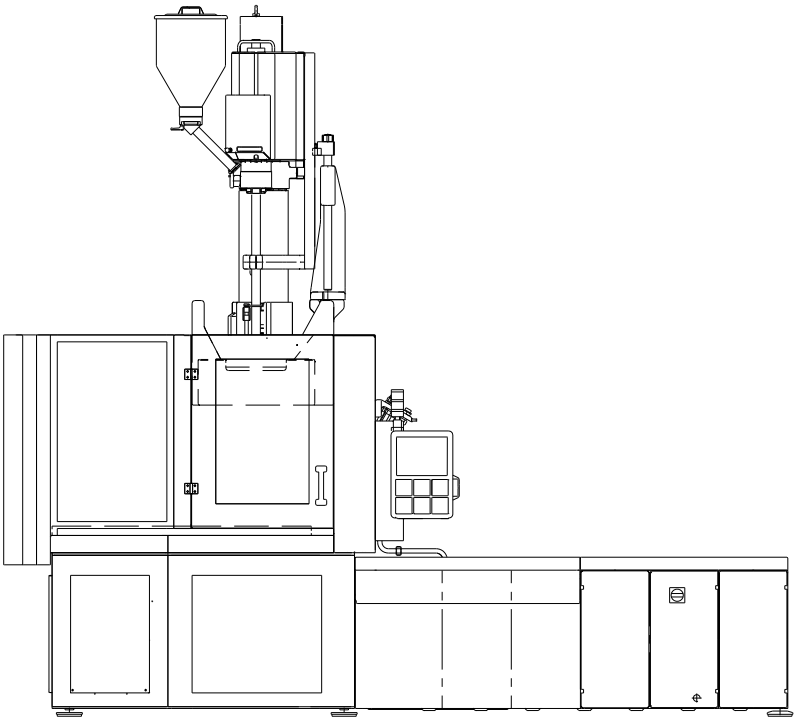
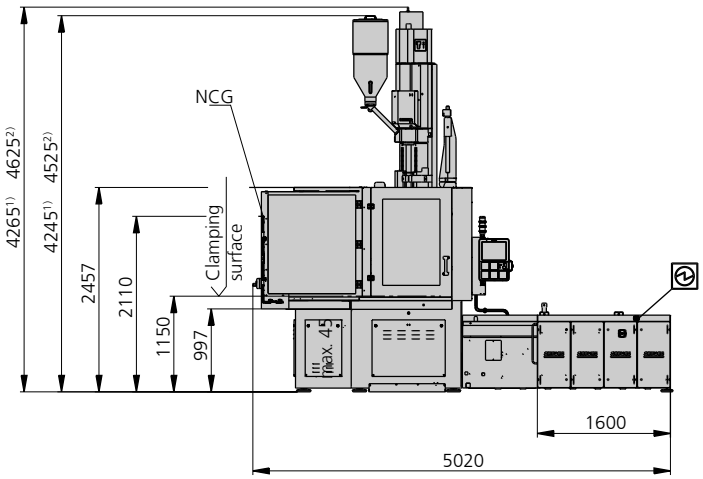


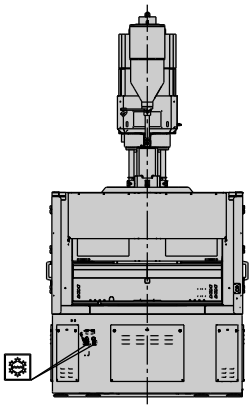
ALLROUNDER 1800 T

Table diameter: 1800 mm
Clamping force: 2000, 2500, 3200 kN
Injection unit (acc. to EUROMAP): 400, 800, 1300, 2100

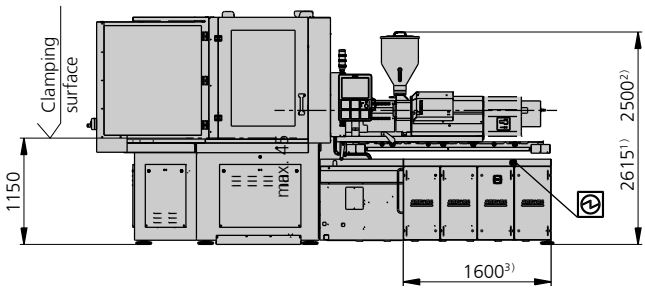
ARBURG

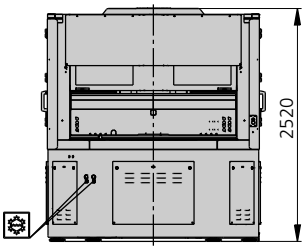
MACHINE DIMENSIONS UP TO 2000 KN | 1800 T

