

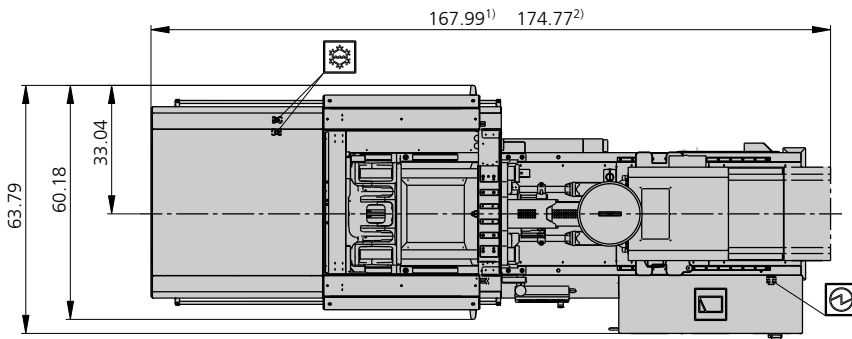
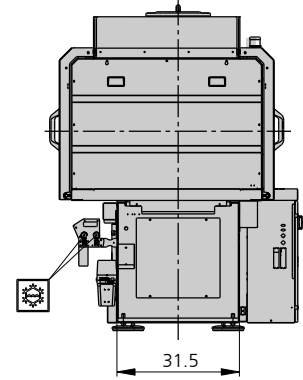
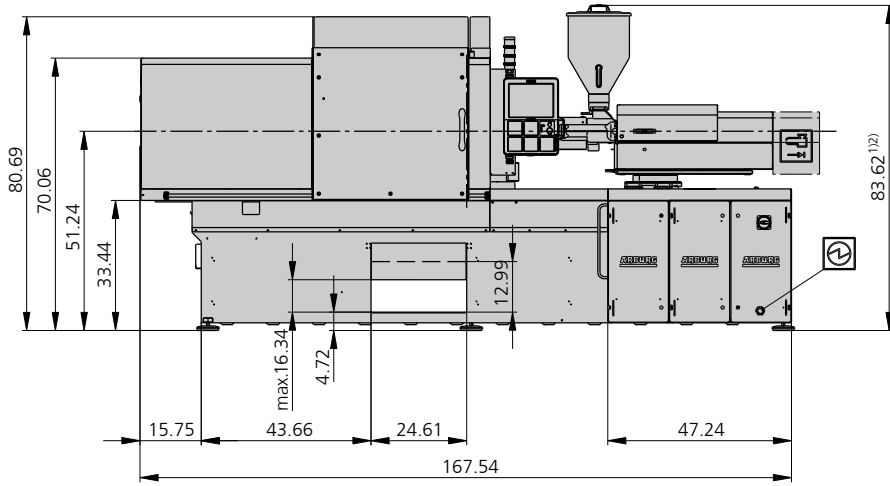
ALLROUNDER 470 E

GOLDEN ELECTRIC

Distance between tie bars: 18.50 x 18.50 (470 x 470 mm)
Clamping force: 110 tons
Injection unit: 3.7 oz, 6.1 oz

ARBURG

MACHINE DIMENSIONS | 470 E GOLDEN ELECTRIC



Electrical connection



Cooling water connection

1) Injection unit 3.7 oz
2) Injection unit 6.1 oz

TECHNICAL DATA | 470 E GOLDEN ELECTRIC

Clamping unit		470 E GOLDEN ELECTRIC	
with clamping force	max. tons	110	
Opening force stroke	max. tons inch	--- 13.78	
Mold height, fixed variable	min.-max. inch	--- 9.84-19.69	
Platen daylight fixed variable	max. inch	--- 23.62-33.46	
Distance between tie bars (w x h)	inch	18.50 x 18.50	
Mold mounting platens (w x h)	max. inch	25.08 x 25.08	
Weight of movable mold half	max. lbs	1672	
Ejector force stroke	max. tons inch	4.40 6.89	
Dry cycle time EUROMAP ²	min. s - inch	1.4 - 12.95	

