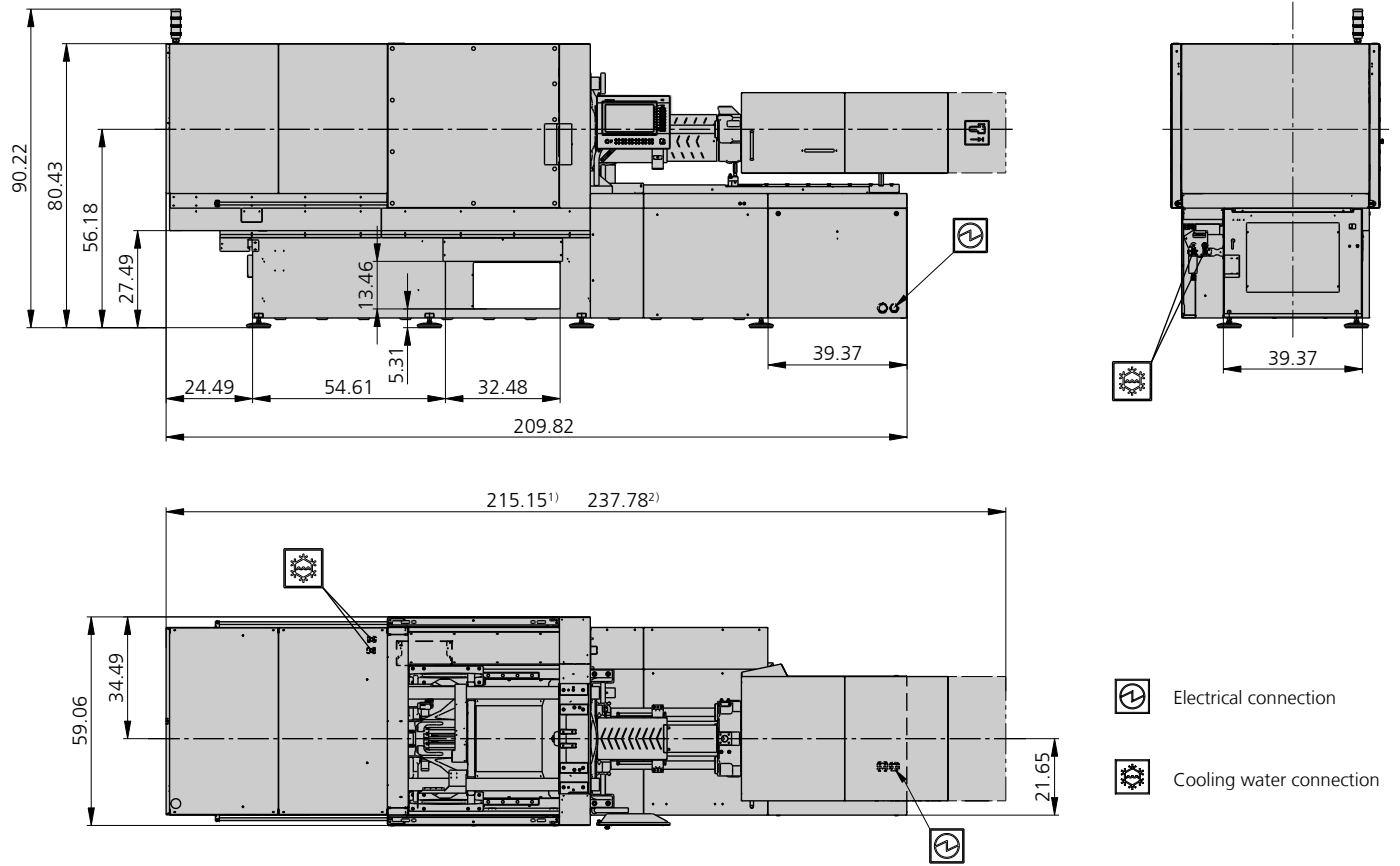


ALLROUNDER 1800 e TREND

Distance between tie bars: 22.44 x 22.44" (570 x 570 mm)
Clamping force: 200 tons
Injection unit: 8.2 oz, 15.3 oz

ARBURG

MACHINE DIMENSIONS | 1800 e TREND



1) Injection unit 8.2 oz
 2) Injection unit 15.3 oz

TECHNICAL DATA | 1800 e TREND

Clamping unit		1800 e TREND
with clamping force	max. tons	200 [220]
Opening force stroke	max. tons inch	--- 19.69
Mold height, fixed variable	min.-max. inch	--- 7.87-23.62
Platen daylight fixed variable	max. inch	--- 27.56-43.31
Distance between tie bars (w x h)	inch	22.44 x 22.44
Mold mounting platens (w x h)	max. inch	31.30 x 31.30
Weight of movable mold half	max. lbs	2860
Ejector force stroke	max. tons inch	6.60 7.87
Dry cycle time EUROMAP ²	min. s - inch	1.9 - 15.71