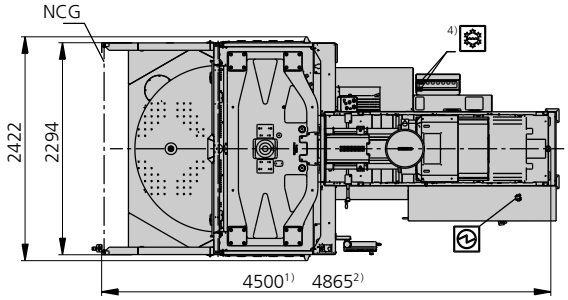




Horizontal version





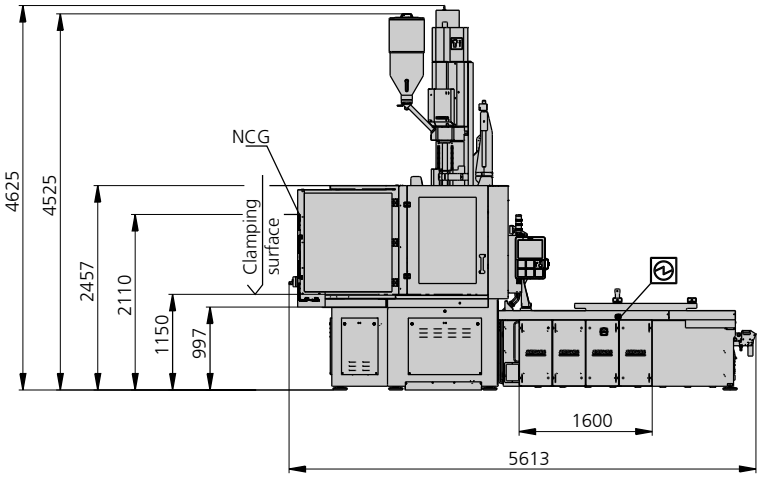


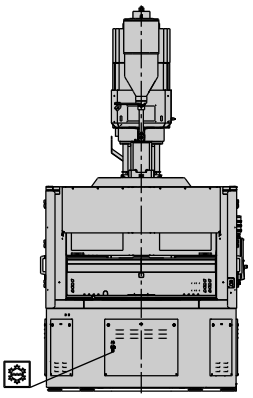
Electrical connection

Cooling water connection

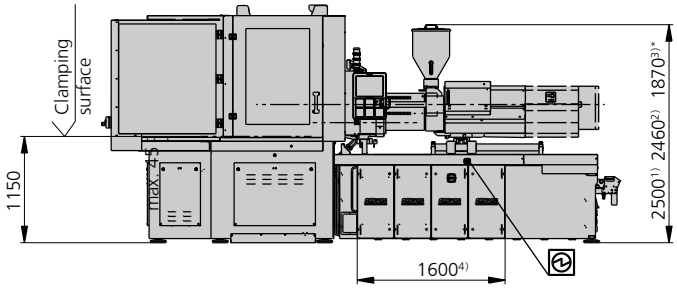
1) Injection unit 400
2) Injection unit 800
3) The control cabinet length and position of the electrical connection can vary due to optional equipment
4) Position of cooling water connections can vary due to optional equipment
NCG - Non-contacting guard (photoelectric safety barrier)

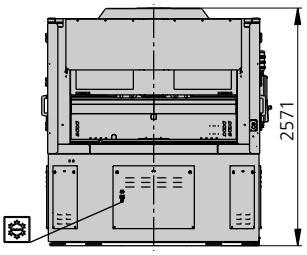
MACHINE DIMENSIONS FROM 2500 KN | 1800 T

