MicroPower 5 and 15 t

The best for micro injection molding

world of innovation

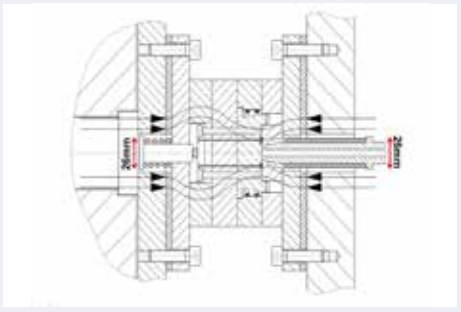
PRECISE – EFFICIENT – ECONOMICAL
The optimum for all types of micro parts

The advantages

» Reliable injection molding technology for shot weights from 0.05 to 4 g
» 2-step injection unit with screw plasticizing and plunger injection
» Energy-efficient, all-electric drive-on-demand motor system
» Innovative 5-point toggle lever clamping unit
» User-friendly through new UNILOG B8 control system with integrated assistance systems
» Compact machine cell with space provided for rotary table, robot, quality control and conveyor belt
» Matching integrated peripherals available (material loader and temperature controller)
» Easy conversion into a clean room cell by adding a laminar flow unit
» Also as 2-component machine with second injection module and an adjusted rotary table available

The machine series

MicroPower standard: 2 clamping force sizes – 5 and 15 t
MicroPower Medical: for clean room applications – 5 and 15 t
MicroPower COMBIMOULD: for multi-component injection molding – 15 t



MicroPower

The system highlights

» **Clamping unit – all-electric – with optimal access**
The *MicroPower* clamping unit is a 2-platen system, in which the clamping force between the nozzle and the toggle lever side is transmitted by a U frame element. The moving platen is driven by an integrated, high-precision 5-point toggle lever. It moves the mold platen guided with high precision on linear bearings smoothly and with high dynamism.

» **Plasticizing unit: best control of micro quantities**
Three injection unit sizes are available for *MicroPower* machines, with shot volumes ranging from 1.2 to 4 cm^3. In all three of these aggregates, plasticizing is effected by a 14 mm 3-zone screw with a 20:1 L/D ratio. Injection takes place via a plunger either 5 or 8 mm in diameter, with injection pressure of up to 3000 bar and with an injection speed of up to 750 mm/s.

» **Small platen drillings – optimal force transmission**
The small through holes of only 26 mm in both mold platens enable optimal clamping force transmission into the mold, thus providing ideal conditions for high precision and long service life of the molds.

» **All-in-one production cell available on request**
The *MicroPower* system is totally modular. Therefore it can be extended into a complete production cell inside the standard machine frame by adding a WITTMANN Scara robot, a rotary table, an optical parts inspection system and a conveyor belt or glass container for finished parts.

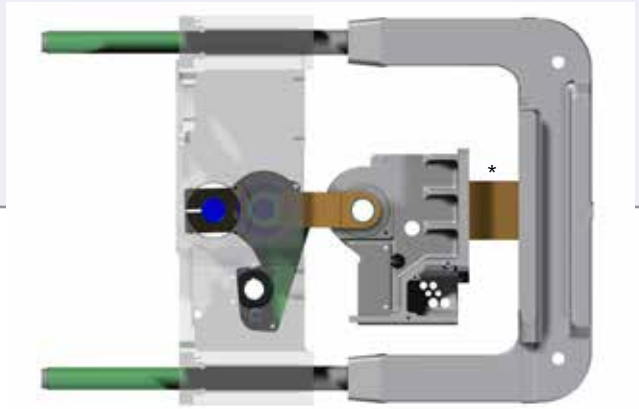
» **Clean room-compatible standard concept**
The standard machine frame is designed for easy cleaning. Without any structural alterations, it can be combined with a laminar flow unit, which supplies class 6 clean air according to ISO 14644-1 standard. Hygienic depositing of the finished parts is possible within the clean room cell strictly according to cavities in an 8-compartment depositing unit with glass containers.

