

ALLROUNDER 270 S

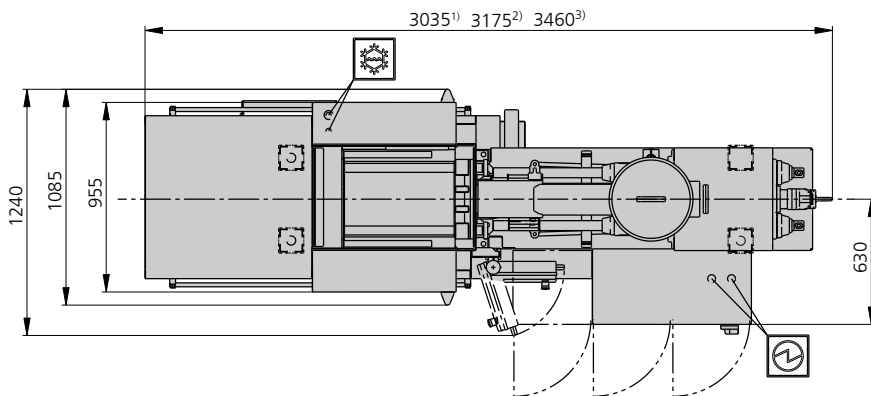
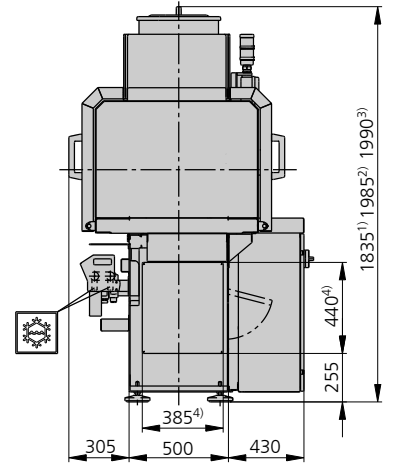
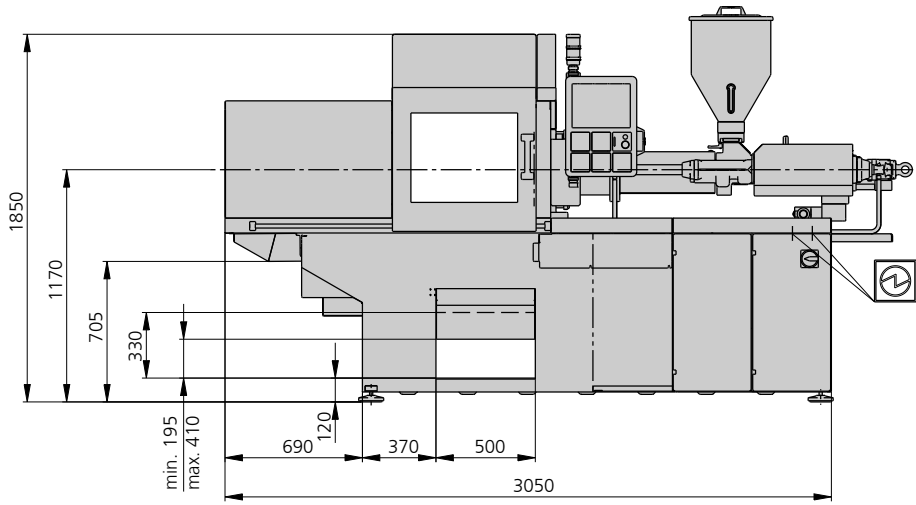
Distance between tie bars: 270 x 270 mm

Clamping force: 250, 350, 400 kN

Injection unit (acc. to EUROMAP): 70, 100, 170

ARBURG

MACHINE DIMENSIONS | 270 S



Electrical connection



Cooling water connection

- 1) Injection unit 70
- 2) Injection unit 100
- 3) Injection unit 170
- 4) Conveyor belt

TECHNICAL DATA | 270 S

Clamping unit			270 S		
with clamping force	max. kN		250	350	400
Opening force stroke	max. kN mm		90 350		
Mould height, fixed variable	min. mm		200 ---		
Platen daylight fixed variable	max. mm		550 ---		
Distance between tie bars (w x h)	mm		270 x 270		
Mould mounting platens (w x h)	max. mm		380 x 380		
Weight of movable mould half	max. kg		135 [200]		
Ejector force stroke	max. kN mm		20 100		
Dry cycle time EUROMAP ²	1 pump	min. s - mm	2,0 - 189		
	2 pumps	min. s - mm	1,2 - 189		
	Accum.	min. s - mm	1,0 - 189		

