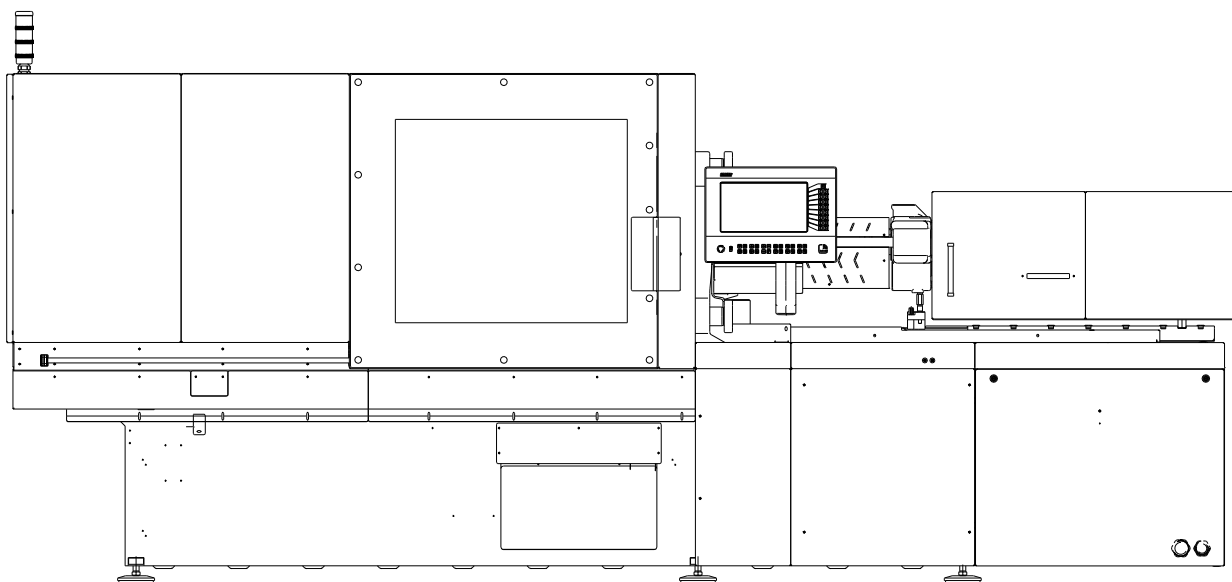




## ALLROUNDER 1300 e TREND

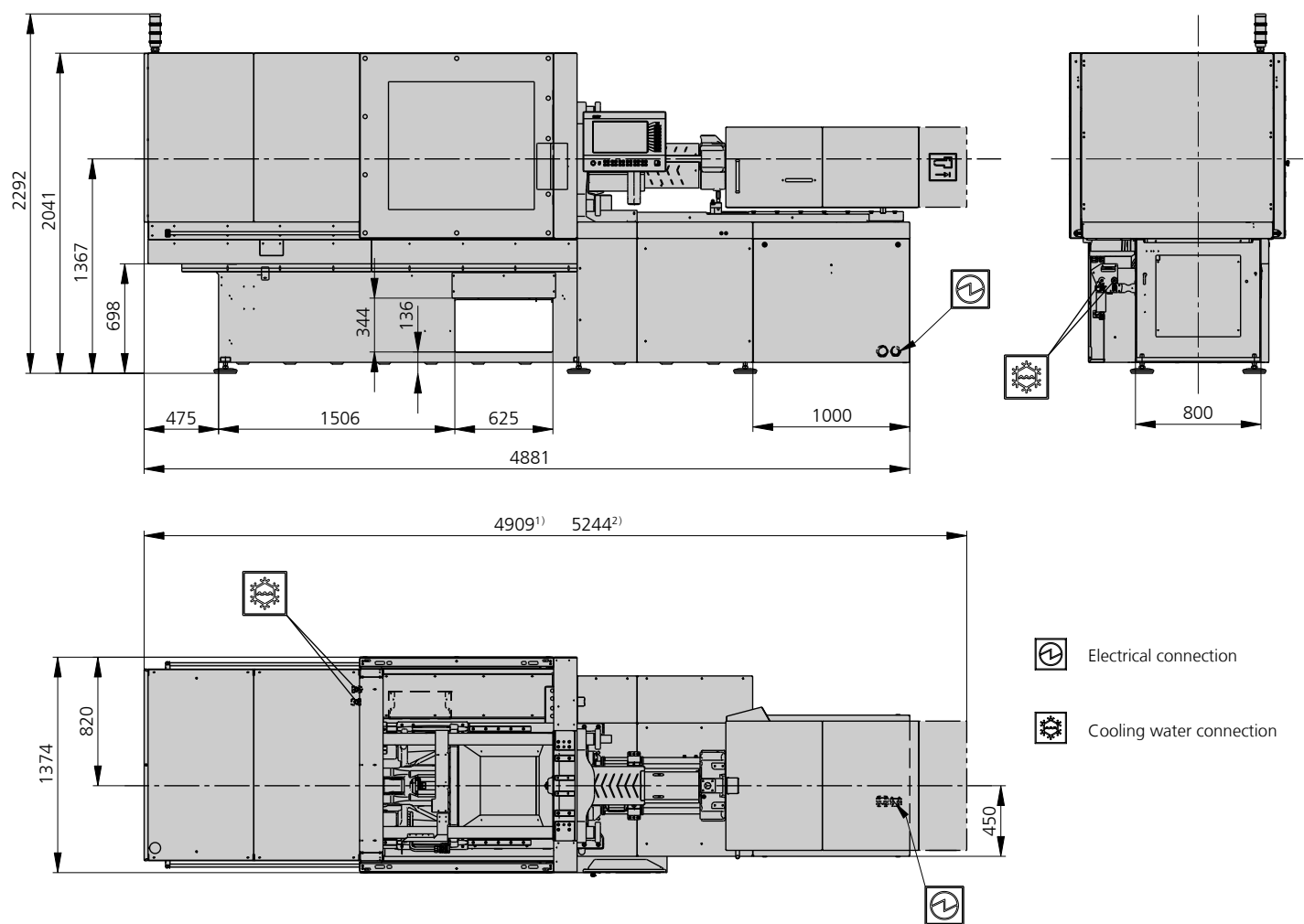
Distance between tie bars: 520 x 520 mm

Clamping force: 1300 kN

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

**ARBURG**

# MACHINE DIMENSIONS | 1300 e TREND



1) Injection unit 290 e

2) Injection unit 400 e

# TECHNICAL DATA | 1300 e TREND

| Clamping unit                     |              | 1300 e TREND   |
|-----------------------------------|--------------|----------------|
| with clamping force               | max. kN      | 1300 [1500]    |
| Opening force   stroke            | max. kN   mm | ---   500      |
| Mould height, fixed   variable    | min.-max. mm | ---   200-600  |
| Platen daylight fixed   variable  | max. mm      | ---   700-1100 |
| Distance between tie bars (w x h) | mm           | 520 x 520      |
| Mould mounting platens (w x h)    | max. mm      | 695 x 695      |
| Weight of movable mould half      | max. kg      | 910            |
| Ejector force   stroke            | max. kN   mm | 35   150       |
| Dry cycle time EUROMAP            | min. s - mm  | 1,7 - 364      |

| Injection unit                           |                 | 290 e         |         |         | 400 e         |         |         |
|------------------------------------------|-----------------|---------------|---------|---------|---------------|---------|---------|
| with screw diameter                      | mm              | 30            | 35      | 40      | 35            | 40      | 45      |
| Effective screw length                   | L/D             | 23,3          | 20      | 17,5    | 23            | 20      | 18      |
| Screw stroke                             | max. mm         | 150           |         |         | 160           |         |         |
| Calculated stroke volume                 | max. cm³        | 106           | 144     | 188     | 154           | 201     | 254     |