Injection unit		3.7 oz			6.1 oz		
with screw diameter	mm	25	30	35	30	35	40
Effective screw length	L/D	24	20	17	23.3	20	17.5
Screw stroke	max. inch	4.72			5.91		
Calculated stroke volume	max. cu. inch	3.6	5.2	7.0	6.5	8.8	11.5
Shot weight	max. oz / PS	1.9	2.7	3.7	3.4	4.7	6.1
Material throughput	max. lbs/h PS	22.0	29.7	35.2	37.4	45.1	53.9
	max. lbs/h PA6.6	11.0	15.4	17.6	18.7	23.1	27.5
Injection pressure	max. psi	36250	29000	21315	36250	29000	22185
Holding pressure time	max. s - psi	300-33350	300-23200	300-16965	300-31610	300-23200	300-17690
Injection flow ²	max. cu. inch/s	4.8	7.0	9.4	6.0	8.2	10.7
	max. cu. inch/s	[7,8]	[10,7]	[14,0]	[7,8]	[10,7]	[14,0]
Injection speed ⁵	max. inch/s	6.3			5.5		
	max. inch/s	[8.27]			[7.09]		
Screw circumferential speed	max. ft./min	102	121	144	92	108	121
Screw torque	max. ft./lbs	155	185	214	236	281	317
Nozzle contact force retraction stroke	max. tons inch	5.50 11.81			5.50 11.81		
Heating capacity zones	kW	9.40 5			6.40 5		
Feed hopper	lbs	80			80		

Drive and connection		3.7 oz		6.1 oz	
with injection unit					
Net weight of machine	lbs	10780		11000	
Sound press. level Ref. only ⁴	dB(A)	55		3	
Electrical connection ³	kW	21		21	
	Total	A		---	
	Machine	A		--- 35	
Cooling water connection	Heat	A		30 ---	
	max. °F	95		22 1"	
	min. Δp psi	22		1"	

Machine type

with EUROMAP size designation ¹

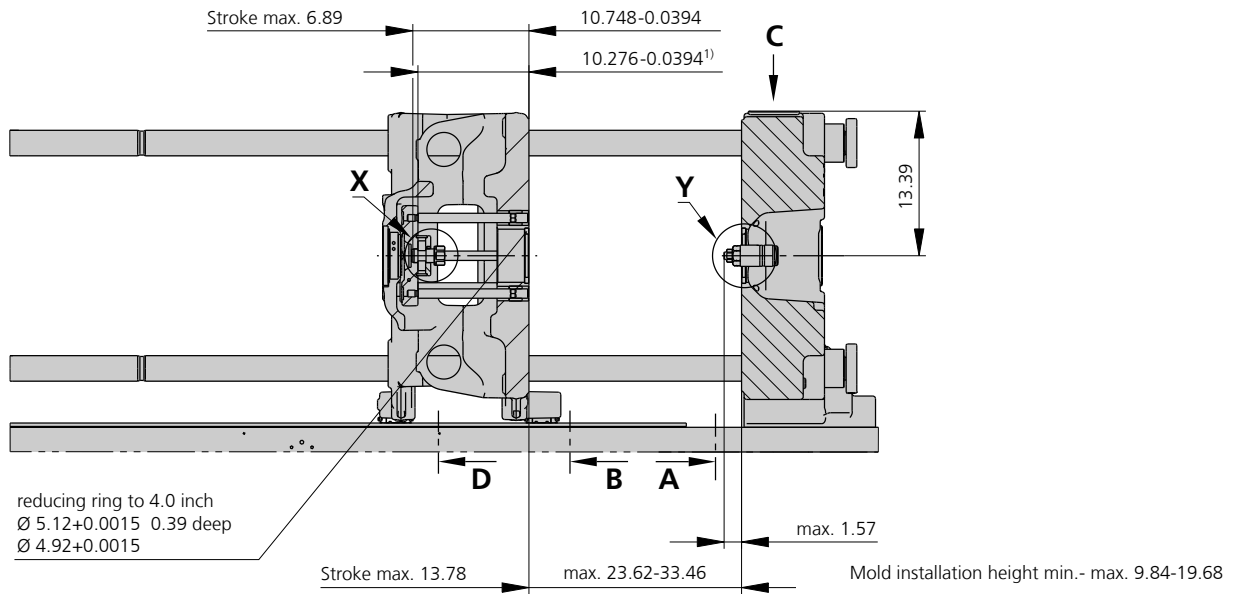
470 E GOLDEN ELECTRIC 110 tons 3.7 | 6.1 oz

Upon request: other machine types and mold installation heights, screws, drive powers etc.