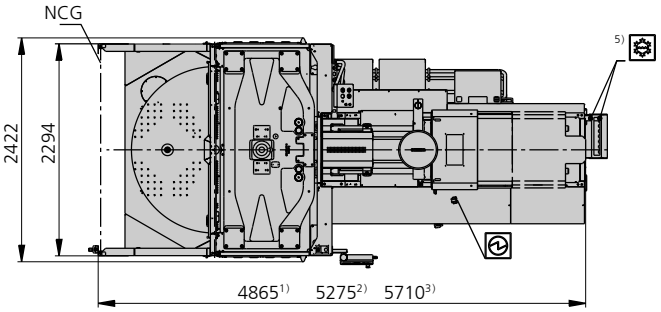




Horizontal version







Electrical connection

Cooling water connection

* without feed hopper
NCG - Non-contacting guard (photoelectric safety barrier)
1) Injection unit 800
2) Injection unit 1300
3) Injection unit 2100
4) The control cabinet length and position of the electrical connection can vary due to optional equipment
5) Position of cooling water connections can vary due to optional equipment

TECHNICAL DATA | 1800 T

Clamping unit				**1800 T**
with clamping force		max.	kN	2000
Opening force | stroke		max.	kN | mm	115 | 300
Mould height, fixed | variable		min.	mm	400 | ---
Platen daylight fixed | variable		max.	mm	700 | ---
Table diameter			mm	1800
Angle of rotation, left/right				180°
Rotation time for 180°		min.	s	3,2
Weight on rotary table		max.	kg	1650
Weight of movable mould half		max.	kg	800
Ejector force | stroke		max.	kN | mm	25 | 175
Dry cycle time EUROMAP ²	2 pumps	min.	s - mm	4,9 - 290
	Accum.	min.	s - mm	---

Injection unit				**400**			**800**			
with screw diameter			mm	35	40	45	45	50	55	
Effective screw length			L/D	23	20	18	22	20	18	
Screw stroke		max.	mm		160			200		
Calculated stroke volume		max.	cm³	154	201	254	318	392	474	
Shot weight		max.	g PS	141	184	232	291	359	434	
Material throughput		max.	kg/h PS	25	29	35	46	53	59	
		max.	kg/h PA6.6	12,5	15	17,5	23	27	30	
Injection pressure		max.	bar	2500	2000	1580	2470	2000	1650	
Holding pressure		max.	bar	2500	2000	1580	2470	2000	1650	
Injection flow ²	2 pumps	max.	cm³/s	128	168	212	174	214	260	
	Accum.	max.	cm³/s	492	642	814	530	656	792	
Screw circumferential	2 pumps	max.	m/min	47	53	60	54	60	66	
speed ²	Accum.	max.	m/min	16	19	21	15	17	19	
Screw torque		max.	Nm	480	550	610		880		
Nozzle contact force | retraction stroke		max.	kN | mm		60 | 400			70 | 400		
Heating capacity | zones			kW		9,4 | 5			19,9 | 8		
Feed hopper			l		50			---		

Drive and connection				**2 pumps**		**Accum.**	
with injection unit				400	800	400	800
Net weight of machine			kg	18200	18500		---
Sound press. level | Insecurity ⁴			dB(A)		---		---
Oil filling			l		260		260
Drive power ²		max.	kW	22	30		---
Electrical connection ³			kW	36	55		---
	Total		A	100	125		---
	Machine		A		---		---
	Heating		A		---		---
Cooling water connection		max.	°C		25		25
		min.	Δp bar		1,5 | DN 25		1,5 | DN 25

Machine type
with EUROMAP size designation ¹
1800 T 2000-400 | 800

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) - large 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.