CLAMPING UNIT
Free mold space

» **High precision**
The *MicroPower* clamping unit meets the most stringent requirements for precision in movements and automation options. Its high standard of precision is achieved by guidance of the system platen on the clamping side and the mold carrier plate on the same linear bearings. The central positioning of the toggle lever inside the U frame clamping unit ensures symmetrical clamping force transmission into the mold.

» **One machine size with two force levels**
- The clamping unit is available with 5 or 15 t clamping force.
- The mold platens on the ejector side come in one uniform size of 240 x 248 mm as standard.
- The width of the fixed platen is either 170 or 240 mm.
- The maximum daylight between platens is 400 mm.

» **Free access and flexible automation**
- Thanks to the U frame, the mold space remains free of tie-bars.
- Ample space is provided on both sides of the U frame for the installation of a rotary table (rotation diameter 443 or 466 mm), a parts handling robot and other peripherals for quality inspection and parts depositing.



*mold

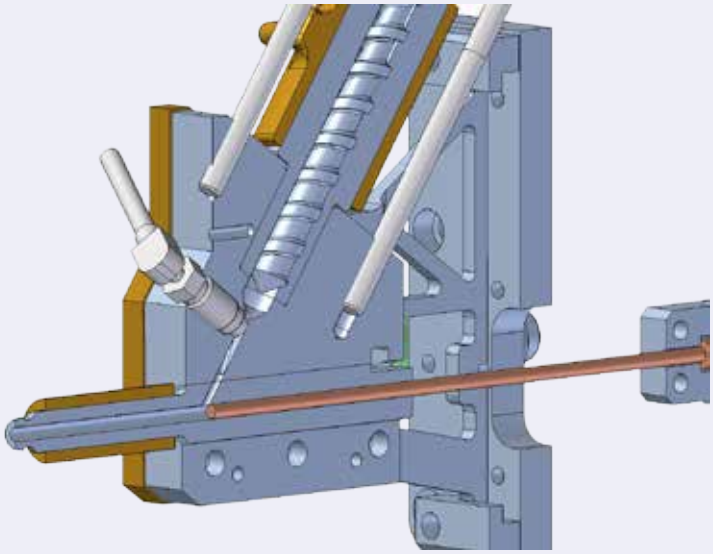
INJECTION UNIT
Specially designed for micro parts

» **Injection unit for extremely small quantities**
The *MicroPower* injection unit is equipped with a two-step plasticizing and injection unit. It is available in three sizes. What all three sizes have in common is their 14 mm plasticizing screw for processing standard-size granulates. The injection plunger comes in different sizes. They are available for shot volumes ranging from 1.2 to 4 cm^3.

» **2-component injection molding**
A 2-component machine also is available by combining two injection aggregates placed next to each other and using a rotary table inside the clamping unit.

Anti-wear options
In addition to the high-quality standard finish, an extensive range of optional versions with extra anti-wear and/or anti-corrosion protection is available. Pre-defined option packages and a selection matrix facilitate the choice of the right version.

INJECTION UNIT
Micro quantities reliably controlled



One system for 3 shot volume levels
The *MicroPower* plasticizing and injection aggregate is a 2-step unit. Step one is plasticizing with controlled back pressure. Step two is a separate plunger injection unit. The plunger of this aggregate functions simultaneously as a shut-off device to separate the melt channel of the plasticizing unit from the injection unit. Behind the injection plunger, an injection pressure sensor is located, which actively regulates the injection process and thus controls the precision and consistency of the molded parts.

The advantages of the *MicroPower* injection unit
- Low-stress metering at low pressure
- System without check valve, therefore no damage to materials through shear stress
- FI-FO injection process (first in – first out)
- Minimal pressure loss during injection
- Extremely small melt cushion, consequently high temperature stability of the shot volume
- Shot weights below 50 mg possible
- All standard granulates can be processed

MicroPower
Production cell "ex works"

The production cell concept is an "ex works" solution for *MicroPower* injection molding machines.

The advantages of the *MicroPower* production cell

» Machine frame closed on all sides as standard. Thus molding of the micro parts takes place in an isolated environment.

