

ALLROUNDER 470 H

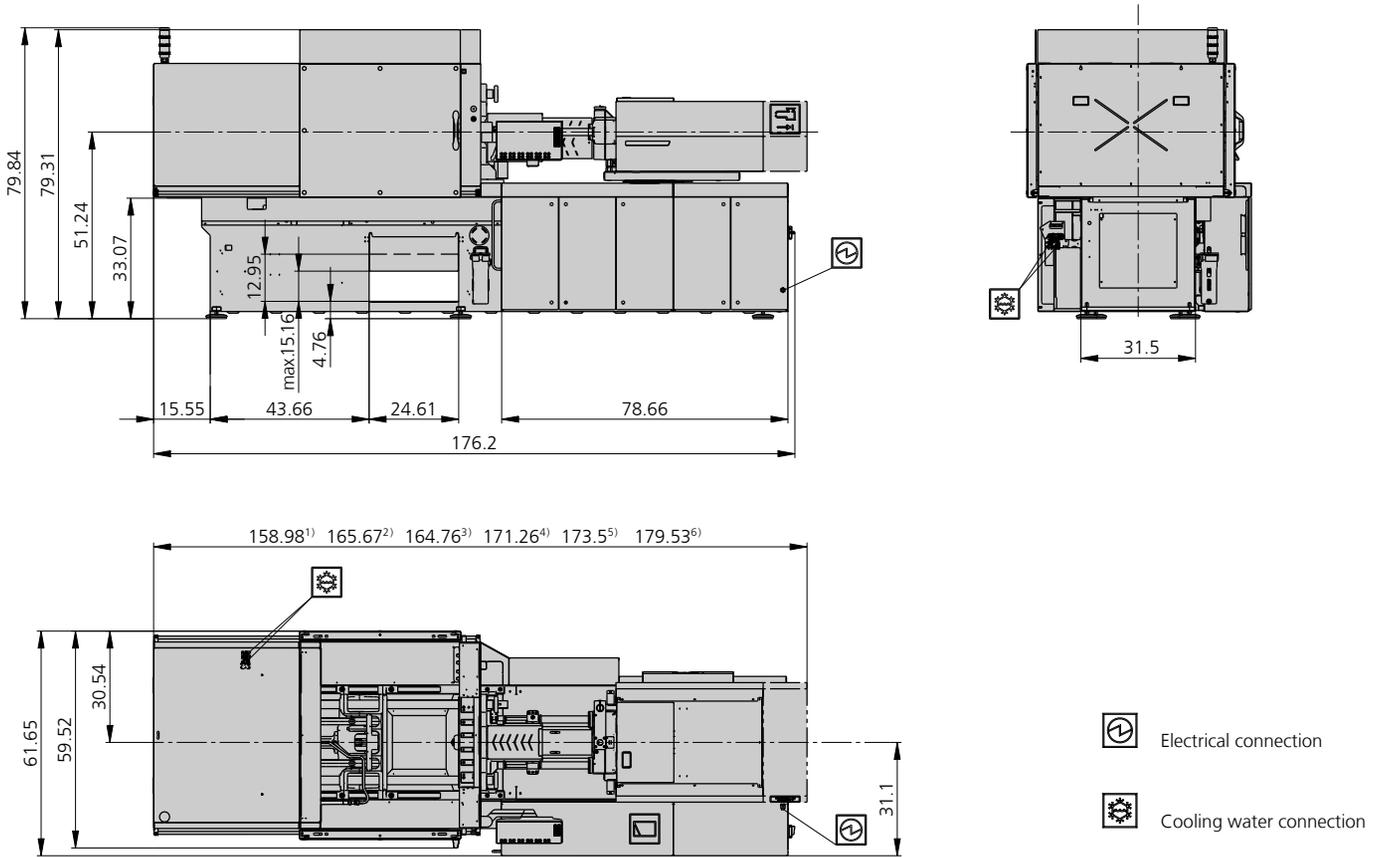
Distance between tie bars: 18.5 x 18.5" (470 x 470 mm)