Injection unit [EUROMAP designation]		8.2 oz [400 e]			15.3 oz [800 e]		
with screw diameter	mm	35	40	45	45	50	55
Effective screw length	L/D	23	20	18	22	20	18
Screw stroke	max. inch	6.30			7.87		
Calculated stroke volume	max. cu. inch	9.4	12.3	15.5	19.4	23.9	28.9
Shot weight	max. oz / PS	5.0	6.5	8.2	10.3	12.7	15.3
Material throughput	max. lbs/h PS	55.0	63.8	77.0	101.2	116.6	129.8
	max. lbs/h PA6.6	27.5	33.0	38.5	50.6	59.4	66.0
Injection pressure	max. psi	36250	29000	22910	35815	29000	23925
Holding pressure time ⁶	max. s - psi	45-30305	43-23200	45-18270	45-28565	45-23200	45-19140
Injection flow ²	max. cu. inch/s	11.8	15.4	19.5	19.4	24.0	29.0
Injection flow ⁷	max. cu. inch/s	[20.5]	[26.8]	[33.9]	[29.2]	[36.0]	[43.6]
Injection flow ⁷	max. cu. inch/s	---	---	---	---	---	---
Injection speed ⁵	max. inch/s	7.9			7.9		
Injection speed ⁸	max. inch/s	[13.8]			[11.8]		
Screw circumferential speed	max. ft./min	85 [174]	98 [197]	112 [223]	89 [177]	98 [197]	108 [217]
Screw torque	max. ft./lbs	354	406	450	664	738	812
Nozzle contact force retraction stroke	max. tons inch	4.40 [6.60] 11.81			5.50 [7.70] 15.75		
Heating capacity zones	kW	9.7 5			19.9 8		

Drive and connection		8.2 oz	15.3 oz
with injection unit			
Net weight of machine	lbs	13750	15180
Sound press. level Ref. only ⁴	dB(A)	58 3	
Electrical connection ³	kW	30 [32]	49 [50]
Total	A	--- ---	
	Machine	--- 50 [70]	
	Heat	30 ---	60 ---
Cooling water connection	max. °F	95	
	min. Δp psi	22 1"	

