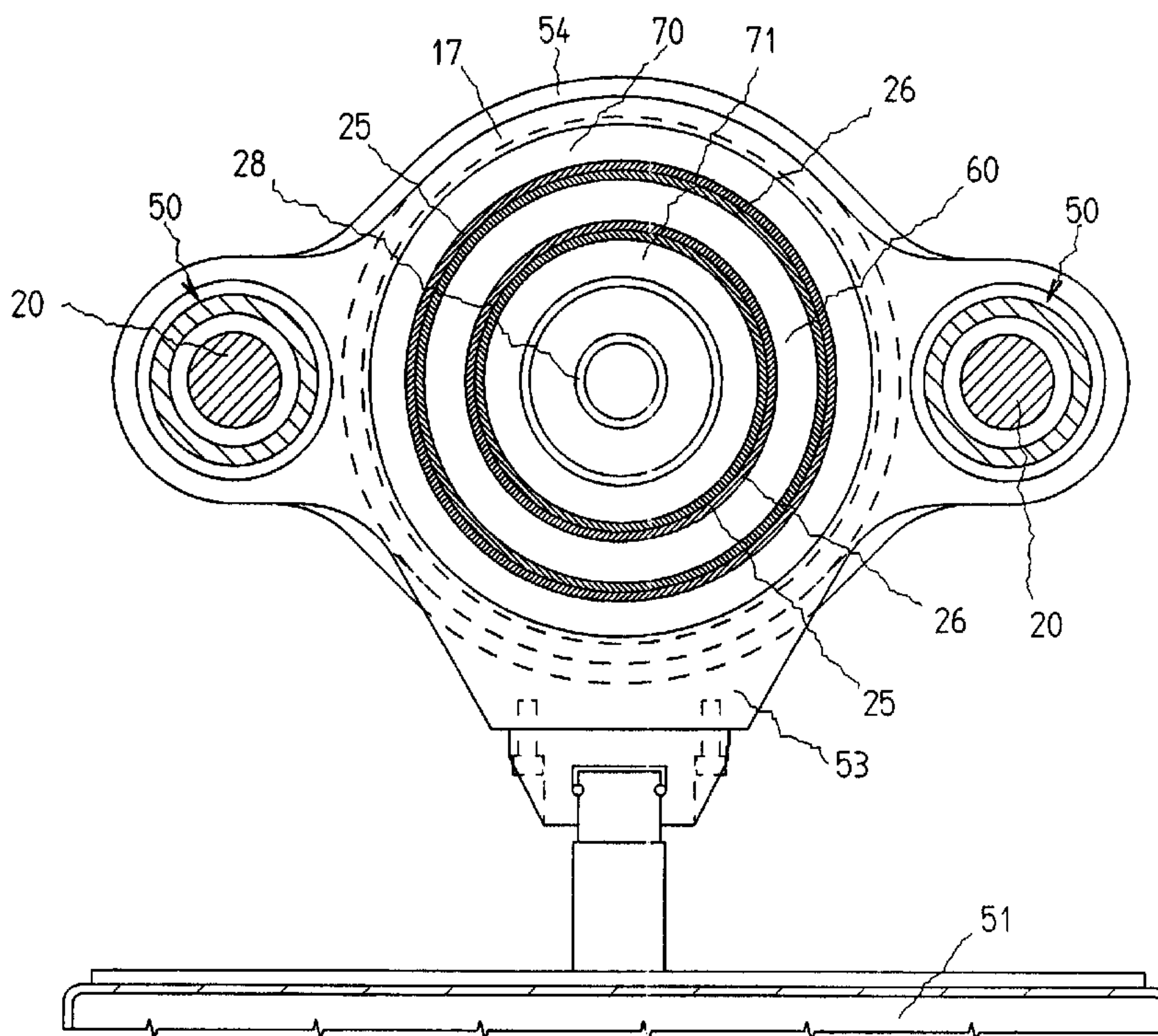




(86) Date de dépôt PCT/PCT Filing Date: 2000/05/02
 (87) Date publication PCT/PCT Publication Date: 2000/11/16
 (85) Entrée phase nationale/National Entry: 2001/10/24
 (86) N° demande PCT/PCT Application No.: EP 2000/003923
 (87) N° publication PCT/PCT Publication No.: 2000/067984
 (30) Priorité/Priority: 1999/05/05 (199 20 626.0) DE

(51) Cl.Int.⁷/Int.Cl.⁷ B29C 45/17, B29C 45/64, B29C 45/50,
B29C 45/40, B29C 45/28, H02K 41/03
 (71) Demandeur/Applicant:
HEHL, KARL, DE
 (72) Inventeur/Inventor:
HEHL, KARL, DE
 (74) Agent: MBM & CO.

(54) Titre : PRESSE D'INJECTION POUR LA TRANSFORMATION DE MATIERES PLASTIQUES
 (54) Title: INJECTION MOLDING MACHINE FOR PROCESSING PLASTICS



(57) Abrégé/Abstract:

The invention relates to an injection molding machine in which the injection molding unit (S) and the mold-closing unit are at least partially operated by electrical drive units in the form of a linear motor. The rotor and the stator of said linear motor have cylindrical lateral surfaces (11, 12), these cylindrical lateral surfaces of the stator and the rotor being arranged concentrically and the stator windings being essentially symmetrical to the a-a axis of motion of the linear motor. According to the invention, several equally acting first lateral surfaces (11) are interleaved with a corresponding number of equally acting other lateral surfaces (12) and the first and/or other lateral surfaces can be operated together, respectively, so that they cooperate. This results in a linear motor which is able to provide the advance forces that are required for injection molding machines.

Abstract

In an injection moulding machine the injection moulding unit and the mould closing unit are at least are at least partially operated by electrical drives in form of a linear motor. The rotor and
5 the stator have cylindrical surfaces which are arranged concentrically. The stator windings are symmetrical to the motion axis of the linear motor. Several equally acting first cylindrical surfaces are interleaved with a corresponding number of equally acting other cylindrical surfaces and are respectively operated together for operative connection. This results in a linear motor that is able to provide the advance forces required for injection moulding.

INJECTION MOLDING MACHINE FOR PROCESSING PLASTICS MATERIALS

DESCRIPTION

5 Reference to related applications

The present application claims the priority of German Patent Application 199 20 626.0, filed on 5.05.1999, the disclosed contents of which are hereby expressly also made the subject-matter of the present application.

10

Field of the invention

The invention relates to an injection moulding machine for processing plastics materials and other plasticisable compounds, wherein at least partially electrically operated driving units
15 are used to operate said machine, in accordance with the preamble of claim 1.

Prior art

A linear motor, which is used as the driving unit and is provided with a rotor and stator, is
20 known for plastics material moulding machines from DE-T2 37 82 817, which forms the basis for the preamble of claim 1 and corresponds to EP 0 280 743 B1, and JP-A 63-1516, said rotor and stator having cylindrical surfaces which are in operative connection with one another. These surfaces permit the magnetic face, which is needed for the required advancing forces, to be suitably incorporated in the drive axis. If the stator windings are symmetrically
25 disposed in accordance with DE-A 44 45 283, the relatively high bearing forces caused by the magnetism are mutually excluded. However, even there, mention is constantly made in the description of only one primary part and one secondary part, which parts co-operate accordingly with one another. If Figure 3 there is additionally considered, it becomes apparent that the internally situated pipe is merely a carrier pipe which, just like the externally situated
30 pipe, is neither a stator nor a rotor. When such a linear motor is used, there is a simultaneous saving in the complex converting means, which are susceptible to wear and serve to convert a rotary movement into a linear movement, such as, for example, a transmission mechanism, a spindle, levers and toothed rods (cf. also EP-A 744 815), but the forces, which are required for a plastics material injection moulding machine, cannot yet be applied there-
35 fore to a sufficient extent.

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Electrical driving units are also often used in conjunction with injection moulding machines. Thus, for example, it is known from EP 0 662 382 to stack together various hollow-shaft motors inside the injection moulding unit to inject the plasticised compound into the injection mould and to fit the nozzle onto the injection mould. However, it is necessary for such purpose, and time-consuming, to convert the rotary movements, produced by the hollow-shaft motors, into translatory movements. However, since all of the shafts or axis for the injection moulding machine are translatory shafts with the exception of the feed screw for metering the material to be plasticised, the use of such hollow-shaft motors is only recommended to a limited extent.

10

From handling techniques and medical techniques, linear motors are known which, however, do not have sufficient advancing forces, so that the linear motors, which are mainly fitted in a flat manner, are not suitable for use in an injection moulding machine. (Company brochure entitled "New Linear Motors and its applications" produced by the company called Fanuc, published in FANUC Tech. Rev. 112, pp. 25-36 (December, 1998); specification sheet linear motors entitled Lin.Mot P belonging to Sulzer Electronics AG, Zurich.)

15

Summary of the invention

Based on this prior art it is the object of the present invention to provide a linear motor for an injection moulding machine, which motor can also apply the advancing forces required for an injection moulding machine.

20

This object is achieved by an injection moulding machine having the features of claim 1.

25

In consequence, various cylindrical faces can be stacked one inside the other so that a plurality of identically acting magnetic faces are produced which contribute towards increasing the advancing forces up to a range which is required for plastics material injection moulding machines, e.g. for applying the closing force. The alleged disadvantage is tolerated in such case, i.e. that the linear motor can tilt more easily so that greater demands for precision are to be made on the means for guiding the parts of the linear motor. However, this is compensated for again by the more compact construction which can be achieved.

30

Although it is known, in prior art, which forces are required for an injection moulding machine to produce moulded parts, only circular arrangements were proposed there, the rotor and stator having concentric surfaces, since the person skilled in the art has probably concluded

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- 3 -

therefrom, incorrectly, that a corresponding alternative arrangement cannot be achieved to a suitable extent. In order to operate the surfaces jointly in operative connection with one another in fact, said surfaces have to be worked with appropriate precision. In such case, the precision required for the operation of the linear motor increases exponentially with an increasing spacing from the central line of the cylindrical surfaces so that the linear motor can tilt more easily, the greater this spacing is, more especially when the linear motor is to be kept short in order to achieve as compact a construction of the entire injection moulding machine as possible. This is further emphasised by the high temperatures which occur at high forces. This may probably also be the reason why, despite their advantages, linear motors have not yet been successful in the field of plastics material injection moulding machines, since hitherto the corresponding forces could still not be applied.

According to claim 7, cooling ducts may be disposed in the cylindrical walls of the stator, so that the heating, caused by the current, can be reliably dissipated. The cooling medium used therefor can, at the same time, be used to control the temperature of other component parts in the injection moulding machine.

Additional advantages are found in the sub-claims and in the following description of the Figures.

