



Vα-Series

50/80/100/150/200

*Servo-Electric Technology Can Help
Keep You In The Lead*

Victor Taichung - an established ISO-9001 company

Victor Embraces The Servo Drive Age Of Injection Molding Technology

By utilizing the advantages of servo-electric technology, Victor-Taichung has created a modular drive design to its V -series of all-electric machines. By incorporating the servo-electric drivers conception, each moving axis of the machine is equipped with an optimally suited electrical drives, which featuring the latest state of the art technology with economic superiority.

From the day the machine starts up, your cost per part will decrease and part quality will increase. All-electric machines use less energy than hydraulic machines, they are more reliable, cycle times are faster because all the servo drivers can move independent, and part quality is higher because of a closed-loop system which is controlled by advanced servo-mechanism and a load cell which continually feed back information.

Accuracy, repeatability and consistency are inherent to servo-electric machine. They are digitally controlled, mechanically driven, just like our famous precision CNC lathe machines and machining centers.

This unique advantage gives Victor-Taichung the ability to create a range of all electric injection molding machines that are not only of the highest quality but also competitively priced as we were able to call on the CNC R&D division for there technical prowess.

With high performance and huge energy saving, the V -series achieves the highest level of productivity and reliability.





Energy Saving From V All-Electric

Huge energy saving cuts molding costs, plant construction and operation costs.



High Productivity

Simultaneous operation is inherent to all-electric servo machines, which enables precise high speed molding in more stable condition.



Precision Shot Control

High performance servo-mechanism achieves ultimate stable molding.



Core Technology

The V -series employs Victor original DSP servo-technology to enhance control performance of the machine servo drivers.



Reliable, Durable Mechanical Units

The interplay of time-proven mechanical units combined with new innovative components. Results in a robust structural design and intelligent drive concepts that makes the V all-electric a solution for high precision applications that anticipates tomorrow's need.



Simple Friendly Operation

High performance-operator friendly concepts. The Victor-PC2000 industrial PC based process control for the V -series.

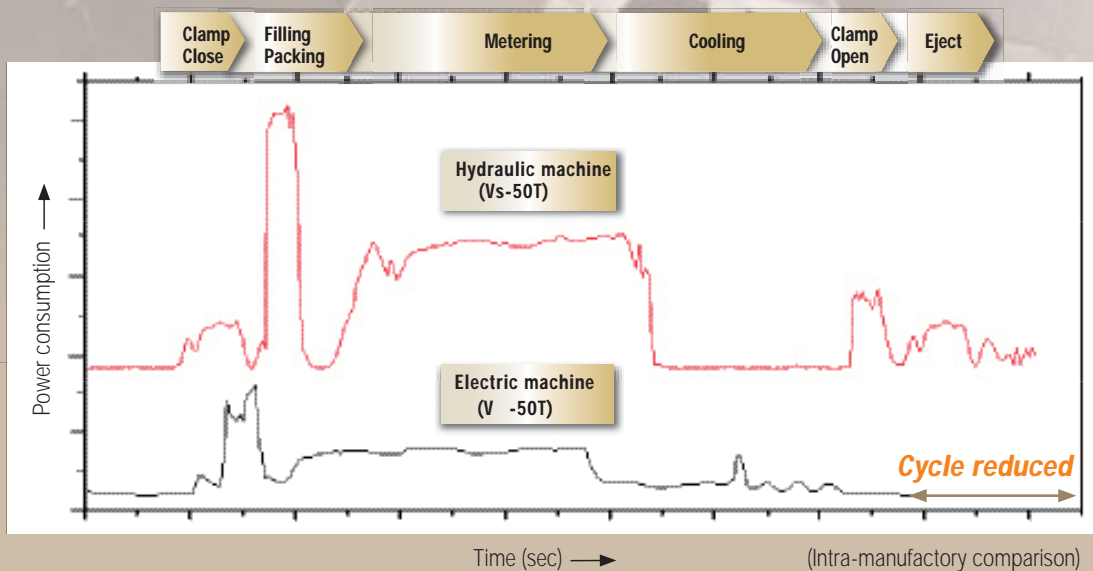


Energy Saving From Va All-Electric

Huge energy saving cuts molding costs, plant construction and operation costs.

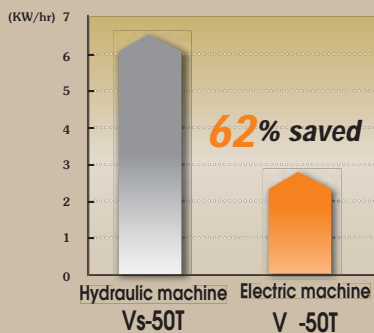
- All-electric machines dramatically reduce operating costs, using 50 ~ 80 percent less power than equivalent hydraulic machines. Connected power requirements for an electric machine are 30% those of a hydraulic machine. Furthermore factory equipment cost is saved (such as air conditioning, cooling water etc.) and also low noise levels improve plant environment.
- Cooling water usage saving to 1/5 or less of the hydraulic machine.
- No hydraulic oil.
- Thanks to a smart regenerative power module, the braking energy recovery during clamp deceleration and other functions. This power is stored and re-used.

Ex. 1 Comparison of power consumption in a cycle base

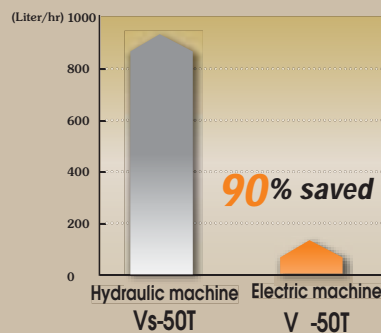


Product : Light guiding panel for cell-phone
 No. of cavity: 4
 Resin : PC
 Weight : 14.345g
 Cycle: 7.9sec (Servo-drive)
 Time (sec)