Clamping force: 110 tons

Injection unit: 3.7 oz, 6.1 oz, 8.2 oz

ARBURG

MACHINE DIMENSIONS | 470 H | COMFORT UND PREMIUM



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

TECHNICAL DATA | 470 H

Clamping unit			470 H		
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	Comfort	min. s - inch	1.4 - 12.95		
	Premium	min. s - inch	1.2 12.95		
	Ultimate	min. s - inch	0.9 - 12.95		

Injection unit [EUROMAP designation]			3.7 oz [170]			6.1 oz [290]			8.2 oz [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. inch		4.72			5.91			6.30		
Calculated stroke volume	max. cu. inch		3.6	5.2	7.0	6.5	8.8	11.5	9.4	12.3	15.5
Shot weight	max. oz / PS		1.9	2.7	3.7	3.4	4.7	6.1	5.0	6.5	8.2
Material throughput	max. lbs/h PS		22.0	29.7	35.2	37.4	45.1	53.9	55.0	63.8	77.0
	max. lbs/h PA6.6		11.0	15.4	17.6	18.7	23.1	27.5	27.5	33.0	38.5
Injection pressure	max. psi		36250	29000	21315	36250	29000	22185	36250	29000	22910
Holding pressure time ²	max. s - psi		45-36250	45-29000	45-21315	45-36250	45-29000	45-22185	45-36250	45-29000	45-22910
Injection flow ³	Comfort	max. cu. inch/s	6.0	8.6	11.7	8.2	11.2	14.6	10.0	13.1	16.5
	Premium	max. cu. inch/s	7.5	10.8	14.7	10.8	14.7	19.2	14.7	19.2	24.3
	Ultimate	max. cu. inch/s	13.5	19.4	26.4	19.4	26.4	34.5	23.5	30.7	38.8
Injection speed ³	Comfort	max. inch/s	7.9			7.5			6.7		
	Premium	max. inch/s	9.8			9.8			9.8		
	Ultimate	max. inch/s	17.7			17.7			15.7		
Screw circumferential speed	Comfort	max. ft./min	161[164]	194[197]	226[230]	151[167]	177[197]	203[226]	154[174]	174[197]	197[223]
	Premium	max. ft./min	164	197	230	167	197	226	174	197	223
	Ultimate	max. ft./min	164	197	230	167	197	226	174	197	223
Screw torque	max. ft./lbs		155	185	214	236	281	317	354	406	450
Nozzle contact force retraction stroke	max. tons inch		5.50 8.27			6.60 9.45			6.60 11.81		
Heating capacity zones	kW		9.00 5			7.70 5			9.70 5		

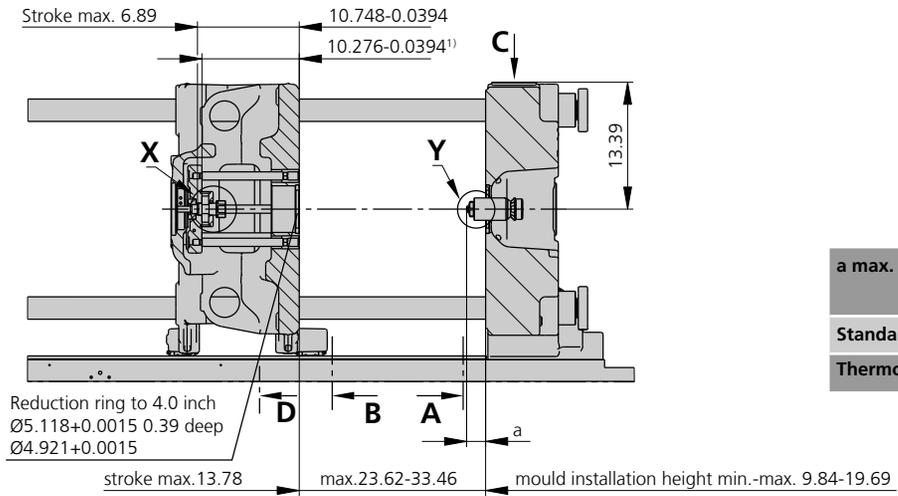
Drive and connection			Comfort			Premium			Ultimate		
with injection unit			3.7 oz	6.1 oz	8.2 oz	3.7 oz	6.1 oz	8.2 oz	3.7 oz	6.1 oz	8.2 oz
Net weight of machine	lbs		11484	11616	11880	11484	11616	11880	11484	11616	11880
Sound press. level Ref. only ⁵	dB(A)		60 3			60 3			67 3		
Oil filling	gal.		31.70			31.70			46.24		
Electrical connection ⁴	kW		21	22	27	26	26	32	29	31	36
	Total	A	63	63	80	80	80	80	80	80	100
	Machine	A	--- 40	--- 50	--- 50	--- 40	--- 50	--- 50	--- 40	--- 50	--- 50
	Heat	A	25 ---	20 ---	30 ---	25 ---	20 ---	30 ---	25 ---	20 ---	30 ---
Cooling water connection	max. °F		86			86			86		
	min. Δp psi		22 1"			22 1"			22 1"		