20

Brief description of the Figures

The invention is explained hereinafter with reference to a plurality of embodiments which are illustrated in the accompanying Figures. In the drawing:

25

- Fig. 1 illustrates an injection moulding unit moved onto the stationary mould carrier of a mould closing unit;
- Fig. 2 is a horizontal sectional view through the injection moulding unit in the region of carrier block and injection bridge;
- 30 Fig. 2a is a sectional view taken along the line 2a-2a of Fig. 2;
- Fig. 3 is a sectional view according to Fig. 2 of an alternative embodiment;
- Fig. 4 illustrates an enlarged portion taken from Fig. 3 in the region of the injection bridge;
- Fig. 5 is a side elevational view of a mould closing unit, which is shown partially in section;

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- Fig. 6 illustrates an enlarged portion taken from Fig. 5 in the region of the movable mould carrier;
- Fig. 7 is a side elevational view, shown partially in section, of a 5-point toggle lever of a mould closing unit;
- 5 Fig. 8 is an enlarged view of one of the two 5-point toggle levers according to Fig. 7;
- Fig. 9 illustrates a mould closing unit having a Y-shaped toggle lever;
- Fig. 10 illustrates the enlarged Y-shaped toggle lever;
- Fig. 11 is a horizontal sectional view through an injection moulding unit in the region of the carrier block and injection bridge in an alternative embodiment;
- 10 Fig. 12 is a side elevational view, shown partially in section, of a mould closing unit of the pulling type;
- Figs. 13 and 14 are views according to Fig. 11 of injection moulding units in two additional embodiments; and
- Fig. 15 illustrates an injection moulding unit provided with a closure nozzle.

15

Detailed description of preferred embodiments

The invention is now explained more fully, by way of example, with reference to the accompanying drawings. However, the embodiments are only examples which are not to restrict the
 20 inventive concept to one specific arrangement.

Fig. 1 illustrates initially the injection moulding unit of an injection moulding machine for processing plastics materials and other plasticisable compounds, such as, for example, ceramic or metallic pulverulent compounds. A plasticising cylinder P is accommodated in the injection
 25 moulding unit on a carrier block 52. The plasticisable compound is plasticised in the plasticising cylinder and injected into an injection mould M via a nozzle 21. For such purpose, the nozzle 21 penetrates the stationary mould carrier 14. The front portion of the injection moulding unit S is supported on the machine base 51 via a supporting member 22 and guided and supported on the machine base via a guiding element 53. In order to fit the nozzle
 30 21 onto the injection mould M, and to remove such if necessary, nozzle driving units 50 are provided which are hydraulically configured in Fig. 2. The cylinders of the hydraulic nozzle driving unit 50 form, with the carrier block 52 and a closure 54, a rigid frame which is guided on guide bars 20. The guiding element 53 is guided on the cylinders of the nozzle drive 50.

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- 5 -

In order to inject plasticised material into the injection mould, an injection unit E is provided. When the injection unit is actuated, the injection bridge 23 and, hence, the feed screw is axially moved. The injection bridge 23 carries the metering motor 28, by means of which a feeding means¹⁵ - a feed screw in the embodiment - can be rotated. While the metering motor 28 has to produce a rotary movement to rotate the feeding means¹⁵, translatory movements are required to drive the nozzle and for injection purposes. A linear motor is used as the electrical driving units for these translatory movements, and it includes a rotor having magnets disposed along a first cylindrical surface 11. The linear motor also has a stator with stator windings 26 disposed along an additional cylindrical surface 12. The cylindrical surfaces 11 and 12 of the stator and rotor are concentrically disposed, so that the magnetic face, which is required to produce suitable advancing forces for movements in the injection moulding machine, can be increased. So that the relatively high bearing forces are eliminated, not only are the circular surfaces provided; additionally the stator windings 26 and preferably also the magnets 25 of the stator are disposed symmetrically relative to the axis of movement a-a of the linear motor. Fig. 2a illustrates the circular surfaces and shows the application of corresponding forces on the basis of the force density which can be achieved at these faces.

In all of the embodiments, what is to be understood by the term surfaces is both the external surface of a cylinder and the internal surface of a pipe; in both cases, cylindrical surfaces 11 and 12 are involved. The magnets 25 may be permanent magnets, but they may also be separately excited coils having an iron core. Furthermore, the driving unit may be operated in a controlled or regulated manner, that is to say, for example, it can be operated as a servomotor over a regulating path.

In the case of the injection moulding units illustrated in Figs. 1 and 4, the linear motors of the injection unit are so disposed that the axis of movement a-a of the linear motor is, at the same time, the injection axis s-s of the injection moulding unit S. When transferred to the mould closing unit shown in Figs. 5 - 8 (see below), the axis of movement a-a of the linear motor is, at the same time, the axis of symmetry s-s of the mould closing unit F. For simplification purposes, the same identification s-s is used in both cases, and also, moreover, the reference numerals in the drawings are so selected that identically acting parts are provided with identical reference numerals.

To produce the necessary advancing forces, the cylindrical faces are disposed in a stacked manner. Figs. 2 and 2a illustrate how a plurality of identically acting first surfaces 11 are

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stacked with a corresponding number of additional surfaces 12 for the injection movement. A cylinder 60 is supported on the closure 54, which is moved jointly with the carrier block 52 via the nozzle driving unit 50 as a consequence of the connection, and it has identically acting surfaces on its inside and on its outside. It may be open to question whether these surfaces
5 are initial surfaces of the rotor or additional surfaces of the stator. In the embodiment, the surfaces of the cylinder 60 are first surfaces of the rotor. These surfaces are formed by identically acting additional or first surfaces of two concentric cylinders 70 and 71. When viewed externally, the impression is given that piston rod and cylinder of a piston-cylinder-unit would extend into one another. The surfaces are so disposed that the internal surface of the exter-
10 nal cylinder 70 co-operates with the outside of the cylinder 60, and the external surface of the internal cylinder 71 co-operates with the inside of the cylinder 60. A greater advancing force than was usual hitherto can be produced by this stacking arrangement.

In order to protect the linear motor from contamination and, if necessary, to produce a cham-
15 ber which can be provided with a suitable lubricant, an additional cylinder 17 moves jointly with the cylinder 60 and is, in this respect, just like the cylinder 60 connected to the closure 54. This cylinder 17 overlaps the linear motor and has, at its front end on the left of Fig. 2, a mounting 18 which co-operates with a bearing face 19 of the cylinder 70. The parts of the linear motors are guided towards one another via mounting 18 and bearing face 19, and, in
20 consequence, the parts of the injection moulding machine are centred in order to ensure a precision which is required to produce high-quality parts. At the same time, the mounting 18 and bearing face 19 act in a sealing manner.

If the stator windings of the concentric cylinders 70 and 71 are energised, an advancing
25 movement results in co-ordination with the magnet of the cylinder 60. While the cylinder 60 remains in an unchanged manner, the concentric cylinders 70 and 71 are moved jointly with the injection bridge 23. Fig. 3 illustrates an alternative embodiment of the injection moulding unit S, where cylinder 60 and concentric cylinders 70 and 71 have been reversed. The cylinder 60, with which the cylinders 70 and 71 co-operate, is mounted on the carrier block 52,
30 said cylinders now being a component part of the injection bridge 23. The reversal necessitates a reversal of rotor and stator. If, in the first embodiment, the cylinder 60 was the rotor, then it is now the stator. The injection bridge 23 also slides here on the cylinders of the hydraulic nozzle driving unit, but a frame, which reinforces the injection moulding unit S per se, is not provided as in the first case. The additional cylinder 17 supports the linear motor by
35 means of mounting 18 and in co-operation with the bearing face 19.

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According to Fig. 3, the stator windings 26 can be divided into a plurality of separate electrical switching zones along their axis of movement a-a. The entire range of movement is shown by the range D. During displacement, all of the switching zones A, B and C are involved during the injection operation, above all towards the end, in order to permit the required forces to be applied with the participation of all of the switching zones. However, as soon as a specific zone is no longer in operative connection with the surfaces of the rotor by means of its face, the zones which are no longer required can be switched-off to save energy.

10 Cooling ducts 27, which lie behind or adjacent the stator windings 26 when viewed from the magnets 25, are associated with said stator windings in the cylindrical walls of the stator, so that the heating, caused by the current, can be reliably dissipated. The cooling medium employed may be used at the same time to control the temperature of other component parts in the injection moulding machine.

15 The enlarged portion according to Fig. 4 shows that the magnets 25 are also attached to the walls of the cylinders 70 and 71. The magnets are provided with the identifications for their north-south (N-S) poles. The stator windings 26, however, are identified with U-V. The injection bridge, which is substantially formed by the concentric cylinders 70 and 71, has sufficient space in its centre, that is to say in the centre of the cylinder 71, to support the metering motor 28 as well as the locking arrangement for the feeding means.

25 The linear motor, as an electrical driving unit, may also be employed for other assemblies of the injection moulding machine. It is possible, more especially, to provide the translatory shafts with linear motors. On the injection moulding side, such shafts are the driving unit for fitting the nozzle 21 onto the injection mould as well as the already explained injection means E or the actuating mechanism for a closure nozzle V (Fig. 15). On the side of the mould closing unit F, this is, for example, the closure mechanism for moving the movable mould carrier 13 towards and away from the stationary mould carrier 14, which may apply the closing force if necessary. If the mould closing unit is constructed so that the closing mechanism only accomplishes the mould closing movement, while the closing force is applied by a separate arrangement, this separate arrangement may be provided with a linear motor. On the mould closing side, an ejector unit 16 or a core puller unit K (Fig. 5) on the injection mould M may also be provided with a linear motor.

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Fig. 5 illustrates a mould closing unit F, wherein the movable mould carrier 13 is moved along guide bars 56 by means of the closing mechanism. During displacement, the injection mould M is alternately closed and opened. The closing mechanism is supported on a supporting element 57. Fig. 6 illustrates an enlarged portion of Fig. 5 in the region of the movable mould carrier. A comparable construction, such as was previously the case with the injection moulding unit, is also apparent here. A cylinder 60, with an inside and an outside, is the rotor with the magnet 25. The movable mould carrier, however, carries the concentric cylinders 70 and 71 as the stator. The cylinder 60 and the additional cylinder 17 are mounted on the supporting element 57, said additional cylinder being mounted and guided on the bearing face 19 here also with the mounting 18. In the embodiment, therefore, relatively large cylinders are also stacked inside one another here. Sufficient space is available in the interior of the cylinder 71 to accommodate an ejector unit 16, which is also actuated as a linear motor. An extremely short structural design is therefore produced.

15 If desirable, however, a plurality of individual cylinders may also be stacked around the closing axis s-s and/or disposed concentrically, which cylinders are then operated identically in this respect.

The linear motor may also be used for other types of closing mechanisms, though the description of the stacking has been somewhat curtailed hereinafter to achieve a clear description. Figs. 7 and 8 illustrate a closing mechanism with a multi-point toggle lever, here a 5-point toggle lever. The movable mould carrier is guided on guide bars 56, and an ejector unit is to be actuated centrally in the movable mould carrier via a linear motor. Fig. 8 illustrates the structure of the 5-point toggle lever 80. The toggle lever is supported on the supporting element 57 by the pivot joint 84. It is supported on the movable mould carrier 13 by the pivot joint 86. The pivot joints 84 and 86 are interconnected via two arms 87 and 88 which, in turn, for their part are pivotally interconnected at the pivot point 85. A pivot point 83 for a pivotal arm 81 is provided on the arm 87. Said pivotal arm communicates with the drive at the pivotal point 82. If the drive is moved linearly along the closing axis, the arm 81 urges the arm 87 in an arc forwardly and then upwardly. The arms 87 and 88 thereby come into an extended position and are prevented from falling-back by automatic locking, supported by the arm 81. The advantage of this embodiment is that, in the extended position, no force has to be applied to the arm 81 in order to maintain the extended position. This is advantageous since, during the linear movement, the covering of the cylindrical surfaces 11 and 12 also reduces, so that the force, produced by the linear motor, is smaller towards the end of the

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movement. Fig. 8 also shows that the linear motor for the ejector unit 16 can be guided back into the cylinder of the linear motor of the closing mechanism O.

