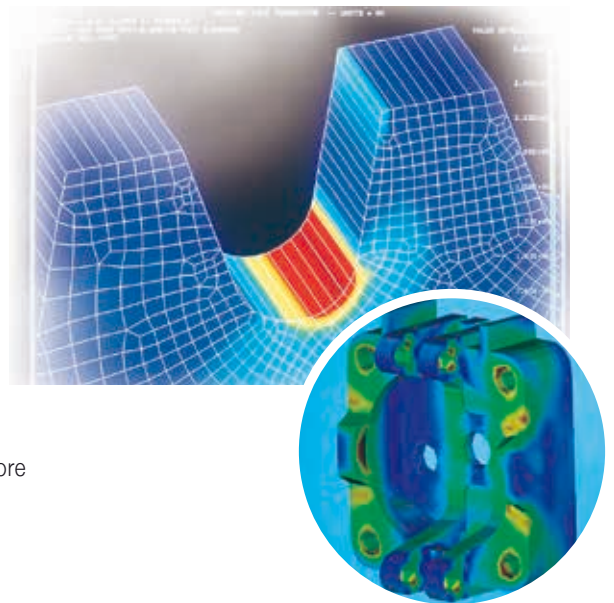
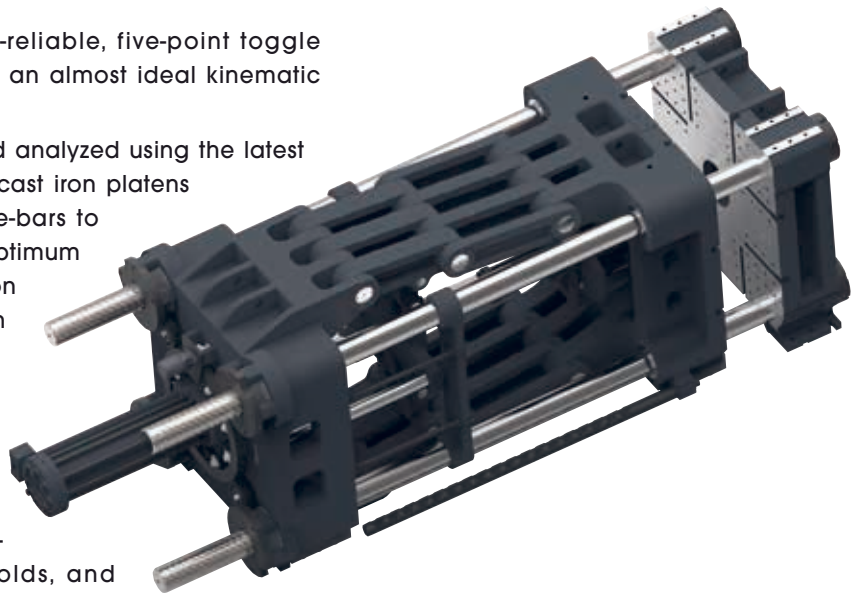


Heavy Duty, Rigid, Clamping Unit

All VR Series machines feature a unique, ultra-reliable, five-point toggle clamping mechanism which is characterized by an almost ideal kinematic velocity feature.

This high precision clamping unit is designed and analyzed using the latest in computer software, i.e. CAD & CAE. The large cast iron platens are extremely robust and with widely spaced tie-bars to accommodate the largest of molds. They have optimum rigidity that matches the current need in precision molding and which minimizes mold deflection caused by clamping force and cavity pressure.

The large, square cast iron platens virtually eliminate deflection. The bushings are manufactured from graphite impregnated phosphor bronze. Designed to run totally oil-free, there's no chance of contaminating molds, and maintenance is limited to long periodic greasing.



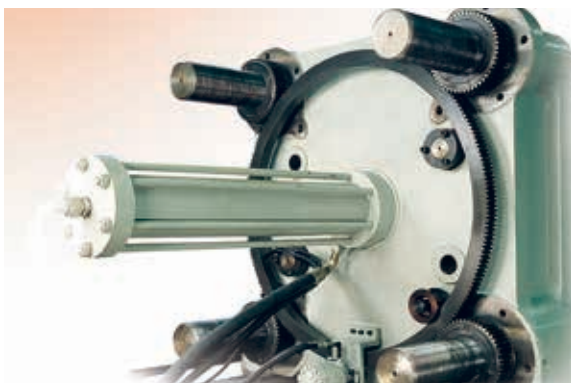
Material:

Platen: Meehanite casting FCD 55
Tie bar: NH48MV (from Japan)
Toggle pin: SCM21 (hard chrome plating)

Advantage:

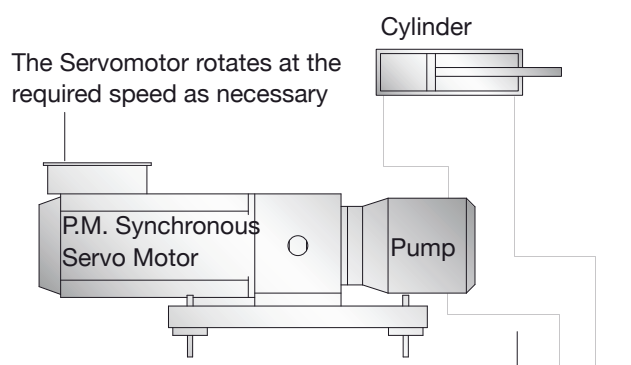
- * Machine life = 15 years more
- * Eliminates the oil pollution
- * Saves maintenance time

Mold height adjustment, which is the bull gear system, is operated by a hydraulic motor and when co-ordinated with a monitoring program proceeds to prevent the possibility of overloading by force and cause machine damage.



Hybrid Hydraulic Control (Option - servomotor pump)

VR Series injection molding machine every moving steps require pressure and flow control by high-effect pump collocating with powerful permanent-magnet synchronous servo motor. This series machine is availability of energy saving up to 60% as compared with general hydraulic machine.



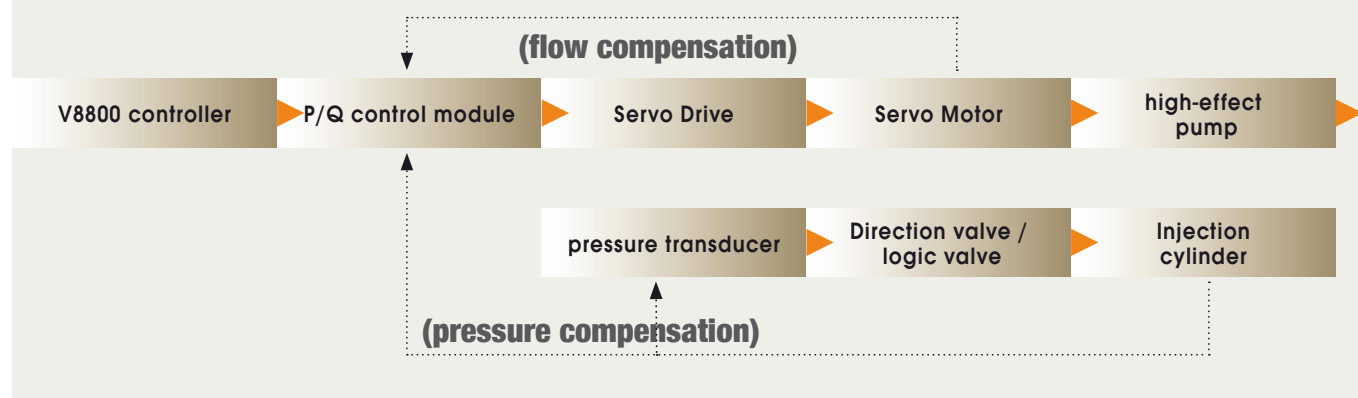
Pressure: Torque of Servomotor / Pressure transducer.
Flow: Revolution speed of Servomotor

- Piston seal: Merkel (German)
- Cylinder seal: NOK (Japan)
- O-Ring: NOK (Japan)
- Back-up Ring: NOK (Japan)

The VR Series adopts logic valves in its hydraulic system circuits. The logic valves give high response performance in injection and mould travelling stages and offers 5% energy reduction due to low-pressure loss, and can guarantee a long service life. Less energy loss means lower heat build-up in addition to a substantial reduction in the requirement of cooling water. This is further help automatic regulation of the hydraulic oil temperature.