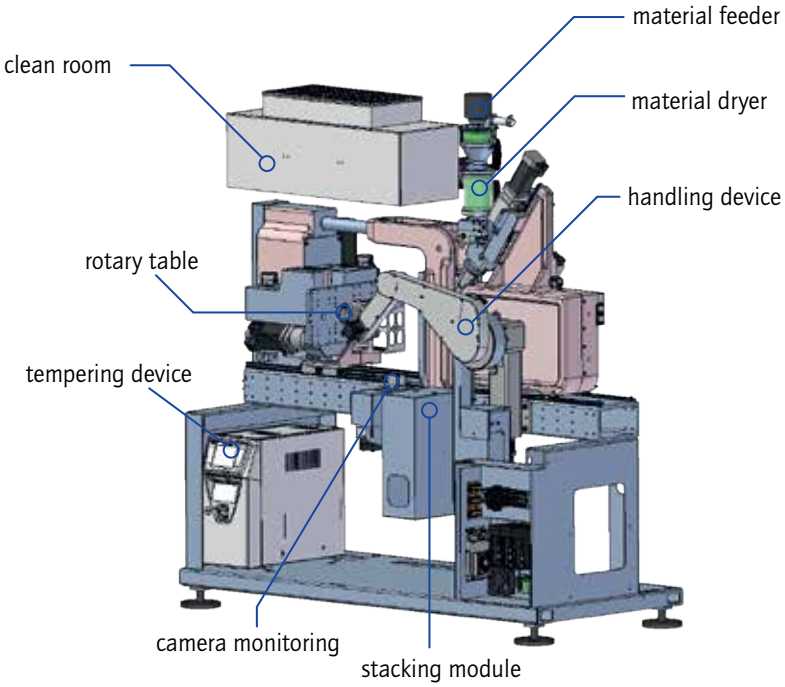
» The enclosed machine cell is designed to provide space for additional equipment modules inside the standard cell.

» The enclosed cell can be fitted with a clean room module. It consists of a suction filter and a ventilation unit for laminar air flow through the machine.

» Cost benefits, since all danger areas are covered and certified ex works.

» *MicroPower* clean room production cells are suitable for producing micro parts for medical technology, as well as the electronics, watch making and optical industries.

» CE mark included for every machine with an insider solution. No separate costs for individual examinations.



CE-certified by type examination CE

UNILOG B8
Complex matters simplified

The new UNILOG B8 machine control system is the WITTMANN BATTENFELD solution to facilitate the operation of complex processes for human operators. For this purpose, the integrated industrial PC has been equipped with an enlarged intuitive touch screen operator terminal. The visualization screen is the interface to the new Windows® 10 IoT operating system, which offers extensive process control functions. Next to the pivotable monitor screen, a connected panel/handset is mounted on the machine's central console.

UNILOG B8
Highlights

» **Operating logic**
with a high degree of self-explanation, similar to modern communication devices

» **2 major operating principles**
- Operating/movement functions via tactile keys
- Process functions on touch screen (access via RFID, key card or key ring)

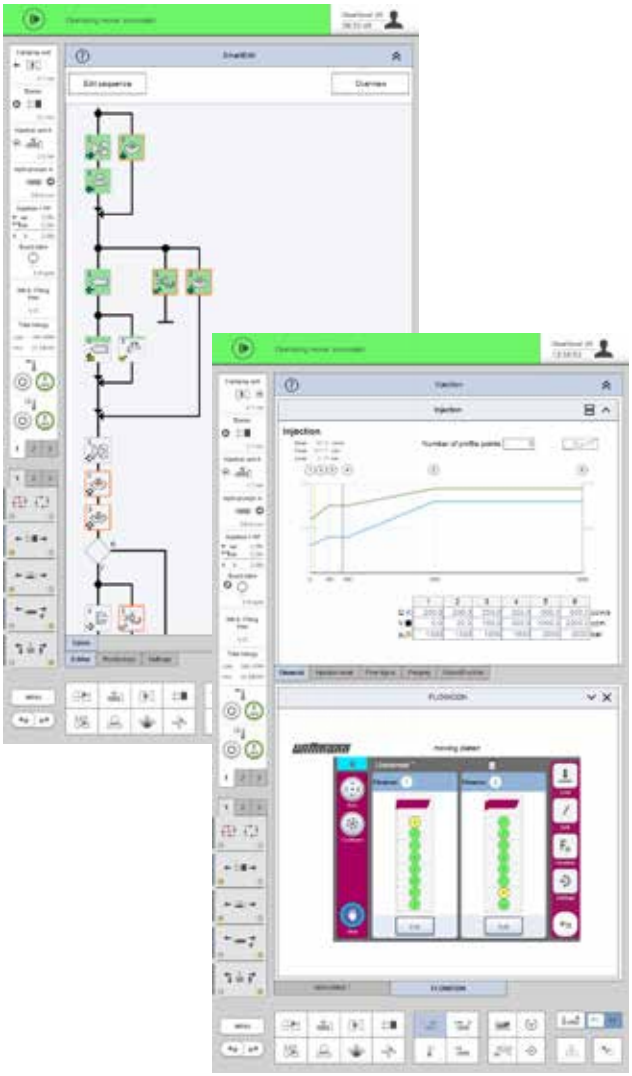
» **Process visualization**
via 21.5" touch screen display (full HD), pivoting laterally

