

ALLROUNDER 470 A

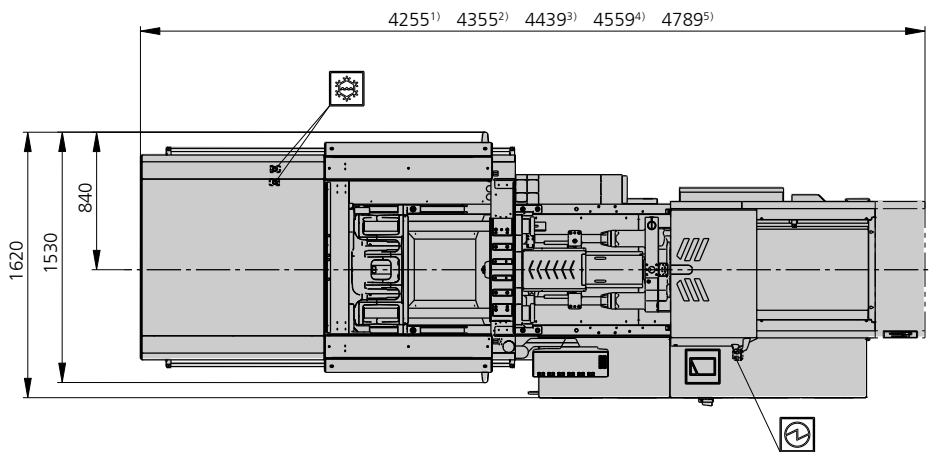
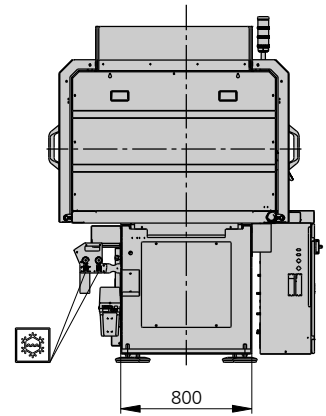
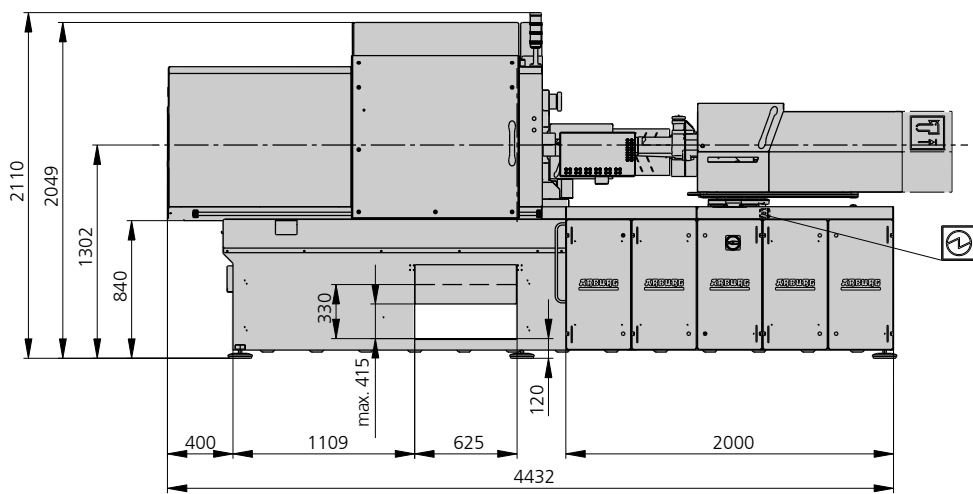
Distance between tie bars: 470 x 470 mm

Clamping force: 1000 kN

Injection unit (acc. to EUROMAP): 170, 290, 400

ARBURG

MACHINE DIMENSIONS | 470 A



Electrical connection



Cooling water connection

- 1) Injection unit 170 Comfort
- 2) Injection unit 170 Premium/Ultimate
- 3) Injection unit 290 Comfort
- 4) Injection unit 290 Premium/Ultimate
- 5) Injection unit 400