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

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.

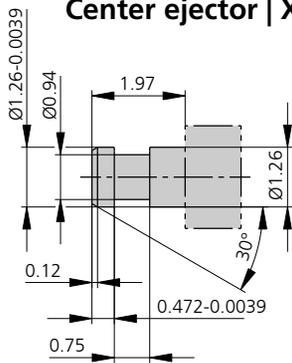
- 1) Clamping force (tons) - Large injection unit = max. stroke volume (cu. inch) x max. injection pressure (psi)
 - 2) Data depend on the performance variant and are valid for constant pressure
 - 3) Data at maximum injection pressure
 - 4) Specifications relate to 240V/60 cycles | 460V/60 cycles.
 - 5) Emission sound pressure level at the workplace. Detailed information in the operating instructions.
- [] Information applies to alternative equipment.

MOLD INSTALLATION DIMENSIONS | 470 H

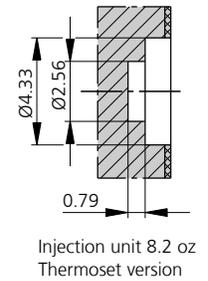
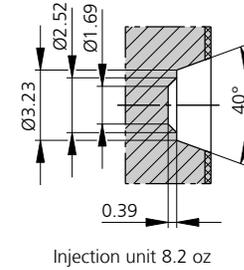
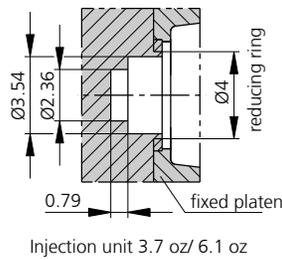