Injection unit			70			100			170		
with screw diameter	mm		18	22	25	20	25	30	25	30	35
Effective screw length	L/D		24,5	20	17,5	25	20	16,7	24	20	17
Screw stroke	max. mm		90			100			120		
Calculated stroke volume	max. cm ³		23	34	44	31	49	71	59	85	115
Shot weight	max. g PS		21	31	40	29	45	65	54	77	105
Material throughput	max. kg/h PS		4,1	5,5	6,5	5,5	8	9,5	10	13,5	16
	max. kg/h PA6.6		2,1	2,8	3,3	2,8	4	4,9	5	7	8
Injection pressure	max. bar		2500	2000	1550	2500	2000	1390	2500	2000	1470
Holding pressure	max. bar		2500	2000	1550	2500	2000	1390	2500	2000	1470
Injection flow ²	1 pump	max. cm ³ /s	42 68	62 100	80 130	64	100	146	66	96	132
	2 pumps	max. cm ³ /s	42 68	62 100	80 130	64	100	146	66	96	132
	Accum.	max. cm ³ /s	138	208	268	172	268	388	216	312	424
Screw circumferential speed ²	1 pump	max. m/min	24 39	30 48	34 55	28	35	42	35	42	49
	2 pumps	max. m/min	24 39	30 48	34 55	28	35	42	35	42	49
	Accum.	max. m/min	15	19	22	11	14	17	14	17	19
Screw torque	max. Nm		90	110	120	120	150	180	210	250	290
Nozzle contact force retraction stroke	max. kN mm		50 150			50 180			50 210		
Heating capacity zones	kW		4,2 4			6,7 5			9 5		
Feed hopper	l		25			50			50		

Drive and connection			1 pump			2 pumps			Accum.		
with injection unit			70	100	170	70	100	170	70	100	170
Net weight of machine	kg		1970	2000	2050	1970	2000	2050	---		
Sound press. level Insecurity ⁴	dB(A)		68 3			68 3			68 3		
Oil filling	l		130			130			130		
Drive power ²	max. kW		11			15			7,5		
Electrical connection ³	kW		17	18	22	21	22	26	14	15	18
	Total	A	50	63	63	63	63	80	50	50	63
	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	Drive
270 S 250-70 100	1 2 -
270 S 350-70 100 170	1 2 -
270 S 400-70 100 170	- 2 Accum.

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).

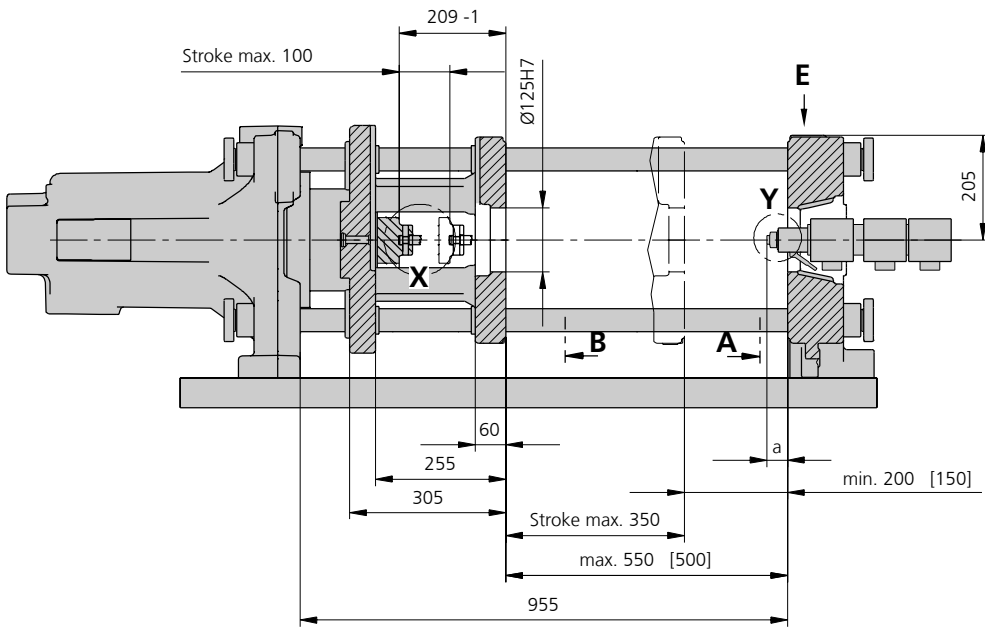
2) Specifications depend on the drive config. - 1st value applies to the lowest clamping force.