TECHNICAL DATA | 470 A

Clamping unit			470 A
with clamping force	max. kN		1000
Opening force stroke	max. kN mm		--- 350
Mould height, fixed variable	min.-max. mm		--- 250-500
Platen daylight fixed variable	max. mm		--- 600-850
Distance between tie bars (w x h)	mm		470 x 470
Mould mounting platens (w x h)	max. mm		637 x 637
Weight of movable mould half	max. kg		760
Ejector force stroke	max. kN mm		40 175
Dry cycle time EUROMAP	Comfort	min. s - mm	1,4 - 329
	Premium	min. s - mm	1,2 - 329
	Ultimate	min. s - mm	0,9 - 329

Injection unit			170			290			400		
with screw diameter	mm		25	30	35	30	35	40	35	40	45
Effective screw length	L/D		24	20	17	23,3	20	17,5	23	20	18
Screw stroke	max. mm		120			150			160		
Calculated stroke volume	max. cm ³		59	85	115	106	144	188	154	201	254
Shot weight	max. g PS		54	77	105	97	132	172	141	184	232
Material throughput	max. kg/h PS		10	13,5	16	17	20,5	24,5	25	29	35
	max. kg/h PA6.6		5	7	8	8,5	10,5	12,5	12,5	15	17,5
Injection pressure	max. bar		2500	2000	1470	2500	2000	1530	2500	2000	1580
Holding pressure time	max. s - bar		300-2310	300-1600	300-1170	300-2180	300-1600	300-1220	300-2090	300-1600	300-1260
Injection flow ²	Comfort [+]	max. cm ³ /s	79 [104]	114 [150]	155 [203]	105 [140]	144 [191]	188 [250]	125 [163]	163 [213]	207 [271]
	Premium	max. cm ³ /s	104	150	203	140	191	250	163	213	271
	Ultimate [+]	max. cm ³ /s	148 [197]	214 [285]	290 [387]	212 [283]	288 [384]	376 [501]	241 [313]	314 [408]	398 [517]
Injection speed ⁵	Comfort [+]	max. mm/s	215 [280]			215 [280]			190 [240]		
	Premium	max. mm/s	280			280			240		
	Ultimate [+]	max. mm/s	350 [400]			350 [400]			300 [325]		
Screw circumferential speed	max. m/min		50	60	70	51	60	69	53	60	68
Screw torque	max. Nm		210	250	290	320	380	430	480	550	610
Nozzle contact force retraction stroke	max. kN mm		50 300			50 300			60 300		
Heating capacity zones	kW		9 5			7,7 5			9,7 5		
Feed hopper	l		50			50			50		

Drive and connection			Comfort			Premium			Ultimate		
with injection unit			170	290	400	170	290	400	170	290	400
Net weight of machine	kg		5220	5280	5400	5220	5280	5400	5220	5280	5400
Sound press. level Insecurity ⁴	dB(A)		63 3			63 3			63 3		
Electrical connection ³		kW	21	22	27	26	26	32	26	26	32
	Total	A	63	63	80	80	80	80	80	80	80
	Machine	A	---			---			---		
	Heating	A	---			---			---		
Cooling water connection	max. °C		30			30			30		
	min. Δp bar		1,5 DN 25			1,5 DN 25			1,5 DN 25		

