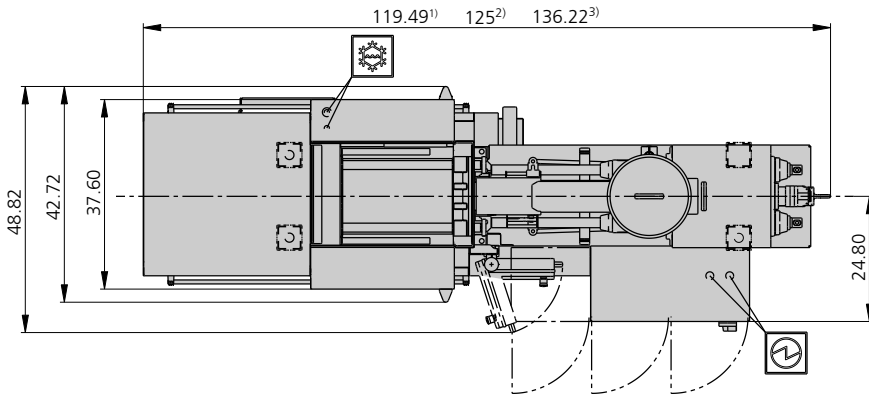
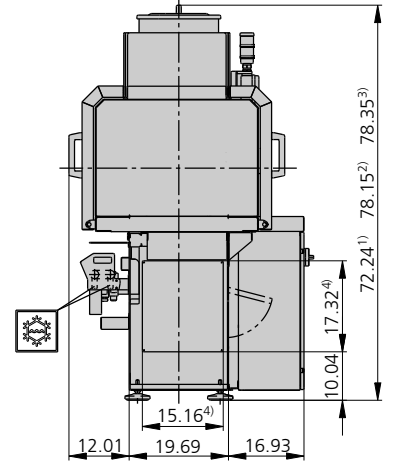
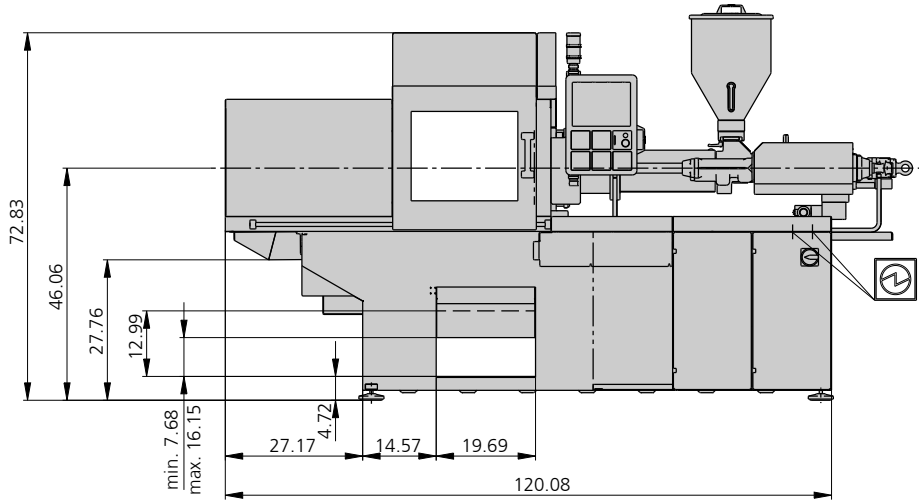


ALLROUNDER 270 S

Distance between tie bars: 10.63 x 10.63" (270 x 270 mm)
Clamping force: 28, 39, 40 tons
Injection unit: 1.4 oz, 2.3 oz, 3.7 oz

ARBURG

MACHINE DIMENSIONS | 270 S



Electrical connection



Cooling water connection

- 1) Injection unit 1.4 oz
- 2) Injection unit 2.3 oz
- 3) Injection unit 3.7 oz
- 4) Conveyor belt

TECHNICAL DATA | 270 S

Clamping unit			270 S		
with clamping force	max. tons		28	39	40
Opening force stroke	max. tons inch		9.90 13.78		
Mold height, fixed variable	min. inch		7.87 ---		
Platen daylight fixed variable	max. inch		21.65 ---		
Distance between tie bars (w x h)	inch		10.63 x 10.63		
Mold mounting platens (w x h)	max. inch		14.96 x 14.96		
Weight of movable mold half	max. lbs		297 [440]		
Ejector force stroke	max. tons inch		2.20 3.94		
Dry cycle time EUROMAP ²	1 pump	min. s - inch	2.0 - 7.44		
	2 pumps	min. s - inch	1.2 - 7.44		
	Accum.	min. s - inch	1.0 - 7.44		

