

ALLROUNDER 270 C

GOLDEN EDITION

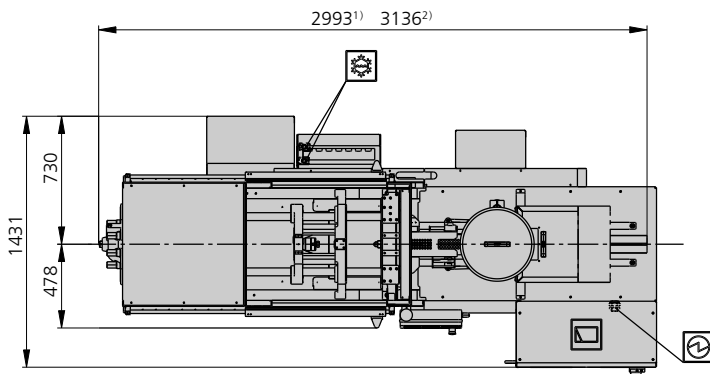
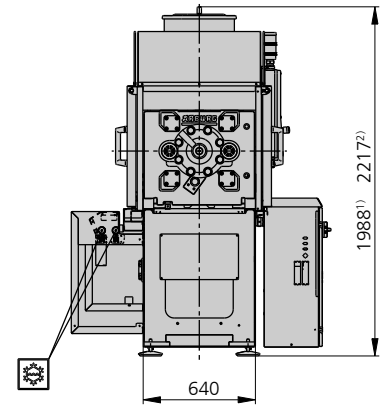
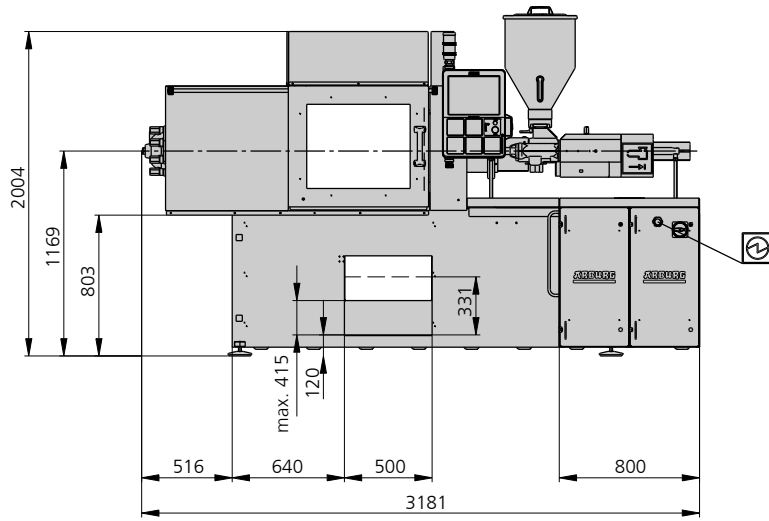
Distance between tie bars: 270 x 270 mm

Clamping force: 400 kN


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

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MACHINE DIMENSIONS | 270 C GOLDEN EDITION



 Electrical connection

 Cooling water connection

1) Injection unit 70
2) Injection unit 100

TECHNICAL DATA | 270 C GOLDEN EDITION

Clamping unit		270 C GOLDEN EDITION	
with clamping force	max. kN	400	
Opening force stroke	max. kN mm	130 350	
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	446 x 446	
Weight of movable mould half	max. kg	180	
Ejector force stroke	max. kN mm	30 125	
Dry cycle time EUROMAP ²	min. s - mm	1,2 - 189	

Injection unit		70			100		
with screw diameter	mm	18	22	25	20	25	30
Effective screw length	L/D	24,5	20	17,5	25	20	16,7
Screw stroke	max. mm	90			100		
Calculated stroke volume	max. cm ³	23	34	44	31	49	71
Shot weight	max. g PS	21	31	40	29	45	65
Material throughput	max. kg/h PS	4,1	5,5	6,5	5,5	8	9,5
	max. kg/h PA6.6	2,1	2,8	3,3	2,8	4	4,9
Injection pressure	max. bar	2500	2000	1550	2500	2000	1390
Holding pressure	max. bar	2500	2000	1550	2500	2000	1390
Injection flow ²	max. cm ³ /s	68	100	130	64	100	146
Screw circumferential speed ²	max. m/min	39	48	55	28	35	42
Screw torque	max. Nm	90	110	120	120	150	180
Nozzle contact force retraction stroke	max. kN mm	50 150			50 180		
Heating capacity zones	kW	4,1 4			4,9 5		
Feed hopper	l	25			50		