» **New screen functions**
- Uniform layout for all WITTMANN appliances
- Recognition of gestures (wiping and zooming by finger movements)
- Container function – split screen for sub-functions and programs

» **Status visualization**
uniform signaling system across the entire WITTMANN group. Headline on the screen with colored status bars and pop-up menus

» **Operator assistance**
Extensive help library integrated

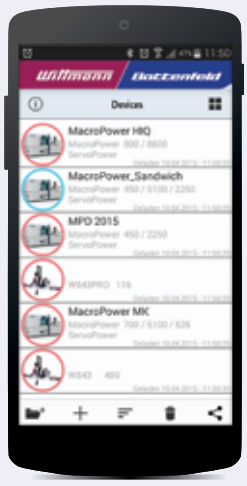
The process in constant view



» ***SmartEdit***
SmartEdit is a visual, icon-based cycle sequence programming facility, which enables direct addition of special functions (core pulls, air valves, etc.) based on a standard process via touch operation on the control system's monitor. In this way, a total user-defined sequence can be compiled from a sequence menu. This machine cycle, visualized either horizontally or vertically, can be adjusted simply and flexibly to the process requirements by finger touch with "drag & drop" movements.

The advantages
- Icon visualization ensures clarity.
- Clear events sequence through node diagram
- Alterations without consequences through "dry test runs"
- Theoretical process sequence can be quickly implemented in practice.
- Automatic calculation of the automation sequence based on the actual set-up data set without machine movements

» ***SmartScreen***
- Partitioning of screen displays to visualize and operate two different functions simultaneously (e.g. machines and peripherals)
- Uniform design of the screen pages within the WITTMANN group
- Max. 3 containers can be addressed simultaneously for the *SmartScreen* function.
- Adjustments of set values can be effected directly in the set value profile.



Remote communication

» ***QuickLook***
Production status check via smartphone – simple and comfortable:
- Production data and statuses of all essential appliances in a production cell
- Complete overview of the most important production parameters
- Access to production data, error signals and user-defined data
- Facilities for grouping of appliances and sorting according to status available

» **Global online service network**
- Web-Service 24/7: direct Internet connection to WITTMANN BATTENFELD service
- Web-Training: efficient staff training by means of the virtual training center

WITTMANN 4.0
Communication in and with production cells

With its communication standard WITTMANN 4.0, the WITTMANN group offers a uniform data transfer platform between injection molding machines and peripheral equipment from WITTMANN. For an appliance exchange, the correct operating software is loaded automatically via an update function according to the "plug & produce" principle.