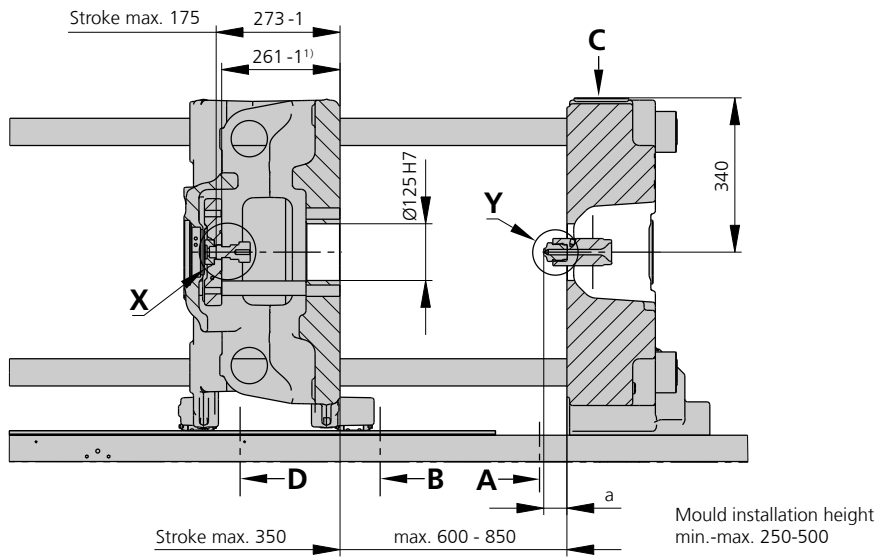
Machine type
with EUROMAP size designation ¹
470 A 1000-170 | 290 | 400

Upon request: other machine types and mould 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.

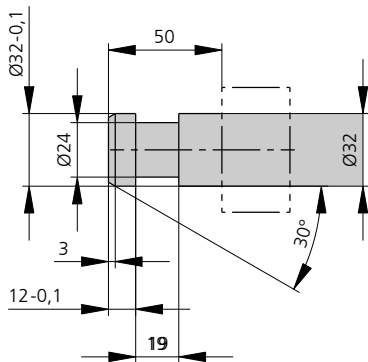
- 1) Clamping force (kN) - size of injection unit = max. stroke volume (cm³) x max. injection pressure (kbar)
 - 2) Specification of maximum injection flow at maximum injection pressure.
 - 3) Specifications relate to 400 V/50 Hz.
 - 4) Emission sound pressure level at the workplace. Detailed information in the operating instructions.
 - 5) Forward speed of plasticising screw at 1000 bar injection pressure.
- [] Specifications apply to alternative equipment.