An alternative type of closing mechanism is the Y-shaped toggle lever shown in Figs. 9 and 10, which is otherwise constructed like the previously described mould closing units F. The Y-shaped toggle lever 90 supports the driving unit, in that it suspends said unit in a freely displaceable manner via two pivotal arms 91. If the rotor 30 is moved, it acts on the pivotal point 93 and brings the arms 92 into the extended position. Here also, a relatively small force is to be applied in the extended position. The rotor 30 may be so configured that, during the application of a small force, it only slightly co-operates with the surfaces of the stator while, during the application of a high force, a total co-operation of the surfaces 11 and 12 is effected.

It is thereby indicated that, basically, the cylindrical surfaces can be so disposed that, when a high force has to be applied, a large covering of the surfaces 11 and 12 also exists, so that a high force is produced also as a consequence of a large abutment face. This is explained for an injection moulding unit S with reference to Fig. 11. The linear motor is employed as injection means E, wherein the covering of the cylindrical surfaces 11 and 12 is increasing when the nozzle is fitted onto the injection mould M. This is achieved when the cylinder 60 is supported on the carrier block. Here, the cylinder 60 is the stator. In order to move the injection bridge, the cylinders 70 and 71 are pulled over the cylinder 60 so that, during the injection process, a greater force is produced the further the feed screw is moved in the direction towards the injection mould. In consequence, the injection bridge 23 moves to the left in Fig. 11.

The same principle can also be achieved with the mould closing unit. Fig. 12 illustrates a linear motor as the closing mechanism, the covering of the cylindrical surfaces 11 and 12 increasing during the application of the closing force. A mould closing unit is involved, wherein the movable mould carrier is pulled over the stationary mould carrier 14. In the embodiment, the bars 56 are not securedly mounted on the stationary mould carrier. They are provided with the first surfaces in this region. If the stator is actuated on the stationary mould carrier, the rotor is pulled into the linear motor, so that a greater covering of the surfaces is produced with an increasing closing movement of the injection mould M, and maximum force is achieved at the end of the mould closing movement. Fig. 12 also shows that the linear motor has its axis of movement a-a coinciding with the central axis of the bar 56.

- 10 -

With an otherwise identical structure as in Fig. 3, Fig. 13 shows that the nozzle driving unit, which was hydraulic in Fig. 3, may also be in the form of a linear motor. In this respect, the bars 20 are provided with magnets, so that they may serve as rotors of the nozzle driving unit N. They co-operate with a stator which slides along the bars 20. Because of this structure, a
5 corresponding movement along the bars 20 is possible.

In an alternative embodiment, Fig. 14 shows that the axis of movement a-a of the linear motor may also coincide with the central axis of the guide bars 20 in the injection moulding unit. In this embodiment, a stacking of injection means and nozzle driving unit N around the bars
10 20 is created. The nozzle driving unit N lies around the bar 20. The guide bar is the rotor, while a sleeve represents the stator 40. This sleeve is the stator on the inside and, in turn, is already the rotor with magnets for the injection means E on the outside. In consequence, an additional sleeve is placed around the sleeve as stator 41, which additional sleeve is, for its part, also the injection bridge 23. Finally, the injection bridge carries the metering motor 28.
15

It is self-evident that this description may be subjected to the most varied modifications, changes and adaptations, which range from equivalents to the dependent claims.

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List of reference numerals

	11	cylindrical surface	60	cylinder
	12	additional cylindrical surface	70,71	concentric cylinder
5	13	movable mould carrier	80	5-point toggle lever
	14	stationary mould carrier	81	arm
	15	feeding means	82,83,85	pivotal point
	16	ejector unit	84,86	pivot joint
	17	additional cylinder	87,88	arm
10	18	mounting	90	Y-shaped toggle lever
	19	bearing face	91	supporting arm
	20	guide bar for S	92	arm
	21	nozzle	93	point of engagement
	22	supporting element	94	pivotal point
15	23	injection bridge	a-a	axis of movement
	24	supporting member	m-m	central axis
	25	permanent magnet	s-s	axis of symmetry or injection axis
	26	stator winding	A,B,C	switching zones
	27	cooling duct	D	entire range
20	28	metering motor	E	injection means
	30	rotor	F	mould closing unit
	40,41	stator	K	core puller unit (Fig. 5)
	50	hydraulic nozzle driving unit	M	injection mould
	51	machine base	N	nozzle driving unit
25	52	carrier block	O	closing mechanism
	53	guiding element	P	plasticising cylinder
	54	closure	S	injection moulding unit
	56	guide bar for F	V	closure nozzle (Fig. 15)
	57	supporting element		

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CLAIMS

1. Injection moulding machine for processing plastics materials and other plasticisable compounds, having an injection moulding unit (S) and a mould closing unit (F), which units
5 are operated at least partially by electric driving units in the form of at least one linear motor, which has a rotor with magnets (25), disposed along a first cylindrical surface (11), and a stator with stator windings (26) disposed along an additional cylindrical surface (12), the cylindrical surfaces (11,12) of stator and rotor being concentrically disposed, and the stator windings (26) being substantially symmetrical relative to the axis of move-
10 ment (a-a) of the linear motor, characterised in that a plurality of identically acting first surfaces (11) are stacked with a corresponding number of identically acting additional surfaces (12), the first and/or additional surfaces each being operable jointly in operative connection.
- 15 2. Injection moulding machine according to claim 1, characterised in that the magnets are magnets or separately excited coils with an iron core.
3. Injection moulding machine according to claim 1, characterised in that the electric driving
20 unit is a regulated servo driving unit.
4. Injection moulding machine according to one of claims 1 to 3, characterised in that identically acting first or respectively additional surfaces are the outside and inside of a cylinder (60), and in that identically acting additional or respectively first surfaces are so disposed on two concentric cylinders (70,71) that the internal surface of the external cylinder (70)
25 co-operates with the outside, and the external surface of the internal cylinder (71) co-operates with the inside of the cylinder (60).
5. Injection moulding machine according to one of claims 1 to 4, characterised in that the linear motor is cylindrical and is overlapped on the outside by an additional cylinder (17),
30 which guides the faces of rotor and stator, which are moved towards one another, along a separate bearing face (19) by means of at least one mounting (18).
6. Injection moulding machine according to one of claims 1 to 5, characterised in that the stator windings (26) are divided along the axis of movement (a-a) into a plurality of separate
35 electrical switching zones.

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7. Injection moulding machine according to one of claims 1 to 6, characterised in that cooling ducts (27), which lie behind or adjacent the stator windings (26) when viewed from the magnets (25), are associated with said stator windings, which ducts have their temperature controlled by means of a cooling medium.
- 5
8. Injection moulding machine according to one of claims 1 to 7, characterised in that the electric driving unit is at least one of the following assemblies of the injection moulding machine:
- 10 - closing mechanism for moving the movable mould carrier (13) towards the stationary mould carrier (14) and away from said stationary carrier and for applying the closing force if necessary,
 - arrangement for applying the closing force,
 - driving unit for fitting the nozzle (21) onto the injection mould (M),
 - injection means for axially moving the feeding means(15),
 - 15 - ejector unit (16),
 - core pulling unit (K) on the injection mould (M),
 - driving unit for a closure nozzle (V).
9. Injection moulding machine according to one of claims 1 to 8, characterised in that the linear motor is employed as the closing mechanism, and in that there is space in the interior of the internal cylinder (71) to accommodate an ejector unit (16).
- 20
10. Injection moulding machine according to one of claims 1 to 9, characterised in that the linear motor is employed as the injection means (E), the covering of the cylindrical surfaces (11,12), increasing during displacement of the feeding means(15) to the injection mould (M).
- 25
11. Injection moulding machine according to one of claims 1 to 10, characterised in that the linear motor is employed as the closing mechanism, the covering of the cylindrical surfaces (11,12) increasing as the parts of the injection mould (M) approach one another.
- 30