Power consumption



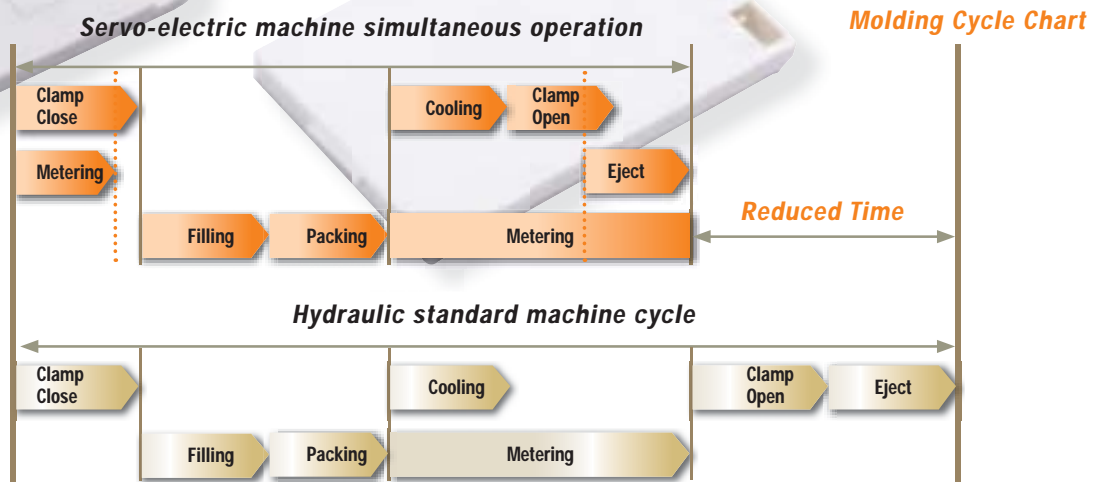
Cooling water consumption



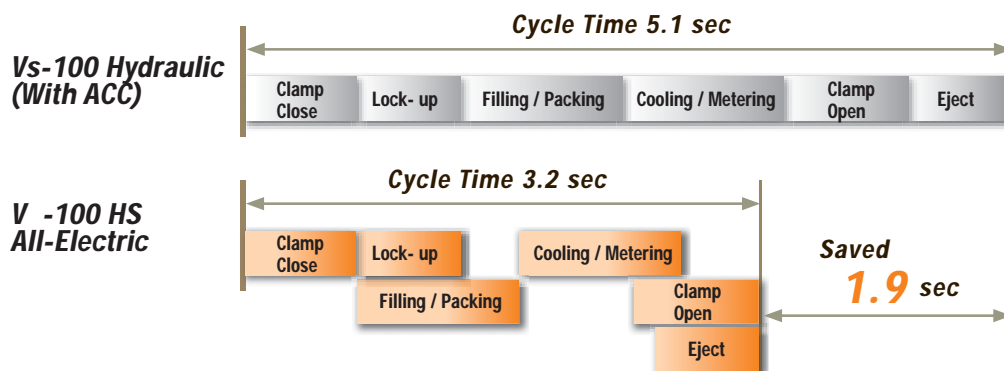
High Productivity

Simultaneous operation is inherent to all-electric servo machines, which enables precise high speed molding in more stable condition.

Electric servo-drive axis work independently with high precision, high dynamics and low noise emissions. Each of the operating axes has its own independent drive and can therefore utilize all the advantages associated with such a design. This enables simultaneous operation of all functions and reduction of dwell times to an absolute minimum.



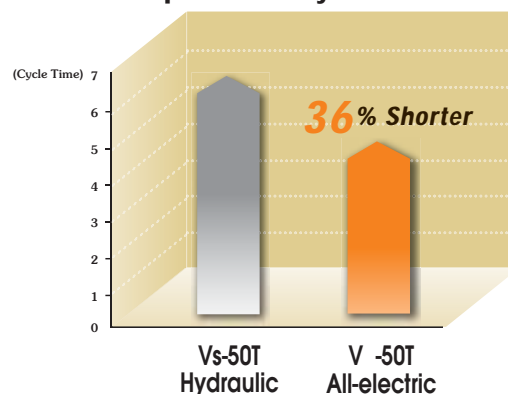
Ex. 2 All-electric VS. Hydraulic cycle time reduction comparison



Comparison of cycle time savings



Product : Pudding cup
 No. of cavity: 2
 Weight : 6.9g / each
 Resin : PP



Precision Shot Control

High performance servo-mechanism achieves ultimate stable molding.

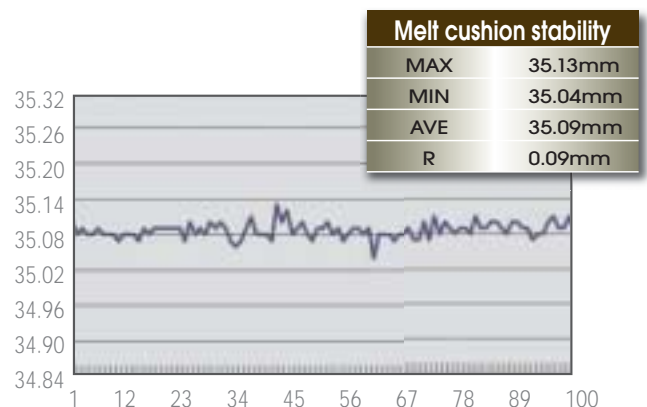
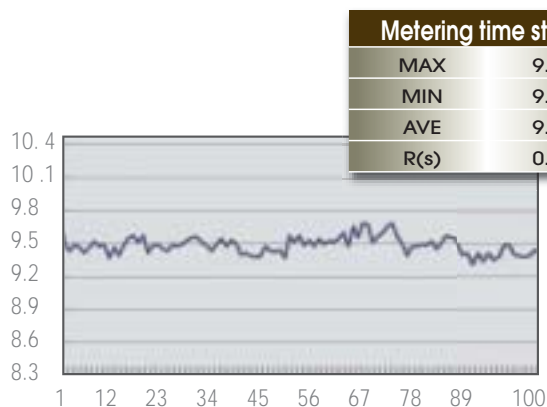
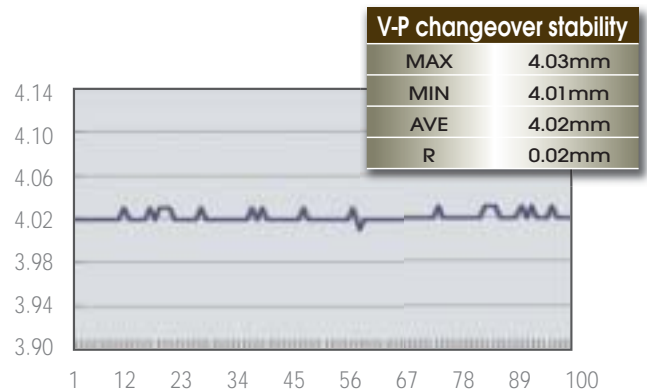
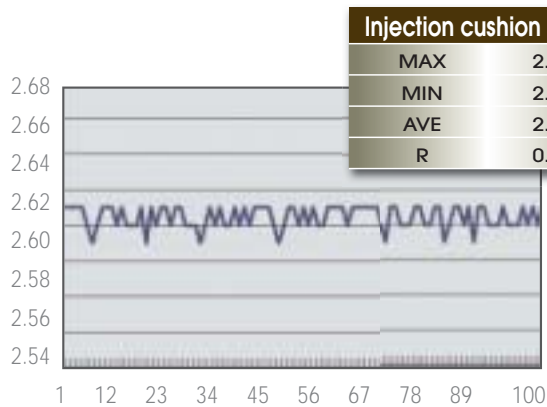
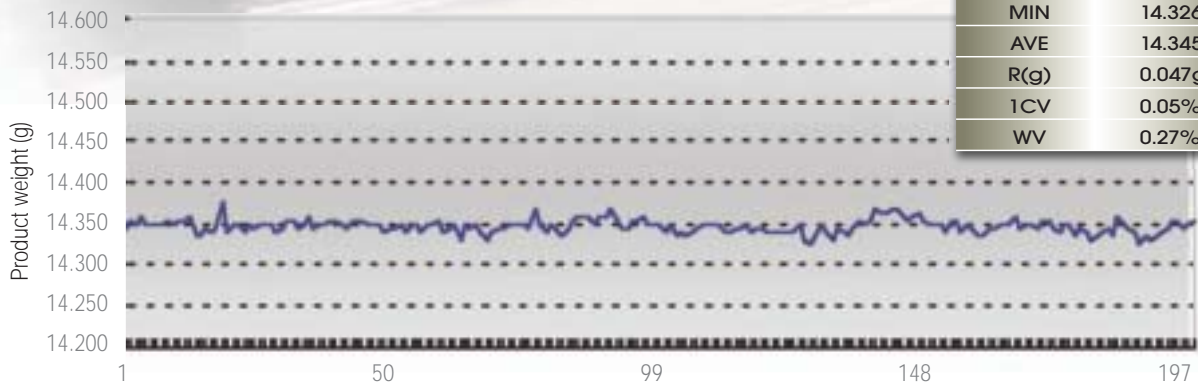
Associating the high performance control system, high-resolution load-cell and digital servo drive technology, which enables the precise control and achieves the outstanding process consistency and repeatability. It enhances product quality through a reduction in performance variation, such as screw end position, pressure at changeover from injection to hold pressure, melt cushion and also metering time. The result is a closer shot to shot weight tolerance.