TECHNICAL DATA | 1800 T

Clamping unit				**1800 T**
with clamping force		max.	kN	2500
Opening force | stroke		max.	kN | mm	115 | 300
Mould height, fixed | variable		min.	mm	400 | ---
Platen daylight fixed | variable		max.	mm	700 | ---
Table diameter			mm	1800
Angle of rotation, left/right				180°
Rotation time for 180°		min.	s	3,2
Weight on rotary table		max.	kg	1650
Weight of movable mould half		max.	kg	800
Ejector force | stroke		max.	kN | mm	25 | 175
Dry cycle time EUROMAP ²	2 pumps	min.	s - mm	4,9 - 290
	Accum.	min.	s - mm	---

Injection unit				**800**			**1300**			
with screw diameter			mm	45	50	55	55	60	70	
Effective screw length			L/D	22	20	18	22	20	17	
Screw stroke		max.	mm		200			235		
Calculated stroke volume		max.	cm³	318	392	474	558	664	904	
Shot weight		max.	g PS	291	359	434	510	607	826	
Material throughput		max.	kg/h PS	46	53	59	86	96	115	
		max.	kg/h PA6.6	23	27	30	43	48	58	
Injection pressure		max.	bar	2470	2000	1650	2380	2000	1470	
Holding pressure		max.	bar	2470	2000	1650	2380	2000	1470	
Injection flow ²	2 pumps	max.	cm³/s	242	300	364	238	284	388	
	Accum.	max.	cm³/s	530	656	792	714	848	1156	
Screw circumferential	2 pumps	max.	m/min	54	60	66	40	43	51	
speed ²	Accum.	max.	m/min	15	17	19	19	21	25	
Screw torque		max.	Nm		880		1510	1640	1920	
Nozzle contact force | retraction stroke		max.	kN | mm		70 | 400			90 | 550		
Heating capacity | zones			kW		19,9 | 8			22,9 | 8		
Feed hopper			l		---			---		

Drive and connection				**2 pumps**		**Accum.**	
with injection unit				800	1300	800	1300
Net weight of machine			kg	21000	21500	---	
Sound press. level | Insecurity ⁴			dB(A)		---	---	
Oil filling			l		300	300	
Drive power ²		max.	kW	45	45	---	
Electrical connection ³			kW	68	71	---	
	Total		A		160	---	
	Machine		A		100	---	
	Heating		A		35	---	
Cooling water connection		max.	°C		25	25	
		min.	Δp bar		1,5 | DN 25	1,5 | DN 25	

Machine type
with EUROMAP size designation ¹
1800 T 2500-800 | 1300

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) - large 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.

TECHNICAL DATA | 1800 T

Clamping unit				**1800 T**
with clamping force		max.	kN	3200
Opening force | stroke		max.	kN | mm	115 | 300
Mould height, fixed | variable		min.	mm	400 | ---
Platen daylight fixed | variable		max.	mm	700 | ---
Table diameter			mm	1800
Angle of rotation, left/right				180°
Rotation time for 180°		min.	s	3,2
Weight on rotary table		max.	kg	1650
Weight of movable mould half		max.	kg	800
Ejector force | stroke		max.	kN | mm	25 | 175
Dry cycle time EUROMAP ²	2 pumps	min.	s - mm	4,9 - 290
	Accum.	min.	s - mm	---

Injection unit				**1300**			**2100**			
with screw diameter			mm	55	60	70	60	70	80	
Effective screw length			L/D	22	20	17	23	20	17,5	
Screw stroke		max.	mm		235			280		
Calculated stroke volume		max.	cm³	558	664	904	792	1078	1407	
Shot weight		max.	g PS	510	607	826	723	984	1286	
Material throughput		max.	kg/h PS	86	96	115	125	145	175	
		max.	kg/h PA6.6	43	48	58	62	74	88	
Injection pressure		max.	bar	2380	2000	1470	2500	2000	1530	
Holding pressure		max.	bar	2380	2000	1470	2500	2000	1530	
Injection flow ²	2 pumps	max.	cm³/s	238	284	388	224	306	400	
	Accum.	max.	cm³/s	714	848	1156	1132	1540	2012	
Screw circumferential	2 pumps	max.	m/min	40	43	51	43	51	58	
speed ²	Accum.	max.	m/min	19	21	25	21	25	28	
Screw torque		max.	Nm	1510	1640	1920	2140	2500	2550	
Nozzle contact force | retraction stroke		max.	kN | mm		90 | 550			110 | 600		
Heating capacity | zones			kW		22,9 | 8			31,4 | 8		
Feed hopper			l		---			---		