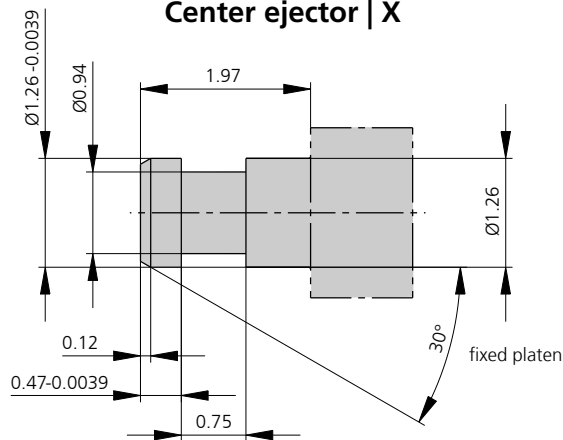
All specifications relate to the basic machine version. Deviations are possible depending on variants, process settings and material type. Depending on the drive, certain combinations, e.g. max. injection pressure and max. injection flow may be mutually exclusive.

- 1) Clamping force (tons) - Size of injection unit = max. stroke volume (cu. inch) x max. injection pressure (psi)
 - 2) Specification of maximum injection flow at maximum injection pressure.
 - 3) Specifications relate to 230V/60 cycles | 460V/60 cycles.
 - 4) Detailed info in the operating instr.
 - 5) Forward speed of plasticizing screw at 1,000 bar injection pressure.
- [] Information applies to alternative equipment.

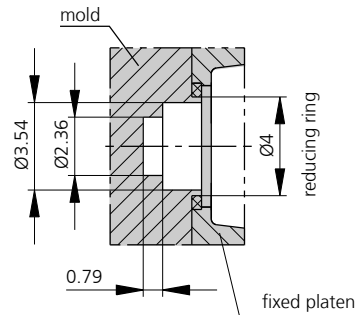
MOLD INSTALLATION DIMENSIONS | 470 E GOLDEN ELECTRIC