VR ES Energy saving system (Injection close-loop feedback control):

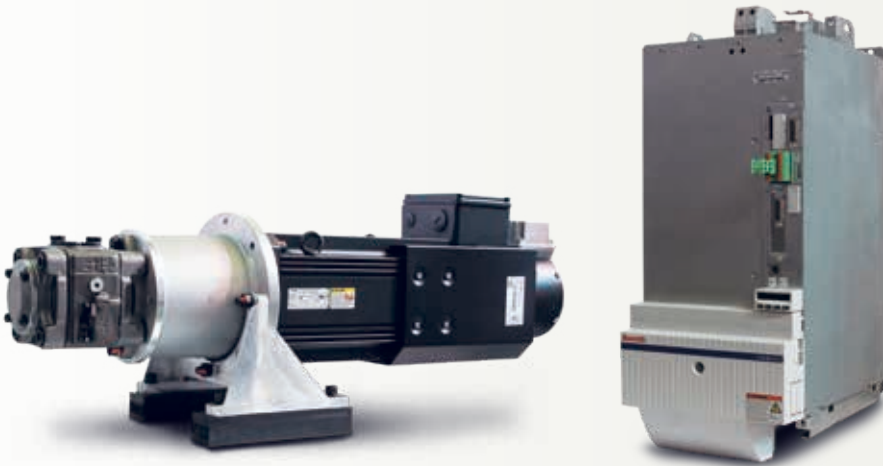
The pressure output signal of servo driven pump is measured injection cylinder and feedback to P/Q control module for close-loop pressure compensation. The flow output signal of servo motor is measured and feedback to P/Q control module for flow compensation to get precision control.



Energy Saving system (Option)

Servo driven pump with variable speed drives for injection moulding machine.

Cost reduction by energy efficiency in Plastic Machinery.



Request on drive system

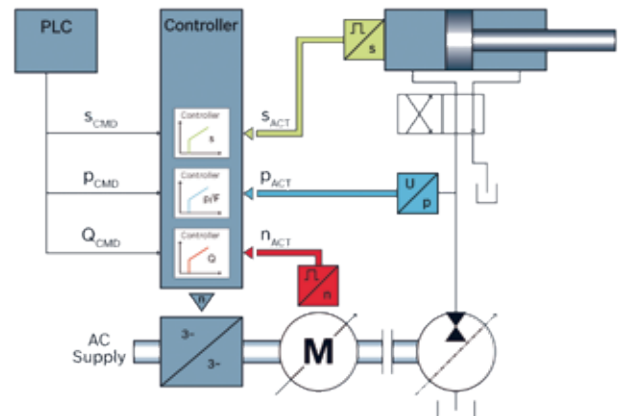
- Reduced energy cost.
- Reduced installed power.
- Less secondary measures for reduction of noise.
- Reduced cost for oil cooling.

Comparison with traditional fixed pump with constant speed.

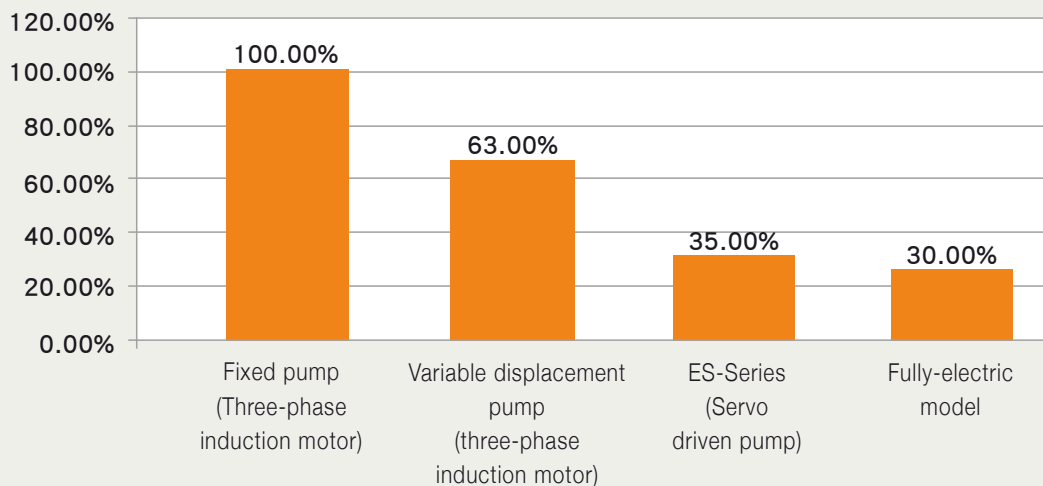
Example: Load sensing

72.3% energy saving
Model: VsES-50T

75s cycle times
const. speed (15kW): 2.9 kW
SVP: 0.8 kW



Power consumption



New Generation V8800 Control

Intuitive 15 inch touch screen framed with keyboard

The swivel mounted 15" LCD high resolution touch screen, graphical user interface, can be optimally positioned for each operator, allowing an easy setting position and easy access to the mould area.

Lighted on/off manual movement buttons for each axis.

Simple Friendly Operation interface

Mold settings can be transferred using a USB drive

The internal memory allows for up to 1000 set to be stored, the USB port enables molding condition files to be stored to an external USB memory stick.



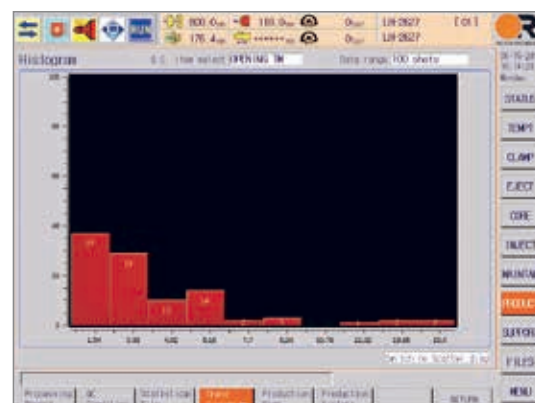
Overall setting screen

- Single screen for setting clamp, ejector, injection, temperature, air-blast and charging etc.
- Great for quick setups and adjustments.
- Improves operator setup efficiency.



Pop-up keyboards for data and text entry

Touch screen panel/Pop-up keyboard for data and text entry. Drop down selection boxes for choosing items from a list.

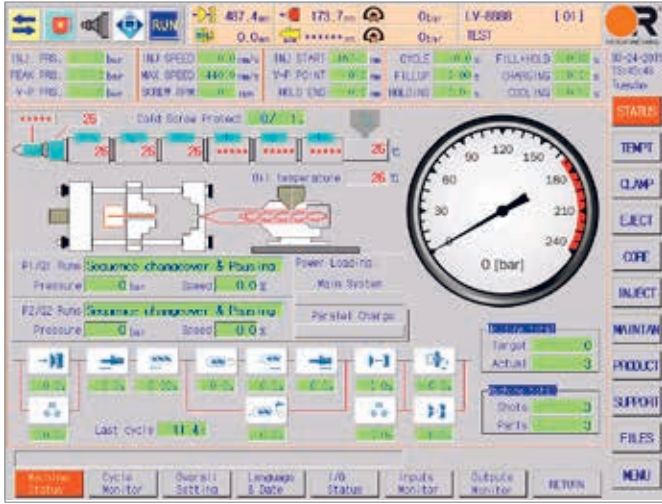


SPC/SQC Production management - quality control

Process cycle data maintains information over the last 10,000 cycles allowing for quick analysis of process history. This data can be printed, and save to USB sticker, for off line Excel analyzing.