FIG. 1

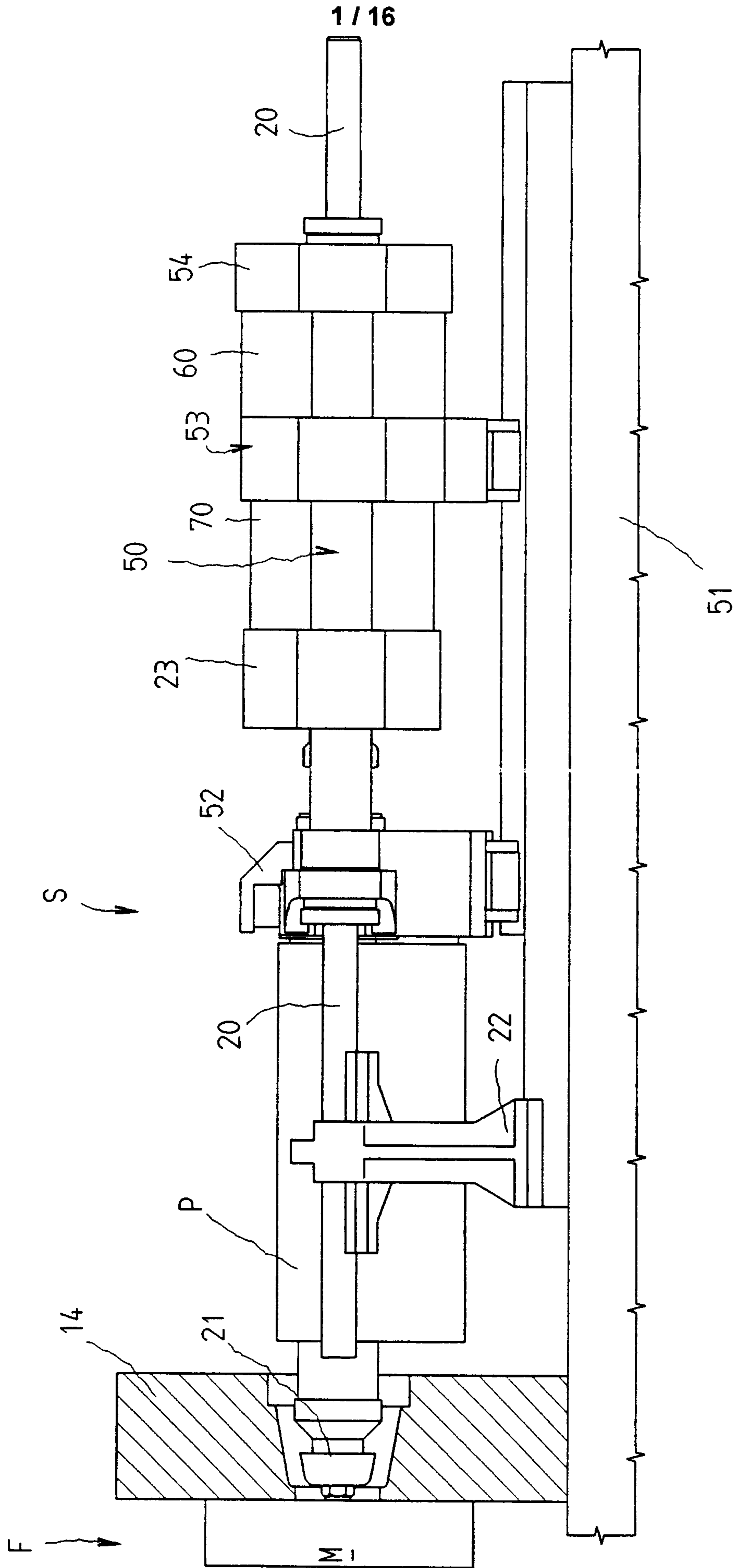
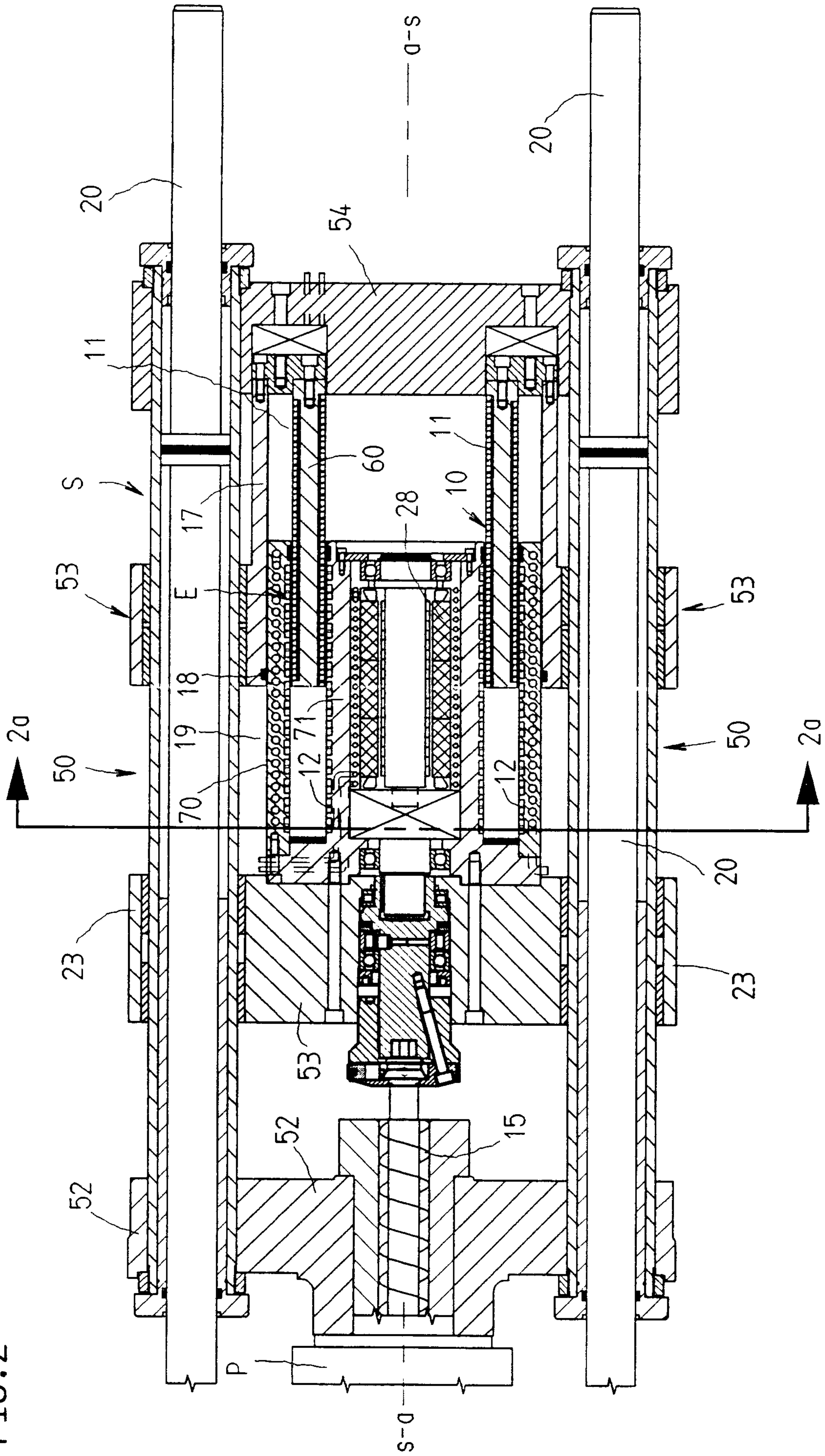


