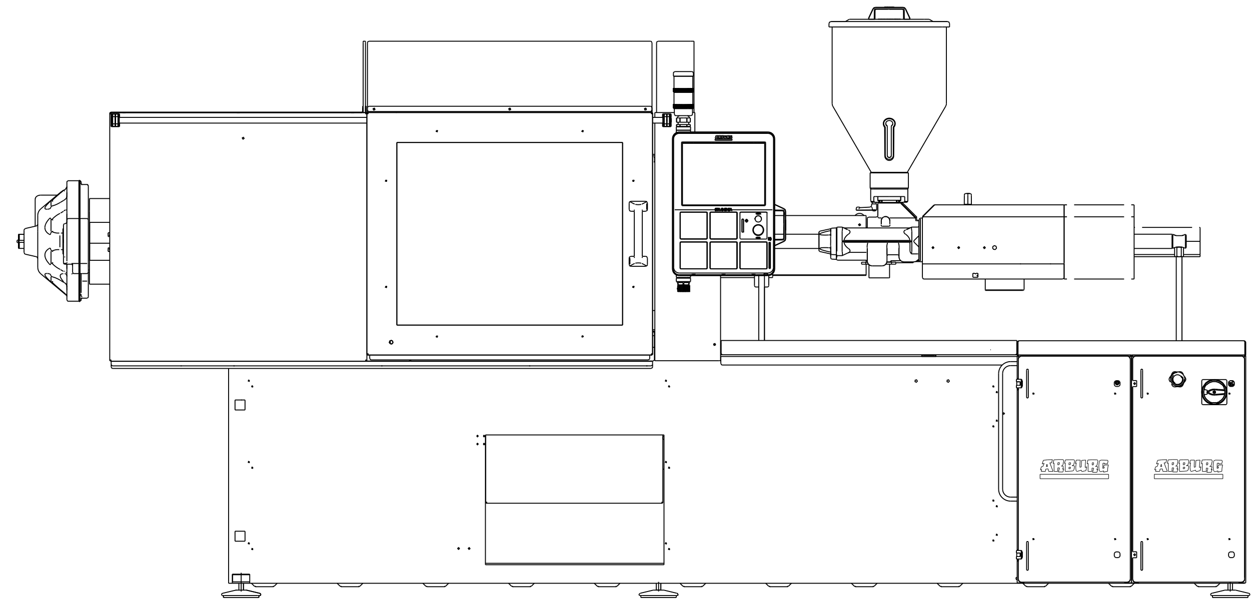


ALLROUNDER 420 C

GOLDEN EDITION

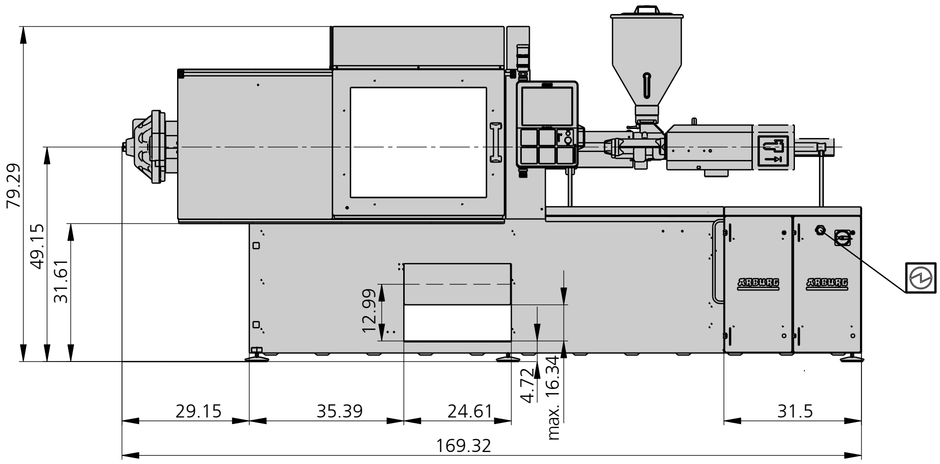
Distance between tie bars: 16.54 x 16.54” (420 x 420 mm)