The Setting Page Of Controller V8800 Series

Machine Status



WeekTime & Auto Tuning



Charge & Suckback



Inject & Holding



Clamp Setting



Barrel Temperature



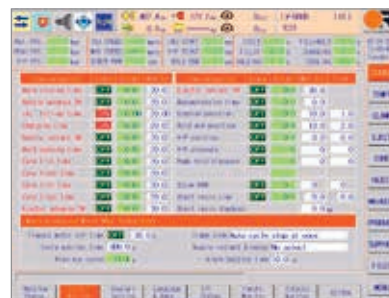
Corepull on Ejection



Mold Setup



Cycle Monitor



Injection Curve



Injection Unit

	VR-350	VR-450	VR-550	VR-700	VR-850	VR-1000	VR-1300
Power driven pivoting injection unit	O	O	O	O	S	S	S
Cold start protection	S	S	S	S	S	S	S
Five injection speed & pressure steps	S	S	S	S	S	S	S
Four holding pressures stages	S	S	S	S	S	S	S
Holding pressure, time dependent	S	S	S	S	S	S	S
Closed loop control for the complete injection profile and back pressure	O	O	O	O	O	O	O
Control for intrusion injection	S	S	S	S	S	S	S
PID temperatures control	S	S	S	S	S	S	S
Thermocouple controlled nozzle zone	S	S	S	S	S	S	S
Screw suck back with open nozzle	S	S	S	S	S	S	S
Pneumatic actuated needle shut-off nozzle	O	O	O	O	O	O	O
Slide-away hopper for quick material change	S	S	S	S	S	S	S
Rigid PVC processing unit	O	O	O	O	O	O	O
Hydraulic accumulator for increased injection speed	O	O	O	O	O	O	O
Stainless steel barrel cover	S	S	S	S	S	S	S
Nozzle guarding	S	S	S	S	S	S	S
Automatic heating and pre-heating	S	S	S	S	S	S	S
Additional temperature zones	O	O	O	O	O	O	O
RPM display	S	S	S	S	S	S	S
Control for automatic purging	S	S	S	S	S	S	S
Low torque / High speed hydraulic screw motor	O	O	O	O	O	O	O
Screw speed adjustable via screen	S	S	S	S	S	S	S
Bimetallic screw and barrel	O	O	O	O	O	O	O
Plug-in ceramic heaters	O	O	O	O	O	O	O
Water-cooled throat & temperature display	S	S	S	S	S	S	S
Hopper (+ magnet)	O	O	O	O	O	O	O
Auto loader	O	O	O	O	O	O	O
Vented screw and barrel	O	O	O	O	O	O	O
Injection unit guided on linear rails	S	S	S	S	S	S	S
Barrel temperature display with set value and deviation	S	S	S	S	S	S	S
Plasticizing time monitor	S	S	S	S	S	S	S
Injection unit forward / back speeds adjustable	S	S	S	S	S	S	S
Suck-back before or after metering	S	S	S	S	S	S	S
Thermocouple breakage alarm	S	S	S	S	S	S	S
Injection endpoint control	S	S	S	S	S	S	S
Insulated barrel cover	O	O	O	O	O	O	O
Long nozzle	S	S	S	S	S	S	S

Injection controlled by linear transducer	S	S	S	S	S	S	S
Carriage controlled by linear transducer	O	O	O	O	O	O	O
Oil heated barrel (some thermoset materials)	O	O	O	O	O	O	O
Heater bands up to 450° C	O	O	O	O	O	O	O
Braided heater bands	O	O	O	O	O	O	O

Clamping Unit

	VR-350	VR-450	VR-550	VR-700	VR-850	VR-1000	VR-1300
Four mold closing / open speed ranges with four adjustable speeds	S	S	S	S	S	S	S
Mold height adjustment by hydraulic motor	S	S	S	S	S	S	S
Hydraulic ejector with adjustable speed, pressure and position and no. strokes	S	S	S	S	S	S	S
Hydraulic unscrew device	O	O	O	O	O	O	O
Core pull x 1, Air blow x 1	S	S	S	S	S	S	S
Core pull x 2, Air blow x 2	O	O	O	O	O	O	O
Core pull x 3, Air blow x 3	O	O	O	O	O	O	O
Mechanical scotch bar	S	S	S	S	S	-	-
Pneumatic operated safety gate	S	S	S	S	S	S	S
Ejection during mold open	O	O	O	O	O	O	O
Phosphor bronze, graphite impregated toggle bushings	S	S	S	S	S	S	S
Chromium plated tie bars	S	S	S	S	S	S	S
Phosphor bronze, graphite impregated platen sliding shoes	S	S	S	S	S	S	S
Clamping measurement by linear transducer	S	S	S	S	S	S	S
Mold safety devices (Low pressure protection)	S	S	S	S	S	S	S
Platen holes and locating ring to Euromap or SPI specifications	S	S	S	S	S	S	S
Additional mold height	O	O	O	O	O	O	O
Mold safety gate operator and rear side	S	S	S	S	S	S	S
Robot fixing holes on top of moving platen	S	S	S	S	S	S	S
Auto lubrication system	S	S	S	S	S	S	S
Auto clamping force set-up	S	S	S	S	S	S	S
Ejector stroke controller by linear transducer	S	S	S	S	S	S	S
Ejector retract confirmed	O	O	O	O	O	O	O
FCD 55 casted platens	S	S	S	S	S	S	S
Ejector forward when safety door open	S	S	S	S	S	S	S
Mold insulation plate	O	O	O	O	O	O	O

Hydraulic System

	VR-350	VR-450	VR-550	VR-700	VR-850	VR-1000	VR-1300
Servo motor pump system	O	O	O	O	O	O	O
Pressure gauges for system monitoring	S	S	S	S	S	S	S
Oil temperature gauge	S	S	S	S	S	S	S
Oil level sight glass	S	S	S	S	S	S	S
Optical oil filter contamination monitor	S	S	S	S	S	S	S
Maintenance hatch for cleaning and checking oil tank	S	S	S	S	S	S	S
Integral tube nest heat exchanger	S	S	S	S	S	S	S
High performance oil seals	S	S	S	S	S	S	S
Proportional valve control for charge back-pressure	S	S	S	S	S	S	S
Precision manifold logic valve control	S	S	S	S	S	S	S
Water / Air chiller	O	O	O	O	O	O	O
High precision directional / flow valves	S	S	S	S	S	S	S
Steel braided hydraulic pipe	S	S	S	S	S	S	S

General Features

	VR-350	VR-450	VR-550	VR-700	VR-850	VR-1000	VR-1300
3 phase socket 220 / 380 / 460 × 1	S	S	S	S	S	S	S
Victor way standardized interface for handling device	S	S	S	S	S	S	S
Heating and motor power are on separate circuits, switchable on or off	S	S	S	S	S	S	S
Solid state heat contacts for plasticizing units	S	S	S	S	S	S	S
Part chute with sensor indicator cycle restart	N/A	N/A	N/A	N/A	N/A	N/A	N/A
Parts removal from both sides	O	O	O	O	O	O	O
Anti-vibration leveling pads	S	S	S	S	S	S	S
Pneumatic core pulls	O	O	O	O	O	O	O
Mold water manifold	O	O	O	O	O	O	O
Mold heating regulators	O	O	O	O	O	O	O
Hot runner regulators	O	O	O	O	O	O	O
Euomap 12/67 for robot interface	O	O	O	O	O	O	O
Conveyor belt	O	O	O	O	O	O	O
Masterbatch color dosing unit	O	O	O	O	O	O	O
Tool kit	S	S	S	S	S	S	S
Spare part packages	O	O	O	O	O	O	O