Machine type (according to EUROMAP) ¹

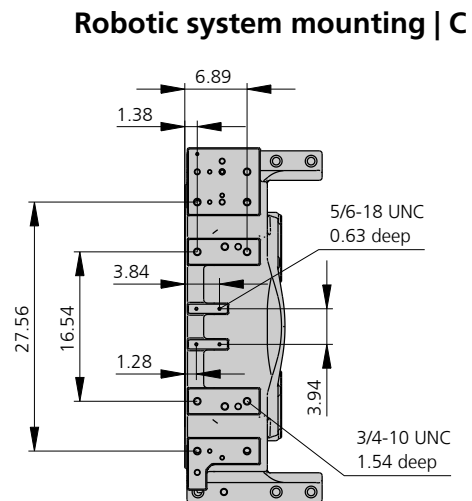
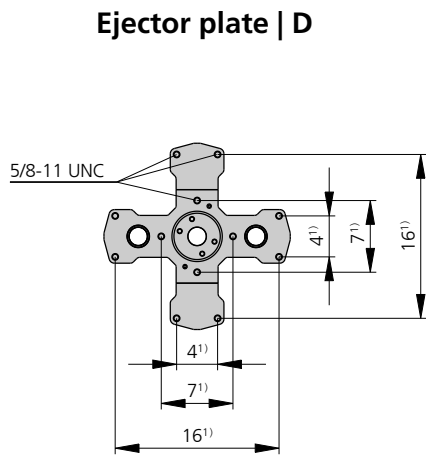
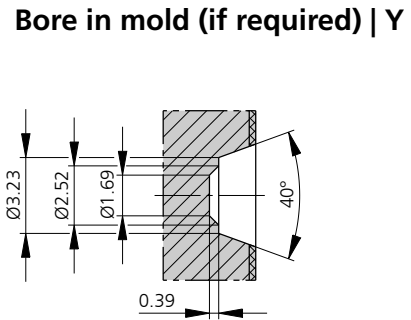
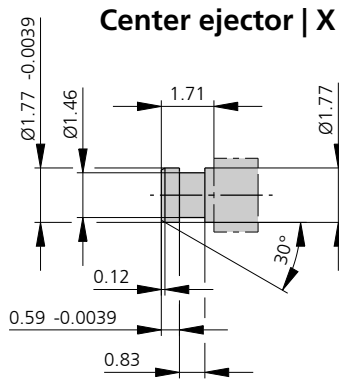
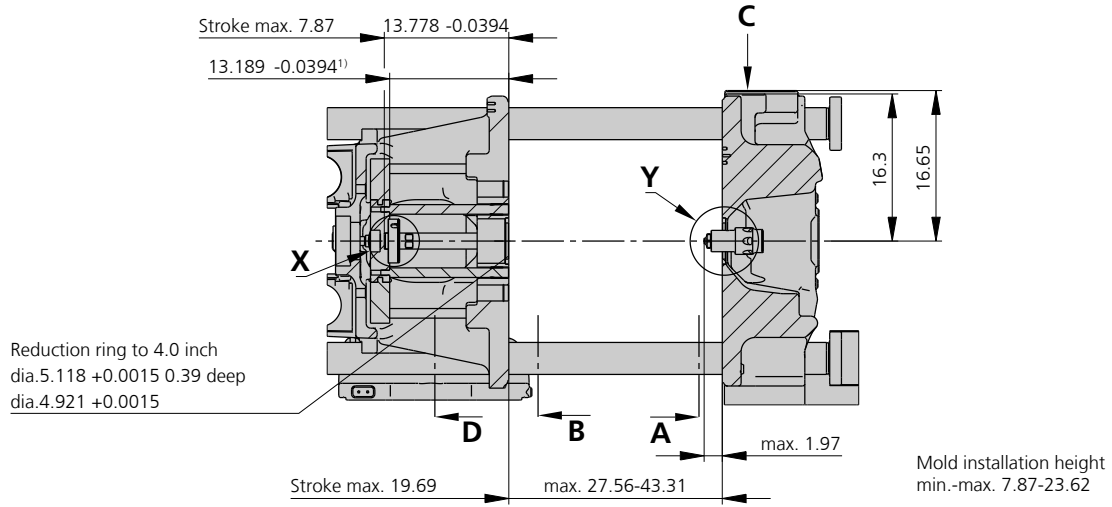
ALLROUNDER 1800 e TREND 400 e | 800 e

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 (kN) - Size injection unit = max. stroke volume (cm³) x max. injection pressure (kbar)
 - 2) Specification of maximum injection flow at 1000 bar injection pressure
 - 3) Specifications relate to 230V/60 cycles | 460V/60 cycles
 - 4) Emission sound pressure level at the workplace. Detailed information in the operating instructions
 - 5) Forward speed of plasticizing screw at 1000 bar injection pressure
 - 6) Holding pressure duration may differ at 500 mm/s injection speed
 - 7) Specification of maximum injection flow at 2000 bar injection pressure
 - 8) Forward speed of plasticizing screw at 2000 bar injection pressure
- [] Information applies to alternative equipment

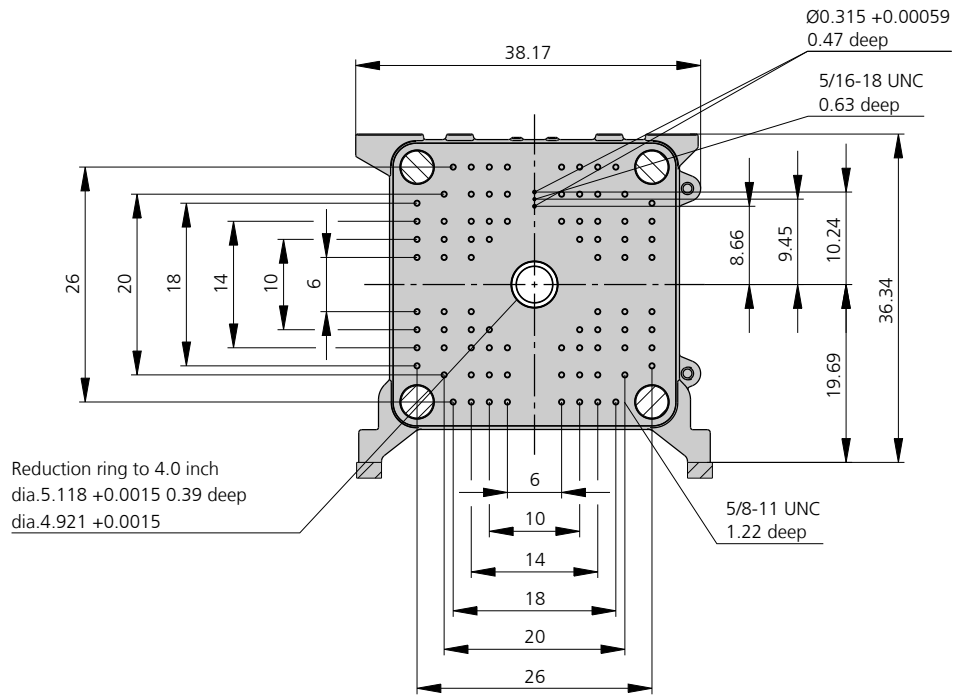
MOLD INSTALLATION DIMENSIONS | 1800 e TREND