Injection unit			1.4 oz			2.3 oz			3.7 oz		
with screw diameter	mm		18	22	25	20	25	30	25	30	35
Effective screw length	L/D		24.5	20	17.5	25	20	16.7	24	20	17
Screw stroke	max. inch		3.54			3.94			4.72		
Calculated stroke volume	max. cu. inch		1.4	2.1	2.7	1.9	3.0	4.3	3.6	5.2	7.0
Shot weight	max. oz / PS		0.7	1.1	1.4	1.0	1.6	2.3	1.9	2.7	3.7
Material throughput	max. lbs/h PS		9.0	12.1	14.3	12.1	17.6	20.9	22.0	29.7	35.2
	max. lbs/h PA6.6		4.6	6.2	7.3	6.2	8.8	10.8	11.0	15.4	17.6
Injection pressure	max. psi		36250	29000	22475	36250	29000	20155	36250	29000	21315
Holding pressure	max. psi		36250	29000	22475	36250	29000	20155	36250	29000	21315
Injection flow ²	1 pump	max. cu. inch/s	2.6 4.1	3.8 6.1	4.9 7.9	2.4 3.9	3.8 6.1	5.5 8.9	4.0	5.9	8.1
	2 pumps	max. cu. inch/s	2.6 4.1	3.8 6.1	4.9 7.9	2.4 3.9	3.8 6.1	5.5 8.9	4.0	5.9	8.1
	Accum.	max. cu. inch/s	8.4	12.7	16.3	10.5	16.3	23.7	13.2	19.0	25.9
Screw circumferential speed ²	1 pump	max. ft./min	79 128	98 157	112 180	56 92	72 115	85 138	115	138	161
	2 pumps	max. ft./min	79 128	98 157	112 180	56 92	72 115	85 138	115	138	161
	Accum.	max. ft./min	49	62	72	36	46	56	46	56	62
Screw torque	max. ft./lbs		66	81	89	89	111	133	155	185	214
Nozzle contact force retraction stroke	max. tons inch		5.50 5.91			5.50 7.09			5.50 8.27		
Heating capacity zones	kW		4.10 4			4.90 5			9.40 5		
Feed hopper	lbs		40			80			80		

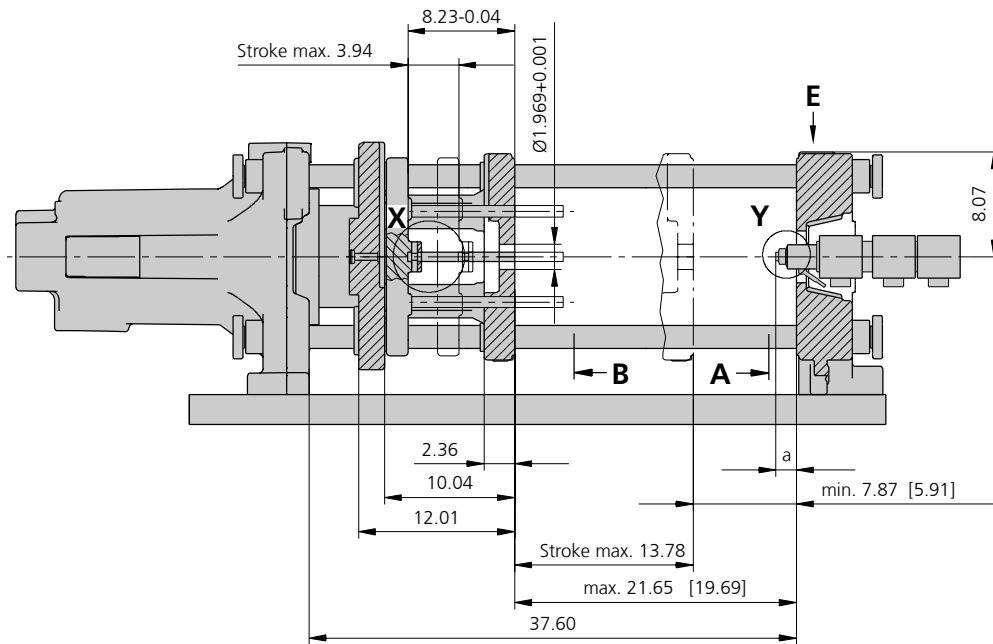
Drive and connection			1 pump			2 pumps			Accum.		
with injection unit			1.4 oz	2.3 oz	3.7 oz	1.4 oz	2.3 oz	3.7 oz	1.4 oz	2.3 oz	3.7 oz
Net weight of machine	lbs		4334	4400	4510	4334	4400	4510	---		
Sound press. level Ref. only ⁴	dB(A)		67 3			67 3			67 3		
Oil filling	gal.		33.03			33.03			33.03		
Drive power ²	max. kW		11			15			7.5		
Electrical connection ³	kW		17	18	22	21	22	26	14	15	18
	Total	A	50 ---	70 ---	80 ---	70 ---	80 ---	90 ---	50 ---	50 ---	60 ---
	Machine	A	--- 18	--- 25	--- 25	--- 30	--- 30	--- 30	--- 18	--- 18	--- 35
Heat	A	15 ---	15 ---	25 ---	15 ---	15 ---	25 ---	15 ---	15 ---	25 ---	
Cooling water connection	max. °F		77			77			86		
	min. Δp psi		22 1"			22 1"			22 1"		