| Shot weight                              | max. g PS       | 97            | 132     | 172     | 141           | 184     | 232     |
| Material throughput                      | max. kg/h PS    | 17            | 20,5    | 24,5    | 25            | 29      | 35      |
|                                          | max. kg/h PA6.6 | 8,5           | 10,5    | 12,5    | 12,5          | 15      | 17,5    |
| Injection pressure                       | max. bar        | 2500          | 2000    | 1530    | 2500          | 2000    | 1580    |
| Holding pressure time <sup>6</sup>       | max. s - bar    | 45-2180       | 45-1600 | 45-1220 | 45-2090       | 45-1600 | 45-1260 |
| Injection flow <sup>2</sup>              | max. cm³/s      | 142           | 194     | 254     | 194           | 252     | 320     |
| Injection flow <sup>7</sup>              | max. cm³/s      | [248]         | [338]   | [442]   | [336]         | [440]   | [556]   |
| Injection flow <sup>7</sup>              | max. cm³/s      | [354]         | [482]   | [628]   | ---           | ---     | ---     |
| Injection speed <sup>5</sup>             | max. mm/s       | 200           |         |         | 200           |         |         |
| Injection speed <sup>8</sup>             | max. mm/s       | [350] [500]   |         |         | [350]         |         |         |
| Screw circumferential speed              | max. m/min      | 26 [51]       | 30 [60] | 34 [69] | 26 [53]       | 30 [60] | 34 [68] |
| Screw torque                             | max. Nm         | 320           | 380     | 430     | 480           | 550     | 610     |
| Nozzle contact force   retraction stroke | max. kN   mm    | 30 [50]   240 |         |         | 40 [60]   300 |         |         |
| Heating capacity   zones                 | kW              | 7,7   5       |         |         | 9,7   5       |         |         |