Ex. 3 High stable molding performance

Injection molding machine: V -100K
 Product: Light guiding panel for cell phone
 Resin: PC



Product weight consistency	
MAX	14.373g
MIN	14.326g
AVE	14.345g
R(g)	0.047g
1CV	0.05%
WV	0.27%

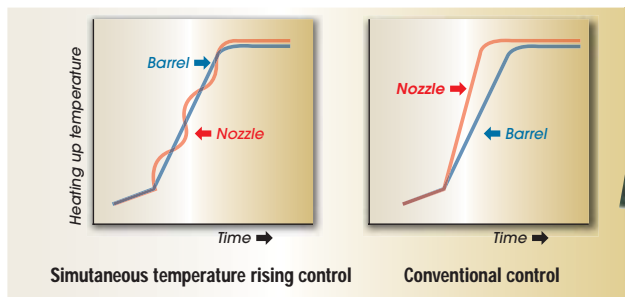


Core Technology

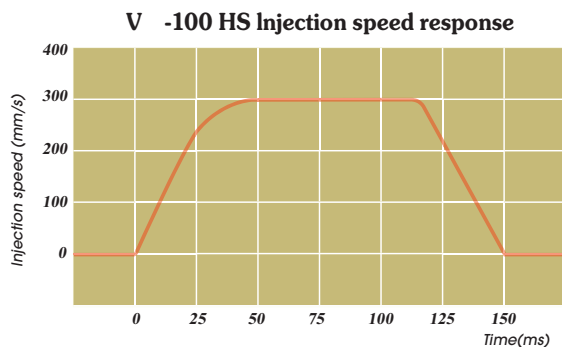
The V-series employs Victor original DSP servo-technology to enhance control performance of the machine servo drivers.

Simultaneous temperature rising control

Simultaneous temperature rise of the nozzle and the barrel. (This feature protects the internal resin of the nozzle from beginning carbonized/ deteriorated)

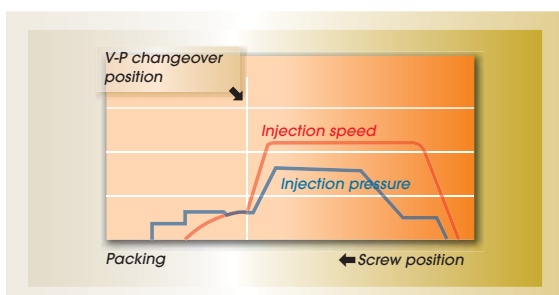


Up to 48-millisecond velocity response for narrow pitch connectors and micro-molding.

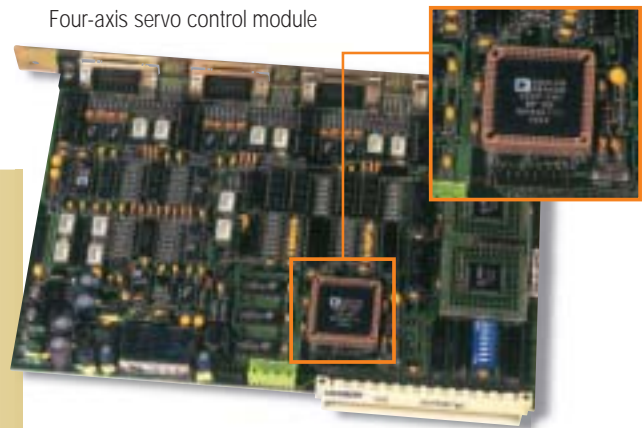


Deceleration toward the V-P changeover position

Achieving automatic speed deceleration control before holding pressure. This control effects to reduce the inertial force during injection for a smooth V-P changeover and to prevent the over-packing.



High speed ADSP 2101 chip



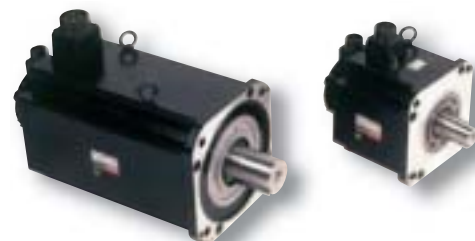
DSP processor scan time of 0.125 millisecond

Victor high speed 20 Mhz ADSP 2101 processing chip achieves an outstanding injection scanning time of 125 micro-second for control, materializes high-precision, stable molding. Quick-response and improved repeatability for process and V-P changeover control ensure excellent, high-speed molding.



High energy efficient servo amplifiers

Utilizing braking energy recovery efficiently, the Va-series achieves the greater electricity saving.