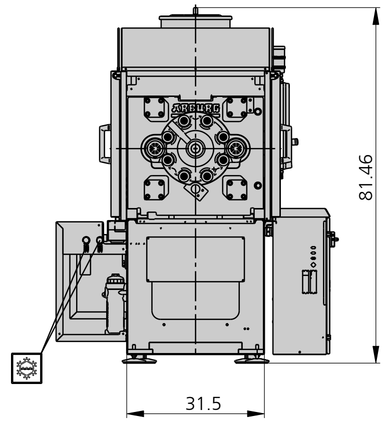
Clamping force: 110 tons

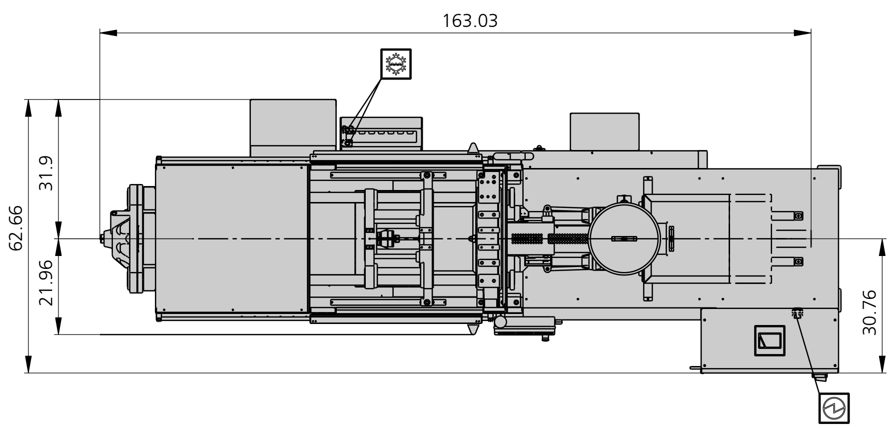
Injection unit: 6.1 oz

ARBURG

MACHINE DIMENSIONS | 420 C GOLDEN EDITION







Electrical connection

Cooling water connection

Drawing shows option T2 without ASH

TECHNICAL DATA | 420 C GOLDEN EDITION

Clamping unit			420 C GOLDEN EDITION
with clamping force	max.	tons	110
Opening force | stroke	max.	tons | inch	27.50 | 19.69
Mold height, fixed | variable	min.	inch	9.84 | ---
Platen daylight fixed | variable	max.	inch	29.53 | ---
Distance between tie bars (w x h)		inch	16.54 x 16.54
Mold mounting platens (w x h)	max.	inch	22.44 x 22.44
Weight of movable mold half	max.	lbs	1320
Ejector force | stroke	max.	tons | inch	4.40 | 6.89
Dry cycle time EUROMAP ²	min.	s - inch	1.8 - 11.57

Injection unit [EUROMAP designation]				6.1 oz [290]			
with screw diameter		mm		30	35	40	
Effective screw length		L/D		23.3	20	17.5	
Screw stroke	max.	inch			5.91		
Calculated stroke volume	max.	cu. inch		6.5	8.8	11.5	
Shot weight	max.	oz / PS		3.4	4.7	6.1	
Material throughput	max.	lbs/h PS		37.4	45.1	53.9	
	max.	lbs/h PA6.6		18.7	23.1	27.5	
Injection pressure	max.	psi		36250	29000	22185	
Holding pressure	max.	psi		36250	29000	22185	
Injection flow ²	max.	cu. inch/s		6.2	8.5	11.1	
Screw circumferential speed ²	max.	ft./min		151	177	203	
Screw torque	max.	ft./lbs		236	281	317	
Nozzle contact force | retraction stroke	max.	tons | inch			6.60 | 9.45		
Heating capacity | zones		kW			7.70 | 5		
Feed hopper		lbs			---		