| Drive and connection                         |             | 290 e        |  | 400 e       |
|----------------------------------------------|-------------|--------------|--|-------------|
| with injection unit                          |             |              |  |             |
| Net weight of machine                        | kg          | 5150         |  | 5200        |
| Sound press. level   Insecurity <sup>4</sup> | dB(A)       |              |  | 58   3      |
| Electrical connection <sup>3</sup>           | kW          | 24 [26] [27] |  | 29 [31]     |
|                                              | Total       | 50 [63] [80] |  | 63 [80]     |
|                                              | Machine     |              |  | ---         |
|                                              | Heating     |              |  | ---         |
| Cooling water connection                     | max. °C     |              |  | 35          |
|                                              | min. Δp bar |              |  | 1,5   DN 25 |

## Machine type (according to EUROMAP) <sup>1</sup>

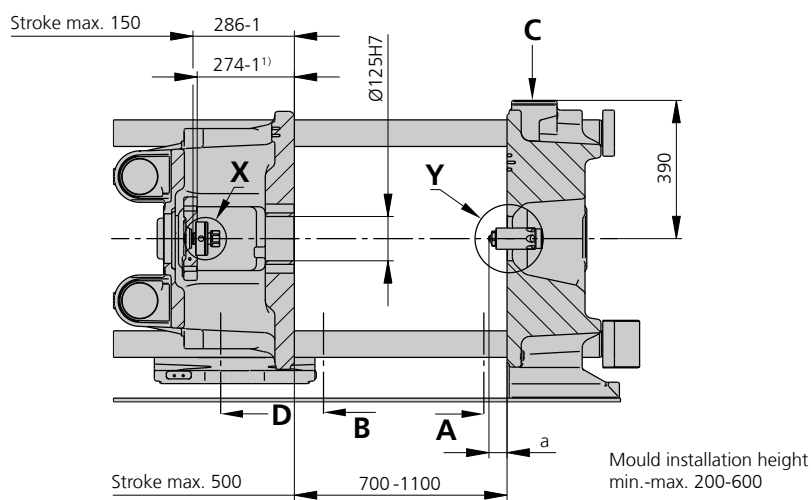
ALLROUNDER 1300 e TREND 290 e | 400 e

## Upon request: other machine types and mould installation heights, screws, drive powers etc.

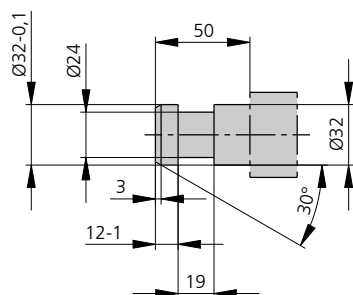
All specifications relate to the basic machine version. Deviations are possible depending on variants, process settings and material type. Depending on the drive, certain combinations, e.g. max. injection pressure and max. injection flow may be mutually exclusive.