FIG. 2



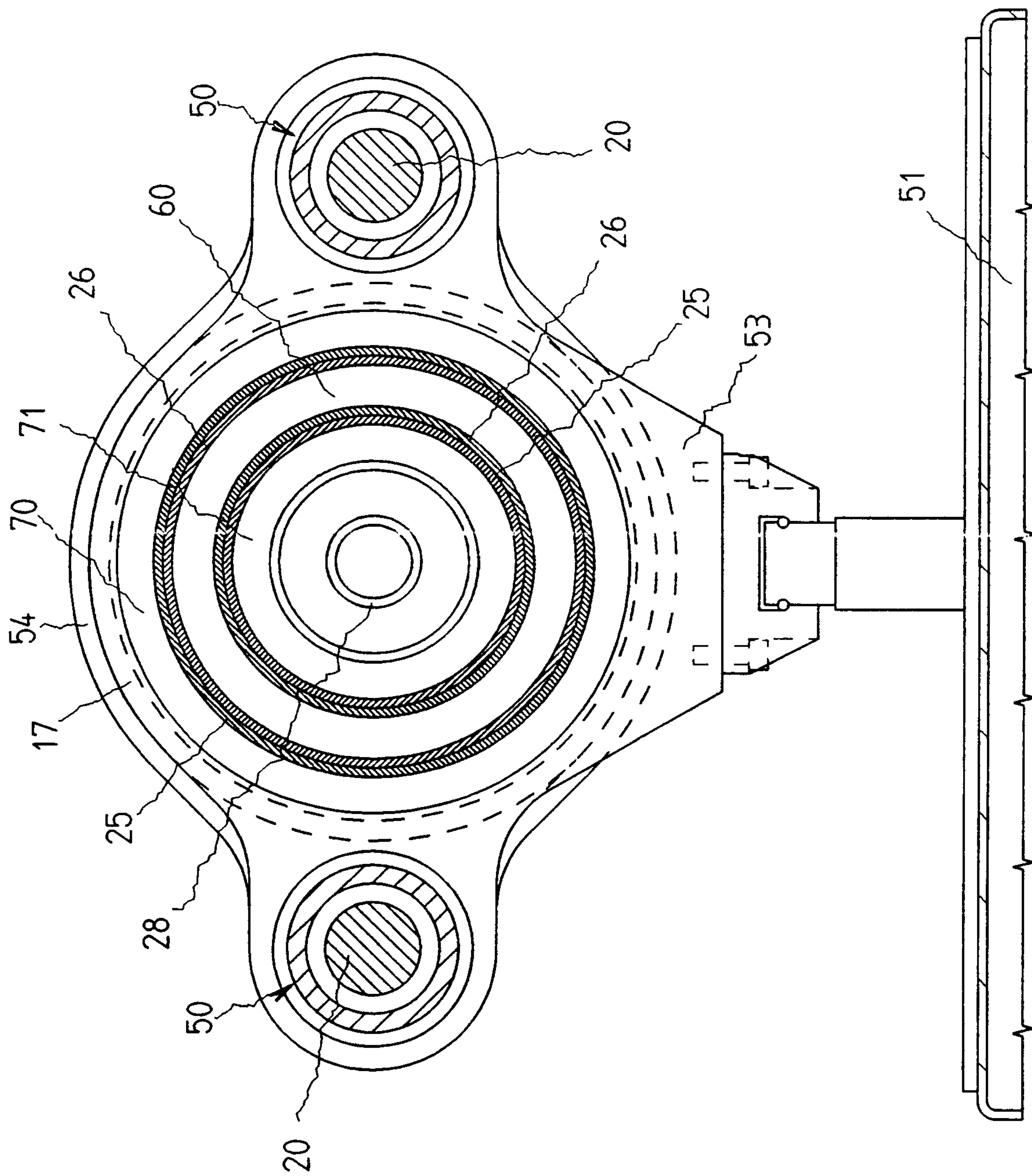


FIG. 2a

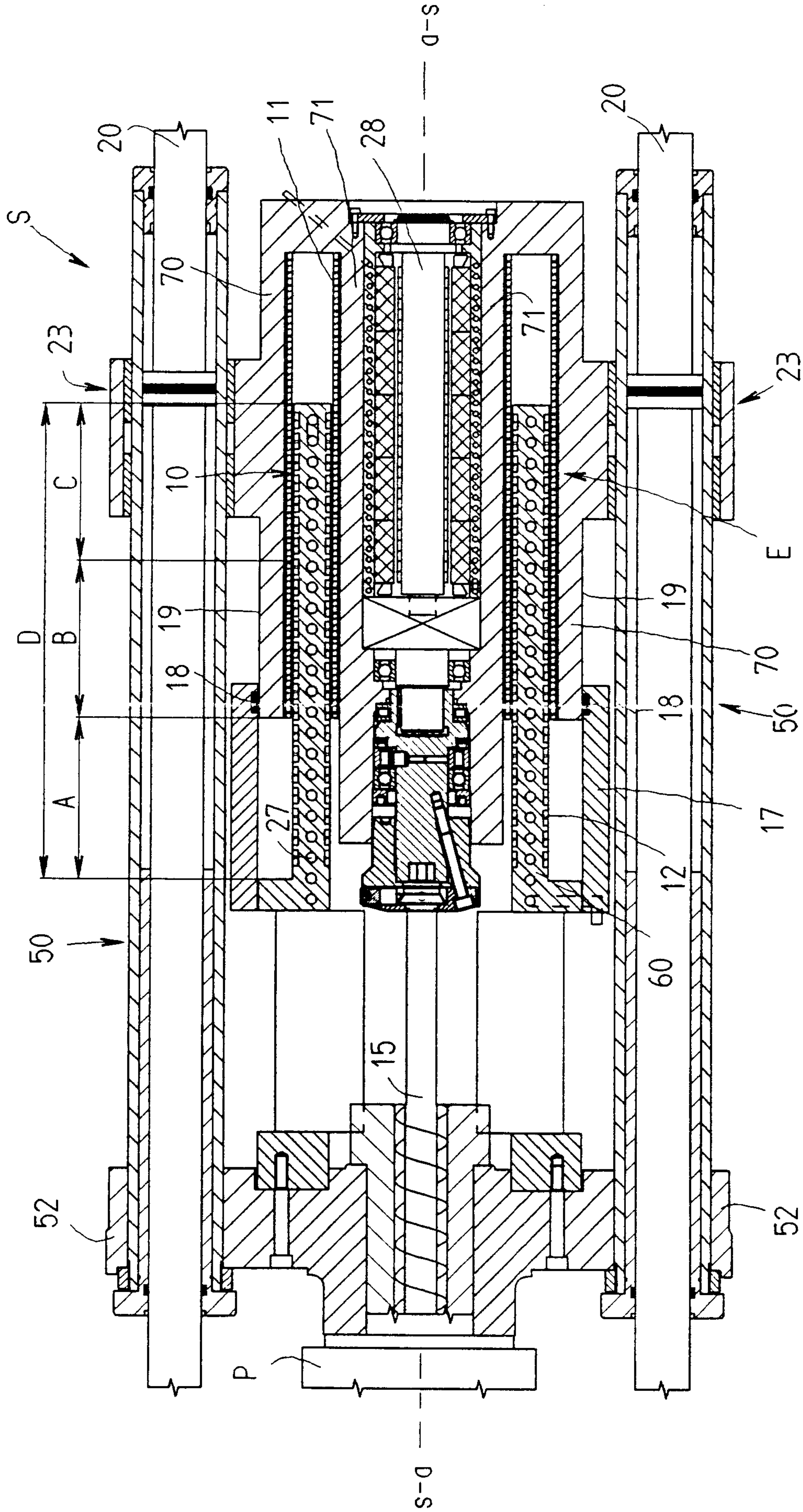
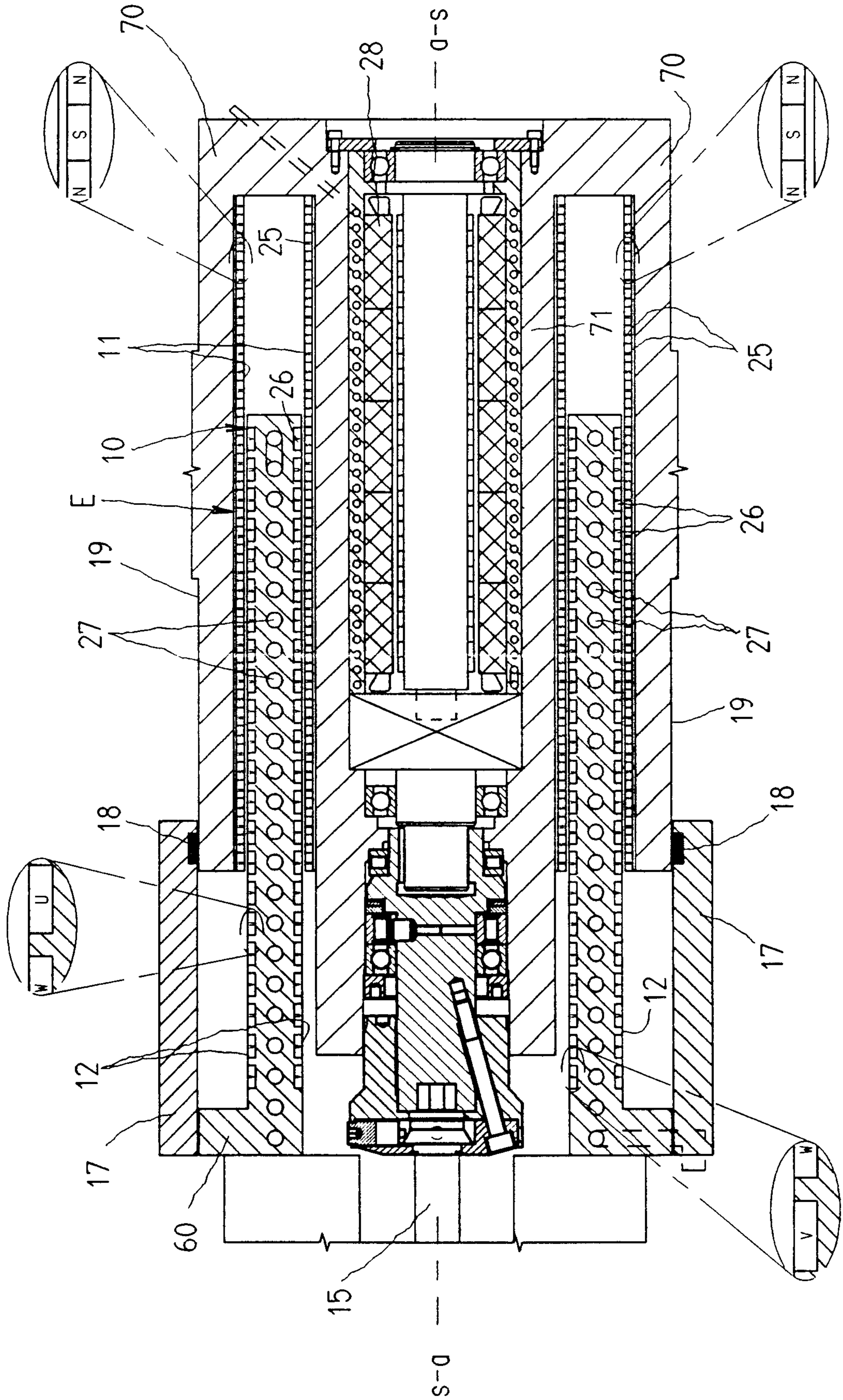
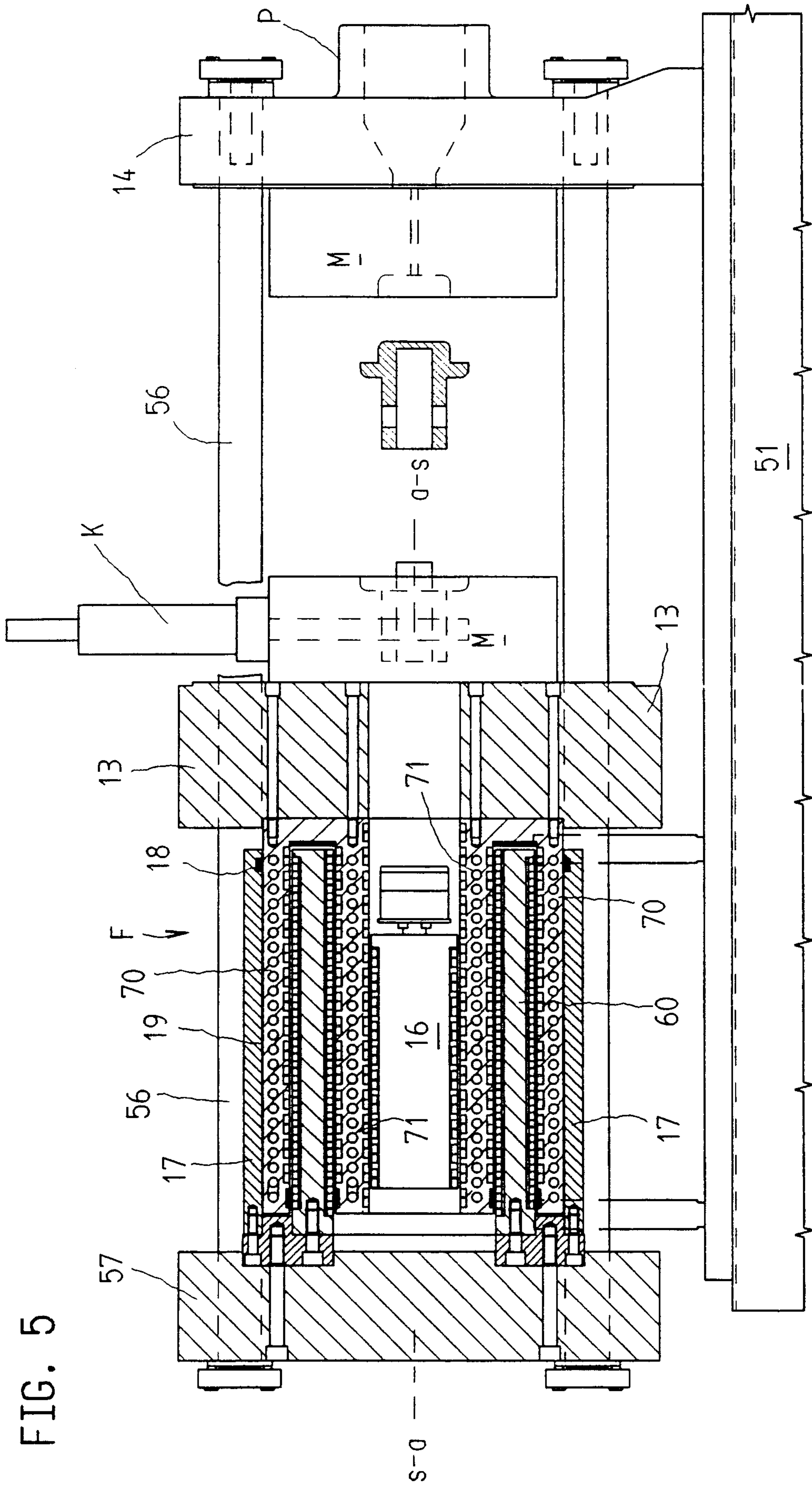


FIG. 3

FIG. 4





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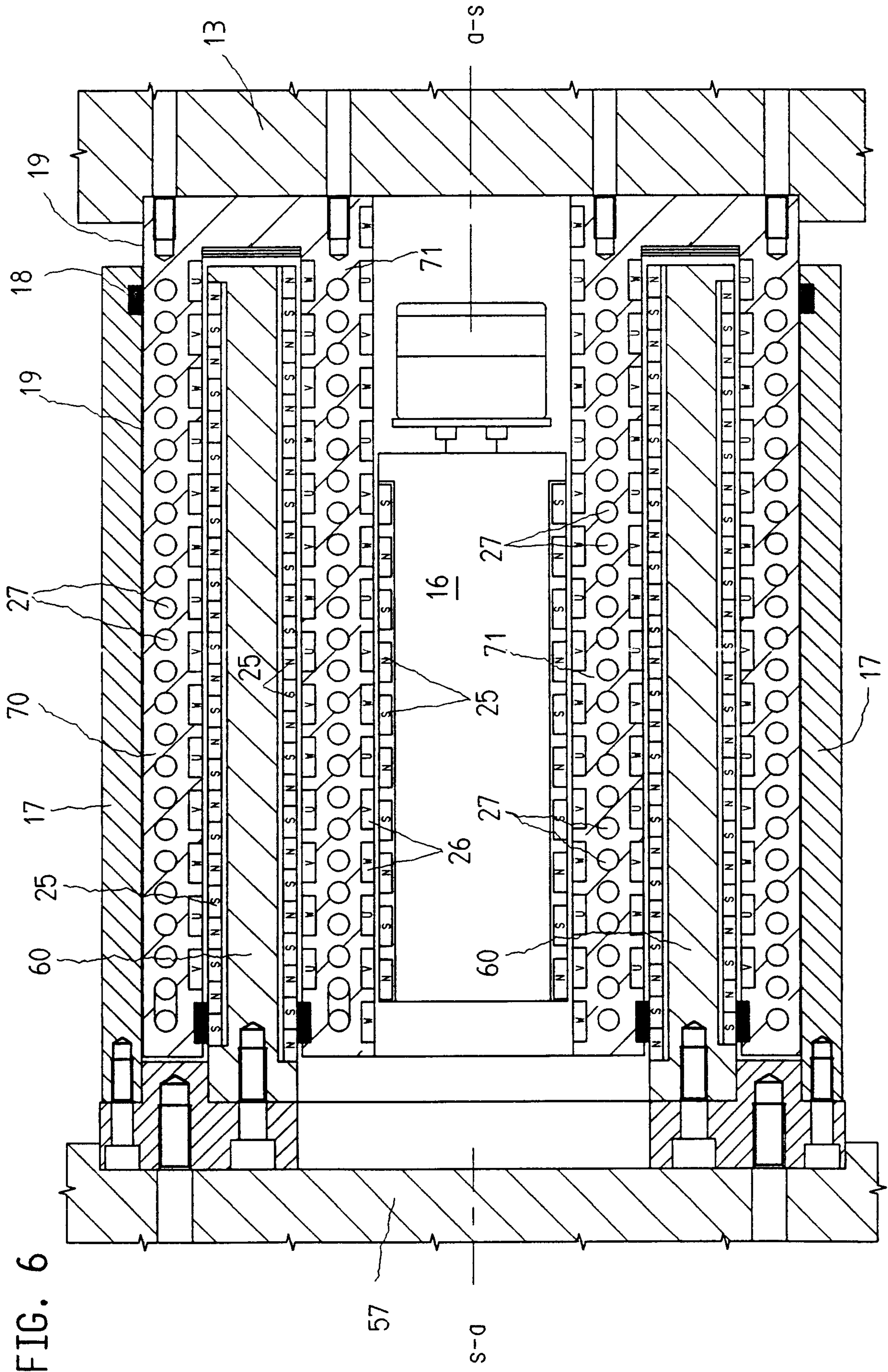