S=Standard O=Option N/A=Not Available

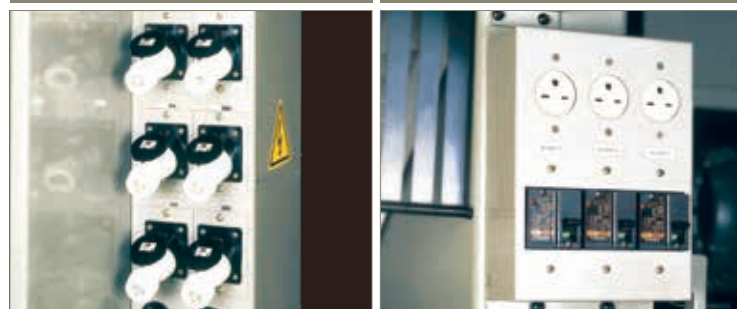
Control & Electrical Unit

	VR-350	VR-450	VR-550	VR-700	VR-850	VR-1000	VR-1300
Modular assembly, compact microprocessor with 1000 mold data storage	S	S	S	S	S	S	S
Data interface for printer (Softcopy & printout via USB memory stick)	S	S	S	S	S	S	S
Data interface for computer connection (RS 232 and RJ45)	S	S	S	S	S	S	S
Reference hints and problem indicators in clear text	S	S	S	S	S	S	S
Hour, minute, second counter	S	S	S	S	S	S	S
Cycle counter	S	S	S	S	S	S	S
Part piece counter	S	S	S	S	S	S	S
Preselectable cycle counter with auto stopping	S	S	S	S	S	S	S
Air eject programmable start and blow time	S	S	S	S	S	S	S
Tolerance monitoring of parameters	S	S	S	S	S	S	S
Standard SPC / SQC program	S	S	S	S	S	S	S
7-day timer for auto heating and preheating	S	S	S	S	S	S	S
Additional temperature control zones	O	O	O	O	O	O	O
Interface for temperature control devices	O	O	O	O	O	O	O
Alarm log	S	S	S	S	S	S	S
Multi language choice	S	S	S	S	S	S	S
Cycle, Filling & metering time indicator	S	S	S	S	S	S	S
Parts counter	S	S	S	S	S	S	S
Reject counter	S	S	S	S	S	S	S
Cushion control	S	S	S	S	S	S	S

Example of standard/ optional equipment

Accessory	Stand	Option
Tool/ fuse kit	●	
Part drop chute		●
Conveyor belt		●
Standard 5-in's/ 5-out's water regulator without flow indicator	●	
4 or extra zones water regulator with the flow indicator		●
Anti-vibration leveling pads	●	
220V/ 380VAC outlet x 1 for auto loader	●	
110VAC outlet receptacle (power sourced by customer)		●
110VAC outlet receptacle (power sourced via machine)		●
AC 220V/ 380VAC outlet receptacle (power sourced by customer)		●
AC 220V/ 380VAC outlet receptacle (power sourced via machine)		●

AC 220V/ 380VAC outlet receptacle 110VAC outlet receptacle



Hydraulic unscrewing motor



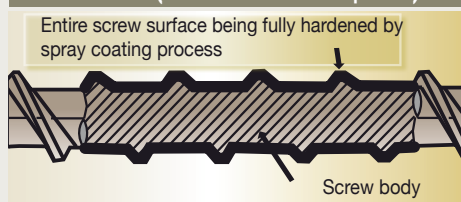
Notes:

- There are A, B and C three grades of bimetallic screw & barrel available, which can be selected by customer depending on what abrasive/corrosive engineering resin & additives used for molding application.
- For further information details, please contact Victor's sales.

A Grade bimetallic barrel and screw set- with 40% tungsten carbide composition included in the barrel's bimetallic content, coupled with a screw which entire surface is fully hardened through HP/HVOF coating treatment process.

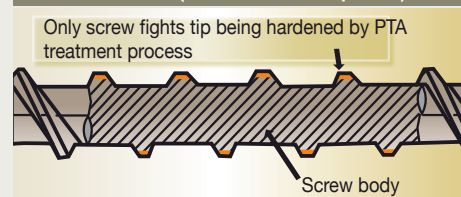
B Grade bimetallic barrel and screw set- with 25% tungsten carbide composition included in the barrel's bimetallic content, coupled with a screw which entire surface is fully hardened through HP/HVOF coating treatment process.

Sectional drawing of screw spindle with HP/HVOF treatment (A & B Grade Screw Spindle)



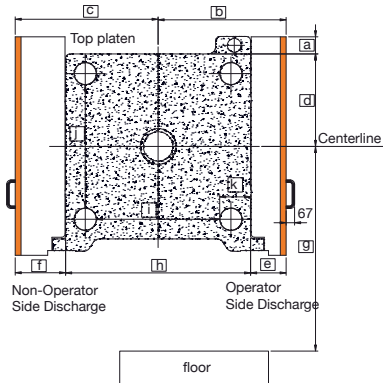
C Grade bimetallic barrel and screw set- with 9.5% tungsten carbide composition included in the barrel's bimetallic content, coupled with a screw which only the flights-tip is hardened through PTA Bimetallic alloy treatment process.

Sectional drawing of screw spindle with PTA treatment (C Grade Screw Spindle)



Various Measurement Relations

350~550 tons

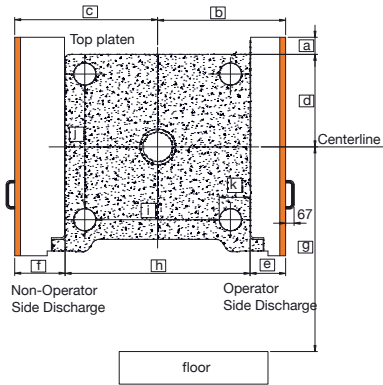


Various Measurement Relations (Euromap)

Model	a	b	c	d	e	f	g	h	i	j	k
VR-350	98	721	786	525	230	295	1578	1080	680	680	200
VR-450	106	850	850	600	294	284	1470	1200	780	780	216
VR-550	122.5	951	951	612.5	240	342	1505	1260	830	830	215
VR-700	0	1020	1230	715	305	515	1340	1430	960	960	240
VR-850	0	1135	1260	780	305	430	1380	1660	1100	1000	280
VR-1000	-67	1224	1304	823	284	364	1535	1880	1250	1100	315
VR-1300	-190	1360	1430	995	330	400	1625	2060	1320	1280	355

Units: mm

700~1300 tons



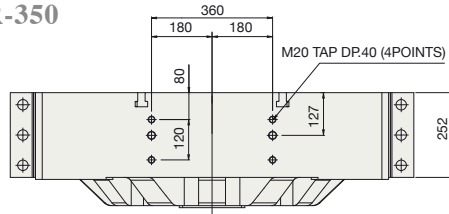
Various Measurement Relations (SPI)