- 1) Clamping force (kN) - size of injection unit = max. stroke volume (cm³) x max. injection pressure (kbar)
- 2) Specification of maximum injection flow at 1000 bar injection pressure.
- 3) Specifications relate to 400 V/50 Hz.
- 4) Emission sound pressure level at the workplace. Detailed information in the operating instructions.
- 5) Forward speed of plasticising screw at 1000 bar injection pressure.
- 6) Holding pressure duration may differ at 500 mm/s injection speed.
- 7) Specification of maximum injection flow at 2000 bar injection pressure
- 8) Forward speed of plasticising screw at 2000 bar injection pressure.
- [ ] Specifications apply to alternative equipment.

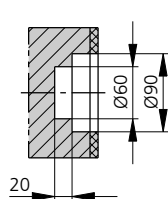
# MOULD INSTALLATION DIMENSIONS | 1300 e TREND



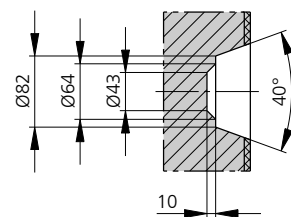
Ejector bolt | X



Bore in mould (if required) | Y

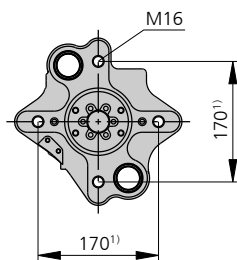


Injection unit 290

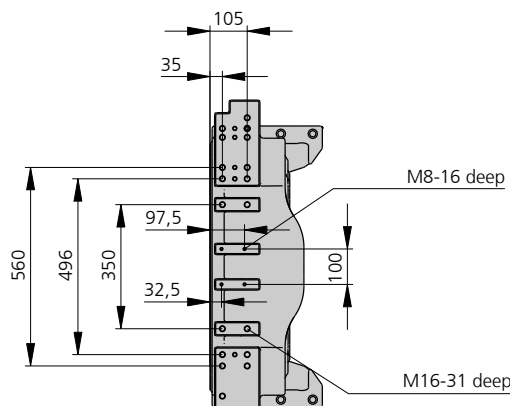


Injection unit 400

Ejector plate | D



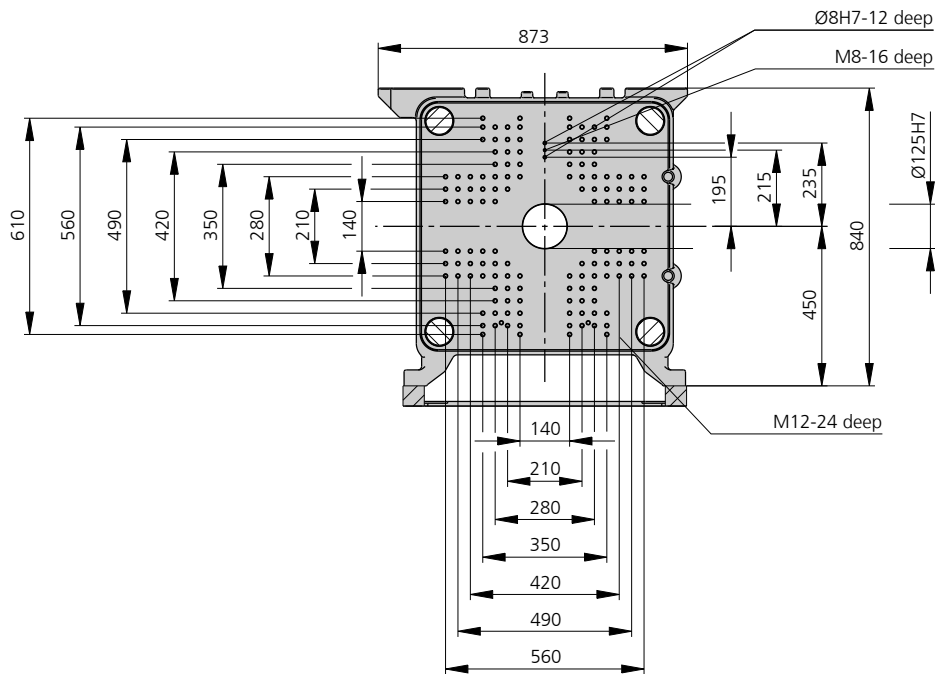
Robotic system mounting | C



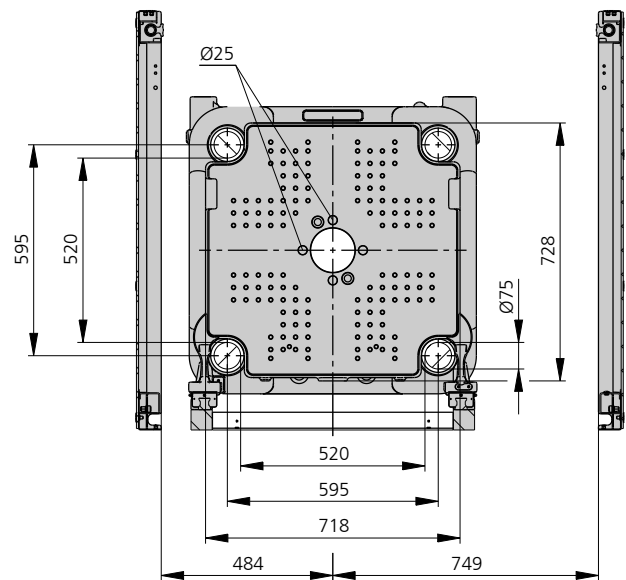
1) Position of ejector plate

# MOULD INSTALLATION DIMENSIONS | 1300 e TREND

Fixed mould mounting platen | A



Moving mould mounting platen | B



# SHOT WEIGHTS | 1300 e TREND

## Theoretical shot weights for the most important injection moulding materials

| Injection units according to EUROMAP |                                      | 290 |     |     | 400 |     |     |  |
|--------------------------------------|--------------------------------------|-----|-----|-----|-----|-----|-----|--|
| Screw diameter                       | mm                                   | 30  | 35  | 40  | 35  | 40  | 45  |  |
| Polystyrene                          | max. g PS                            | 97  | 132 | 172 | 141 | 184 | 232 |  |
| Styrene heteropolymerizates          | max. g SB                            | 95  | 129 | 168 | 137 | 179 | 227 |  |
|                                      | max. g SAN, ABS <sup>1)</sup>        | 93  | 126 | 165 | 135 | 176 | 223 |  |