FIG. 6

S-S

FIG. 7

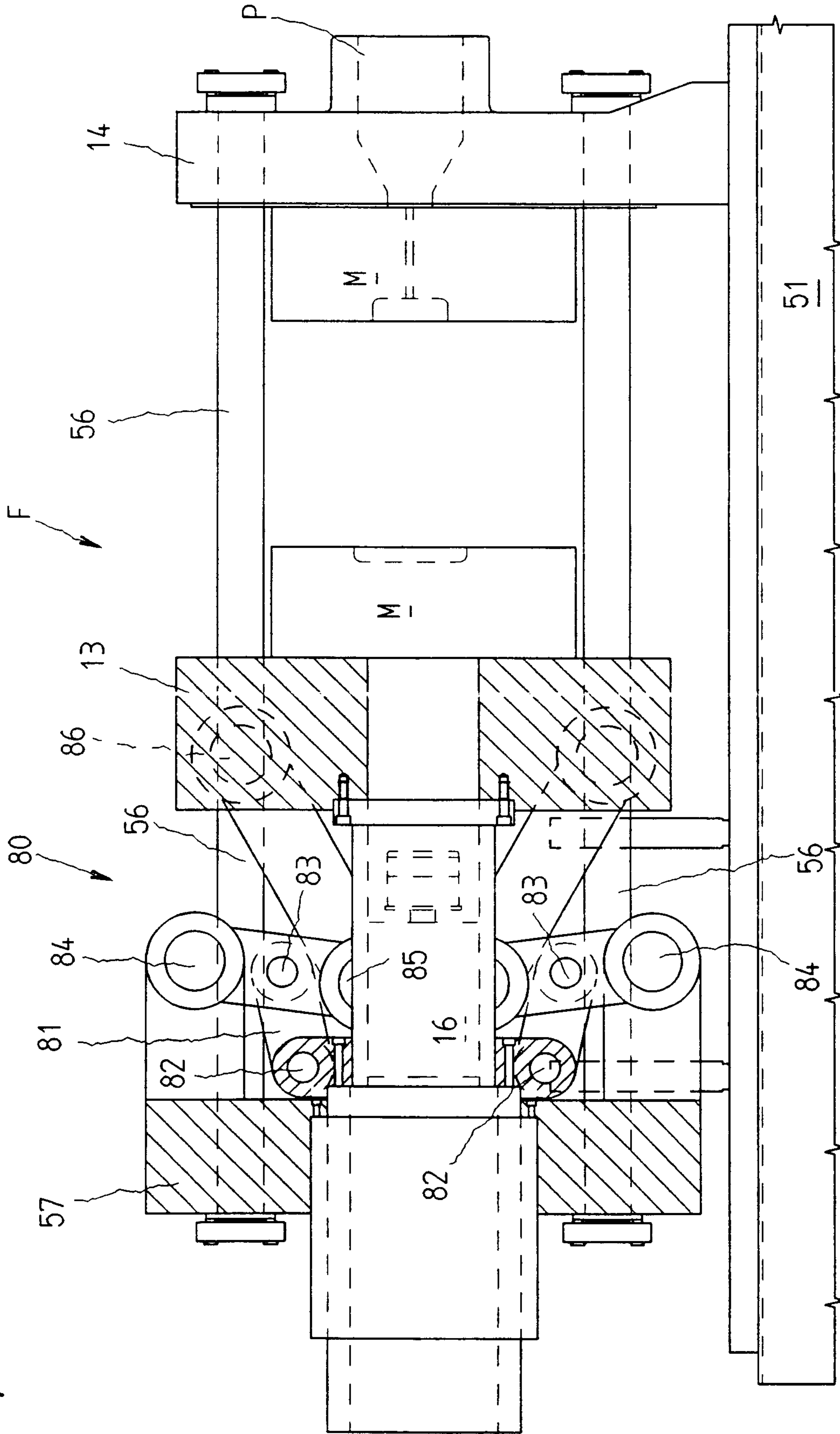
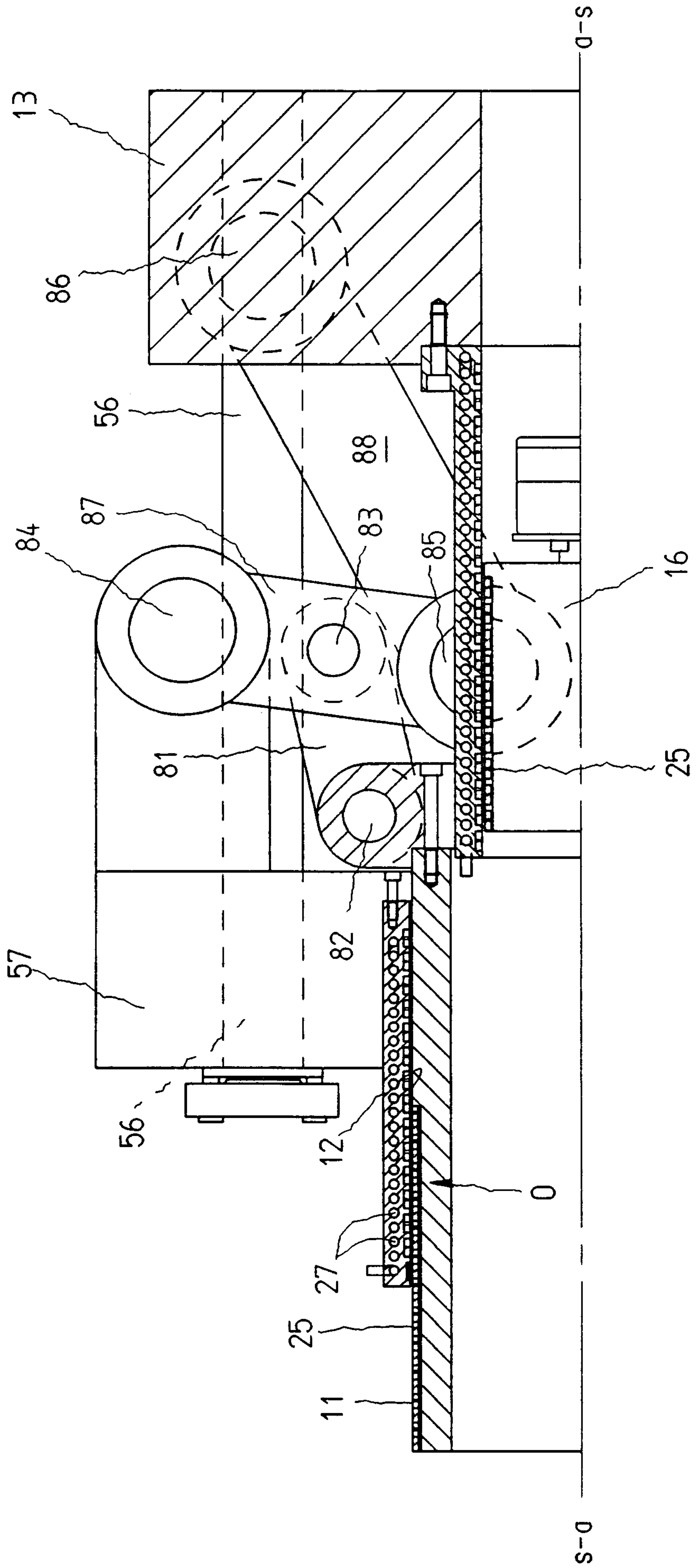