High-power/ low inertia AC servo motors

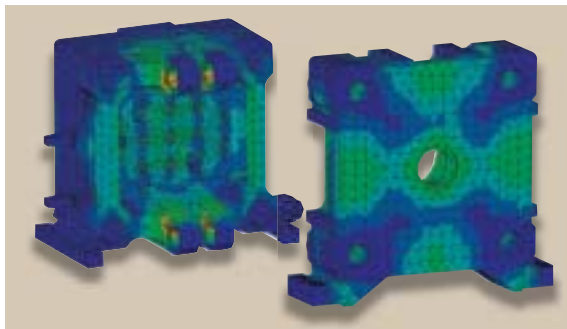
Air cooled AC servo motor with light weight pulleys that drives-provides lower inertia, rapid acceleration and deceleration response.

Reliable, Durable Mechanical Units

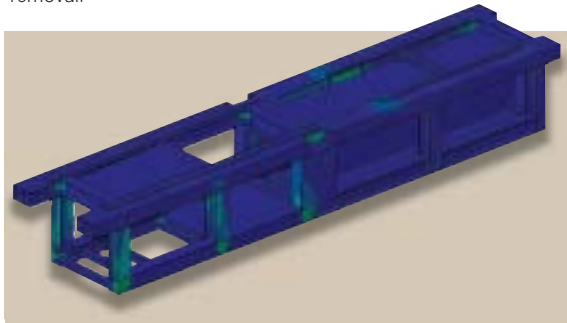
The interplay of time-proved mechanical units combined with new innovative components. Results in a robust structural design and intelligent drive concepts that makes the V all-electric a solution for high precision applications that anticipates tomorrow's need.

Rigid cast platen & Tubular steel base design using FEA (Finite Element Analysis)

- Rigid cast platen- box design, FEM optimized moving platen ensures minimum deflection for maximum control and toggle linkage durability.

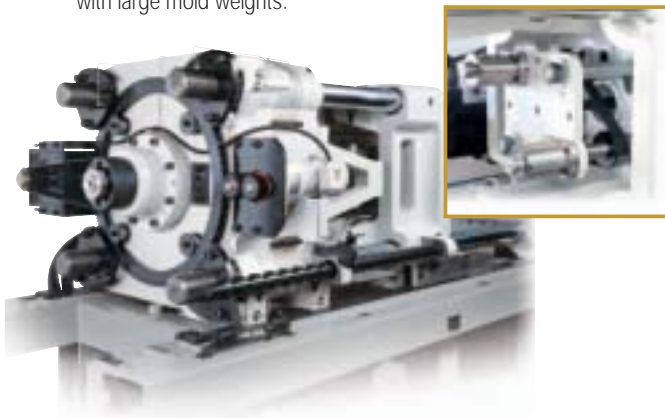


- Hard to deflect, hard to twist- Tubular steel frame is featured on V machines for maximum rigidity with multi-directional parts removal.



Extra rigid, durable clamp unit

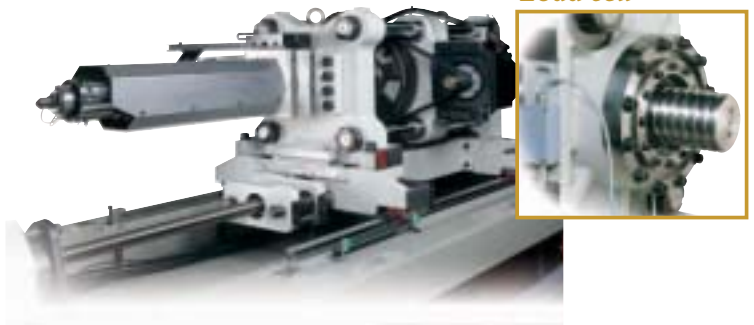
- The heavy duty clamping unit enables the use of wide platens and achieves high reliable molding.
- Moving platen with the wide span guides on hardened steel ways ensures platen parallelism and to reduce platen tipping with large mold weights.



Powerful, quick-response injection unit

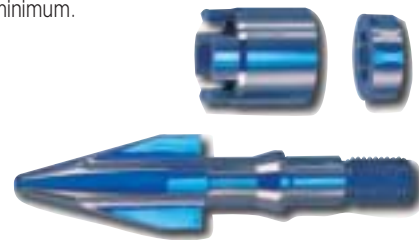
Precision linear guide bearing injection unit carriage for smooth and reliable sled movement.

- Lower inertia injection mechanism allows for a quick response.
- Servo motors and ball screw are coupled on a highly accurate guide mechanism.
- Swiss made load cell measures the actual screw pressure on the ball screw. Amplifier box in-turn sends the signal back to control for close loop control.



The multi-notch locking style screw tip

- The locking style tip is useful for stabilizing part weight and increasing product precision. Comparing the conventional screw tip, the gap between the screw and check ring is reduced to the least, thereby the back flowing resin can be reduced to minimum.



Bushings

- The toggle bushings are manufactured from graphite impregnated phosphor bronze. Also designed to run totally oil-less to reduce the lubrication and maintenance required, they insure smooth, quick movement of the toggle system and keep the platens parallel.



General Design Features

Control unit	Stand.	Option
Advanced Victor PC2000 controller - Pentium PC based on industrial standard	●	
10 " TFT colour LCD operating panel	●	
48 x DC24 Volts output points	●	
48 x DC0.5 Volts input points	●	
20 Mhz ADSP 2101 servo processor	●	
Multi-language selection (Chinese, English, Japanese)	●	
Other language selection		●
Independent operation capability of each axis (Clamp, eject, injection and charging)	●	
Clamp / Ejection	Stand.	Option
Clamp close 4 steps/ Clamp open 4 steps digital control	●	
Advanced mold protection control	●	
One stage injection compression software	●	
Multistage injection compression software		●
Mold-set mode follows an safety moving speed on clamp/ ejector for mounting the mould	●	
Auto die-height/ clamping tonnage adjustment	●	
Clamping force monitoring	●	
2 Stages ejector (Advance x 2/ Retreat x 1 speed digital control)	●	
Eject on the fly	●	
Ejection delay timer	●	
In- mold degating/ Pre-ejector software		●
Advance ejection protection control	●	
Digital clamp/ ejection position display	●	
+/- 0.1 mm repeatability of clamp/ ejection functions	●	
+/- 0.01 mm repeatability of clamp/ ejection functions		●
Robot arm coming in during mold opening function		●
Temperature Control	Stand.	Option
Auto synchronized nozzle/ barrel heat-up control	●	
Nozzle/ barrel temperature digital setting	●	
Thermocouple breakage detection	●	
PID auto tuning of temperature control	●	
7 spare sections for optional temperature circuit	●	
7-days timer for auto heating and preheating	●	
Shut down sequence- lower temperature by idle timer or alarm	●	
All zones temperature heating- waveform tracing	●	
Separate / unit selection capability	●	
Feed throat temperature display	●	
Heater failure detection-Hardware/ Software		●
Print / Storage	Stand.	Option
128 mold file capacity	●	
Alphabet name file capability	●	
Last storing log	●	
Molding parameters print out (Note 1)	●	
Selectable process data print (Note 1)	●	

Note 1) The available printer model is limited.

