

ALLROUNDER 720 A

Clamp-Design

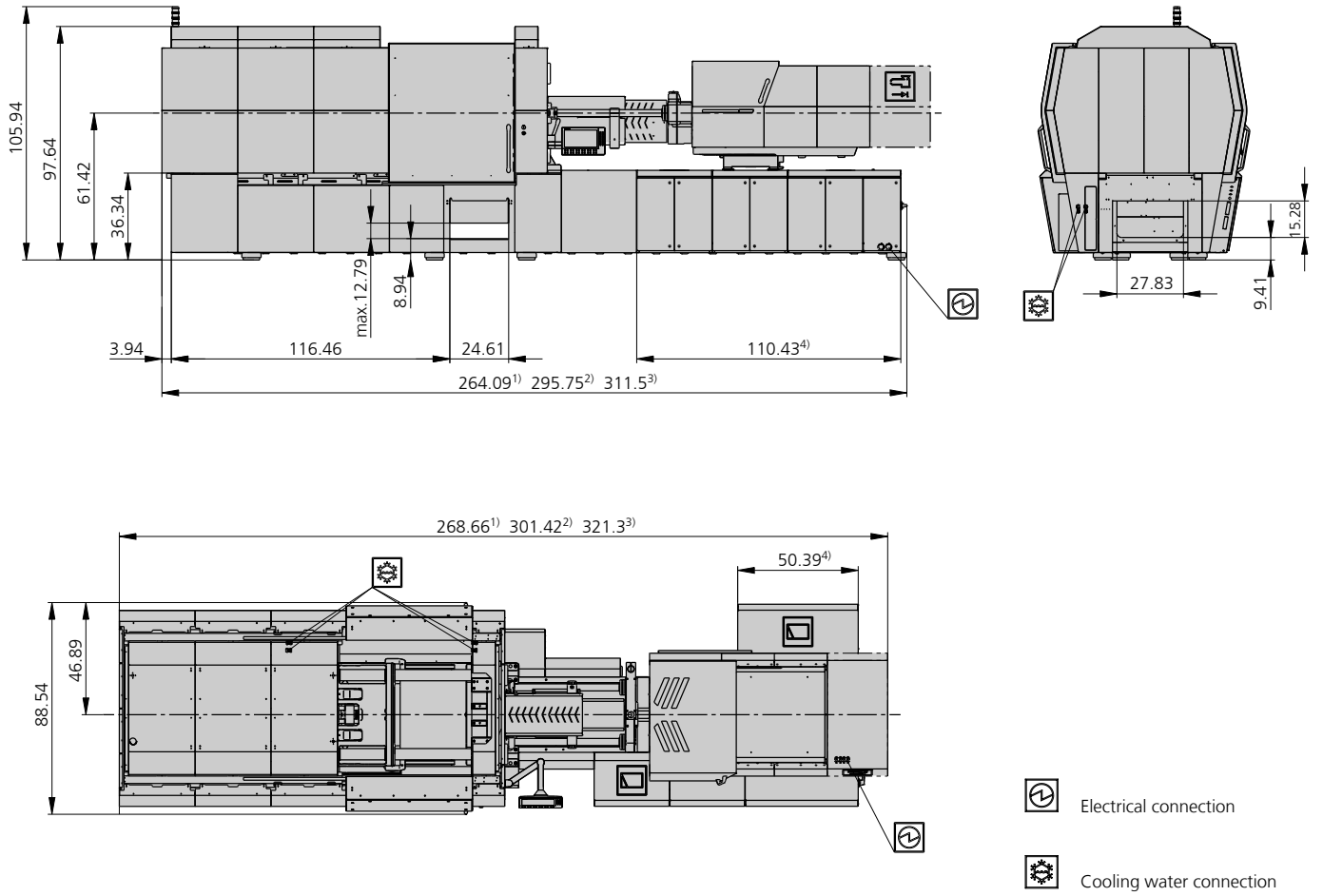
Distance between tie bars: 28.35 x 28.35" (720 x 720 mm)