Model	a	b	c	d	e	f	g	h	i	j	k
VR-350	3.85	28.38	30.94	20.66	9.05	11.61	62.12	42.52	26.77	26.77	7.87
VR-450	4.17	33.46	33.46	23.62	11.57	11.18	57.87	47.24	30.71	30.71	8.5
VR-550	4.82	37.44	37.44	24.11	9.45	13.46	59.25	49.61	32.67	32.67	8.46
VR-700	0	40.2	48.4	28.15	12	20.3	52.75	56.3	37.79	37.79	9.45
VR-850	0	44.7	49.6	30.7	12	16.9	54.3	65.4	43.31	39.37	11
VR-1000	-2.63	48.2	51.35	32.4	11.19	14.34	60.4	74.01	49.21	43.3	12.4
VR-1300	-7.5	53.54	56.29	39.17	12.99	15.74	63.9	81.1	51.96	50.3	13.97

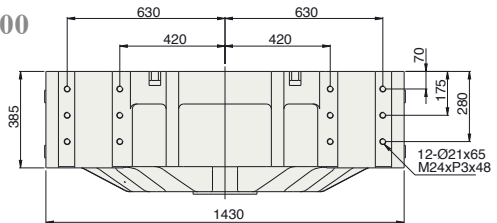
Units: inch

Robot Installation Measurement Stationary Platen top View part

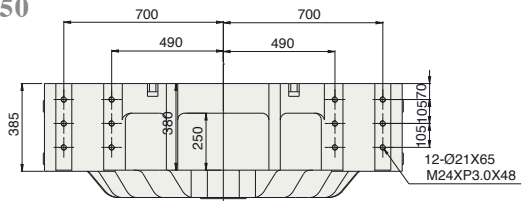
VR-350



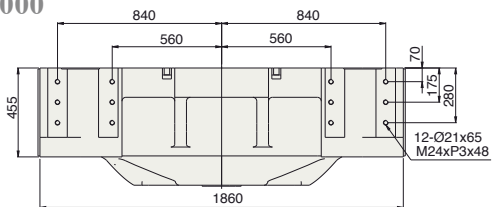
VR-700



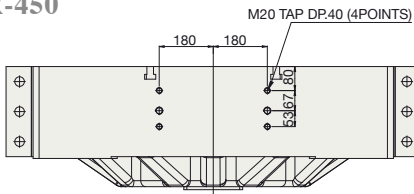
VR-850



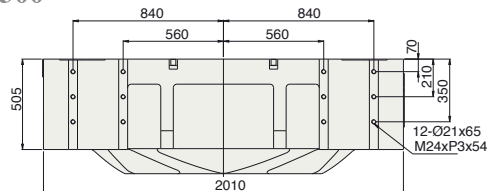
VR-1000



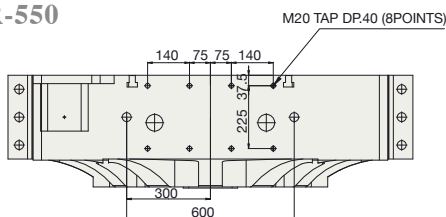
VR-450



VR-1300



VR-550

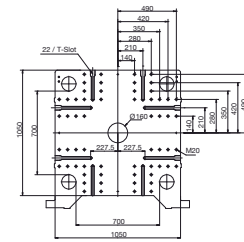
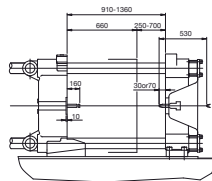
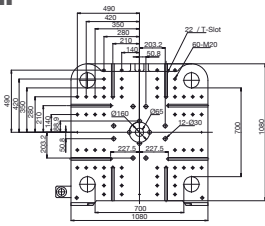


Euromap Platen Information

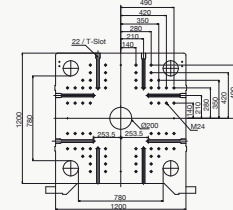
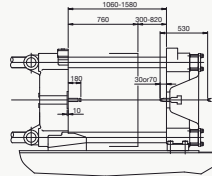
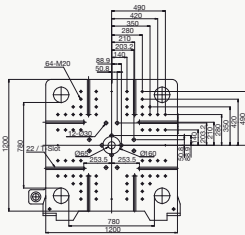
Moving platen

Fixed platen

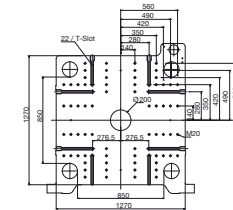
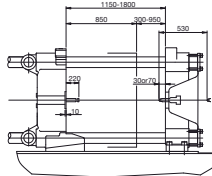
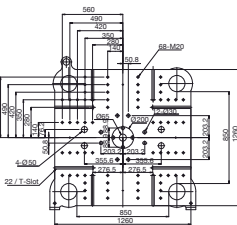
VR-350



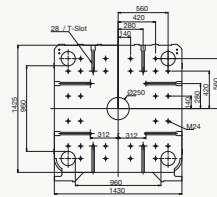
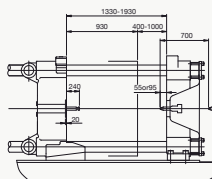
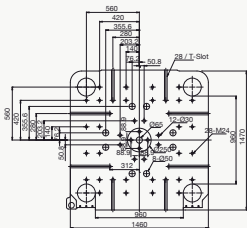
VR-450



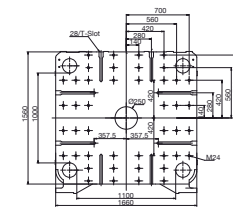
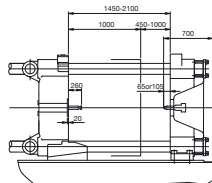
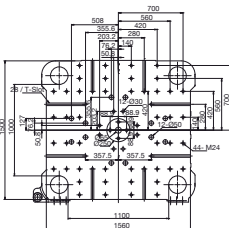
VR-550



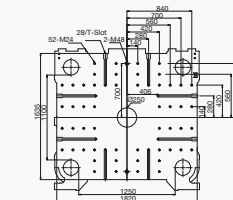
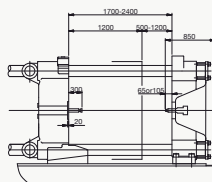
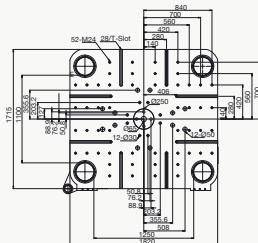
VR-700



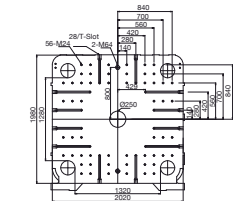
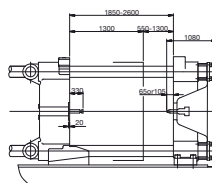
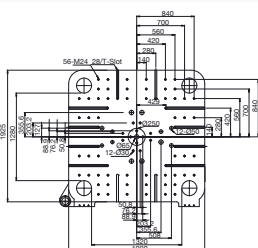
VR-850



VR-1000



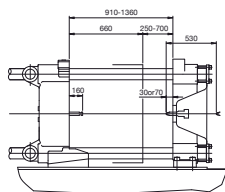
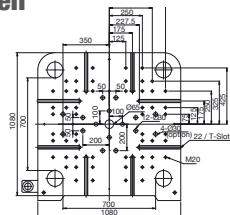
VR-1300



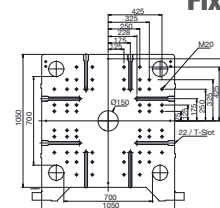
JIS Platen Information

Moving platen

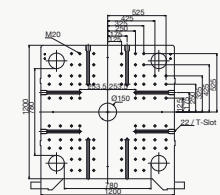
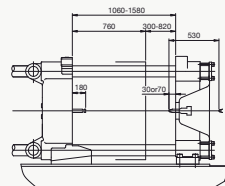
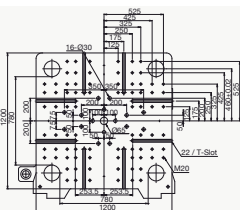
VR-350



