

ALLROUNDER 470 S

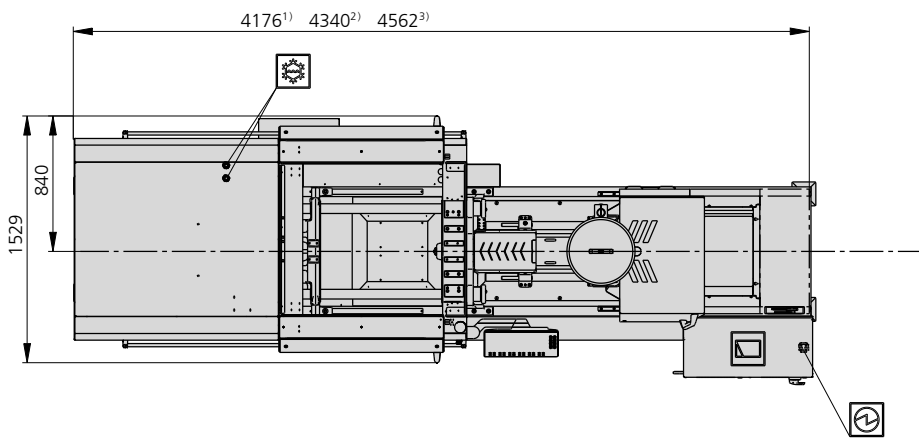
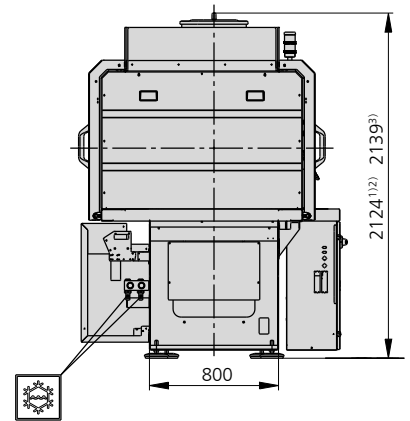
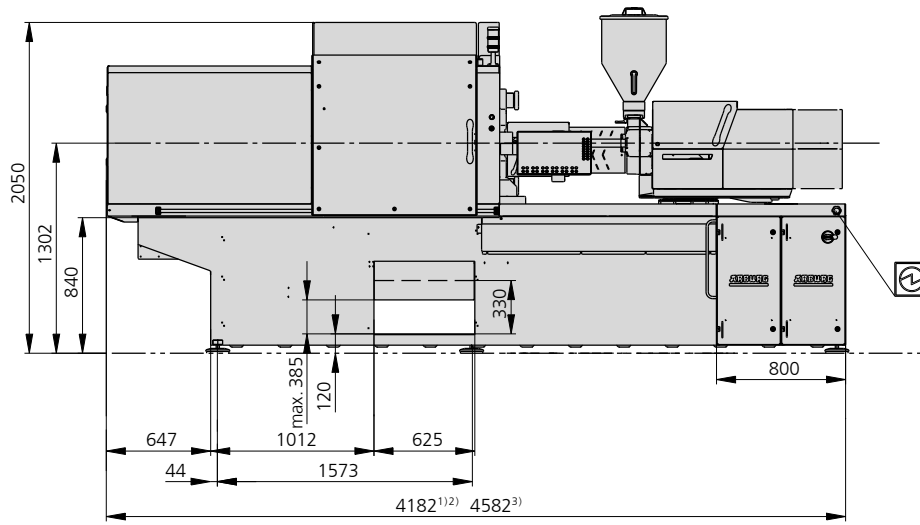
Distance between tie bars: 470 x 470 mm

Clamping force: 800, 1000, 1100 kN

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

ARBURG

MACHINE DIMENSIONS | 470 S



Electrical connection



Cooling water connection

- 1) injection unit 170
- 2) injection unit 290
- 3) injection unit 400

TECHNICAL DATA | 470 S

Clamping unit			470 S		
with clamping force	max. kN		800	1000	1100
Opening force stroke	max. kN mm		255 500		
Mould height, fixed variable	min. mm		250 ---		
Platen daylight fixed variable	max. mm		750 ---		
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 ²	1 pump	min. s - mm	2,3 2,1 - 329		
	2 pumps	min. s - mm	1,8 - 329		
	Accum.	min. s - mm	1,5 - 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	max. bar		2500	2000	1470	2500	2000	1530	2500	2000	1580
Injection flow ²	1 pump	max. cm ³ /s	120	172	236	130	178	232	128	168	212
	2 pumps	max. cm ³ /s	120	172	236	130	178	232	128	168	212
	Accum.	max. cm ³ /s	216	312	424	316	430	562	492	642	814
Screw circumferential speed ²	1 pump	max. m/min	49 50	59 60	69 70	46 51	54 60	62 69	47	53	60
	2 pumps	max. m/min	49 50	59 60	69 70	46 51	54 60	62 69	47	53	60
	Accum.	max. m/min	14	17	19	20	24	27	16	19	21
Screw torque	max. Nm		210	250	290	320	380	430	480	550	610
Nozzle contact force retraction stroke	max. kN mm		50 210			60 240			60 300		
Heating capacity zones	kW		9 5			7,7 5			9,7 5		
Feed hopper	l		50			50			50		