Machine type		Drive
with EUROMAP size designation ¹		
270 S 28 tons 1.4 oz 2.3 oz		1 2 Accum.
270 S 39 tons 1.4 oz 2.3 oz 3.7 oz		1 2 Accum.
270 S 40 tons 1.4 oz 2.3 oz 3.7 oz		- 2 Accum.

Upon request: other machine types and mold installation heights, screws, drive powers etc.
 All specifications relate to the basic machine version. Deviations are possible depending on variants, process settings and material type. Depending on the drive, certain combinations, e.g. max. injection pressure and max. injection flow may be mutually exclusive.

1) Clamping force (tons) - size of injection unit = max. stroke volume (cu. inch) x max. injection pressure (psi)
 2) Specifications depend on the drive config. - 1st value applies to the lowest clamping force.
 3) Specifications relate to 230V/60 cycles | 460V/60 cycles.
 4) Detailed info in the operating instr.
 [] Information applies to alternative equipment.

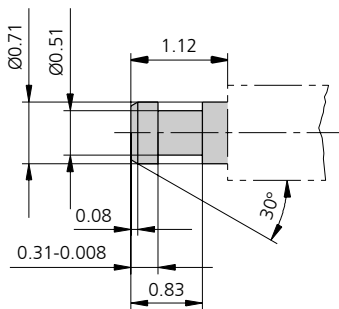
MOLD INSTALLATION DIMENSIONS | 270 S



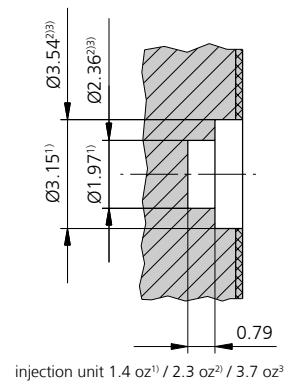
a max.	Injection unit
	1.4 oz / 2.3 oz / 3.7 oz
Standard	1.57
Thermoset	0.79

Dimensions for horizontally-displaceable injection unit (VARIO principle) reduced by 0.78 inch