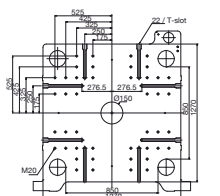
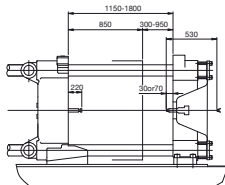
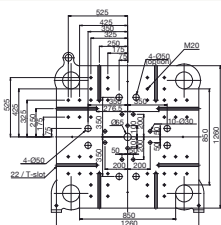
Fixed platen



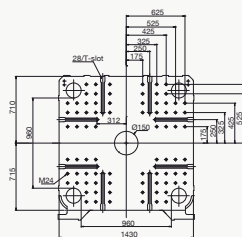
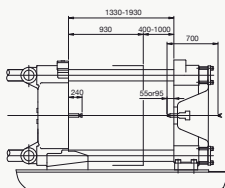
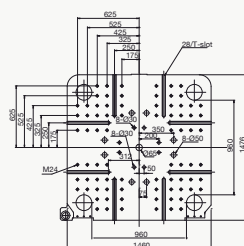
VR-450



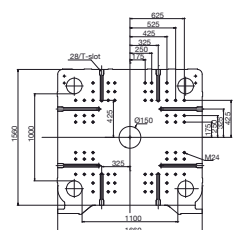
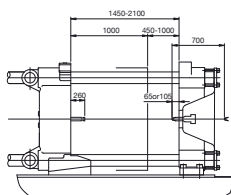
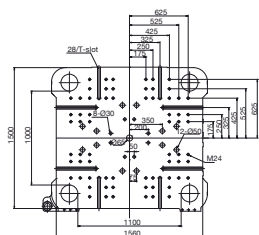
VR-550



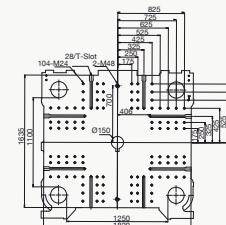
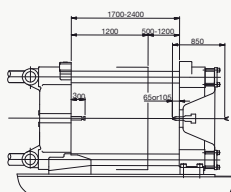
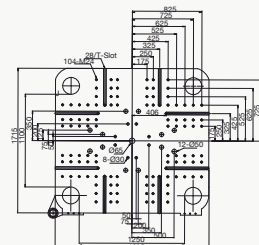
VR-700



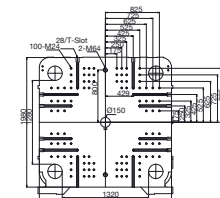
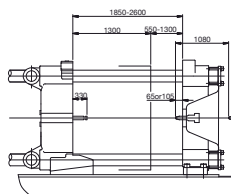
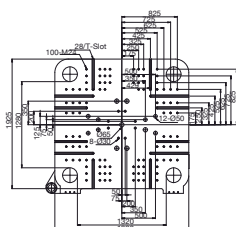
VR-850



VR-1000



VR-1300



Euromap Specifications

Injection Unit	VR-350										VR-450							VR-550												
	F			E			N				E			N				P			N			P				R		
Calculated injection capacity	cm ³	332	393	475	570	679	872	946	1160	1433	570	679	872	946	1160	1433	1344	1659	2099	946	1160	1433	1344	1659	2099	2011	2545	3142		
Actual shot weight - PS	grams	312	368	445	534	636	817	886	1088	1343	534	636	817	886	1088	1343	1259	1555	1968	886	1088	1343	1259	1555	1968	1885	2385	2945		
Actual shot weight - PS	oz	11	13	16	19	22	29	31	38	47	19	22	29	31	38	47	44	55	69	31	38	47	44	55	69	66	84	104		
Calculated Plasticizing Capacity - PS	g/s	40.5	50.2	62.7	41.9	52.2	70	36.9	45.2	60	41.9	52.2	70	36.9	45.2	60	43.6	56.6	77.2	50.5	62.2	82.2	59.7	77.7	105.8	66.6	91.1	125		
Injection pressure-Max.	kgf/cm ²	2117	1792	1481	1944	1633	1272	1988	1620	1313	1944	1633	1272	1988	1620	1313	2019	1635	1292	1988	1620	1313	2019	1635	1292	2252	1779	1441		
Injection Rate	cm ³ /sec	330	390	472	359	428	549	307	377	466	359	428	549	307	377	466	303	303	473	421	517	638	415	512	648	415	555	686		
Injection speed	mm/sec	198			151			93				151			93				74			127			102				85	
Screw diameter	mm	46	50	55	55	60	68	65	72	80	55	60	68	65	72	80	72	80	90	65	72	80	72	80	90	80	90	100		
Screw L/D ratio ※(1)		22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	23	20	18		
Max. Theoretical screw torque	N.m	1504			2212			3668				2212			3668				4536			3668			4536				4942	
Screw speed	rpm	400			267			159				267			159				144			218			198				176	
Screw stroke	mm	200			240			285				240			285				330			285			330				400	
Nozzle stroke	mm	380			450			530				450			530				530			530			530				530	
Nozzle contact force	ton	4.7			7.4			11.1				7.4			11.1				11.1			11.1			11.1				11.1	
Temperature control zones	no.	4			4			5				4			5				5			5			5				6	
Total heating wattage	kw	12.95			18.6			26				18.6			26				30			26			30				32	
Clamping Unit																														
Clamping force	ton				350							450							550											
Clamp stroke- Max.	mm				710							760							850											
Open daylight- Max.	mm				1360							1580							1800											
Mold thickness (Min. - Max.)	mm				250 - 700							300 - 820							300 - 950											
Platen dimension (H × V)	mm				1080 × 1080							1200 × 1200							1260 × 1260											
Tie-bar distance (H × V)	mm				700 × 700							780 × 780							850 × 850											
Ejector stroke	mm				160							180							220											
Ejector force	ton	10.2			10.2			8.9				11.3			9.9				9.9			11								
Dry cycle time	sec				3.6							4.1							4.5											
General																														
Motor power (Standard)	HP (Kw)				60 (44.4)							60 (44.4)							75 (55.9)											
Servo motor power (ES Option) Max. Flow	kw				18 + 22.5							44							53.4											
Oil tank capacity (Standard)	L				700							880							930											
Oil tank capacity (ES system Option)	L				490							680							600											
Hydraulic sys. pressure	kg/cm ²	160			160			140				160			140				140			140								
Machine Weight	ton				17							21							27.5											
Machine dimensions (Standard)	mm				7475 × 1900 × 2440							8385 × 2050 × 2353							9290 × 2150 × 2596											
Machine dimensions (ES System option)	mm				7835 × 1950 × 2440							8745 × 2050 × 2353							9650 × 2150 × 2596											

Notes: Due to continual improvements, specifications technical information and dimensions are subject to change without prior notice.

※(1) Screw L/D rate [18(*20), 20(*22), 22(*24)] Optional special for household produce.