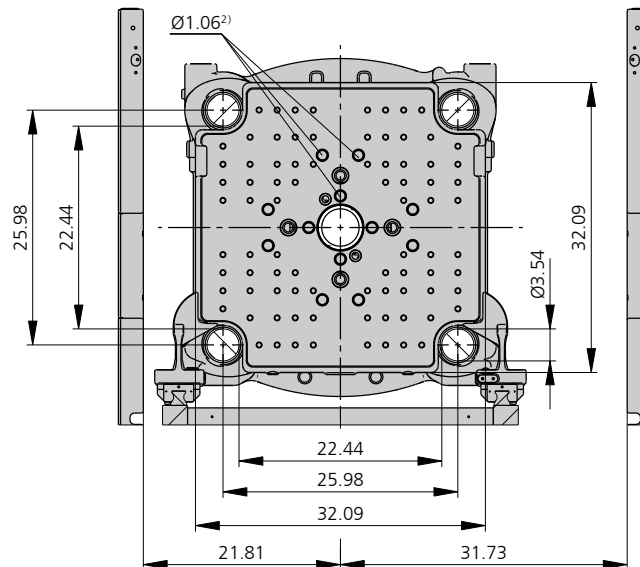
1) Positions of ejector plate

MOLD INSTALLATION DIMENSIONS | 1800 e TREND

Fixed mold mounting platen | A



Moving mold mounting platen | B



2) Guide

SHOT WEIGHTS | 1800 e TREND

Theoretical shot weights for the most important materials

Injection units		8.2 oz			15.3 oz		
Screw diameter	inch	1.38	1.57	1.77	1.77	1.97	2.17
	mm	35	40	45	45	50	55
Polystyrene	max. oz PS	5.0	6.5	8.2	10.3	12.7	15.3
Styrene heteropolymerizates	max. oz SB	4.8	6.3	8.0	10.0	12.3	15.0
	max. oz SAN, ABS ¹⁾	4.8	6.2	7.9	9.8	12.1	14.7
Cellulose acetate	max. oz CA ¹⁾	5.6	7.3	9.2	11.5	14.3	17.2
Celluloseacetobutyrate	max. oz CAB ¹⁾	5.2	6.8	8.6	10.7	13.2	16.0
Polyethyl methacrylate	max. oz PMMA	5.1	6.7	8.5	10.6	13.1	15.8
Polyphenylene oxide, mod.	max. oz PPO	4.6	6.0	7.6	9.5	11.7	14.2
Polycarbonate	max. oz PC	5.2	6.8	8.6	10.8	13.3	16.1
Polysulphone	max. oz PSU	5.4	7.0	8.9	11.1	13.8	16.6
Polyamides	max. oz PA 6.6 PA 6 ¹⁾	4.9	6.5	8.2	10.2	12.6	15.2
	max. oz PA 6.10 PA 11 ¹⁾	4.6	6.0	7.6	9.5	11.7	14.2
Polyoximethylene (Polyacetal)	max. oz POM	6.1	8.0	10.1	12.7	15.6	18.9
Polyethylene terephthalate	max. oz PET	5.9	7.7	9.8	12.2	15.1	18.2
Polyethylene	max. oz PE-LD	3.7	4.9	6.2	7.7	9.6	11.6
	max. oz PE-HD	3.9	5.0	6.4	8.0	9.9	12.0
Polypropylene	max. oz PP	4.0	5.2	6.5	8.2	10.1	12.2
Fluoropolymerides	max. oz FEP, PFA, PCTFE ¹⁾	7.9	10.4	13.1	16.4	20.2	24.5
	max. oz ETFE	6.9	9.0	11.4	14.3	17.7	21.4
Polyvinyl chloride	max. oz PVC-U	6.0	7.8	9.9	12.4	15.3	18.5
	max. oz PVC-P ¹⁾	5.5	7.2	9.2	11.4	14.1	17.1

1) average value

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