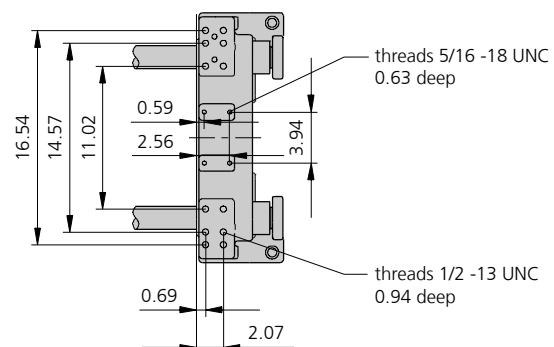
Center ejector | X



Bore in mold (if required) | Y



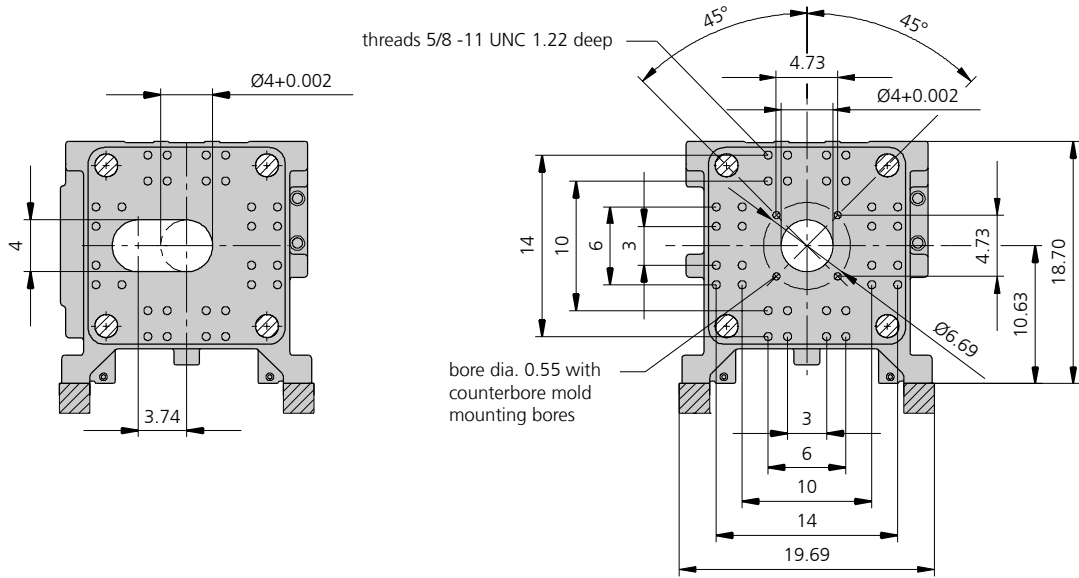
Robotic system mounting | E



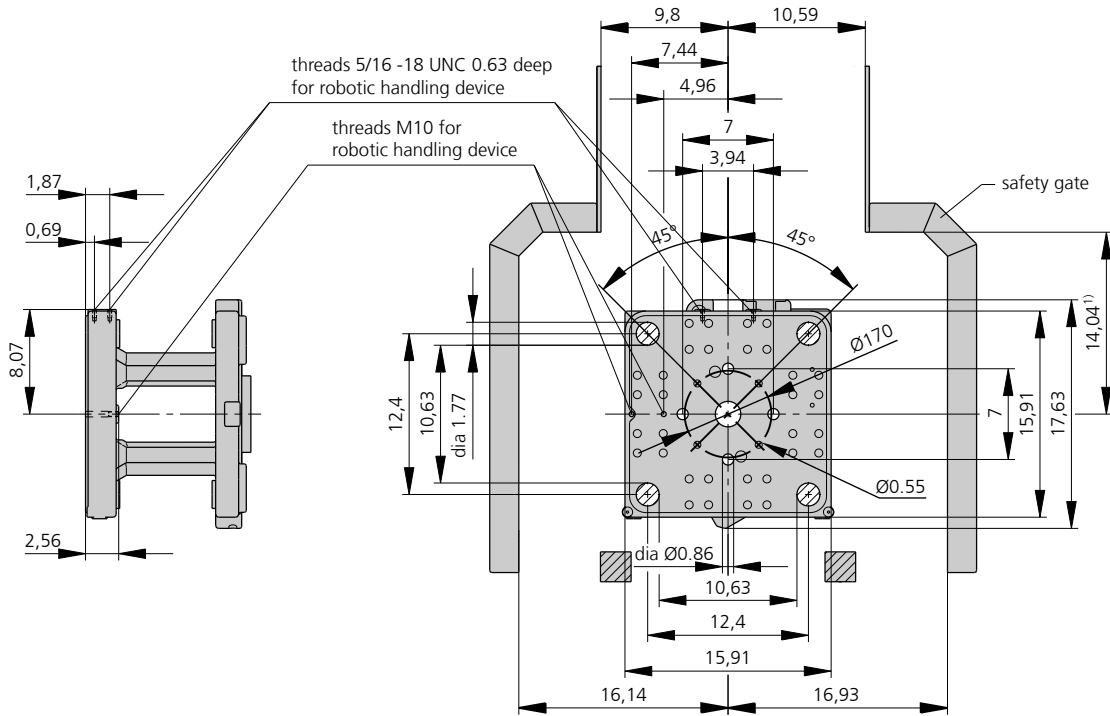
[] Specifications apply to alternative equipment