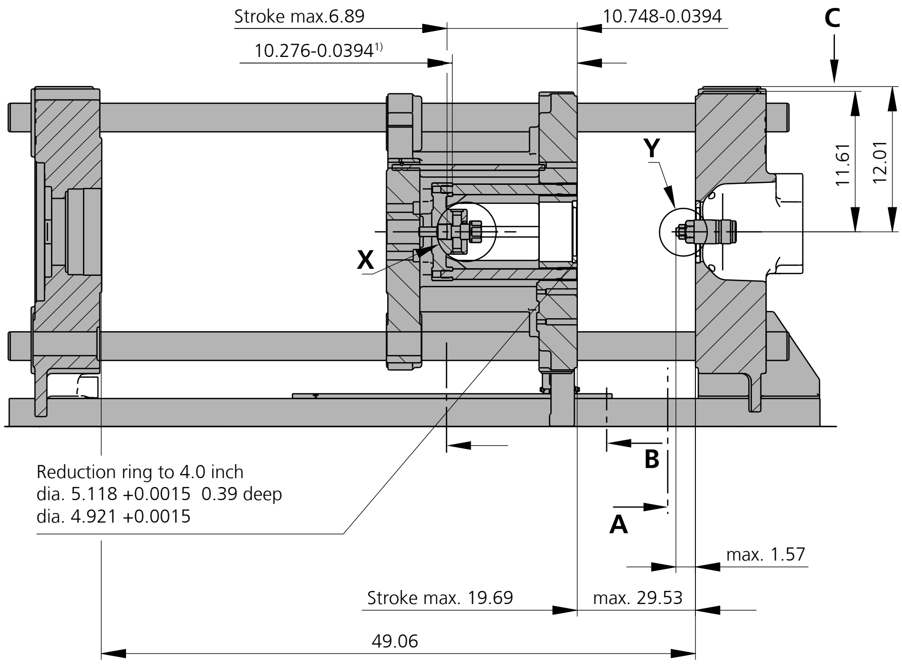
Drive and connection					2 pumps	
with injection unit					6.1 oz	
Net weight of machine			lbs		8030	
Sound press. level | Ref. only ⁴			dB(A)		68 | 3	
Oil filling			gal.		52.84	
Drive power ²		max.	kW		15	
Electrical connection ³			kW		24	
	Total		A		80 | ---	
	Machine		A		--- | 30	
	Heat		A		20 | ---	
Cooling water connection		max.	°F		86	
		min.	Δp psi		22 | 1"	

Machine type
with EUROMAP size designation ¹
420 C GOLDEN EDITION 1000-290

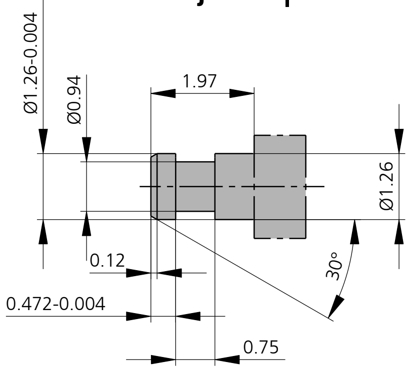
All specifications relate to the basic machine version. Deviations are possible depending on variants, process settings and material type. Depending on the drive, certain combinations, e.g. max. injection pressure and max. injection flow may be mutually exclusive.

1) Clamping force (tons) - size of injection unit = max. stroke volume (cu. inch) x max. injection pressure (psi)
2) Specifications depend on drive version / drive design.
3) Specifications relate to 230V/60 cycles | 460V/60 cycles.
4) Detailed info in the operating instr.
[ ]Information applies to alternative equipment.