Injection / Plastication	Stand.	Option
Load-cell close loop control for the complete injection profile/ metering pressure	●	
Pre-injection function	●	
Independent operation of recovery during clamp operation		●
Selectable surge-pressure cut transfer mode	●	
Injection 5 steps/ Pack 4 steps digital control	●	
Screw rotation/ pressure 3 steps control	●	
V-P transfer based on time, position and pressure	●	
Digital indication of screw pressure, speed, position and decompression	●	
Cavity pressure dependent changeover from filling to holding pressure		●
Signal dependent changeover from filling to holding pressure		●
Two stage automatic purge sequence	●	
Injection start delay timer	●	
Cold screw start prevention	●	
Charging start delay timer	●	
Suck-back function	●	
Pre-suck back function. Decompression prior to charge	●	
Sprue break function (Changeable injection unit retreat timing)	●	
+/-0.01 mm shot size accuracy	●	
Advanced melt pressure control	●	
Processor pressure/velocity/position scan time of 0.125 millisecond	●	
Production Management	Stand.	Option
Production management setup	●	
Alarm history (Up to 100 items)	●	
Alarm message logging/ diagnosis display	●	
Consecutive bad-parts alarm	●	
Cavity No./ cycle counters	●	
Power on time/ Run hour display	●	
Container production management	●	
Servo fault alarm	●	
Charging time alarm	●	
Temperature alarm	●	
Thermocouple breakage alarm	●	
Heater failure alarm		●
Grease lubrication fault/ used up alarm	●	
Resetting cycle counter	●	
Monitor	Stand.	Option
Molding condition upper/ lower limit monitor	●	
Injection profile waveform monitor	●	
Charging back-pressure waveform monitor	●	
100 cycles statistical processing of monitored date (SPC)	●	
Graphic display cycle step & time monitor	●	
Process parameters plotting monitor	●	
I/O diagnosis monitoring screen	●	
Servo processing condition monitor	●	

Standard/Option Equipments

Injection Unit	Stand.	Option
Pivoting injection unit	●	
Injection unit guided on linear guide way	●	
Spring shut-off nozzle		●
Pneumatic actuated needle shut-off nozzle		●
Hydraulic actuated needle shut-off nozzle (1)		●
Slides shut-off hopper for quick material change	●	
Thermoset package		●
Thermocouple controlled nozzle zone		●
SSR control for heaters	●	
Rigid PVC package		●
Increased nozzle touch force (2)		●
High pressure/ speed injection unit (3)		●
Stainless steel barrel cover	●	
Nozzle purge shield	●	
General-purpose nitrided screw and barrel	●	
Corrosion/ abrasion resistant screw and barrel (Bimetallic coating) (8)		●
Chromium-plated screw		●
Multi-notch locking style screw tip		●
Plug-in ceramic band heaters		●
Feed throat temperature control		●
Auto loader		●
Long nozzle as accessory	●	
Band heaters up to 450 (4)		●
Braided band heaters		●
Hopper + magnet		●
Communication / Interface	Stand.	Option
RS232 Data interface for printer/ Process information monitoring system (PIS) (7)	●	
Ethernet communication –TCP/IP capability via auxiliary		●
Victor standard interface for robot-Terminals in cabinet	●	
Euromap12/ 67 for robot interface		●
Mould heater control hardware		●
Masterbatch colour dosing device interface		●
Core pulling device interface		●
Unscrewing motor interface		●
Valve gate interface		●
Ejector plate retract confirmation interface		●
Container signal output-Terminals in cabinet		●
General	Stand.	Option
Alarm lamp	●	
3 Color warming tower		●
Alarm buzzer	●	
Core pull and ejection motion/ no motion mode selection while gate is open in semi-auto mode		●
Ground fault breaker		●
Designated machine guarding color		●

Clamping Unit	Stand.	Option
Box design rigid cast platens	●	
Mechanical safety/ ratchet bar	●	
Electric & ring gear driven die-height adjustment	●	
Selectable locating ring diameter to fit the mould	●	
Adjustable moving platen supports on hardened steel plates	●	
Movable platen with wide-span & skate-type supports (5)	●	
Stainless steel drop chute	●	
Centralized automatic grease lubrication for ball screws on clamp/ injection unit	●	
Chromium plated tie bars	●	
Hardened steel chromed toggle pins and phosphor bronze oil-less bushings	●	
Manual lubrication for toggle	●	
Centralized automatic grease lubrication for toggle		●
Platen holes fit to JIS, Euromap or SPI specification	●	
Additional mould height		●
Clamp unit safety gate operator and rear side	●	
Clamp unit top cover for safety	●	
Mould top cover for safety and mould protection		●
Part drop area covers for safety		●
Robot fixing platen on top of stationary platen	●	
High speed ejection (Eject force is limited)		●
Increased ejection force (See technical data)		●
One stage air blast (Moving platen side)	●	
3-Way valves for air blast/ air shut-off nozzle		●
Second/ third stage independent air blast (6)		●
Servo-electric/ Electric/ hydraulic driven unscrewing motor (1)		●
Pneumatic/ hydraulic actuated core system (1)		●
Tri-directional part removal base design	●	
Full-access connection to center ejector	●	
T-slotted die platens		●
Servos / Controls	Stand.	Option
High resolution absolute pulse encoders	●	
No liquid cooling. No water required. Air cooled high-power/ low inertia Sanyo Denki AC servo motors	●	
High energy efficient Sanyo Denki servo amplifiers	●	
100 % PC hardware	●	
Separate Metric/ English unit selection capability	●	
VPC2000 control features include PS2 keyboard port, Ethernet port, printer port and parallel port	●	

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)		●
Transformer for local power source	●	

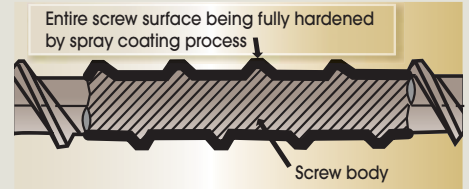
Notes:

- (1) For the hydraulic type, a separate hydraulic unit is needed
- (2) Increased to 2.0 ton from standard 1.5 ton/ Increased to 3.0 ton from standard 2.0 ton/ Increased to 4.0 ton from standard 2.5 ton
- (3) The high speed differs depending on injection unit
- (4) Standard band heater can be used at a maximum working temperatures of 360 / High watts band heaters are available as optional as for the use in high working temperatures up to 450
- (5) V -200 by double rollers
- (6) 3 stage independent air blast (One for stationary platen side/ two for moving platen side)
- (7) PIS monitoring system via an optional auxiliary
- (8) Depending on the kind of quality steel used and the abrasive/ corrosive engineering resin & additives for application, there are A, B and C three grades of bimetallic barrels on choosing, see the descriptions on the right

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.

