

# Shibaura Machine

## DC250R-M/EM DIE CASTING MACHINE

Specification Item		Unit	DC250R-M/EM
Die Closing	Die locking force	kN	2500
	Platen dimensions (VxH)	mm	850 x 850
	Tie-bar spacing (VxH)	mm	580 x 580
	Tie-bar diameter	mm	115
	Die thickness	mm	600 ~ 300
	Die stroke	mm	360
Injection	Maximum injection force	kN	270
	Intensification ratio		1 : 1.94
	Plunger stroke	mm	415
	Tip protrusion	mm	230
	Injection port position (From machine center)	mm	-125
	Injection speed	m/s	0.03 ~ 8.0
	Tip diameter	mm	50 ~ 70
	Sleeve length	mm	212
Ejection	Ejection force	kN	124
	Ejection stroke	mm	10 ~ 80
Hydraulic	Number of movable cores	Size x No.	3/8" x each 1
	Number of movable core ports	No. of Set	3/4" x 4
	Operating pressure	Mpa	15
	Required hydraulic oil volume	ℓ	430
	Hydraulic oil tank capacity	ℓ	350
Water	Die cooling water inlet port size	Rc	1 + 1/4"
	Die cooling water outlet port size	Rc	2 + 1/2"
	Oil cooler water inlet port size	Rc	1"
	Oil cooler water outlet port size	Rc	1"
	Die cooling adjustment valve (fixed)	Rc x No.	1/4" x 7
	Die cooling adjustment valve (moving)	Rc x No.	1/4" x 8
	Sprue bush cooling adjustment valve	Rc x No.	1/4" x 2
	Required cooling water (oil cooler)	L/min	35
	Required cooling water (for die)	L/min	70 ~ 120
Electrical	For hydraulic pump	kW	22
	For die height adjustment	kW	1.5
	For lubrication pump	W	40
	Electrical capacity	KVA	40/60
	Power supply (Customer Specification)	V	AC 200 to 220
Air	Air connection port	Rc	1/4", 3/8" each 1
	Air pressure	Mpa	0.4
Size	Necessary floor space	mm	5829 X 1830
	Machine height	mm	2781
	Machine mass	ton	9.7

**Note:** Due to continuous improvements, specifications are subject to change without notice.

### SHIBAURA MACHINE COMPANY AMERICA

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