Drive and connection			1 pump			2 pumps			Accum.		
with injection unit			170	290	400	170	290	400	170	290	400
Net weight of machine	kg		4500	4550	4750	4500	4550	4750	---		
Sound press. level Insecurity ⁴	dB(A)		66 3			66 3			66 3		
Oil filling	l		180			180			180	180	240
Drive power ²	max. kW		18,5			18,5	18,5	22	15		
Electrical connection ³	kW		30	27	30	30	27	34	26	24	26
	Total	A	80			80	80	100	80	63	80
	Machine	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		Drive
470 S 800-170 290		1 2 -
470 S 1000-170 290 400		1 2 -
470 S 1100-170 290 400		- 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).

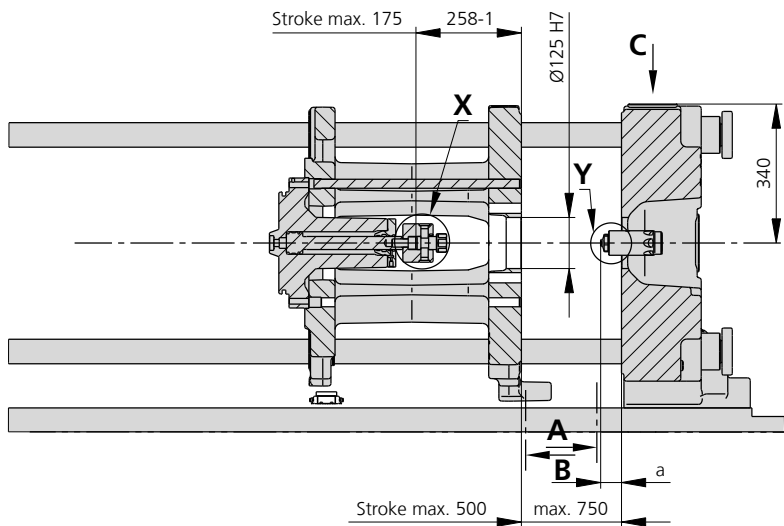
2) Specifications depend on the drive config. - 1st value applies to the lowest clamping force.

3) Specifications relate to 400 V/50 Hz.

4) Detailed info in the operating instr.

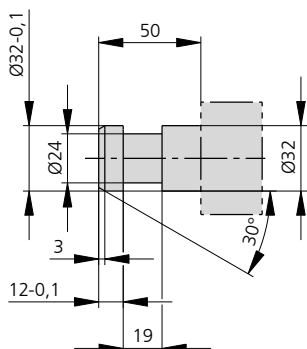
[] Specifications apply to alternative equipment.

MOULD INSTALLATION DIMENSIONS | 470 S

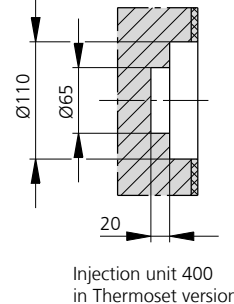
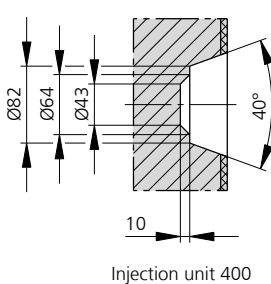
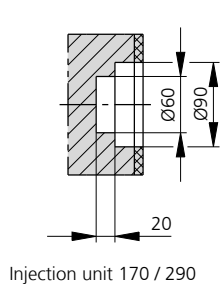