VR-700									VR-850									VR-1000									VR-1300								
N			P			R			P			R			S			R			S			J			S			J			B		
946	1160	1433	1344	1659	2099	2011	2545	3142	1344	1659	2099	2011	2545	3142	2990	3691	4467	2011	2545	3142	2990	3691	4467	4320	5227	6220	2990	3691	4467	4320	5227	6220	5702	6786	7964
886	1088	1343	1259	1555	1968	1885	2385	2945	1259	1555	1968	1885	2385	2945	2803	3460	4187	1885	2385	2945	2803	3460	4187	4049	4899	5830	2803	3460	4187	4049	4899	5830	5344	6360	7465
31	38	47	44	55	69	66	84	104	44	55	69	66	84	104	99	122	147	66	84	104	99	122	147	143	173	205	99	122	147	143	173	205	188	224	263
50.5	62.2	82.2	59.7	77.7	105.8	66.6	91.1	125	75.8	98.6	134.4	84.7	115.5	169.94	77.6	102.64	131.1	108	147.5	202.5	87.5	115.8	147.7	83.3	106.3	146.6	103.6	136.9	175	98.6	125.8	173.6	120.2	148.8	184.7
1988	1620	1313	2019	1635	1292	2252	1779	1441	2019	1635	1292	2252	1779	1441	2108	1707	1411	1971	1557	1262	2108	1707	1411	2150	1777	1493	2108	1707	1411	2105	1777	1493	2085	1752	1493
421	517	638	415	512	648	425	538	664	527	651	823	540	683	843	505	623	754	689	872	1076	644	795	962	632	764	909	762	941	1139	747	904	1076	771	917	1076
127			102			85			129			107			79			137			101			80			120			95			81		
65	72	80	72	80	90	80	90	100	72	80	90	80	90	100	90	100	110	80	90	100	90	100	110	100	110	120	90	100	110	100	110	120	110	120	130
22	20	18	22	20	18	22	20	18	22	20	18	23	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18
3668			4536			4942			4536			4942			7140			4942			7140			8649			7140			8694			10290		
218			198			176			251			224			128			286			163			118			193			139			126		
285			330			400			330			400			470			400			470			550			470			550			600		
530			530			530			530			530			700			530			700			850			700			850			1080		
11.1			11.1			11.1			11.1			11.1			10.6			11.1			10.6			13.2			10.6			13.2			13.2		
5			5			6			5			6			7			6			7			7			7			7			8		
26			30			32			30			32			52			32			52			65			52			65			77		

700									850									1000									1300								
930									1000									1200									1300								
1930									2100									2400									2600								
400 - 1000									450 - 1100									500 - 1200									550 - 1300								
1460 × 1460									1560 × 1495									1820 × 1720									1970 × 1935								
960 × 960									1100 × 1000									1250 × 1100									1320 × 1280								
260									260									300									330								
15									18.6									24.7									28.1								
5.5									6.1									7.3									8.1								

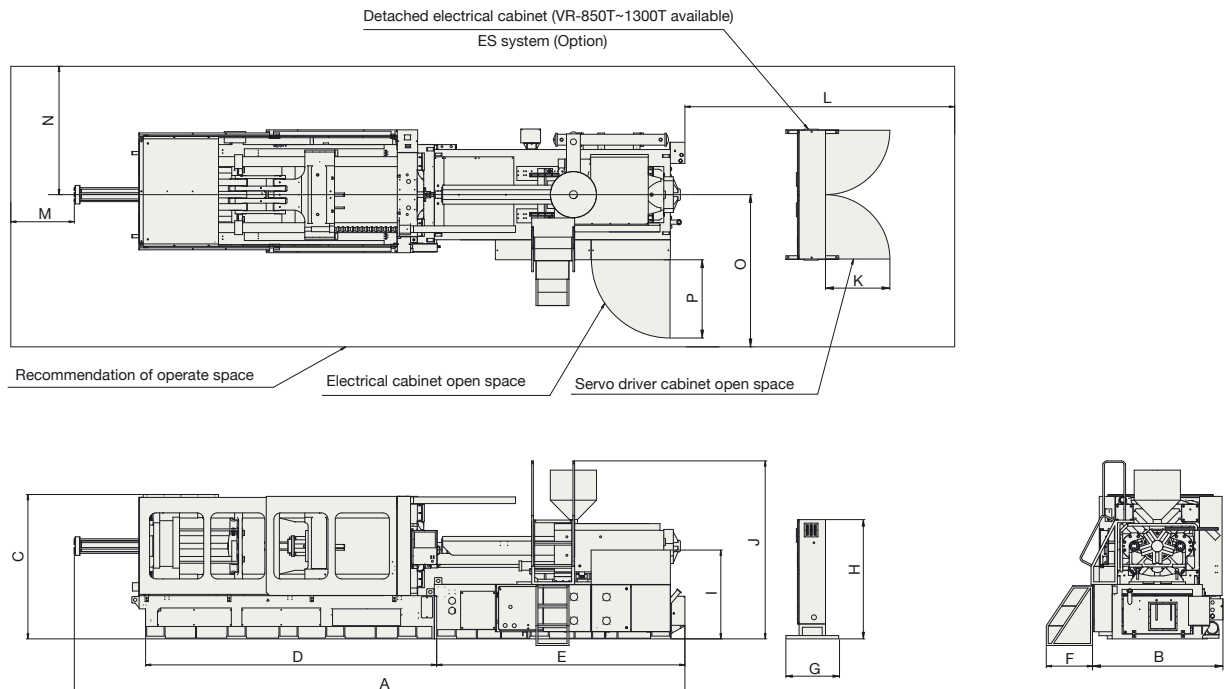
75 (55.9)									100 (74.6)									120 (89.5)									150 (111.9)								
53.4									44+44									53.4+53.4									44+44+44								
620									1010									1510									1810								
640									920									1300									1600								
140									140									140									140								
32.5			33.3			33.9			35.6			37.3			40.8			56.3			57			58.8			71.9			73.6			76.4		
9936 × 2290 × 2600									10812 × 2500 × 2703									12890 × 3505 × 3090									14550 × 3905 × 3242								
9936 × 2290 × 2600									10812 × 2500 × 2703									12890 × 3505 × 3090									14550 × 3905 × 3242								