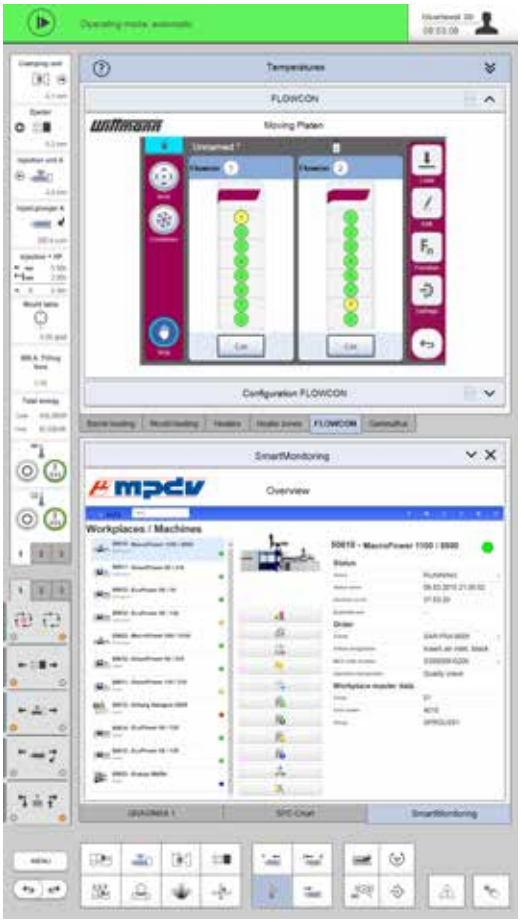
Connection of peripherals via WITTMANN 4.0

» **WITTMANN FLOWCON plus water flow regulator, GRAVIMAX blenders and ATON dryers**
- Units directly addressed and controlled via the machine's control system
- Joint saving of data in the production cell, the machine and in the network via MES

» **WITTMANN robots with R9 control system**
- Operation of robots via the machine's monitor screen
- High-speed communication between machine and robot to synchronize movements
- Important machine movements can be set via the R9 robot control system

» **WITTMANN TEMPRO plus D temperature controllers**
- Setting and control of temperatures via the machine's control system possible
- All functions can be operated either on the unit or via the machine's control system

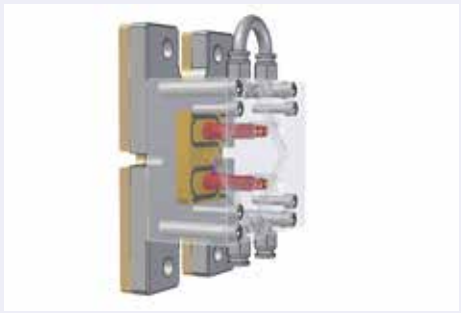
Integration in MES system
Integration of the machines and complete production cells in an MES system is the prerequisite for efficient and transparent manufacturing operations according to the Industry 4.0 standard. WITTMANN BATTENFELD cooperates closely with MPDV Mikrolab GmbH, a leading MES service provider. The Windows® 10 IoT operating system makes it possible to have even selected status information from all connected machines in production as *SmartMonitoring* displayed on the control system screen of every machine. Direct MES data input via the B8 control system is also possible.



WITTMANN 4.0 system
With WITTMANN 4.0, a machine and its robots and peripherals are transformed into a uniform technical organism, which communicates externally via a specific IP address. A single point entry increases the cyber security significantly.

"single point entry" via router into the industry 4.0 world

OPTIONEN
Flexible – proven – powerful



MicroPower
The option highlights

» **Rotary table**
The rotary table enables use of 2 bottom mold halves to achieve shorter cycle times on the one hand, and on the other hand to implement insertion and removal processes. In the multi-component version, the rotary table serves to accommodate the two different mold halves.

» **Silicone processing in micro dimensions**
For liquid silicone processing, for example in the production of medical components, a micro two-component material loader is available, including a blending and metering system. With this equipment, the machine can be quickly converted from thermoplastics to LIM injection molding.

» **High-precision coining (EXPERT-pvT-Coining)**
For the production of optical or micro-structured parts, a high-precision coining system is available as an optional equipment package. In this process, the coining pressure is controlled with high dynamism via the clamping stroke, depending on mold temperature or cavity pressure.

» **HiQ control for hot runners**
With decreasing part size, the proportion of sprue in the shot volume increases, due to the nature of the system. Minimizing the proportion of sprue is given a high priority in WITTMANN BATTENFELD product development.

» **WITTMANN peripherals in micro dimensions**
The optional WITTMANN 4.0 peripherals integration package is the basis for "plug & produce" technology of WITTMANN BATTENFELD injection molding machines with peripheral units from WITTMANN.