a max.	Injection unit	
		3.7/6.1 oz
Standard	40	50
Thermoset	20	50

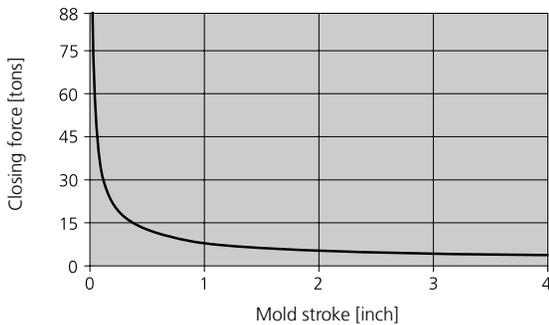
Center ejector | X



Bore in mold (if required) | Y

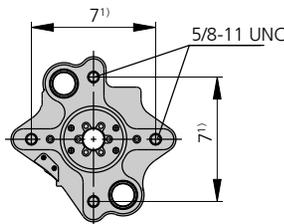


Closing force for spring molds / during injection compression molding*

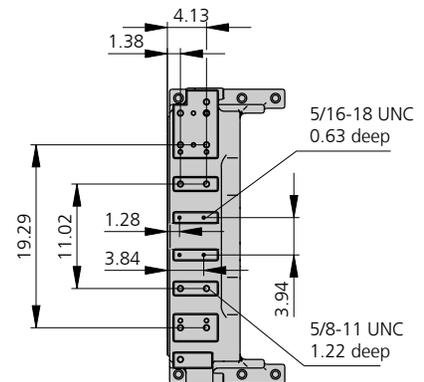


* automatic locking force adjustment up to 2.2 tons

Ejector plate²⁾ | D



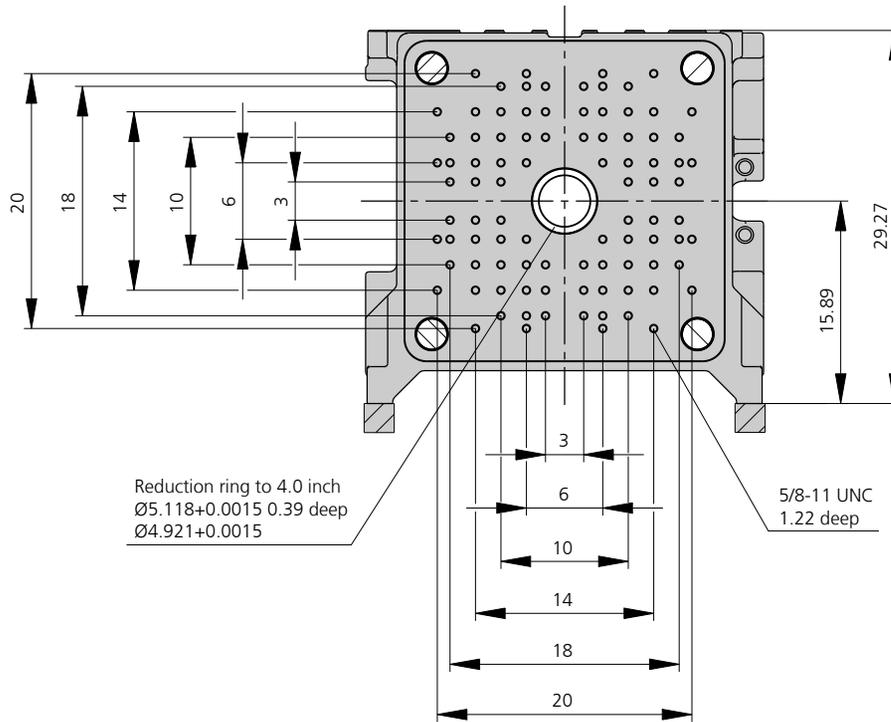
Robotic system mounting | C



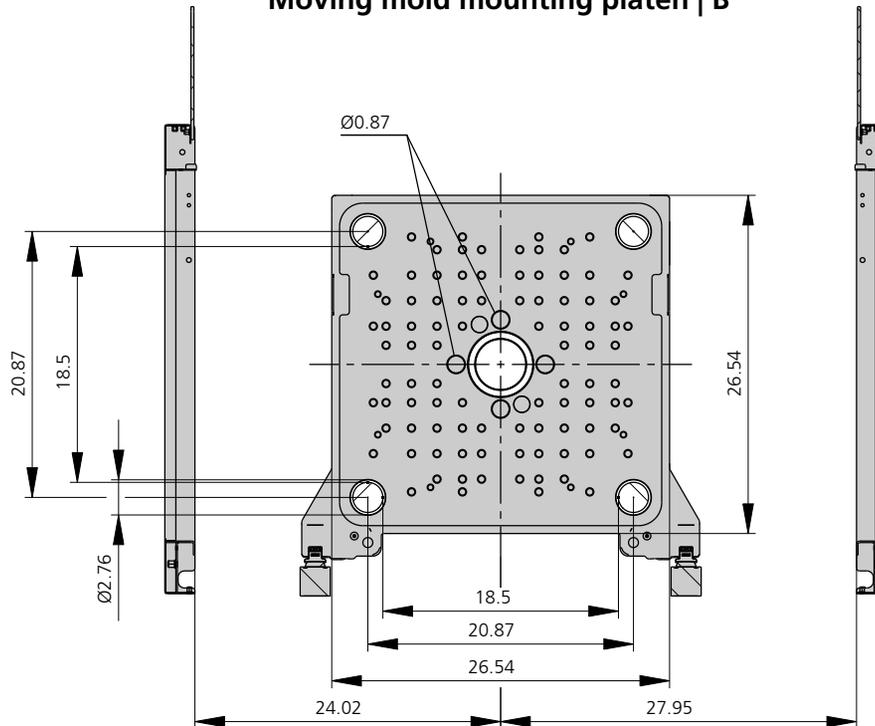
1) Positions of ejector plate
 2) Depending on the expansion stage/option dependent