3) Specifications relate to 400 V/50 Hz.

4) Detailed info in the operating instr.

[] Specifications apply to alternative equipment.

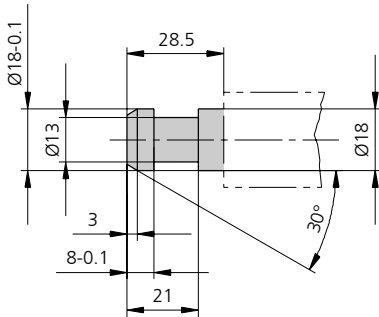
MOULD INSTALLATION DIMENSIONS | 270 S



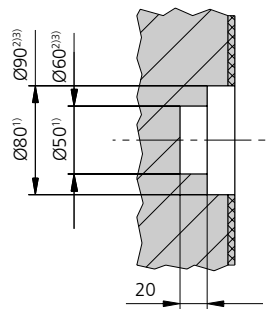
a max.	Injection unit
	70 / 100 / 170
Standard	40
Thermoset	20

Dimensions for horizontally-displaceable injection unit (VARIO principle) reduced by 20 mm

Ejector bolt | X

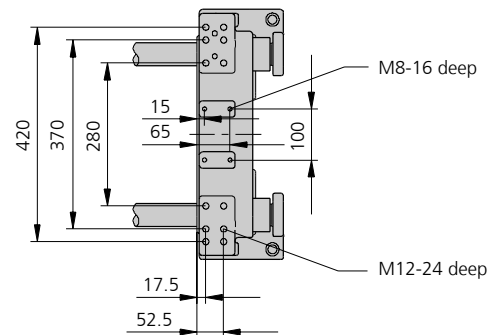


Bore in mould (if required) | Y



size 70 injection unit⁽¹⁾ / 100⁽²⁾ / 170⁽³⁾

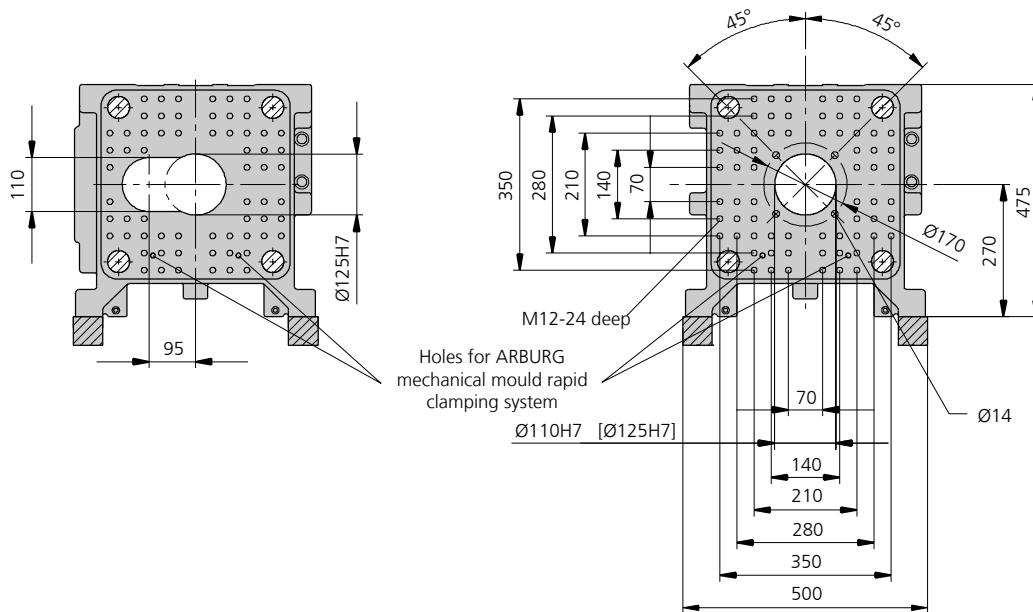
Robotic system mounting | E



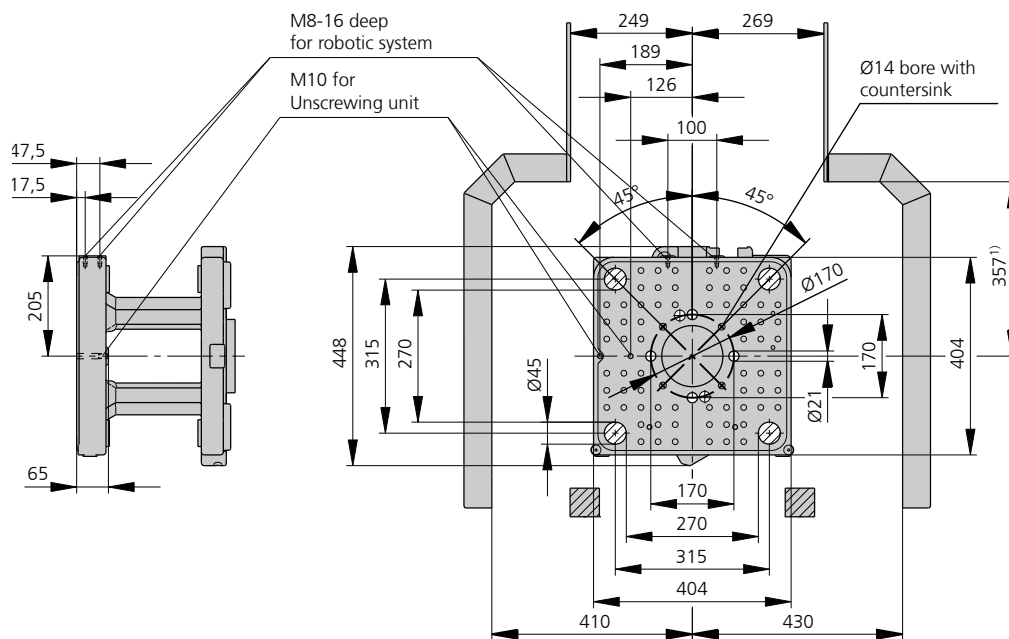
[] Specifications apply to alternative equipment

MOULD INSTALLATION DIMENSIONS | 270 S

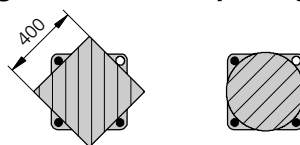
Fixed mould mounting platen | A



Moving mould mounting platen | B



Useful clamping surface when pulling the tie rods



1) Pivoting clamping unit – guard closed at the top
 [] Specifications apply to alternative equipment

SHOT WEIGHTS | 270 S

Theoretical shot weights for the most important injection moulding materials

Injection units according to EUROMAP		70			100			170		
Screw diameter	mm	18	22	25	20	25	30	25	30	35