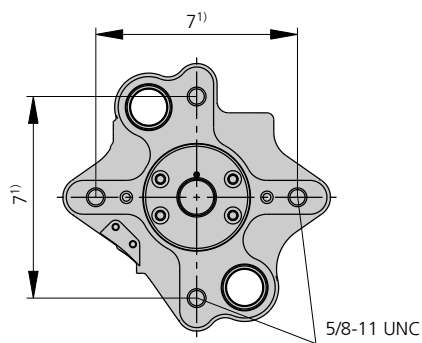
Center ejector | X



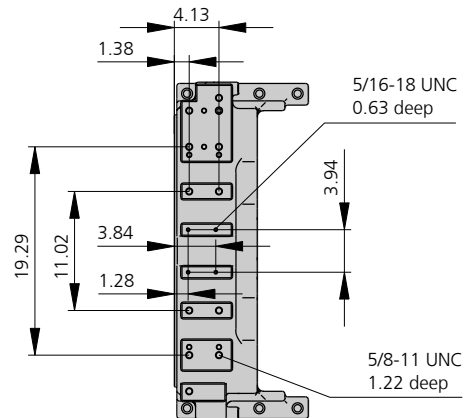
Bore in mold (if required) | Y



Ejector plate | D



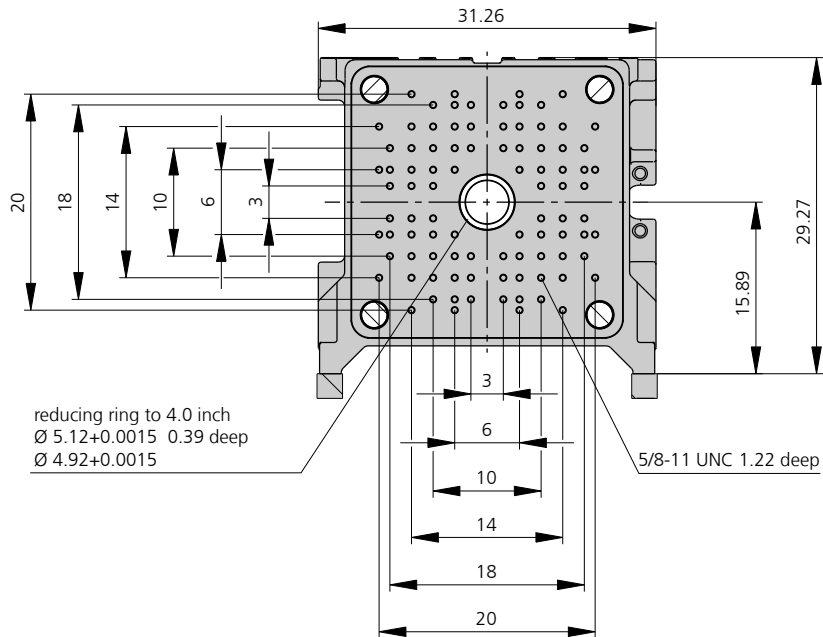
Robotic system mounting | C



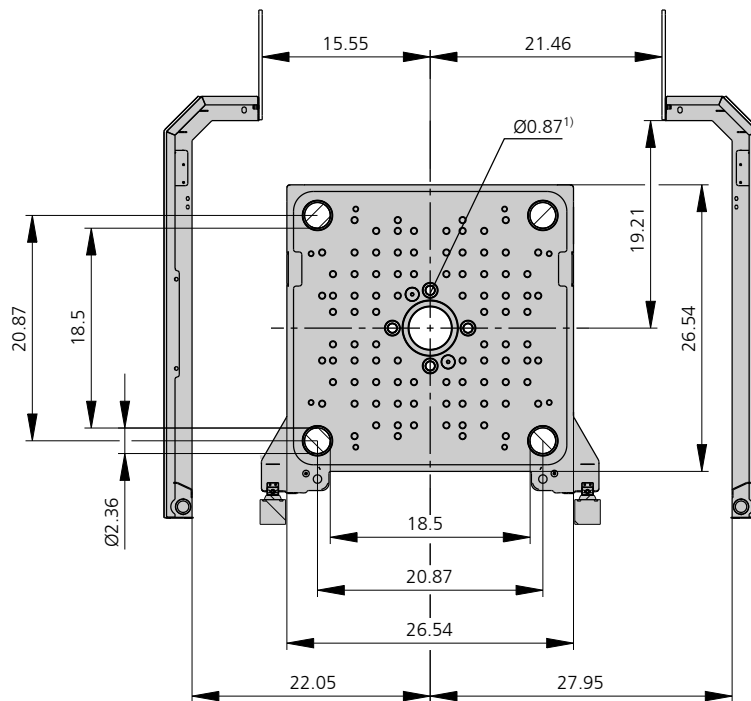
1) Positions of ejector plate

MOLD INSTALLATION DIMENSIONS | 470 E GOLDEN ELECTRIC

Fixed mold mounting platen | A



Moving mold mounting platen | B



1) Guide

SHOT WEIGHTS | 470 E GOLDEN ELECTRIC

Theoretical shot weights for the most important materials

Injection units		3.7 oz			6.1 oz			
Screw diameter	inch	0.98	1.18	1.38	1.18	1.38	1.57	
	mm	25	30	35	30	35	40	
Polystyrene	max. oz PS	1.9	2.7	3.7	3.4	4.6	6.1	
Styrene heteropolymerizates	max. oz SB	1.9	2.7	3.6	3.3	4.6	5.9	
	max. oz SAN, ABS ¹⁾	1.8	2.6	3.6	3.2	4.4	5.8	
Cellulose acetate	max. oz CA ¹⁾	2.1	3.1	4.2	3.8	5.2	6.8	
Celluloseacetobutyrate	max. oz CAB ¹⁾	2.0	2.9	3.9	3.6	4.9	6.4	
Polyethyl methacrylate	max. oz PMMA	2.0	2.8	3.8	3.5	4.8	6.3	
Polyphenylene oxide, mod.	max. oz PPO	1.8	2.5	3.5	3.2	4.3	5.6	
Polycarbonate	max. oz PC	2.0	2.9	3.9	3.6	4.9	6.4	
Polysulphone	max. oz PSU	2.1	3.0	4.0	3.7	5.0	6.6	
Polyamides	max. oz PA 6.6 PA 6 ¹⁾	1.9	2.7	3.7	3.4	4.6	6.0	
	max. oz PA 6.10 PA 11 ¹⁾	1.7	2.5	3.4	3.2	4.3	5.6	
Polyoximethylene (Polyacetal)	max. oz POM	2.3	3.4	4.6	4.2	5.8	7.5	
Polyethylene terephthalate	max. oz PET	2.3	3.3	4.4	4.1	5.5	7.2	
Polyethylene	max. oz PE-LD	1.4	2.1	2.8	2.6	3.5	4.6	
	max. oz PE-HD	1.5	2.1	2.9	2.7	3.6	4.7	
Polypropylene	max. oz PP	1.5	2.2	3.0	2.7	3.7	4.8	
Fluoropolymerides	max. oz FEP, PFA, PCTFE ¹⁾	3.0	4.4	6.0	5.5	7.4	9.7	
	max. oz ETFE	2.7	3.8	5.2	4.8	6.5	8.5	
Polyvinyl chloride	max. oz PVC-U	2.3	3.3	4.5	4.1	5.6	7.3	
	max. oz PVC-P ¹⁾	2.1	3.1	4.2	3.8	5.2	6.8	

1) average value

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