Clamping force: 355 tons

Injection unit: 15.3 oz, 29.8 oz, 45.4 oz

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MACHINE DIMENSIONS | 720 A



- 1) Injection unit 15.3 oz
- 2) Injection unit 29.8 oz
- 3) Injection unit 45.4 oz
- 4) Depending on drive power and injection unit

TECHNICAL DATA | 720 A

Clamping unit			720 A		
with clamping force	max. tons		355		
Opening force stroke	max. tons inch		--- 23.62		
Mold height, fixed variable	min.-max. inch		--- 11.81-31.5		
Platen daylight fixed variable	max. inch		--- 35.43-55.12		
Distance between tie bars (w x h)	inch		28.35 x 28.35		
Mold mounting platens (w x h)	max. inch		40.94 x 40.94		
Weight of movable mold half	max. lbs		6380		
Ejector force stroke	max. tons inch		9.46 9.84		
Dry cycle time EUROMAP	Comfort	min. s - inch	2.3 - 19.84		
	Ultimate	min. s - inch	1.5 - 19.84		

Injection unit			15.3 oz			29.8 oz			45.4 oz		
with screw diameter	mm		45	50	55	55	60	70	60	70	80
Effective screw length	L/D		22	20	18	22	20	17	23	20	17.5
Screw stroke	max. inch		7.87			9.45			11.02		
Calculated stroke volume	max. cu. inch		19.4	23.9	28.9	34.8	41.4	56.3	48.3	65.8	85.8
Shot weight	max. oz / PS		10.3	12.7	15.3	18.4	21.9	29.8	25.5	34.7	45.4
Material throughput	max. lbs/h PS		101.2	116.6	129.8	189.2	211.2	253.0	275.0	319.0	385.0
	max. lbs/h PA6.6		50.6	59.4	66.0	94.6	105.6	127.6	136.4	162.8	193.6
Injection pressure	max. psi		35815	29000	23925	34510	29000	21315	36250	29000	22185
Holding pressure time	max. s - psi		300-28710	300-23200	300-19140	300-27550	300-23200	300-16965	300-31610	300-23200	300-17690
Injection flow ²	Comfort [+]	max. cu. inch/s	10.7 [14.6]	13.2 [18]	15.9 [21.7]	15.9 [21.7]	19 [25.9]	25.8 [35.2]	20.7 [27.6]	28.2 [37.6]	36.8 [49]
	Ultimate [+]	max. cu. inch/s	19.4 [29.1]	24 [36.1]	29 [43.6]	29.0	34.5	47.1	43.1 [56.1]	58.7 [76.3]	76.7 [99.7]
Injection speed ⁵	Comfort [+]	max. inch/s	5.91 [7.87]			4.33 [5.91]			4.72 [6.3]		
	Ultimate [+]	max. inch/s	9.45 [11.81]			7.87			9.84 [12.8]		
Screw circumferential speed	max. ft./min		177	197	217	180	197	230	167	196.86	226
Screw torque	max. ft./lbs		664	738	812	1115	1211	1417	1580	1846	2104
Nozzle contact force retraction stroke	max. tons inch		7.70 15.75			9.90 19.69			12.10 23.62		
Heating capacity zones	kW		19.90 8			22.90 8			31.20 8		
Feed hopper	lbs		---			---			---		

Drive and connection			Comfort			Ultimate		
with injection unit			15.3 oz	29.8 oz	45.4 oz	15.3 oz	29.8 oz	45.4 oz
Net weight of machine	lbs		35090	38170	41910	36190	39270	43010
Sound press. level Ref. only ⁴	dB(A)		60 3			60 3		
Electrical connection ³	kW		52	68	93	58	74	98
	Total	A	---			---		
	Machine	A	--- 70	--- 80	--- 110	--- 70	--- 80	--- 100
Cooling water connection	Heat	A	60 ---	70 ---	80 ---	60 ---	70 ---	80 ---
	max. °F		86			86		
	min. Δp psi		22 1"			22 1"		