FIG. 8



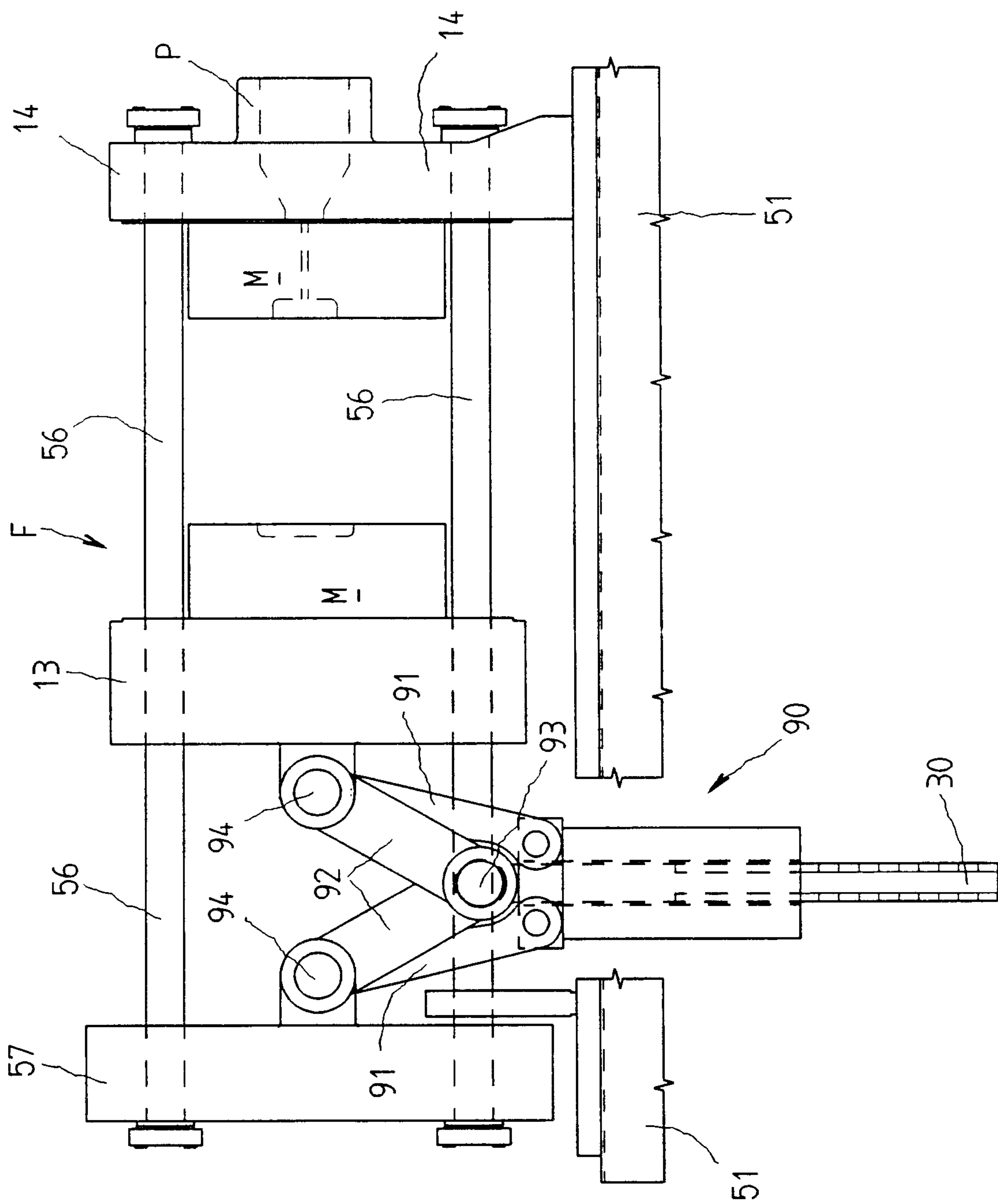


FIG. 9

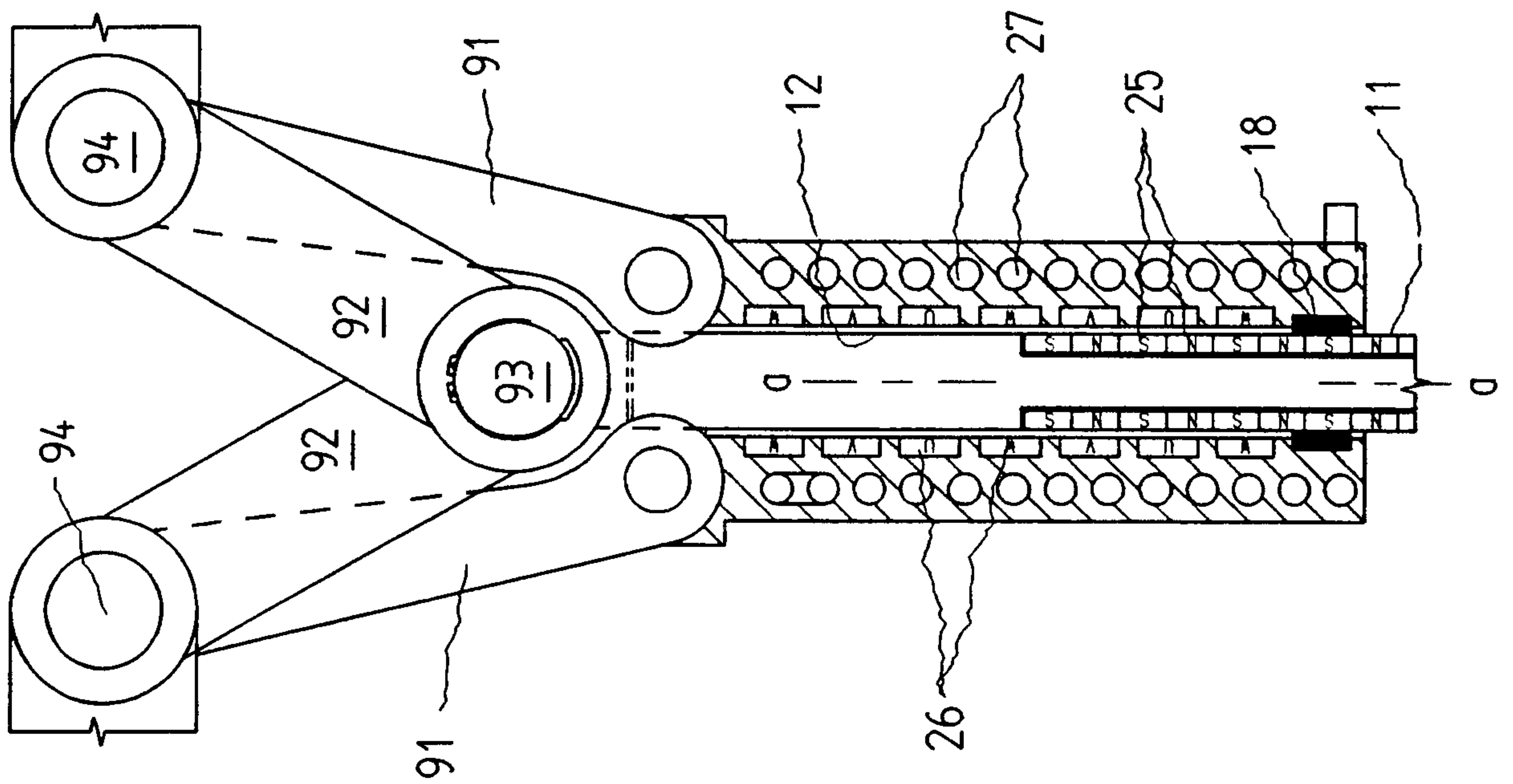
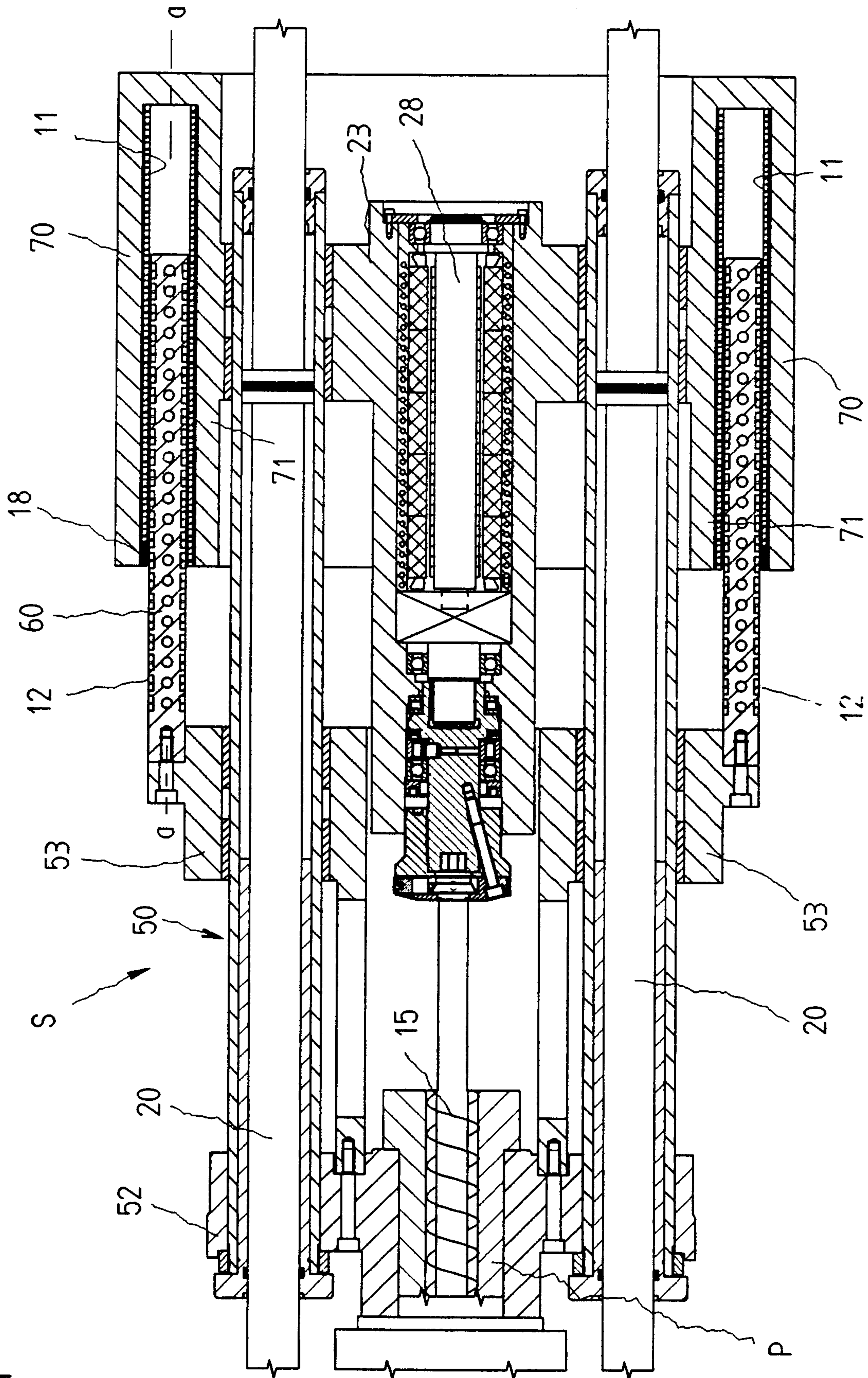