Drive and connection			**2 pumps**		**Accum.**	
with injection unit			1300	2100	1300	2100
Net weight of machine		kg	21500	22000		---
Sound press. level | Insecurity ⁴		dB(A)		---		---
Oil filling		l	300	400		400
Drive power ²		max. kW	45	55		---
Electrical connection ³		kW	71	89		---
	Total	A	125	---		---
	Machine	A	100	125		---
	Heating	A	35	50		---
Cooling water connection		max. °C		25		25
		min. Δp bar		1,5 | DN 25		1,5 | DN 25

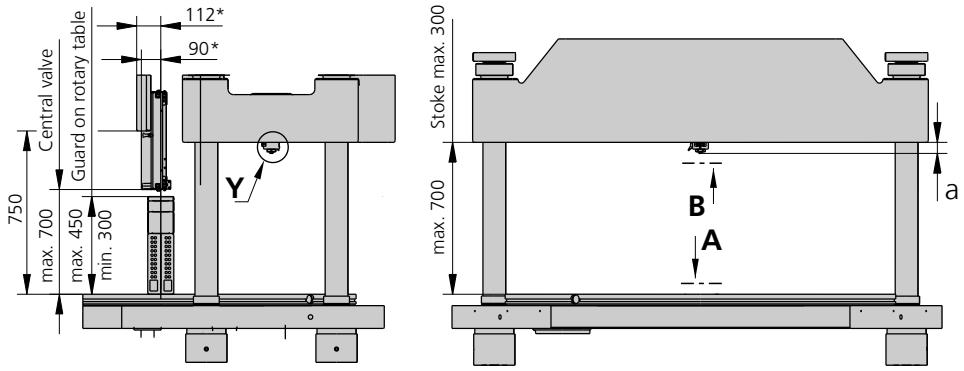
Machine type
with EUROMAP size designation ¹
1800 T 3200-1300 | 2100

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) - large 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.

1800 T

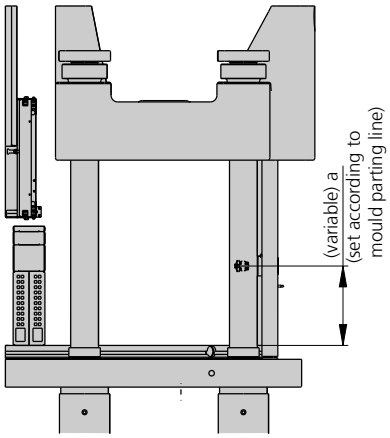
MOULD INSTALLATION DIMENSIONS UP TO 2000 KN | 1800 T



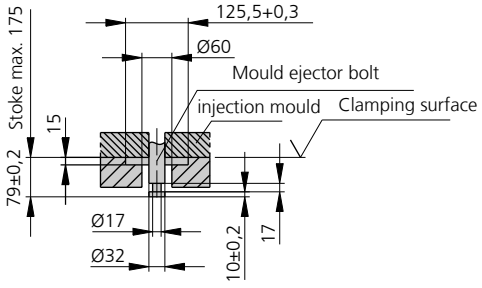
*Dimensions from table centre (guard of projecting edge + safety gate)

a max.	Injection unit 400 / 800
Standard	50
Thermoset	50

Vertical clamping unit



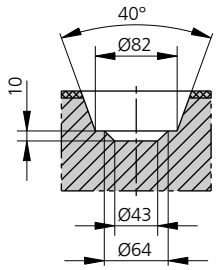
Ejector bolt



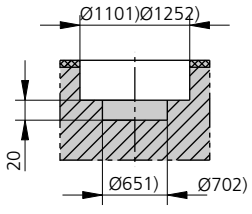
	Injection unit 400	800
a min.	300	300
a max.	400	500
b min.	100	120
c min.	270	270