a max.	Injection unit	
	170 / 290	400
Standard	40	50
Thermoset	20	50

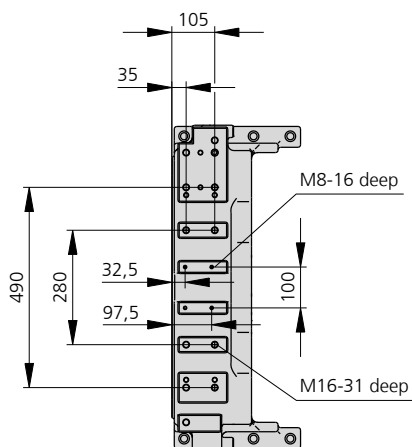
Ejector bolt | X



Bore in mould (if required) | Y

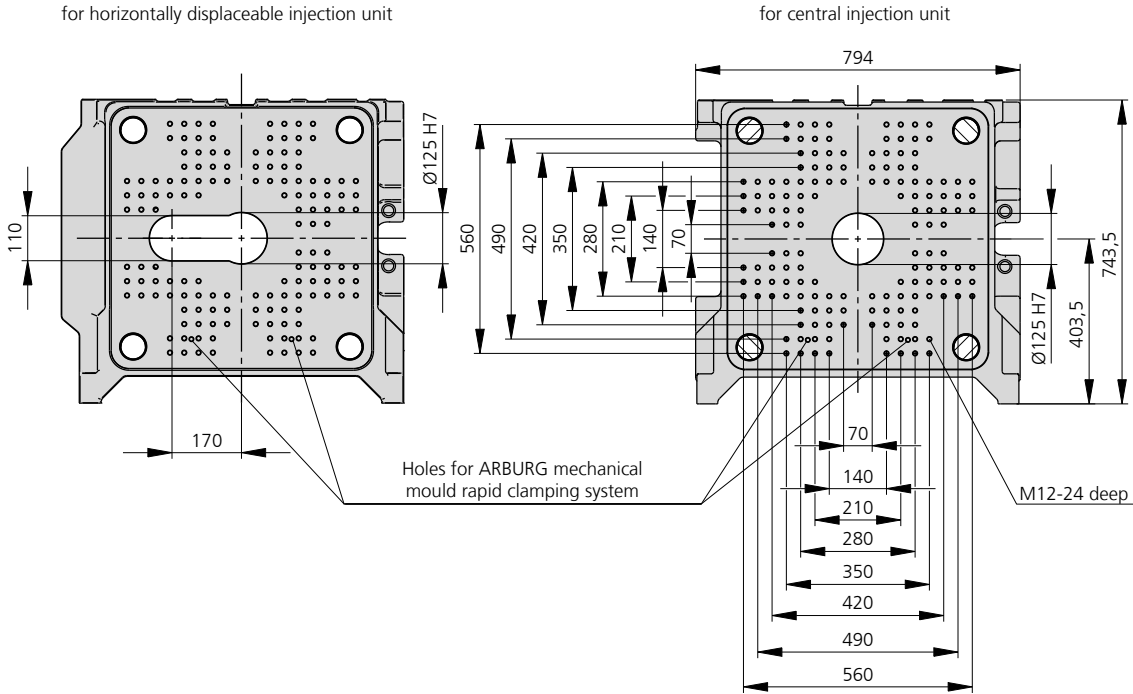


Robotic system mounting | C

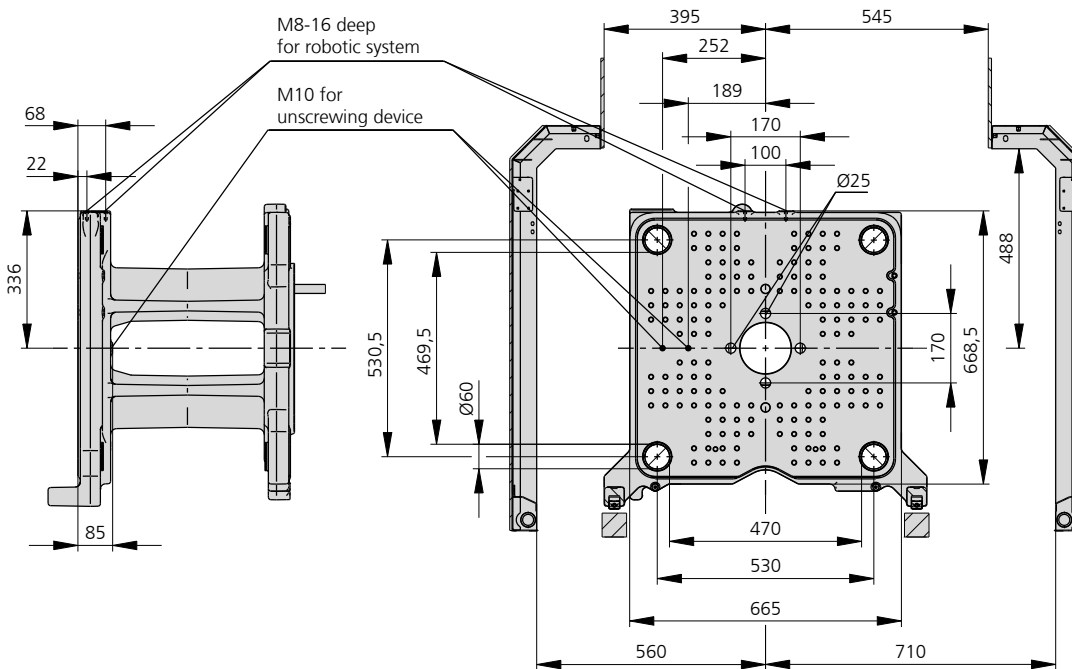


MOULD INSTALLATION DIMENSIONS | 470 S

Fixed mould mounting platen | A



Moving mould mounting platen | B



SHOT WEIGHTS | 470 S

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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