MOLD INSTALLATION DIMENSIONS | 270 S

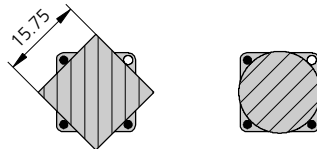
Fixed mold mounting platen | A



Moving mold mounting platen | B



Useful clamping surface when pulling the tie rods



1) Pivoting clamping unit – guard closed at the top

SHOT WEIGHTS | 270 S

Theoretical shot weights for the most important materials

Injection units		1.4 oz			2.3 oz			3.7 oz		
Screw diameter	inch	0.71	0.87	0.98	0.71	0.87	0.98	0.98	1.18	1.38
	mm	18	22	25	18	22	25	25	30	35
Polystyrene	max. oz PS	0.7	1.1	1.4	0.7	1.1	1.4	1.9	2.7	3.7
Styrene heteropolymerizates	max. oz SB	0.7	1.1	1.4	0.7	1.1	1.4	1.9	2.7	3.6
	max. oz SAN, ABS ¹⁾	0.7	1.1	1.4	0.7	1.1	1.4	1.8	2.6	3.6
Cellulose acetate	max. oz CA ¹⁾	0.8	1.2	1.6	0.8	1.2	1.6	2.1	3.1	4.2
Celluloseacetobutyrate	max. oz CAB ¹⁾	0.8	1.1	1.5	0.8	1.1	1.5	2.0	2.9	3.9
Polyethyl methacrylate	max. oz PMMA	0.8	1.1	1.5	0.8	1.1	1.5	2.0	2.8	3.8
Polyphenylene oxide, mod.	max. oz PPO	0.7	1.0	1.3	0.7	1.0	1.3	1.8	2.5	3.5
Polycarbonate	max. oz PC	0.8	1.2	1.5	0.8	1.2	1.5	2.0	2.9	3.9
Polysulphone	max. oz PSU	0.8	1.2	1.6	0.8	1.2	1.6	2.1	3.0	4.0
Polyamides	max. oz PA 6.6 PA 6 ¹⁾	0.7	1.1	1.4	0.7	1.1	1.4	1.9	2.7	3.7
	max. oz PA 6.10 PA 11 ¹⁾	0.7	1.0	1.3	0.7	1.0	1.3	1.7	2.5	3.4
Polyoximethylene (Polyacetal)	max. oz POM	0.9	1.4	1.8	0.9	1.4	1.8	2.3	3.4	4.6
Polyethylene terephthalate	max. oz PET	0.9	1.3	1.7	0.9	1.3	1.7	2.3	3.3	4.4
Polyethylene	max. oz PE-LD	0.6	0.8	1.1	0.6	0.8	1.1	1.4	2.1	2.8
	max. oz PE-HD	0.6	0.9	1.1	0.6	0.9	1.1	1.5	2.1	2.9
Polypropylene	max. oz PP	0.6	0.9	1.1	0.6	0.9	1.1	1.5	2.2	3.0
Fluoropolymerides	max. oz FEP, PFA, PCTFE ¹⁾	1.2	1.8	2.3	1.2	1.8	2.3	3.0	4.4	6.0
	max. oz ETFE	1.0	1.5	2.0	1.0	1.5	2.0	2.7	3.8	5.2
Polyvinyl chloride	max. oz PVC-U	0.9	1.3	1.7	0.9	1.3	1.7	2.3	3.3	4.5
	max. oz PVC-P ¹⁾	0.8	1.2	1.6	0.8	1.2	1.6	2.1	3.1	4.2

1) average value

ARBURG GmbH + Co KG
 Arthur-Hehl-Strasse
 72290 Lossburg
 Tel.: +49 7446 33-0
 www.arburg.com
 contact@arburg.com