| Cellulose acetate                    | max. g CA <sup>1)</sup>              | 109 | 148 | 194 | 158 | 207 | 262 |  |
| Celluloseacetobutyrate               | max. g CAB <sup>1)</sup>             | 101 | 138 | 180 | 147 | 192 | 243 |  |
| Polymethyl methacrylate              | max. g PMMA                          | 100 | 136 | 178 | 145 | 190 | 240 |  |
| Polyphenylene ether, mod.            | max. g PPE                           | 90  | 122 | 160 | 131 | 171 | 216 |  |
| Polycarbonate                        | max. g PC                            | 102 | 139 | 181 | 148 | 193 | 244 |  |
| Polysulphone                         | max. g PSU                           | 105 | 143 | 187 | 153 | 199 | 252 |  |
| Polyamides                           | max. g PA 6.6   PA 6 <sup>1)</sup>   | 96  | 131 | 171 | 140 | 183 | 231 |  |
|                                      | max. g PA 6.10   PA 11 <sup>1)</sup> | 90  | 122 | 160 | 131 | 171 | 216 |  |
| Polyoximethylene (Polyacetal)        | max. g POM                           | 120 | 163 | 213 | 174 | 227 | 287 |  |
| Polyethylene terephthalate           | max. g PET                           | 115 | 157 | 205 | 167 | 219 | 277 |  |
| Polyethylene                         | max. g PE-LD                         | 73  | 100 | 130 | 106 | 139 | 176 |  |
|                                      | max. g PE-HD                         | 76  | 103 | 134 | 110 | 143 | 181 |  |
| Polypropylene                        | max. g PP                            | 77  | 105 | 137 | 112 | 146 | 185 |  |
| Fluoropolymerides                    | max. g FEP, PFA, PCTFE <sup>1)</sup> | 155 | 211 | 276 | 225 | 294 | 372 |  |
|                                      | max. g ETFE                          | 136 | 185 | 242 | 196 | 256 | 324 |  |
| Polyvinyl chloride                   | max. g PVC-U                         | 117 | 159 | 208 | 170 | 222 | 281 |  |
|                                      | max. g PVC-P <sup>1)</sup>           | 108 | 147 | 192 | 157 | 205 | 260 |  |

1) average value

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