WITTMANN peripherals specially developed for the *MicroPower*:
- TEMPRO plus D Micro 100/140/160
- DRYMAX Micro F2-15 compact + material loader
- W8VS2 Vertical Scara
- W8VS4 Vertical Scara

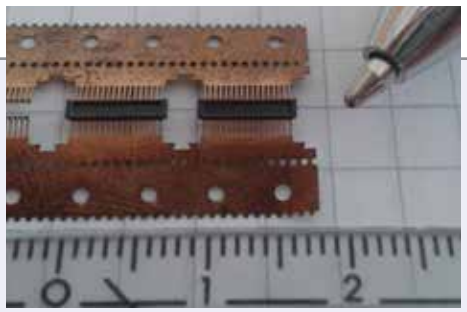
APPLICATION TECHNOLOGY
Outstanding competence

Photo: Micro Systems (UK) Ltd.

» **Clean room injection molding**
When medical components or electronic parts need to be manufactured in a particle-free environment, the *MicroPower* concept offers excellent conditions with its easy-to-clean mold environment and an optional clean air supply system.

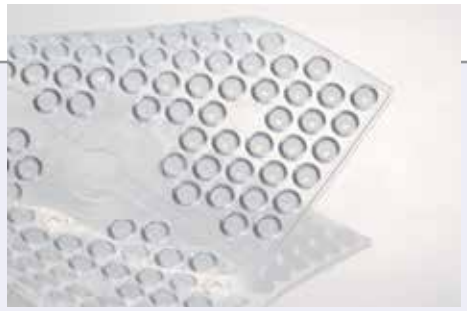
Photo: mikrotechnik Freudenreich GmbH & Co. KG

» **COMBIMOULD**
Two or more plastic materials in different colors or with different attributes can be combined into one part by upgrading the standard *MicroPower* with a second micro aggregate or by combining several machines into one production unit.



» **Reel-to-reel molding**
To produce electronic parts, punched structures are fed through the clamping unit and insert-molded. The ample mold mounting space of the *MicroPower* offers optimal conditions for this process.

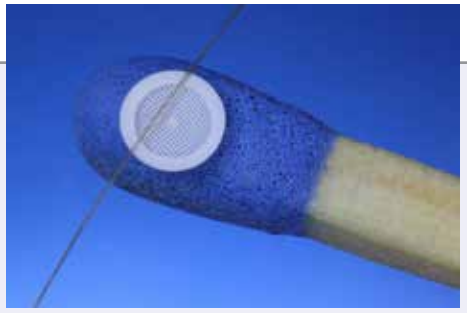
» **Insert molding**
When individual parts such as plug contacts need to be insert-molded, an insert station on a rotary table outside the mold is available for this purpose. A high-precision Scara handling robot and a metal parts feeding station can be integrated into the machine as additional modules.



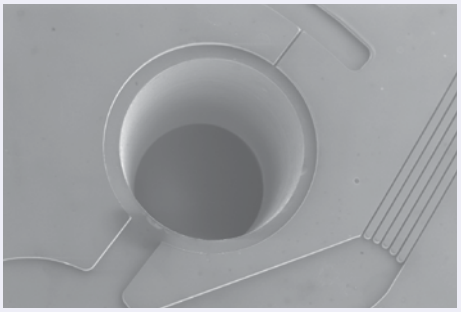
» **LIM – Liquid Injection Molding**
LIM designates the injection molding process for making elastic parts from 2-component liquid silicone rubber (LSR). LIM micro parts are used for optical and medical applications.

Photo: Frauenhofer IFAM

» **PIM (CIM/MIM) – Powder Injection Molding**
Powder injection molding (PIM) is a manufacturing process for series production of parts made of metallic or ceramic materials. PIM is the ideal process to make complex, functional components with stringent material requirements in large quantities.



» **High-precision micro parts**
In addition to standard plastics processing, the *MicroPower* injection unit is an ideal choice for manufacturing high-precision parts from engineering plastics such as POM, PEEK or PSU.



» **Microstructures**
The quality of the plastic melt generated gently and at a constant temperature inside the *MicroPower* injection unit is particularly suited for high-precision reproduction of micro structures inside the mold, from sensor structures to Fresnel lenses or copy protection holograms.