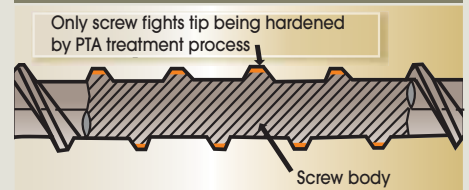
B Grade bimetallic barrel and screw set- with 25% tungsten carbide composition included in the barrel's bimetallic content, coupled with a screw which entire surface is fully hardened through HP/HVOF coating treatment process.

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



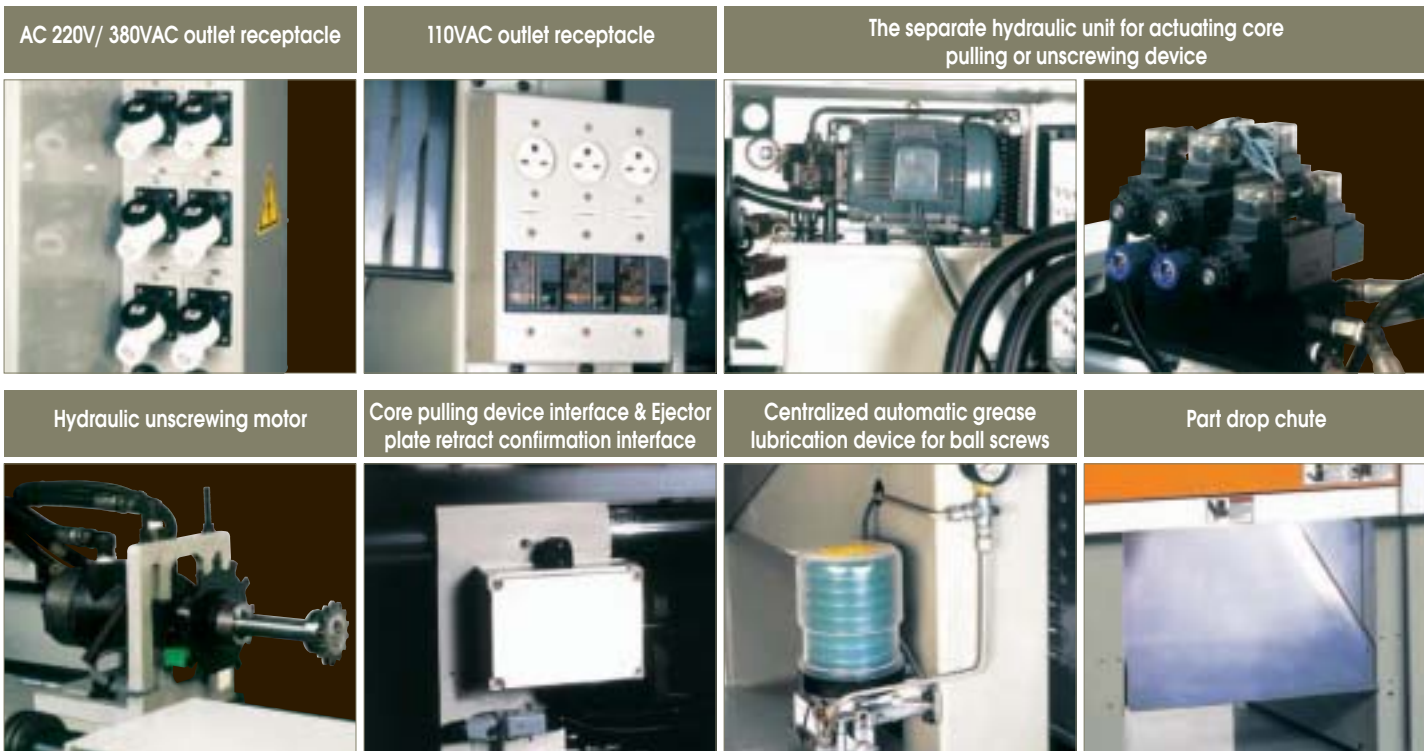
C Grade bimetallic barrel and screw set- with 9.5% tungsten carbide composition included in the barrel's bimetallic content, coupled with a screw which only the flights-tip is hardened through PTA Bimetallic alloy treatment process.

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



● For the bimetallic barrel selection details contact Victor sales

Example of standard/ optional equipment

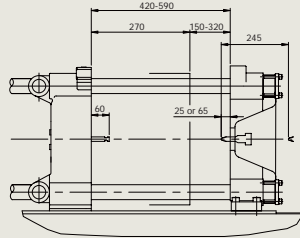
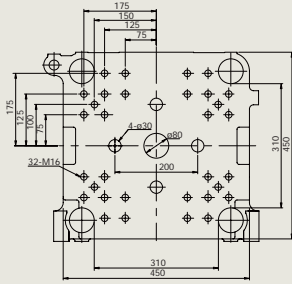


● The appearance and the specification of machine may be altered for betterment without notice

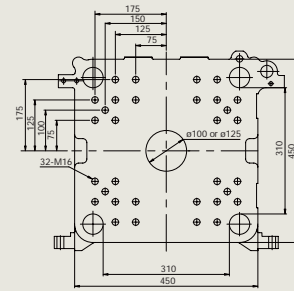
JIS platen information



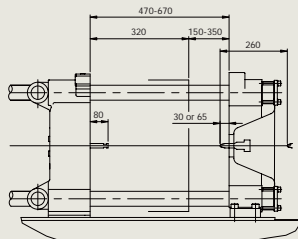
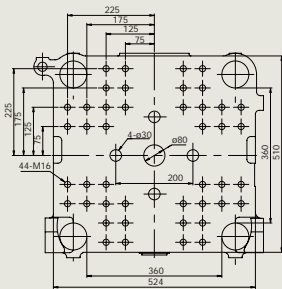
Va-50 Moving platen