Bore in mould (if required) | Y

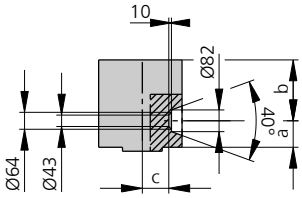
Injection unit 400 / 800



Injection unit 400[1] / 800[2]
Thermoset version



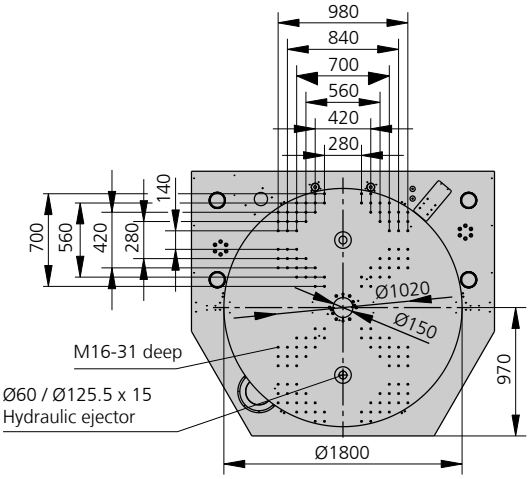
Bore in mould (if required)



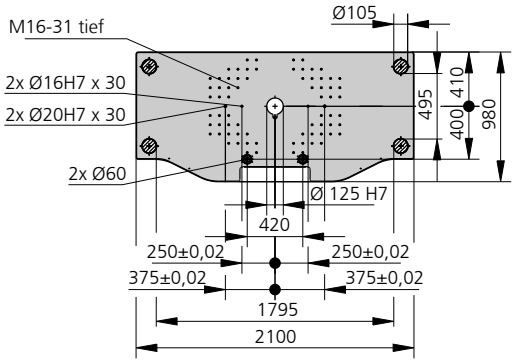
1) Injection unit 400
2) Injection unit 800

MOULD INSTALLATION DIMENSIONS UP TO 2000 KN | 1800 T

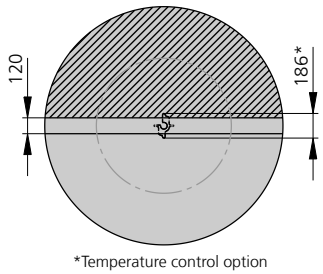
Moving mould mounting platen | A



Fixed mould mounting platen (rotary table) | B

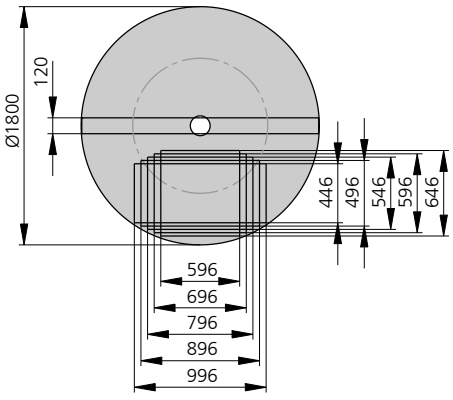


Usable clamping surface

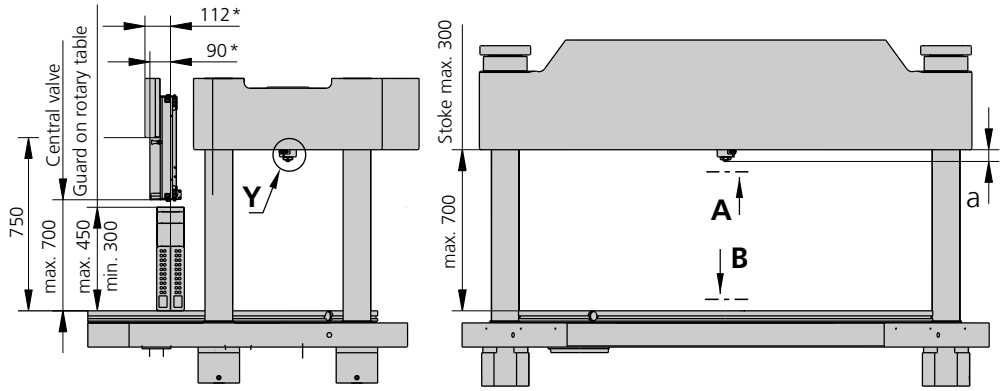


*Temperature control option

Mould grid dimensions 2-station mould



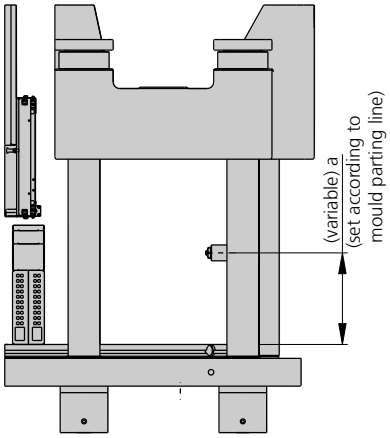
MOULD INSTALLATION DIMENSIONS FROM 2500 KN | 1800 T