Drive and connection		2 pumps	
with injection unit		70	100
Net weight of machine	kg	2150	2180
Sound press. level Insecurity ⁴	dB(A)	68 3	
Oil filling	l	165	
Drive power ²	max. kW	7,5	11
Electrical connection ³	kW	14	19
	Total	A	50
	Machine	A	63
Cooling water connection	Heating	A	---
	max. °C	30	
	min. Δp bar	1,5 DN 25	

Machine type

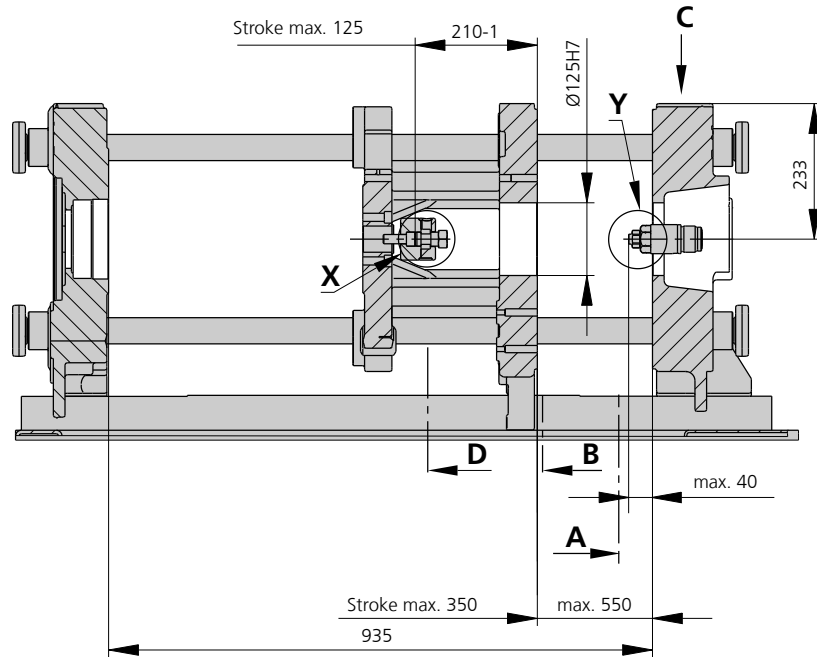
with EUROMAP size designation ¹

270 C GOLDEN EDITION 400-70 | 100

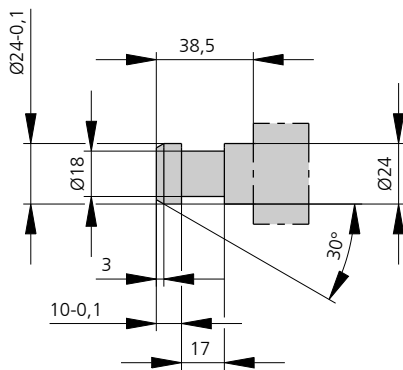
All specifications relate to the basic machine version. Deviations are possible depending on variants, process settings and material type. Depending on the drive, certain combinations, e.g. max. injection pressure and max. injection flow may be mutually exclusive.

- 1) Clamping force (kN) - size of injection unit = max. stroke volume (cm³) x max. injection pressure (kbar)
 - 2) Specifications depend on the drive variant / drive configuration.
 - 3) Specifications relate to 400 V/50 Hz.
 - 4) Detailed info in the operating instr.
- [] Specifications apply to alternative equipment.