MOLD INSTALLATION DIMENSIONS | 470 H

Fixed mold mounting platen | A



Moving mold mounting platen | B



SHOT WEIGHTS | 470 H

Theoretical shot weights for the most important materials

Injection units		3.7 oz			6.1 oz			8.2 oz		
Screw diameter	inch	0.98	1.18	1.38	1.18	1.38	1.57	1.38	1.57	1.77
	mm	25	30	35	30	35	40	35	40	45
Polystyrene	max. oz PS	1.9	2.7	3.7	3.4	4.6	6.1	5.0	6.5	8.2
Styrene heteropolymerizates	max. oz SB	1.9	2.7	3.6	3.3	4.6	5.9	4.8	6.3	8.0
	max. oz SAN, ABS ¹⁾	1.8	2.6	3.6	3.2	4.4	5.8	4.8	6.2	7.9
Cellulose acetate	max. oz CA ¹⁾	2.1	3.1	4.2	3.8	5.2	6.8	5.6	7.3	9.2
Celluloseacetobutyrate	max. oz CAB ¹⁾	2.0	2.9	3.9	3.6	4.9	6.4	5.2	6.8	8.6
Polymethyl methacrylate	max. oz PMMA	2.0	2.8	3.8	3.5	4.8	6.3	5.1	6.7	8.5
Polyphenylene oxide, mod.	max. oz PPO	1.8	2.5	3.5	3.2	4.3	5.6	4.6	6.0	7.6
Polycarbonate	max. oz PC	2.0	2.9	3.9	3.6	4.9	6.4	5.2	6.8	8.6
Polysulphone	max. oz PSU	2.1	3.0	4.0	3.7	5.0	6.6	5.4	7.0	8.9
Polyamides	max. oz PA 6.6 PA 6 ¹⁾	1.9	2.7	3.7	3.4	4.6	6.0	4.9	6.5	8.2
	max. oz PA 6.10 PA 11 ¹⁾	1.7	2.5	3.4	3.2	4.3	5.6	4.6	6.0	7.6
Polyoximethylene (Polyacetal)	max. oz POM	2.3	3.4	4.6	4.2	5.8	7.5	6.1	8.0	10.1
Polyethylene terephthalate	max. oz PET	2.3	3.3	4.4	4.1	5.5	7.2	5.9	7.7	9.8
Polyethylene	max. oz PE-LD	1.4	2.1	2.8	2.6	3.5	4.6	3.7	4.9	6.2
	max. oz PE-HD	1.5	2.1	2.9	2.7	3.6	4.7	3.9	5.0	6.4
Polypropylene	max. oz PP	1.5	2.2	3.0	2.7	3.7	4.8	4.0	5.2	6.5
Fluoropolymerides	max. oz FEP, PFA, PCTFE ¹⁾	3.0	4.4	6.0	5.5	7.4	9.7	7.9	10.4	13.1
	max. oz ETFE	2.7	3.8	5.2	4.8	6.5	8.5	6.9	9.0	11.4
Polyvinyl chloride	max. oz PVC-U	2.3	3.3	4.5	4.1	5.6	7.3	6.0	7.8	9.9
	max. oz PVC-P ¹⁾	2.1	3.1	4.2	3.8	5.2	6.8	5.5	7.2	9.2

1) average value

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