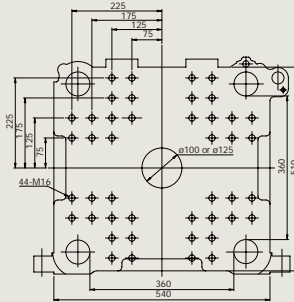
Fixed platen



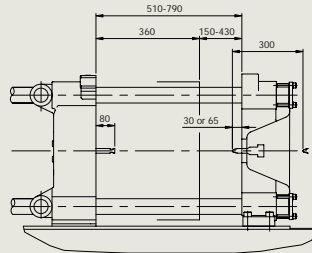
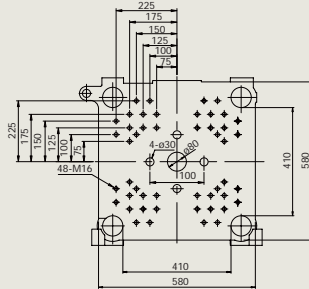
Va-80 Moving platen



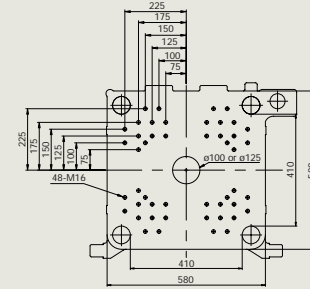
Fixed platen



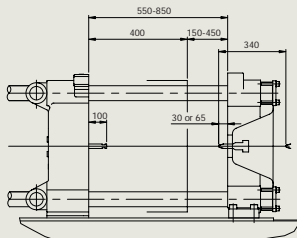
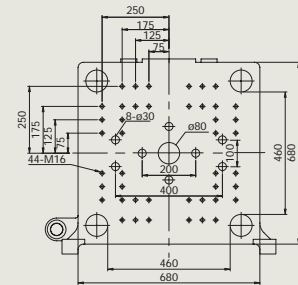
Va-100 Moving platen



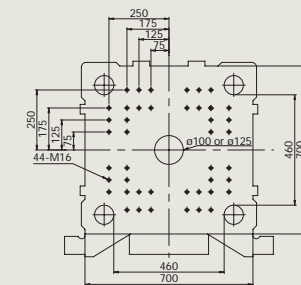
Fixed platen



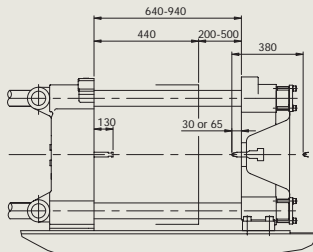
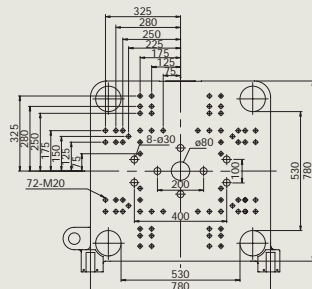
Va-150 Moving platen