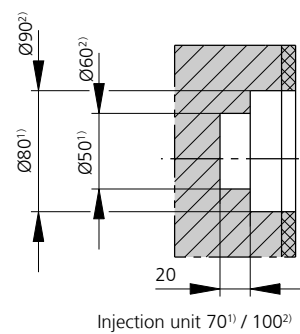
MOULD INSTALLATION DIMENSIONS | 270 C GOLDEN EDITION



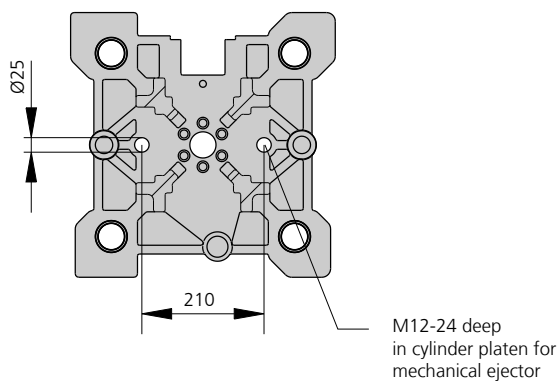
Ejector bolt | X



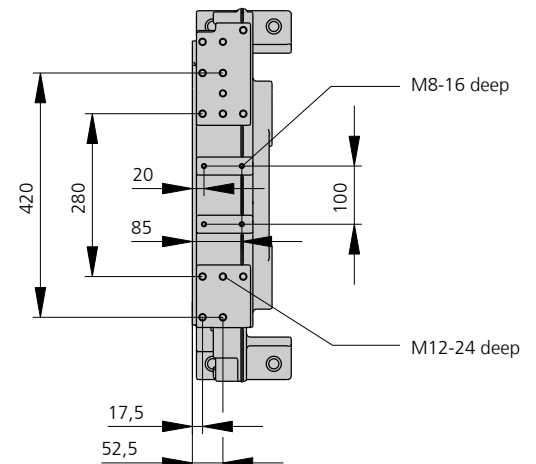
Bore in mould (if required) | Y



View | D

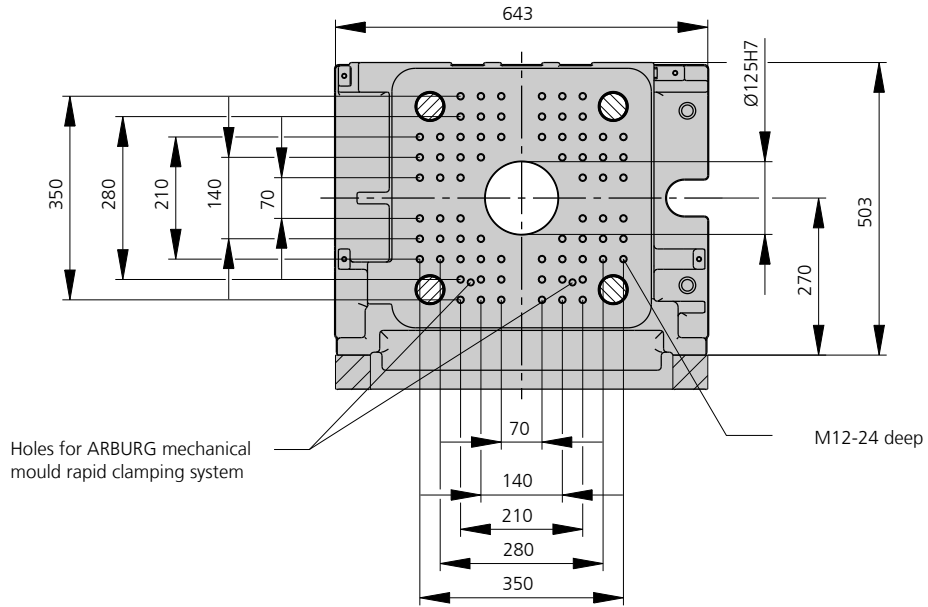


Robotic system mounting | C

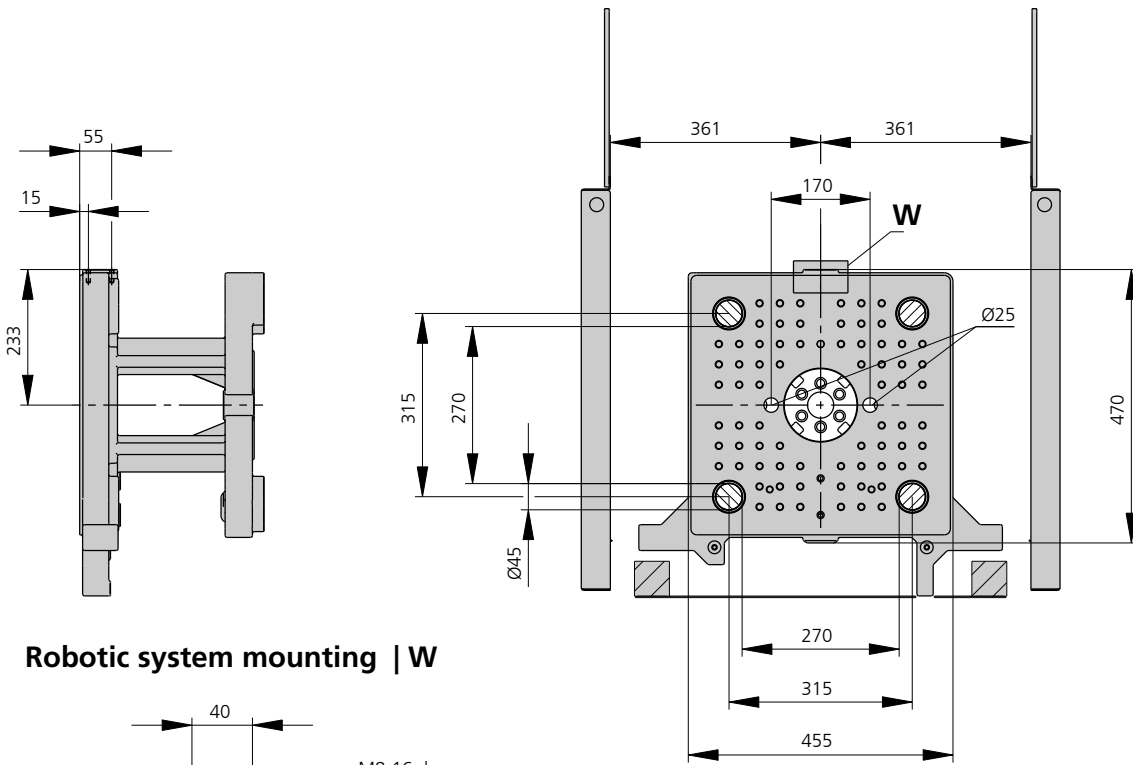


MOULD INSTALLATION DIMENSIONS | 270 C GOLDEN EDITION

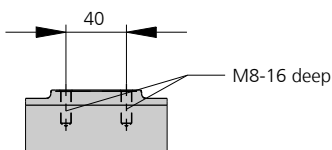
Fixed mould mounting platen | A



Moving mould mounting platen | B



Robotic system mounting | W



SHOT WEIGHTS | 270 C GOLDEN EDITION

Theoretical shot weights for the most important injection moulding materials

Injection units according to EUROMAP		70			100		
Screw diameter	mm	18	22	25	20	25	30
Polystyrene	max. g PS	21	31	40	29	45	65
Styrene heteropolymerizates	max. g SB	20	31	39	28	44	63
	max. g SAN, ABS ¹⁾	20	30	39	27	43	62