SPI Specifications

		VR-350										VR-450										VR-550									
Injection Unit		F			E			N				E			N				P			N			P				R		
Calculated injection capacity	in ³	20.26	23.98	28.98	34.78	41.43	53.21	57.73	70.79	87.45	34.78	41.43	53.21	57.73	70.79	87.45	82.02	101.24	128.09	57.73	70.79	87.45	82.02	101.24	128.09	122.72	155.31	191.74			
Actual shot weight - PS	grams	312	368	445	534	636	817	886	1088	1343	534	636	817	886	1088	1343	1259	1555	1968	886	1088	1343	1259	1555	1968	1885	2385	1945			
Actual shot weight - PS	oz	11	13	16	19	22	29	31	38	47	19	22	29	31	38	47	44	55	69	31	38	47	44	55	69	66	84	104			
Calculated Plasticizing Capacity - PS	g/s	40.5	50.2	62.7	41.9	52.2	70	36.9	45.2	60	41.9	52.2	70	36.9	45.2	60	43.6	56.6	77.2	50.5	62.2	82.2	59.7	77.7	105.8	66.6	91.1	125			
Injection pressure- Max.	Psi	30110	25487	21064	27649	23226	18091	28275	23041	18674	27649	23226	18091	28275	23041	18674	28716	23254	18376	28275	23041	18674	28716	23254	18376	32030	25302	20495			
Injection Rate	in ³ /sec	20.13	23.8	28.8	21.9	26.11	33.5	18.73	23	28.43	21.9	26.11	33.5	18.73	23	28.43	18.49	22.82	28.86	25.69	31.55	38.93	25.32	31.24	39.54	25.93	32.83	40.52			
Injection speed	in/sec	7.79			5.94			3.66				5.94			3.66				2.91			4.99			4.01				3.34		
Screw diameter	in	1.81	1.96	2.16	2.16	2.36	2.67	2.56	2.83	3.15	2.16	2.36	2.67	2.56	2.83	3.15	2.83	3.15	3.54	2.56	2.83	3.15	2.83	3.15	3.54	3.15	3.53	3.94			
Screw L/D ratio ※(1)		22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	23	20	18			
Max. Theoretical screw torque	N.m	1504			2212			3668				2212			3668				4536			3668			4536				4942		
Screw speed	rpm	400			267			159				267			159				144			218			198				176		
Screw stroke	in	7.87			9.44			11.22				9.44			11.22				12.99			11.22			12.99				15.74		
Nozzle stroke	in	14.96			17.71			20.86				17.71			20.86				20.86			20.86			20.86				20.86		
Nozzle contact force	U.S ton	5.18			8.15			12.23				8.15			12.23				12.23			12.23			12.23				12.23		
Temperature control zones	No.	4			4			5				4			5				5			5			5				6		
Total heating wattage	Kw	12.95			18.6			26				18.6			26				30			26			30				32		
Clamping Unit																															
Clamping force	U.S ton	385						496										606													
Clamp stroke- Max.	in	27.95						29.92										33.46													
Open daylight- Max.	in	53.54						62.2										70.86													
Mold thickness (Min. - Max.)	in	9.8 - 27.5						11.8 - 32.2										11.8 - 37.4													
Platen dimension (H × V)	in	42.5 × 42.5						47.2 × 47.2										49.6 × 49.6													
Tie-bar distance (H × V)	in	27.6 × 27.6						30.7 × 30.7										33.4 × 33.4													
Ejector stroke	in	6.2						7										8.6													
Ejector force	U.S ton	11.24			11.24			9.8				12.45			10.9				10.9			12.1			12.1				12.1		
Dry cycle time	sec	3.6						4.1										4.5													
General																															
Motor power (Standard)	HP (Kw)	60 (44.4)						60 (44.4)										75 (55.9)													
Servo motor power (ES Option) Max. Flow	Kw	18 + 22.5						44										53.4													
Oil tank capacity (Standard)	L	700						880										930													
Oil tank capacity (ES system Option)	L	490						680										600													
Hydraulic sys. pressure	Psi	2275			2275			1991				2275			1991				1991			1991			1991				1991		
Machine Weight	U.S ton	18.7						23.1										30.3													
Machine dimensions (Standard)	in	294.3 × 76.8 × 96.1						330.1 × 80.7 × 92.6										365.7 × 84.6 × 102.2													
Machine dimensions (ES System option)	in	308.5 × 76.8 × 96.1						344.3 × 80.7 × 92.6										379.9 × 84.6 × 102.2													

VR-700									VR-850									VR-1000									VR-1300								
N			P			R			P			R			S			R			S			J			S			J			B		
57.73	70.79	87.45	82.02	101.24	128.09	122.72	155.31	191.74	82.02	101.24	128.09	122.72	155.31	191.74	182.47	225.25	272.61	122.72	155.31	191.74	182.47	225.25	272.61	263.63	318.99	379.59	182.47	225.25	272.61	263.63	318.99	379.59	347.97	414.13	486.02
886	1088	1343	1259	1555	1968	1885	2385	2945	1259	1555	1968	1885	2385	2945	2803	3460	4187	1885	2385	2945	2803	3460	4187	4049	4899	5830	2803	3460	4187	4049	4899	5830	5344	6360	7465
31	38	47	44	55	69	66	84	104	44	55	69	66	84	104	99	122	147	66	84	104	99	122	147	143	173	205	99	122	147	143	173	205	188	224	263
50.5	62.2	82.2	59.7	77.7	105.8	66.6	91.1	125	75.8	98.6	134.4	84.7	115.5	158.6	76.1	90.5	115.8	108	147.5	202.5	87.5	87.5	147.7	83.3	106.3	146.6	103.6	136.9	175	98.6	125.8	173.6	120.2	148.8	184.7
28275	23041	18674	28716	23254	18376	32030	25302	20495	28716	23254	18376	32030	25032	20495	29982	24278	20068	28033	22145	17949	29982	24278	20068	30579	25274	21234	29982	24278	20068	30579	25274	21234	29654	24918	21234
25.69	31.55	38.93	25.32	31.24	39.54	25.93	32.83	40.52	32.16	39.72	50.22	32.95	41.68	51.44	30.81	38.02	46.01	42.04	53.21	65.66	39.3	48.51	58.7	38.56	46.62	55.47	46.5	57.42	69.51	45.58	55.16	65.66	47.05	55.96	65.66
4.99			4.01			3.34			5.07			4.21			3.11			5.39			3.97			3.14			4.72			3.74			3.18		
2.56	2.83	3.15	2.83	3.15	3.54	3.15	3.54	3.94	2.83	3.15	3.54	3.15	3.54	3.94	3.54	3.94	4.33	3.14	3.54	3.93	3.54	3.93	4.33	3.93	4.33	4.72	3.54	3.93	4.33	3.93	4.33	4.72	4.33	4.72	5.11
22	20	18	22	20	18	22	20	18	22	20	18	23	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18	22	20	18
3668			4536			4942			4536			4942			7140			4942			7140			8649			7140			8694			10290		
218			198			176			251			224			128			286			163			118			193			139			126		
11.22			12.99			15.74			12.99			15.74			18.5			15.7			18.5			21.6			18.5			21.6			23.6		
20.86			20.86			20.86			20.86			20.86			27.55			20.86			27.55			33.46			27.55			33.46			42.52		
12.23			12.23			12.23			12.23			12.23			11.68			12.23			11.68			14.55			11.68			14.55			14.55		
5			5			6			5			6			7			6			7			7			7			7			8		
26			30			32			30			32			52			32			52			65			52			65			77		
771									936									1102.3									1432.99								
36.61									39.37									47.24									51.18								
75.98									82.68									94.48									102.36								
15.7 - 39.3									17.7 - 43.3									19.68 - 47.24									21.65 - 51.18								
57.5 × 56.9									62.99 × 58.85									71.65 × 67.71									77.55 × 76.18								
37.8 × 37.8									43.3 × 39.4									49.21 × 43.3									52 × 50								
10.23									10.23									11.81									12.99								
16.5									20.5									27.22									30.97								
5.5									6.1									7.3									8.1								
75 (55.9)									100 (74.6)									120 (89.5)									150 (111.9)								
53.4									44 + 44									53.4 + 53.4									44 + 44 + 44								
620									1010									1510									1810								
640									920									1300									1600								
1991									1991									1991									1991								
35.8			36.7			37.3			39.2			41.1			44.9			61.7			62.8			64.8			79.3			81.2			84.2		
391.2 × 90.2 × 102.4									425.7 × 98.4 × 106.4									507 × 138 × 121									572 × 153 × 127								
391.2 × 90.2 × 102.4									425.7 × 98.4 × 106.4									507 × 138 × 121									572 × 153 × 127								

Machine Layout (excl. Transformer)



ITEM \ MODEL	Standard										ES (Option)				stairs (Option)	
	A	B	C	D	E	L	M	N	O	P	K	G	H	I	F	J
VR-350	7500	1950	2100	3840	3000	1000	1000	1975	2450	975	X	X	X	1450	700	2768
VR-450	8400	2050	2080	4445	3270	1000	1000	2025	2500	975	X	X	X	1450	700	2572
VR-550	9300	2150	2200	4580	3570	1000	1000	2075	2550	975	X	X	X	1450	700	2700
VR-700	9950	2950	2400	5255	4280	1000	1000	2475	2950	615	X	X	X	1450	700	2695
VR-850	10850	2500	2445	5320	4890	3600	1000	2250	2725	630	975	800	1800	X	700	2376
VR-1000	12595	2595	2568	6575	5456	3347	763	1860	2370	750	1202	820	1653	X	700	3042
VR-1300	13561	2856	2773	7035	5700	3131	522	2720	2300	750	1202	820	1653	X	700	3130



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