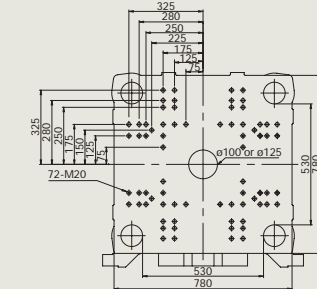
Fixed platen



Va-200 Moving platen

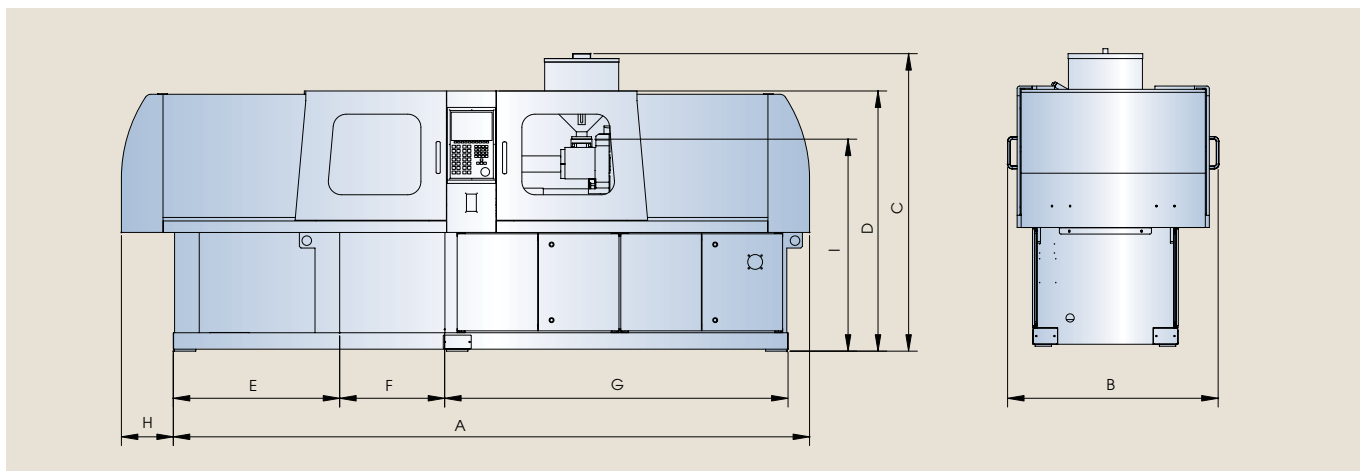


Fixed platen



V series technical information and dimensions

Machine Models		V -50Y		V -50X		V -50K		V -80K		V -80H	
Injection Unit Specifications											
Screw Dia.	mm	16	19	22	26	28	32	28	32	32	36
Theoretical Displacement	cm ³	14	20	35	49	61	80	61	80	104	132
Inj. Capacity, Max. GP-PS	Grams	11	16	31	43	58	76	58	76	99	125
	oz	0.39	0.56	1.09	1.52	2.05	2.68	2.05	2.68	3.49	4.40
Max. Inj. Press. (1)	kgf / cm ²	2480	1758	2732	1956	2404	1840	2404	1840	2466	1948
Max. Pack Press. (1)	kgf / cm ²	2108	1494	2322	1663	2043	1564	2043	1564	2097	1656
Max. Inj. Speed (1)	mm / s	300		166		166		166		166	
Max. Inj. Rate (1)	cm ³ / sec	60	85	63	88	102	133	102	133	133	169
Max. Inj. Speed (2)	mm / s	300		300		300		300		300	
Max. Inj. Rate (2)	cm ³ / sec	60	85	114	159	185	241	185	241	241	305
Plasticizing Capacity (PS)	kg / hr	11.53	19.28	29.08	45.12	51.68	71.82	51.68	71.82	71.82	99.97
Screw L/D ratio		22	20	22	20	22	20.5	22	20.5	22	20.5
Screw Stroke	mm	70		90		100		100		130	
Screw Speed (7)	rpm	0 - 375		0 - 375		0 - 375		0 - 375		0 - 375	
Nozzle Touch Force	Tonf	1.5 (2.0)		1.5 (2.0)		1.5 (2.0)		2 (3.0)		2 (3.0)	
Nozzle Moving Stroke	mm	245		245		245		260		260	
Total Heat Capacity	kw	2.80		4.59		5.80		5.80		6.80	
Clamp Unit Specifications											
Clamping Force	Tonf	50		50		50		80		80	
Max. Clamp Stroke	mm	270		270		270		320		320	
Min/Max Mould Height	mm	150 - 320		150 - 320		150 - 320		150 - 350		150 - 350	
Max Open Daylight	mm	590		590		590		670		670	
Tie-bar Distance (H x V)	mm	310 x 310		310 x 310		310 x 310		360 x 360		360 x 360	
Platen Dimensions (H x V)	mm	446 x 446		446 x 446		446 x 446		540 x 510		540 x 510	
Locating Ring	mm	100 / 125		100 / 125		100 / 125		100 / 125		100 / 125	
Clamp Speed											
Dry Cycle Time (4)	sec	1.5		1.5		1.5		1.75		1.75	
Ejector Stroke	mm	60		60		60		80		80	
Max. Ejector Force	ton	2		2		2		2.5 (3.3)		2.5 (3.3)	
Machine General Specifications											
Shipping Weight (Roughly)	Kg	2500						3600			
Machine Dimensions	mm	3500 x 1180 x 1830						3850 x 1210 x 1770			
Electric Specifications											
Machine Power Supply Capacity	kVA	12	12 (15.5 2)		15.5 (22.5 2)		16.6 (23.6 2)		20.6 (27.6 2)		
Machine Transformer Size	kVA	23.0	23.0		23.0 (33.0 2)		23.0 (33.0 2)		33.0 (43.0 2)		
Input Power Source		220 VAC ± 10% 3Ph 60 ± 1 Hz or 200 VAC ± 10% 3Ph 50/60 Hz ± 1 Hz									



V -100K		V -100M		V -150M		V -150G			V -200G			V -200F		
28	32	32	36	32	36	38	40	46	38	40	46	46	50	55
61	80	116	147	116	147	180	200	265	180	200	265	332	392	475
58	76	110	139	110	139	171	190	250	171	190	250	315	372	451
2.05	2.68	3.88	4.90	3.88	4.9	6.0	6.70	8.82	6.0	6.70	8.82	11.11	13.12	15.90
2404	1840	2466	1948	2466	1948	2564	2314	1750	2564	2314	1750	2490	2107	1741
2043	1564	2097	1656	2097	1656	2179	1967	1488	2179	1967	1488	2117	1791	1480
166		166		166		166		166	166		166		166	
102	133	133	169	133	169	188	208	276	188	208	276	276	327	395
300		300		300		240		240	240		240		N / A	
185	241	241	305	241	305	272	302	399	272	302	399	N / A	N / A	N / A
51.68	71.82	71.82	99.97	71.82	99.97	122.14	134.52	191.6	122.14	134.52	191.6	199.72	244.58	307.8
22	20.5	22	20.5	22	20.5	21.7	20.5	18	21.7	20.5	18	22	20.5	18
100		145		145		160		160	160		160		200	
0 - 375		0 - 375		0 - 375		0 - 375		0 - 375	0 - 375		0 - 375		0 - 375	
2 (3.0)		2 (3.0)		2.5 (4.0)		2.5 (4.0)		2.5 (4.0)	2.5 (4.0)		2.5 (4.0)		2.5 (4.0)	
300		300		340		340		340	340		340		380	
5.80		6.80		6.80		8.02		8.02	8.02		8.02		12.90	
100		100		150		150		150	200		200		200	
360		360		400		400		400	440		440		440	
150 - 430		150 - 430		150 - 450		150 - 450		150 - 450	200 - 500		200 - 500		200 - 500	
790		790		850		850		850	940		940		940	
410 x 410		410 x 410		460 x 460		460 x 460		460 x 460	530 x 530		530 x 530		530 x 530	
580 x 580		580 x 580		680 x 680		680 x 680		680 x 680	780 x 780		780 x 780		780 x 780	
100 / 125		100 / 125		100 / 125		100 / 125		100 / 125	100 / 125		100 / 125		100 / 125	
1.88		1.88		2.15		2.15		2.15	2.40		2.40		2.40	
80		80		100		100		100	130		130		130	
2.5 (3.3)		2.5 (3.3)		3.3 (4.5)		3.3 (4.5)		3.3 (4.5)	3.3 (4.5)		3.3 (4.5)		3.3 (4.5)	
4300		4300		6200		6200		6200	8100		8100		8100	
4065 x 1300 x 1830		4065 x 1300 x 1830		5565 x 1418 x 1860		5565 x 1418 x 1860		5565 x 1418 x 1860	5650 x 1460 x 2010		5650 x 1460 x 2010		5650 x 1460 x 2010	
16.6 (23.6 2)		20.6 (27.6 2)		26.0 (36.0 2)		36.0 (41.0 2)		36.0 (41.0 2)	40.0 (45.0 2)		40.5		40.5	
23.0 (33.0 2)		33.0 (43.0 2)		33.0 (43.0 2)		43.0 (54.0 2)		43.0 (54.0 2)	54.0		54.0		54.0	

220 VAC ± 10% 3Ph 60 ± 1 Hz or 200 VAC ± 10% 3Ph 50/60 Hz ± 1 Hz

Remarks:

- (1) Limitations may apply in certain molding conditions
- (2) High speed/pressure option
- (3) Euromap dry cycle time
- The theoretical injection capacity is (cross section area of cylinder) x (stroke of screw)
- The injection & plasticizing capacity is applicable for GP-PS and available to the grade of resin, molding condition and mould.

6. Figures in () are also optional.

7. Maximum screw rpm may not be applicable if large-sized screw extruding with some kinds of tough material (RPVC, PC etc.)

Note:

- For the continual improvements, specifications are subject to change without notice
- Actual figures of the specification will vary depending on final machine configuration.

Machine Models	A	B	C	D	E	F	G	H	I
Va-50	3280	1180	1830	1410	690	500	2090	220	1310
Va-80	3602	1210	1770	1457	842	600	2087	308	1250
Va-100	3869	1285	1809	1582	1012	639	2088	316	1289
Va-150	5365	1418	2096	1859	1415	770	2980	200	1563
Va-200	5362	1460	2010	1845	1350	898	3012	387	1490



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