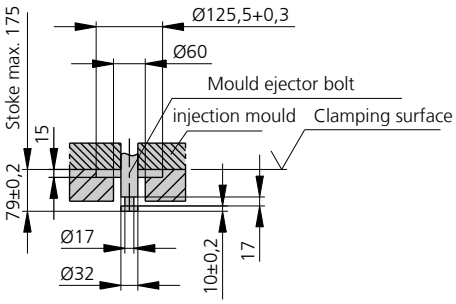
a max.	Injection unit 400 / 800
Standard	50
Duromer	50

*Dimensions from table centre (guard of projecting edge + safety gate)

Vertical clamping unit



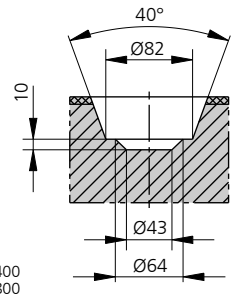
Hydraulic ejector



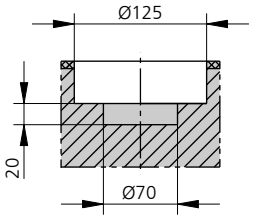
	Injection unit		
	800	1300	2100
a min.	300	350	400
a max.	500	450	500
b min.	120	120	120
c min.	270	170	130

Bore in mould (if required) | Y

Injection unit 800



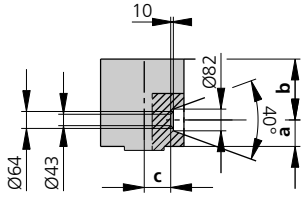
Injection unit 800
Thermoset version



1) Injection unit 400
2) Injection unit 800
3) Injection unit 1300
4) Injection unit 2100

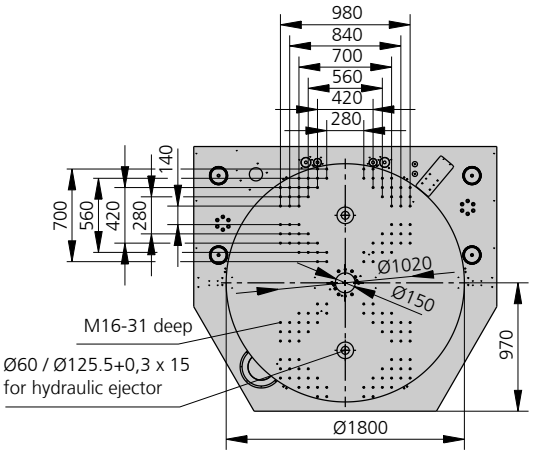
Bore in mould (if required)