FIG. 10

FIG. 11



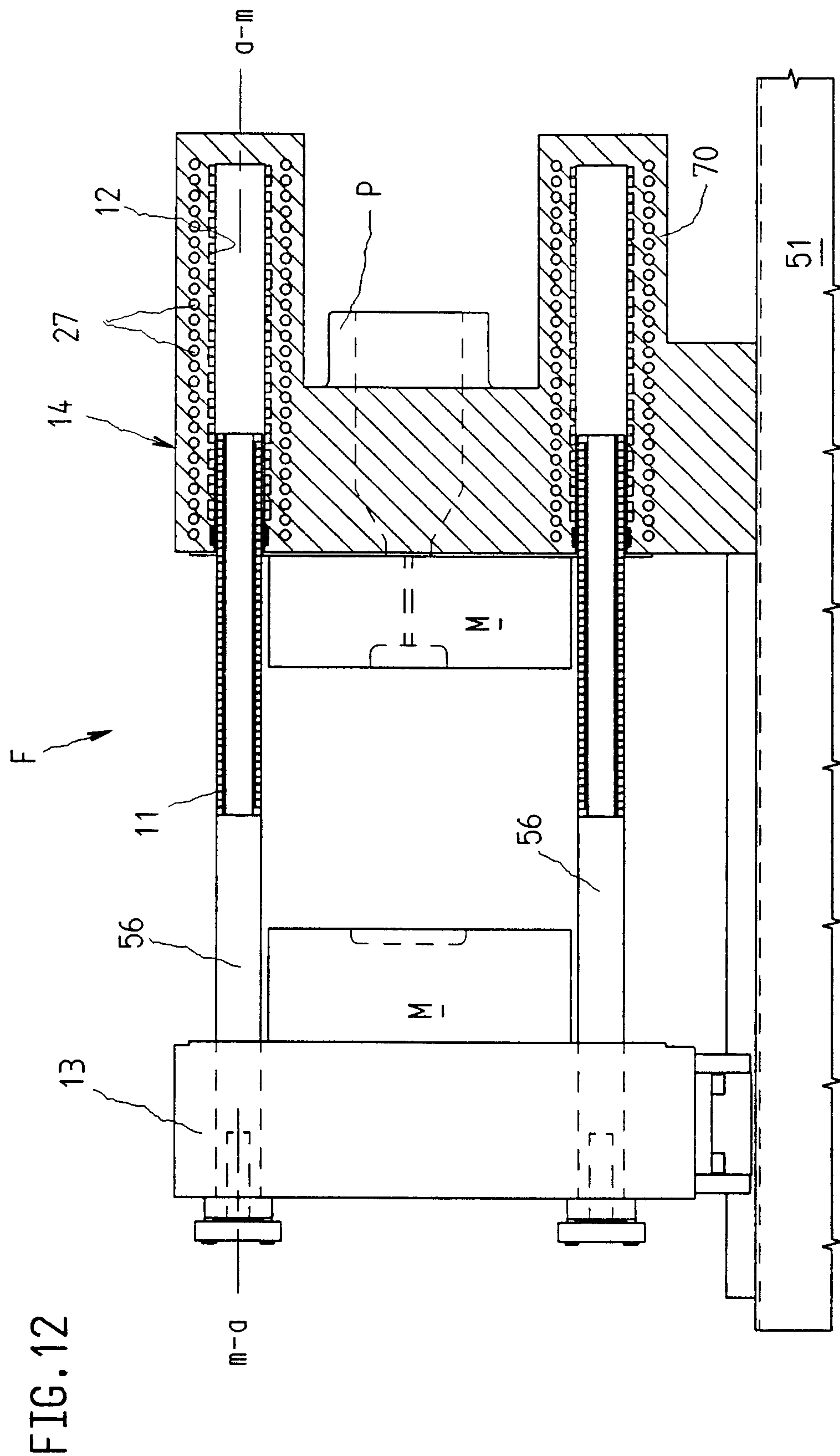


FIG. 13

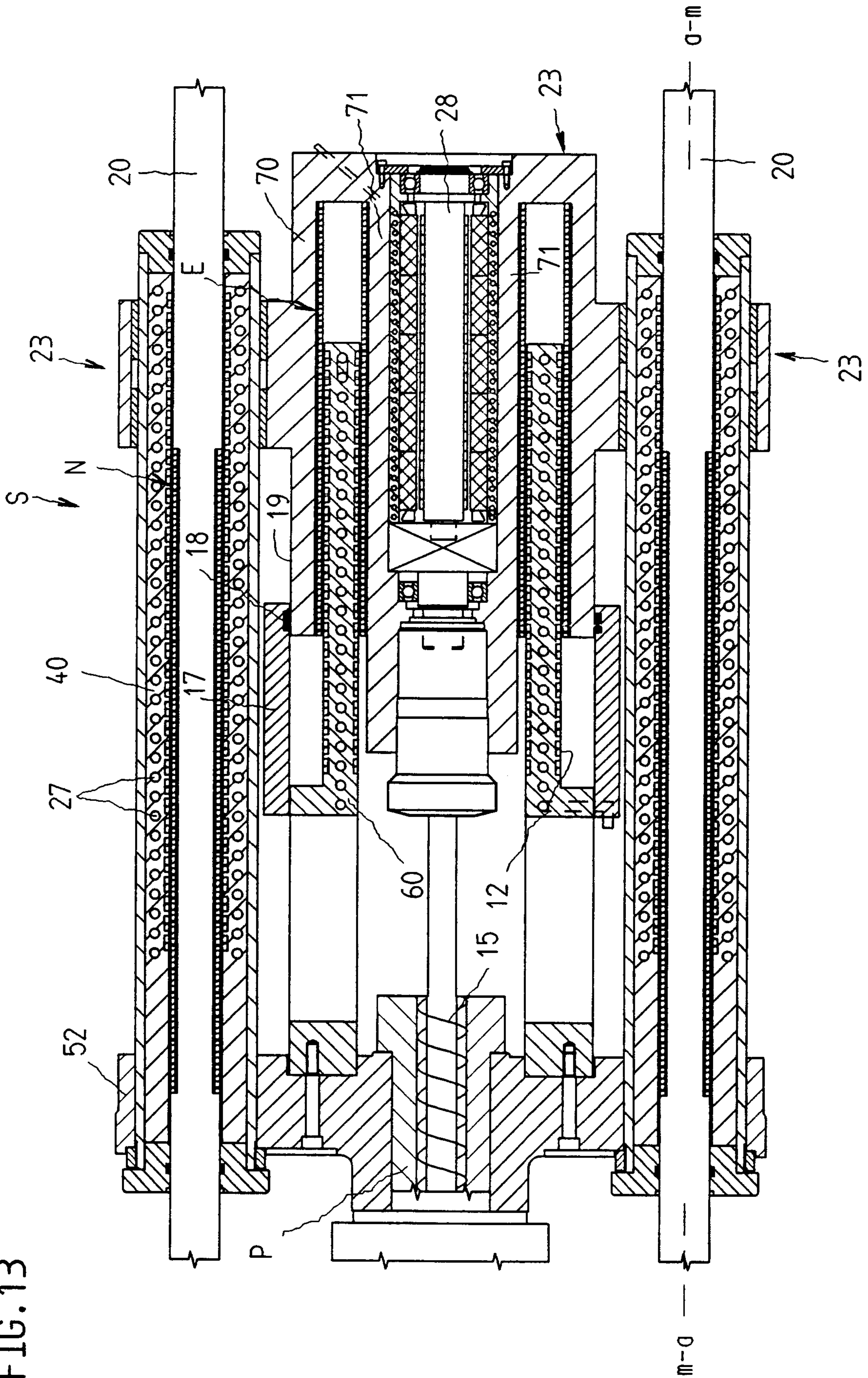
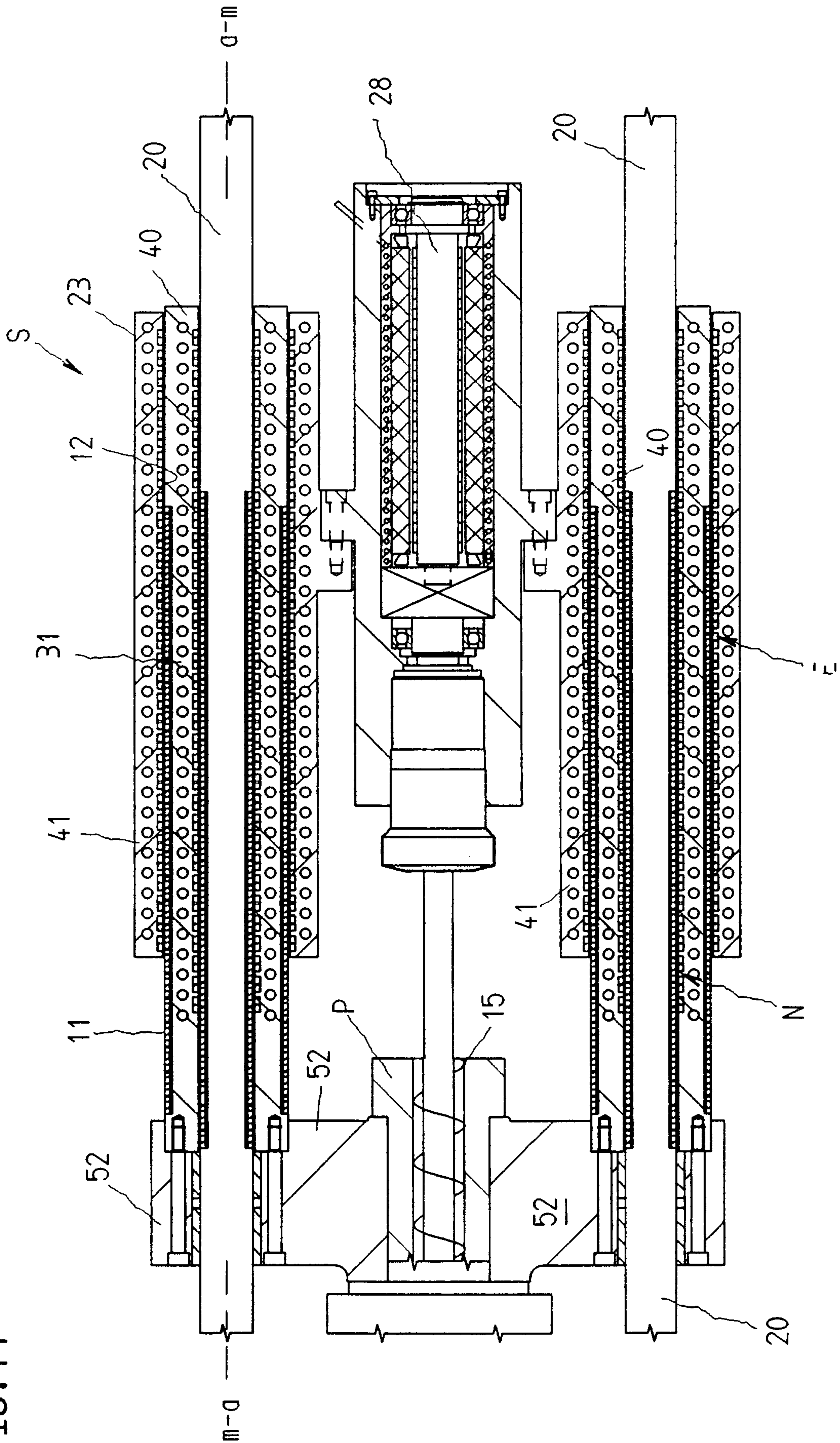


FIG. 14



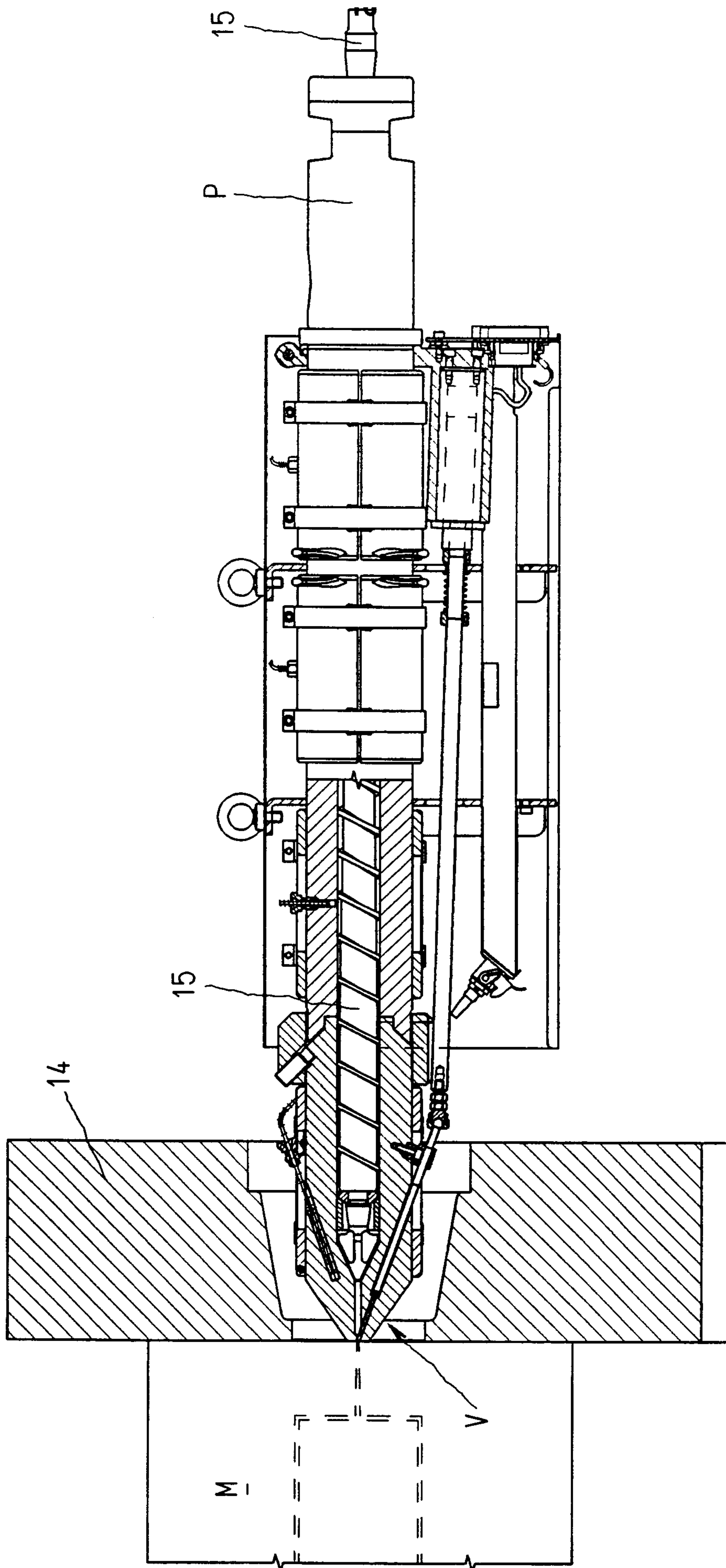


FIG. 15