Machine type

with EUROMAP size designation ¹

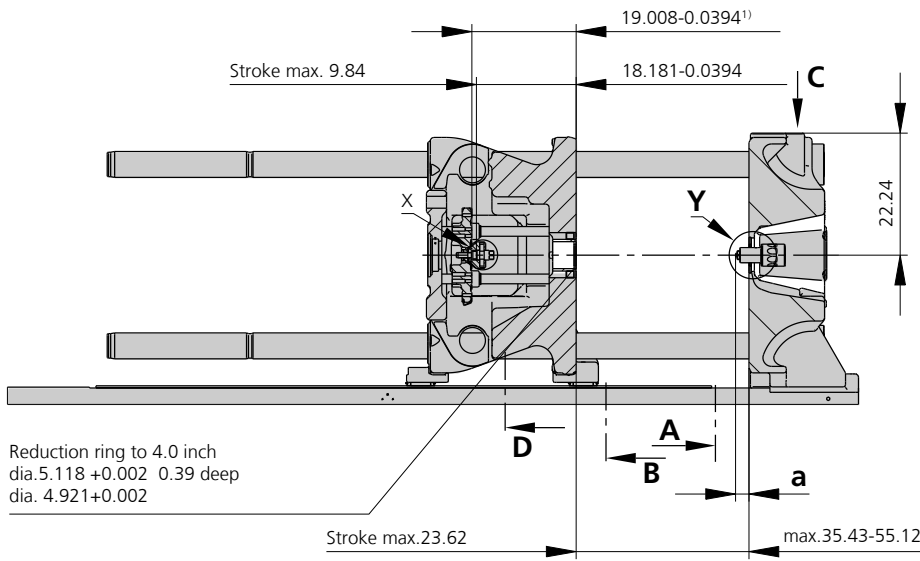
720 A 355 tons 15.3 oz | 29.8 oz | 45.4 oz

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) Emission sound pressure level at the workplace. Detailed information in the operating instructions.
 - 5) Forward speed of plasticizing screw at 1,000 bar injection pressure.
- [] Specifications apply to alternative equipment.

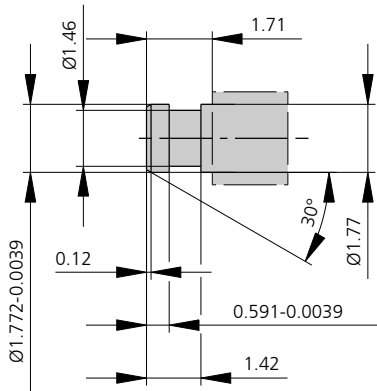
MOLD INSTALLATION DIMENSIONS | 720 A



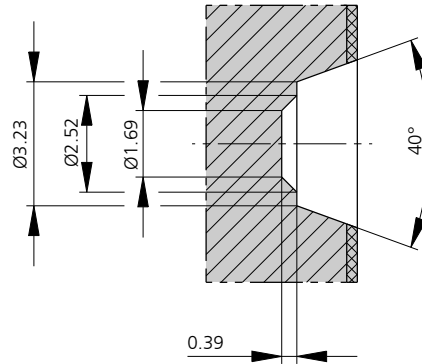
a max.	Injection unit	
		15.3 oz
	1.97	2.36