Polystyrene	max. g PS	21	31	40	29	45	65	54	77	105
Styrene heteropolymerizates	max. g SB	20	31	39	28	44	63	53	76	103
	max. g SAN, ABS ¹⁾	20	30	39	27	43	62	52	74	101
Cellulose acetate	max. g CA ¹⁾	24	35	45	32	50	73	61	87	119
Celluloseacetobutyrate	max. g CAB ¹⁾	22	33	42	30	47	68	56	81	110
Polymethyl methacrylate	max. g PMMA	22	32	42	30	46	67	56	80	109
Polyphenylene ether, mod.	max. g PPE	19	29	37	27	42	60	50	72	98
Polycarbonate	max. g PC	22	33	42	30	47	68	57	81	111
Polysulphone	max. g PSU	23	34	44	31	49	70	58	84	115
Polyamides	max. g PA 6.6 PA 6 ¹⁾	21	31	40	28	44	64	53	77	104
	max. g PA 6.10 PA 11 ¹⁾	19	29	37	26	41	60	50	72	98
Polyoximethylene (Polyacetal)	max. g POM	26	39	50	35	55	80	66	96	130
Polyethylene terephthalate	max. g PET	25	37	48	34	53	77	64	92	126
Polyethylene	max. g PE-LD	16	24	30	22	34	49	41	59	80
	max. g PE-HD	16	24	31	22	35	50	42	60	82
Polypropylene	max. g PP	17	25	32	23	36	51	43	62	84
Fluoropolymerides	max. g FEP, PFA, PCTFE ¹⁾	33	50	65	46	72	103	86	124	169
	max. g ETFE	29	44	57	40	63	91	76	109	148
Polyvinyl chloride	max. g PVC-U	25	38	49	35	54	78	65	94	127
	max. g PVC-P ¹⁾	23	35	45	32	50	72	60	87	118

1) average value

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