STANDARD

Base machine
Paint RAL 7047 tele grey 4/RAL 5002 ultramarine blue
Rectangular main beam on one-piece base frame
Built-in control cabinet
Part transp. on operator side, or parallel to machine axis
Drillings for peripheral equipment – like robot, camera, etc. – operator sided on rectangular main beam

Clamping unit
Clamping system: 5-point toggle with servo electrical direct drive
Servo-electric mold height adjustment
Clamping and opening forces for mold safety system adjustable
Mold safety program with envelope curves monitoring for optimal mold cover
Precise platen parallelism with low-maintenance moving platen support
Platen drillings metrical as per EUROMAP
Clamping force displayed on screen
Clamping force monitoring incl. display via screen
Servo electric ejector
Mechanical ejector couple
Cooling hole in the mould mounting platen

Injection unit
Servo closed loop control
Increased injection performance
Screw drive by 3-phase servo motor, screw speed continuously adjustable via screen
Barrel, screw, distributor block and injection nozzle in hot-work tool steel, injection piston TIN coated
Thermocouple failure monitor
Plug-in ceramic heater bands
Open nozzle
Quick removal for injection nozzle and cylinder
Hopper of V2A stainless steel can be shut and emptied
Linear bearings for the injection unit
Selectable barrel stand-by temperature
Decompression before and/or after metering
Physical units – bar, ccm, mm/s etc.
Screw protection
Peripheral screw speed indication
Linear interpolation of holding pressure set values
Bar chart for barrel temperature with set value and actual value display
Selectable injection pressure limitation
Changeover from injection to holding pressure depending on stroke, time and pressure

Safety gate
Maintenance-free safety gate locked by electromagnet
Safety gate with electric monitoring according to CE standard
Safety gate on the rear side

Cooling and conditioning
Watercooling with open cooling system
Feeding zone with controlled cooling system

Additional equipment
Operating instructions
User manual

Electrics
Operating voltage 230/400 V-3PH, 50 Hz
Common voltage supply for drive and heat
Separate voltage supply for drive and heat USA/CDN
USB – 2 x operating unit
1 Ethernet interface (switch cabinet)
Printer via USB connection or network
Signal towar at the machine

Control system
Control system UNILOG B8 – 21,5" multi-touch screen (full HD)
Software for operating hours counter
Closing/opening – 5 profile steps
Ejection forward/back – 3 profile steps
Injection/holding pressure – 10 profile steps
Injection parallel to clamp force build-up
Screw speed/back pressure – 6 profile steps
Parts counter with good/bad part evaluation
Purging program
Stroke zero offset settings
Start-up program
Adjustable injection pressure limitation
Switchover to holding press. MASTER/SLAVE by injection time, screw stroke/injection vol. and injection pressure
Self-teaching temperature controller
Display of temperature inside electrical cabinet
Seven-day timer
Access authorization vie USB interface, password system and RFID authorization system
Freely configurable status bar
Physical, process-related units
Energy consumption monitoring for motors and heating
Automatic dimming
Logbook with filter function
User programming system (APS)
Cycle time analysis
Energy measurement displayed
Freely configurable screen pages „user page"
Notepad function
Hardcopy function
Internal data storage via USB connection or network
Online language selection
Online selection of imperial or metric units
Operator manual incl. hydr., mech. and el. schedules online
Time monitoring
BASIC Quality Monitoring (1 freely configurable network connection, quality table with 1000 storage depth, events protocol (logbook) for 1000 events, actual value graphics with 5 curves, 1 envelope curves monitoring)
Injection integral supervision
Metering integral supervision
Alarm message via Email
SmartEdit – sequence editor

OPTIONS

Clamping unit
Servo electric rotary table
Mechanical mold safety mechanism
SPI bolt pattern
Ejector platen safety device as per EUROMAP 13
Parts chute for separation of good/bad parts
Nickel plated platen in lieu of standard
Air valve, action initiated (ON) and timer (OFF)
Non-standard layout of fastening bores in clamping/nozzle platen
Turning-out device with servo motor, installed on ejector plate