Mold installation height min.-max.11.81-31.5

Center ejector | X

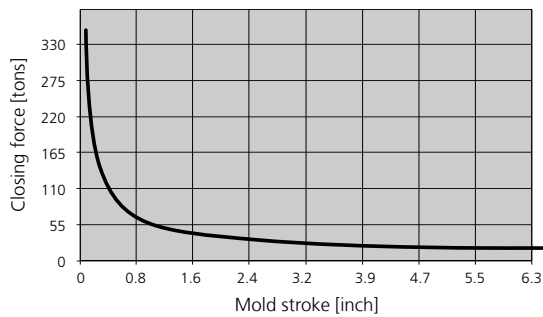


Bore in mold (if required) | Y



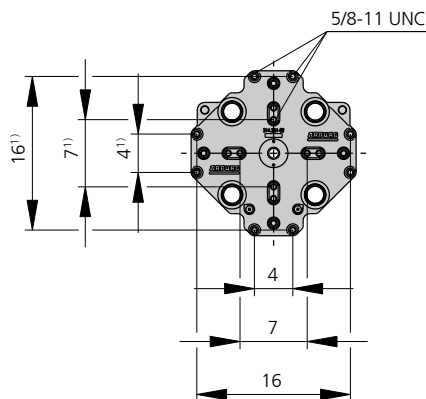
Injection unit 15.3 oz¹⁾ and 29.8 oz²⁾
Thermoset execution -
Injection unit 45.4 oz on request

Closing force for spring molds / during injection compression molding*

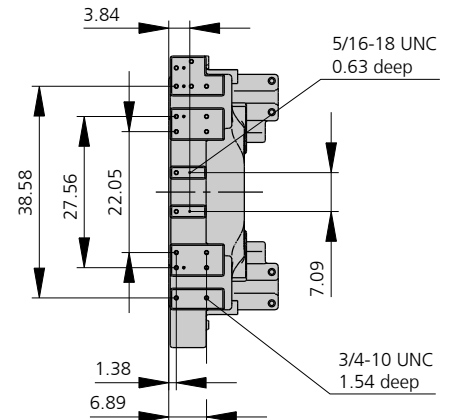


1) Positions ejector plate
Reinforced mold mounting platens optionally available (see performance variant 3)