MOULD INSTALLATION DIMENSIONS | 470 A

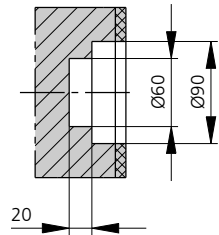


a max.	Injection unit	
	170 / 290	400
Standard	40	50
Thermoset	20	50

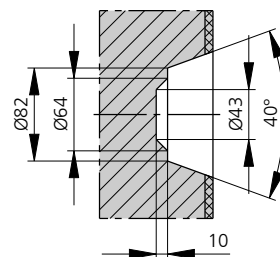
Ejector bolt | X



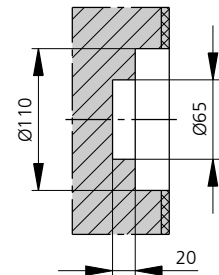
Bore in mould (if required) | Y



Injection unit 170 / 290

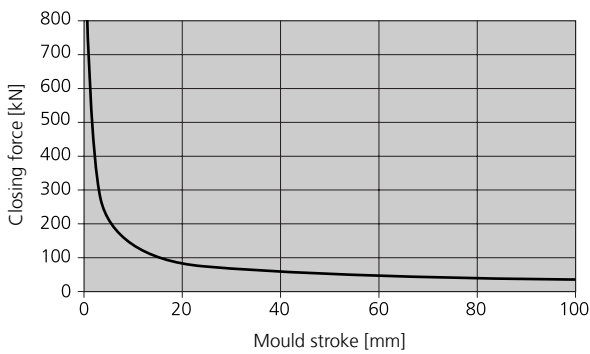


Injection unit 400



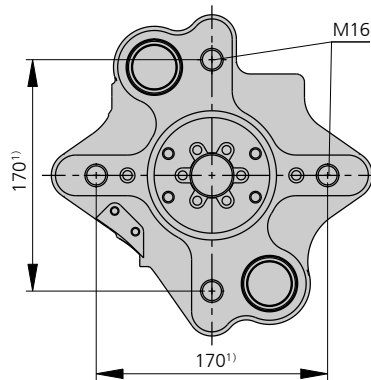
Injection unit 400
Thermoset version

Closing force for spring moulds / during injection compression moulding*

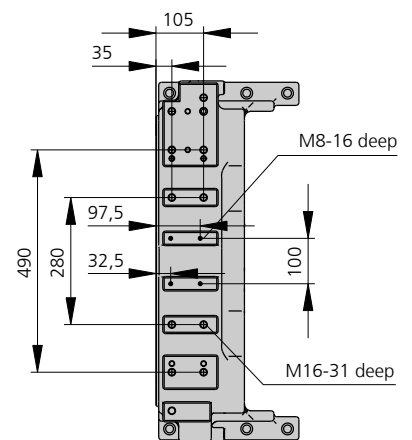


* automatic locking force adjustment up to 20 kN

Ejector plate | D



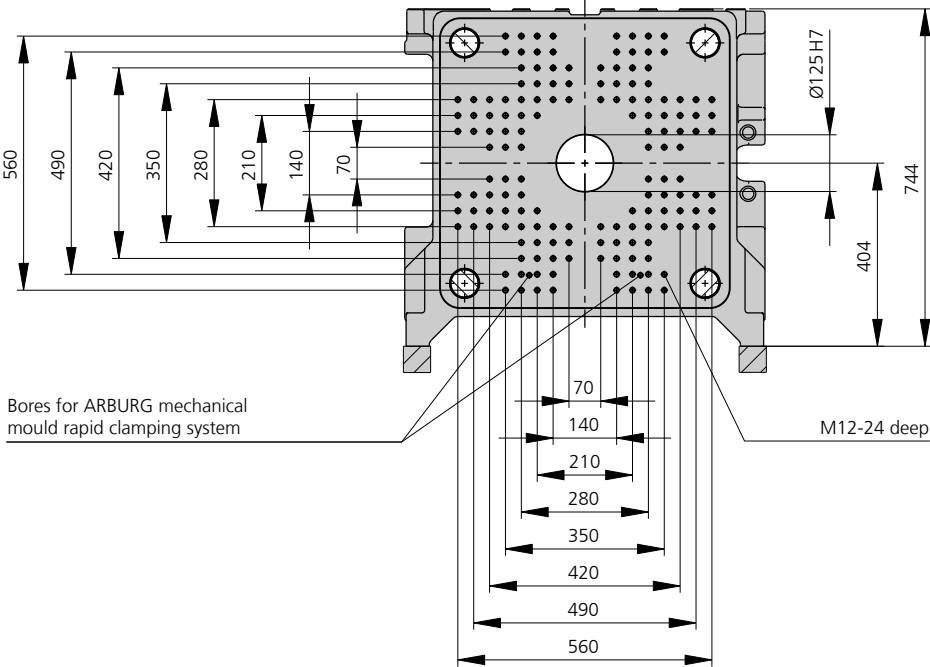
Robotic system mounting | E



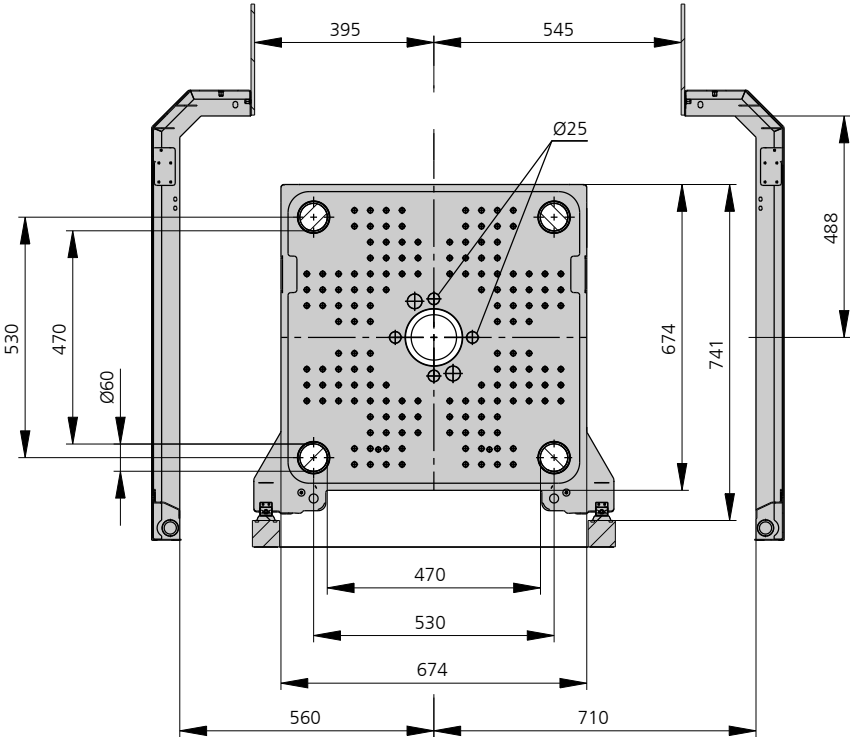
1) Positions of ejector plate

MOULD INSTALLATION DIMENSIONS | 470 A

Fixed mould mounting platen | A



Moving mould mounting platen | B



SHOT WEIGHTS | 470 A

Theoretical shot weights for the most important injection moulding materials

Injection units according to EUROMAP		170			290			400		
Screw diameter	mm	25	30	35	30	35	40	35	40	45
Polystyrene	max. g PS	54	77	105	97	132	172	141	184	232
Styrene heteropolymerizates	max. g SB	53	76	103	95	129	168	137	179	227