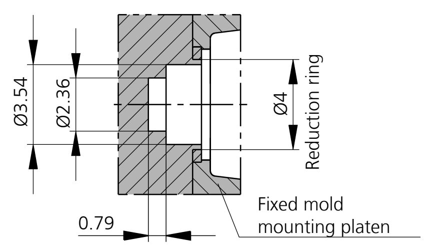
MOLD INSTALLATION DIMENSIONS | 420 C GOLDEN EDITION



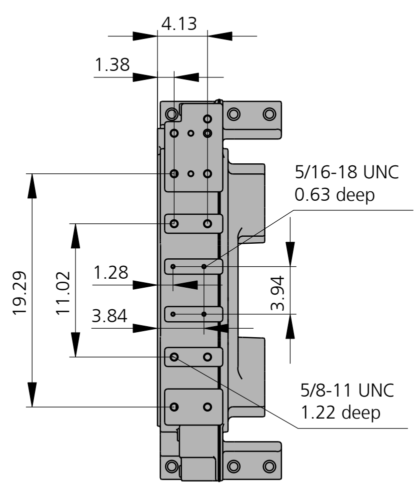
Center ejector | X



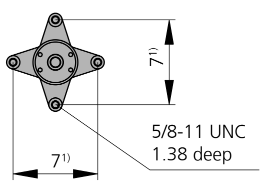
Bore in mold (if required) | Y



Robotic system mounting | C



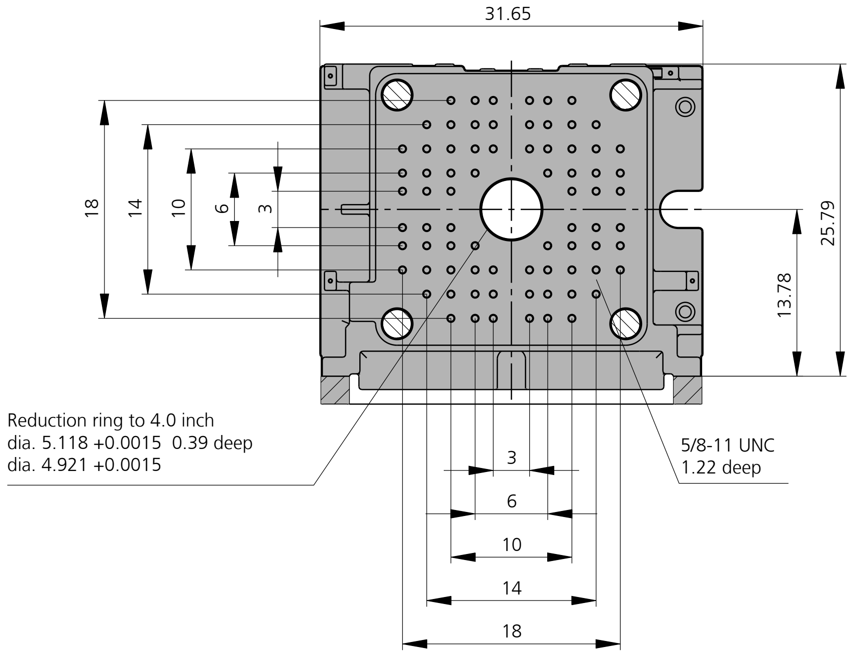
D view



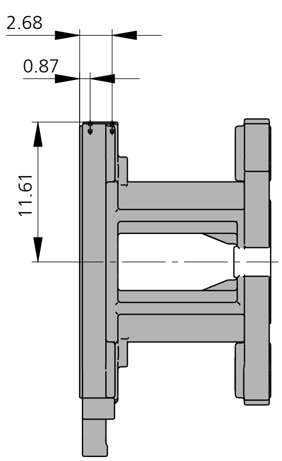
1) Positions of ejector plate
2) Guide

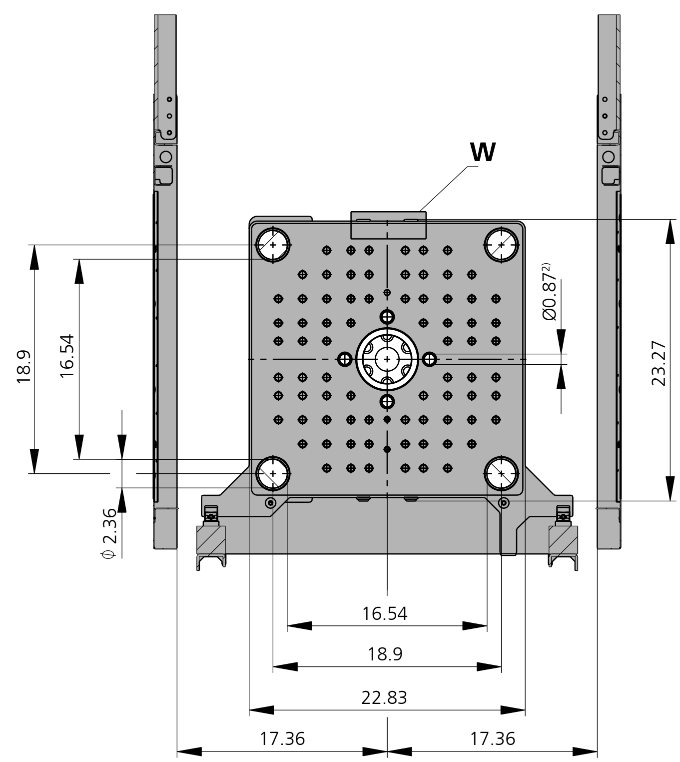
MOLD INSTALLATION DIMENSIONS | 420 C GOLDEN EDITION

Fixed mold mounting platen | A

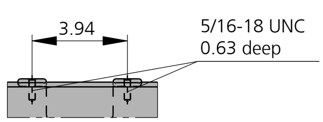


Moving mold mounting platen | B





Robotic system mounting | W



SHOT WEIGHTS | 420 C GOLDEN EDITION

Theoretical shot weights for the most important materials

Injection units			6.1 oz			
Screw diameter	inch		1.18	1.38	1.57		
	mm		30	35	40		
Polystyrene	max. oz	PS	3.4	4.6	6.1		
Styrene heteropolymerizates	max. oz	SB	3.3	4.6	5.9		
	max. oz	SAN, ABS[1)]	3.2	4.4	5.8		