Ejector plate | D

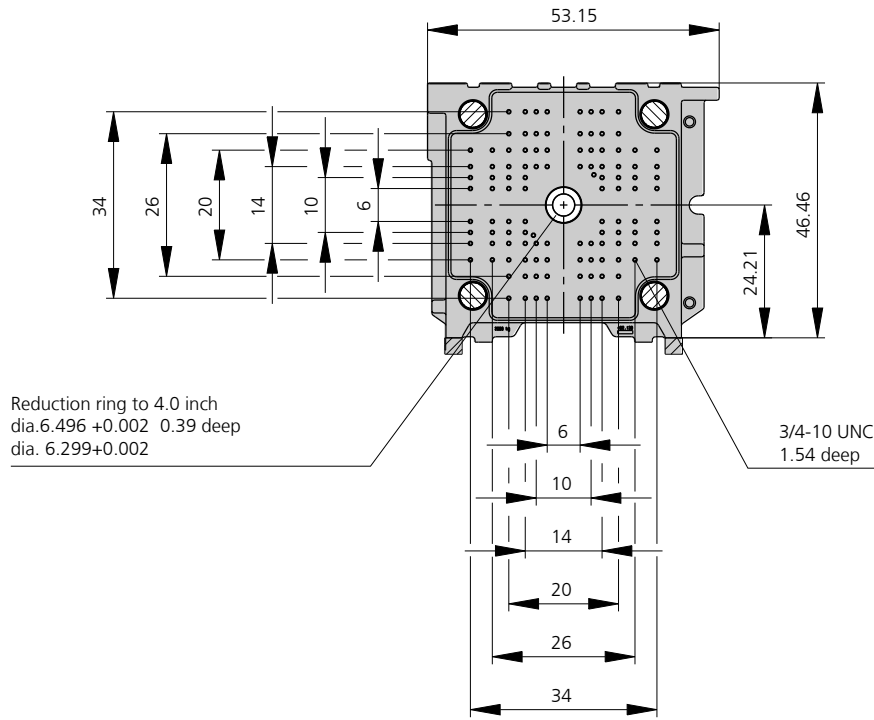


Robotic system mounting | C

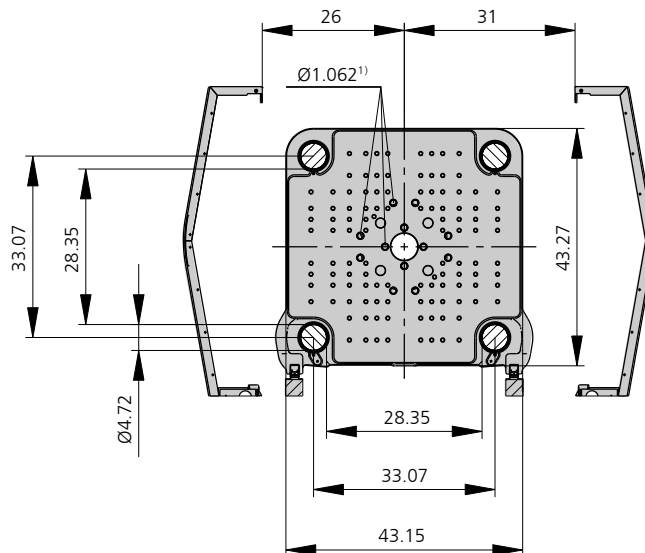


MOLD INSTALLATION DIMENSIONS | 720 A

Fixed mold mounting platen | A



Moving mold mounting platen | B



SHOT WEIGHTS | 720 A

Theoretical shot weights for the most important materials

Injection units		15.3 oz			29.8 oz			45.4 oz		
Screw diameter	inch	1.77	1.97	2.17	2.17	2.36	2.76	2.36	2.76	3.15
	mm	45	50	55	55	60	70	60	70	80
Polystyrene	max. oz PS	10.3	12.7	15.3	18.4	21.9	29.8	25.5	34.7	45.4
Styrene heteropolymerizates	max. oz SB	10.0	12.3	15.0	18.0	21.4	29.1	24.9	33.9	44.3
	max. oz SAN, ABS ¹⁾	9.8	12.1	14.7	17.6	21.0	28.5	24.4	33.3	43.4
Cellulose acetate	max. oz CA ¹⁾	11.5	14.3	17.2	20.7	24.6	33.5	28.7	39.1	51.0
Celluloseacetobutyrate	max. oz CAB ¹⁾	10.7	13.2	16.0	19.2	22.9	31.1	26.7	36.3	47.5
Polyethyl methacrylate	max. oz PMMA	10.6	13.1	15.8	19.0	22.6	30.8	26.3	35.9	46.9
Polyphenylene oxide, mod.	max. oz PPO	9.5	11.7	14.2	17.1	20.3	27.6	23.7	32.2	42.1
Polycarbonate	max. oz PC	10.8	13.3	16.1	19.3	23.0	31.3	26.8	36.5	47.7
Polysulphone	max. oz PSU	11.1	13.8	16.6	20.0	23.7	32.3	27.7	37.7	49.2
Polyamides	max. oz PA 6.6 PA 6 ¹⁾	10.2	12.6	15.2	18.2	21.7	29.6	25.4	34.5	45.1
	max. oz PA 6.10 PA 11 ¹⁾	9.5	11.7	14.2	16.7	20.3	27.6	23.7	32.2	42.1
Polyoximethylene (Polyacetal)	max. oz POM	12.7	15.6	18.9	22.7	27.0	36.8	31.5	42.9	56.0
Polyethylene terephthalate	max. oz PET	12.2	15.1	18.2	21.9	26.0	35.4	30.4	41.3	54.0
Polyethylene	max. oz PE-LD	7.7	9.6	11.6	13.9	16.5	22.5	19.3	26.2	34.3
	max. oz PE-HD	8.0	9.9	12.0	14.3	17.0	23.2	19.9	27.1	35.4
Polypropylene	max. oz PP	8.2	10.1	12.2	14.6	17.4	23.7	20.3	27.7	36.2
Fluoropolymerides	max. oz FEP, PFA, PCTFE ¹⁾	16.4	20.2	24.5	29.4	35.0	47.6	40.8	55.6	72.6
	max. oz ETFE	14.3	17.7	21.4	25.8	30.7	41.8	35.6	48.5	63.3
Polyvinyl chloride	max. oz PVC-U	12.4	15.3	18.5	22.2	26.4	36.0	30.8	42.0	54.8
	max. oz PVC-P ¹⁾	11.4	14.1	17.1	20.5	24.4	33.2	28.5	38.8	50.7

1) average value

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