	max. g SAN, ABS ¹⁾	52	74	101	93	126	165	135	176	223
Cellulose acetate	max. g CA ¹⁾	61	87	119	109	148	194	158	207	262
Celluloseacetobutyrate	max. g CAB ¹⁾	56	81	110	101	138	180	147	192	243
Polymethyl methacrylate	max. g PMMA	56	80	109	100	136	178	145	190	240
Polyphenylene ether, mod.	max. g PPE	50	72	98	90	122	160	131	171	216
Polycarbonate	max. g PC	57	81	111	102	139	181	148	193	244
Polysulphone	max. g PSU	58	84	115	105	143	187	153	199	252
Polyamides	max. g PA 6.6 PA 6 ¹⁾	53	77	104	96	131	171	140	183	231
	max. g PA 6.10 PA 11 ¹⁾	50	72	98	90	122	160	131	171	216
Polyoximethylene (Polyacetal)	max. g POM	66	96	130	120	163	213	174	227	287
Polyethylene terephthalate	max. g PET	64	92	126	115	157	205	167	219	277
Polyethylene	max. g PE-LD	41	59	80	73	100	130	106	139	176
	max. g PE-HD	42	60	82	76	103	134	110	143	181
Polypropylene	max. g PP	43	62	84	77	105	137	112	146	185
Fluoropolymerides	max. g FEP, PFA, PCTFE ¹⁾	86	124	169	155	211	276	225	294	372
	max. g ETFE	76	109	148	136	185	242	196	256	324
Polyvinyl chloride	max. g PVC-U	65	94	127	117	159	208	170	222	281
	max. g PVC-P ¹⁾	60	87	118	108	147	192	157	205	260

1) average value

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