Injection unit 800 / 1300 / 2100

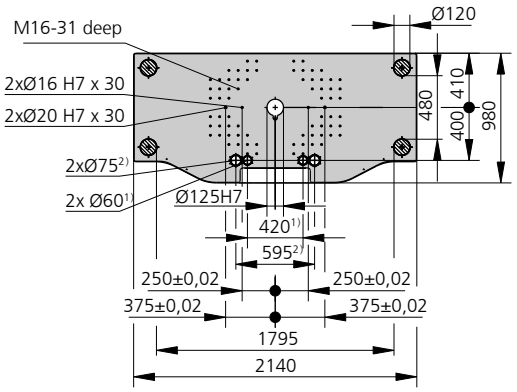


MOULD INSTALLATION DIMENSIONS FROM 2500 KN | 1800 T

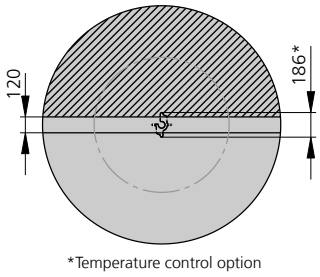
Moving mould mounting platen | A



Fixed mould mounting platen (rotary table) | B

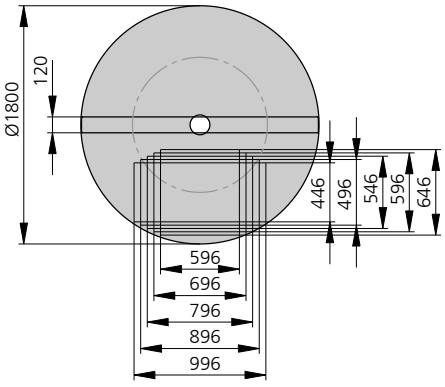


Usable clamping surface



*Temperature control option

Mould grid dimensions 2-station mould



1) Injection unit 800
2) Injection unit 1300 / Injection unit 2100

SHOT WEIGHTS | 1800 T

Theoretical shot weights for the most important injection moulding materials

Injection units according to EUROMAP		400			800			1300		
Screw diameter	mm	35	40	45	45	50	55	55	60	70
Polystyrene	max. g PS	141	184	232	291	359	434	510	607	826
Styrene heteropolymerizates	max. g SB	137	179	227	284	350	424	498	593	807
	max. g SAN, ABS[1)]	135	176	223	278	344	416	488	581	791
Cellulose acetate	max. g CA[1)]	158	207	262	327	404	488	574	683	930
Celluloseacetobutyrate	max. g CAB[1)]	147	192	243	304	375	454	534	635	865
Polymethyl methacrylate	max. g PMMA	145	190	240	300	371	449	527	627	854
Polyphenylene ether, mod.	max. g PPE	131	171	216	270	333	403	473	563	767
Polycarbonate	max. g PC	148	193	244	305	377	456	536	638	868
Polysulphone	max. g PSU	153	199	252	316	390	471	554	659	897
Polyamides	max. g PA 6.6 | PA 6[1)]	140	183	231	289	357	431	507	603	821
	max. g PA 6.10 | PA 11[1)]	131	171	216	270	333	403	473	563	767
Polyoximethylene (Polyacetal)	max. g POM	174	227	287	359	443	536	630	749	1020
Polyethylene terephthalate	max. g PET	167	219	277	346	427	517	607	723	984
Polyethylene	max. g PE-LD	106	139	176	219	271	328	385	458	624
	max. g PE-HD	110	143	181	227	280	339	398	473	644
Polypropylene	max. g PP	112	146	185	232	286	346	406	484	658
Fluorpolymerides	max. g FEP, PFA, PCTFE[1)]	225	294	372	465	574	695	816	971	1322
	max. g ETFE	196	256	324	408	504	609	716	852	1160
Polyvinyl chloride	max. g PVC-U	170	222	281	351	434	525	616	734	998
	max. g PVC-P[1)]	157	205	260	324	401	485	569	678	922

Injection units according to EUROMAP		2100		
Screw diameter	mm	60	70	80
Polystyrene	max. g PS	723	984	1286
Styrene heteropolymerizates	max. g SB	707	962	1256
	max. g SAN, ABS[1)]	693	943	1231
Cellulose acetate	max. g CA[1)]	814	1108	1447
Celluloseacetobutyrate	max. g CAB[1)]	757	1030	1346
Polymethyl methacrylate	max. g PMMA	747	1017	1329
Polyphenylene ether, mod.	max. g PPE	671	914	1194
Polycarbonate	max. g PC	760	1034	1351
Polysulphone	max. g PSU	785	1069	1396
Polyamides	max. g PA 6.6 | PA 6[1)]	719	978	1278
	max. g PA 6.10 | PA 11[1)]	671	914	1194
Polyoximethylene (Polyacetal)	max. g POM	893	1215	1588
Polyethylene terephthalate	max. g PET	861	1172	1531
Polyethylene	max. g PE-LD	546	744	971
	max. g PE-HD	564	768	1003
Polypropylene	max. g PP	576	784	1025
Fluorpolymerides	max. g FEP, PFA, PCTFE[1)]	1157	1575	2058
	max. g ETFE	1015	1382	1805
Polyvinyl chloride	max. g PVC-U	874	1190	1554
	max. g PVC-P[1)]	808	1099	1436

1) average value

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