Cellulose acetate	max. g CA ¹⁾	24	35	45	32	50	73
Celluloseacetobutyrate	max. g CAB ¹⁾	22	33	42	30	47	68
Polymethyl methacrylate	max. g PMMA	22	32	42	30	46	67
Polyphenylene ether, mod.	max. g PPE	19	29	37	27	42	60
Polycarbonate	max. g PC	22	33	42	30	47	68
Polysulphone	max. g PSU	23	34	44	31	49	70
Polyamides	max. g PA 6.6 PA 6 ¹⁾	21	31	40	28	44	64
	max. g PA 6.10 PA 11 ¹⁾	19	29	37	26	41	60
Polyoximethylene (Polyacetal)	max. g POM	26	39	50	35	55	80
Polyethylene terephthalate	max. g PET	25	37	48	34	53	77
Polyethylene	max. g PE-LD	16	24	30	22	34	49
	max. g PE-HD	16	24	31	22	35	50
Polypropylene	max. g PP	17	25	32	23	36	51
Fluoropolymerides	max. g FEP, PFA, PCTFE ¹⁾	33	50	65	46	72	103
	max. g ETFE	29	44	57	40	63	91
Polyvinyl chloride	max. g PVC-U	25	38	49	35	54	78
	max. g PVC-P ¹⁾	23	35	45	32	50	72

1) average value

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