Cellulose acetate	max. oz	CA[1)]	3.8	5.2	6.8		
Celluloseacetobutyrate	max. oz	CAB[1)]	3.6	4.9	6.4		
Polymethyl methacrylate	max. oz	PMMA	3.5	4.8	6.3		
Polyphenylene oxide, mod.	max. oz	PPO	3.2	4.3	5.6		
Polycarbonate	max. oz	PC	3.6	4.9	6.4		
Polysulphone	max. oz	PSU	3.7	5.0	6.6		
Polyamides	max. oz	PA 6.6 | PA 6[1)]	3.4	4.6	6.0		
	max. oz	PA 6.10 | PA 11[1)]	3.2	4.3	5.6		
Polyoximethylene (Polyacetal)	max. oz	POM	4.2	5.8	7.5		
Polyethylene terephthalate	max. oz	PET	4.1	5.5	7.2		
Polyethylene	max. oz	PE-LD	2.6	3.5	4.6		
	max. oz	PE-HD	2.7	3.6	4.7		
Polypropylene	max. oz	PP	2.7	3.7	4.8		
Fluorpolymerides	max. oz	FEP, PFA, PCTFE[1)]	5.5	7.4	9.7		
	max. oz	ETFE	4.8	6.5	8.5		
Polyvinyl chloride	max. oz	PVC-U	4.1	5.6	7.3		
	max. oz	PVC-P[1)]	3.8	5.2	6.8		

1) average value

ARBURG GmbH + Co KG
Arthur-Hehl-Strasse
72290 Lossburg
Tel.: +49 7446 33-0
www.arburg.com
contact@arburg.com

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