Injection unit
Grooves in the feeding zone of barrel for improved feeding
High temperature heaterbands up to 450° C
Barrel insulation
Enter block with additional connection for nitrogen supply in lieu of standard
Wear and corrosion resistant injection unit AK+
Equipment package for liquid silicone
Equipment package for PIM (MIN/CIM)
Equipment package for technical plastics (PC, PMMA, ABS)
Equipment package for bioresorbable materials
Screw in special geometry for PIM (MIM/CIM) execution in addition
Screw in special geometry for biodegradable material in addition
Screw in special geometry for technical plastics in addition
Conversion kit injection unit reduction to size 3 in AK+
Vacuum package: vacuum pump incl. interface, vacuum valve, vacuum sensor
Material hopper in DURAN glas design, 0.6 litres in volume
Connecting flange for customer-supplied hopper drier or drying unit
Equipment packages available in lieu of standard and/or in addition

Safety gate
Pneumatic safety gate at the operator side
Initiate next cycle by closing safety gate in semi-auto operation
Front side safety system for manual part removal

Pneumatic
Pneumatic maintenance unit incl. pressure regulation
Pneumatic core pullers incl. pressure regulator
Additional compressed-air controller

Cooling and conditioning
Watercooling with closed cooling system
Hosting of cooling circuits on the fixed platen of the moving platen
Integrated WITTMANN temperating units and dryer
Cooling circuits 2x additionally without shut-off valve

Granulat/dryer/feeder
Integrated WITTMANN dryer/dew point sensor
Integrated WITTMANN feeder

Robot/handling unit
W8VS2 WITTMANN Vertical Scara Robot with 3 servo axis
W8VS4 WITTMANN Vertical Scara Robot with 4 servo axis
Teachbox R8.2/R9
Additional valve
Additional vacuum circuit (Venturi)
Additional vacuum circuit (Venturi with blow-off function)
I/O expansion control cabinet (8I/8O)
Interface for COGNEX camera
Adapter for gripper plate (EOAT) with crash sensor
Conveyor belt

Electrics
Temperature control zone for hot runner
Special voltage
Control cabinet cooler
Interface for handling equipment
Temperature control interface digital, serial 20 mA TTY protocol
CAN-Bus-interface for mold conditioner as per EUROMAP 66-2
Interface for WITTMANN dryer integrated
Interface for WITTMANN temperating units integrated
Interface for robots as per EUROMAP 67
Interface for robots as per EUROMAP 67 with additional signals for rotary table
Adaptor from EUROMAP 67 to EUROMAP 12
Interface for conveyor belt and dosing unit
Interface for full integration of robot incl. Ethernet switch
Host computer interface/PDA (EUROMAP 63)
Relays contact parallel to plasticizing
Kistler module for cavity pressure dependent switchover
BNC connectors for injection process analysis
Machine fault (potential-free contact)
Part inlay monitoring via vacuum
Variotherm processing package
Signal tower with acustic element
Special network form (IT network); isolating transformer required
Isolating transformer for IT network
CEE socket 16 A
Protection of the socket circuits via residual-current-operating circuit breaker with 30 mA conventional tripping current
Additional emergency-stop button, mounted on the rear of the machine
Add. screen text not according to EU (max. 2 languages in addition to German)
Second injection parameter record for lower mold allocation or injection parameter change-over during start-up phase
Interface evacuation with software (incl. vacuum valves for rotary table)
Interface for freely configurable mold monitoring

Control system
Energy consumption analysis
Switch over to holding pressure by cavity or melt pressure
Switch over to holding pressure by external signal
Injection compression and venting sequences
Second injection data setting for automatic start up
HiQ-Cushion – melt cushion control
HiQ-Flow – injection integral control
HiQ-Melt – monitoring of material quality
Injection compression program/Extended injection compression program
Gate start special program
Special program according to customer specification
User specific limiting input value system
Program in US dimensions
RJG eDart interface
EXPERT Quality Monitoring (4 freely configurable network connections, quality table with 10000 storage depth, events protocol (logbook) for 10000 events, actual value graphic with 16 curves, 4 envelope curves monitoring, SPC charts, trend diagrams)

Additional euipment
Special paint and/or touch-up paint
Tool kit
Levelling pads
Lighting in mold space
Distance blocks 100 mm for leveling mounts
Spare parts package
Sprue-cut-off-appliance with air nozzle

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