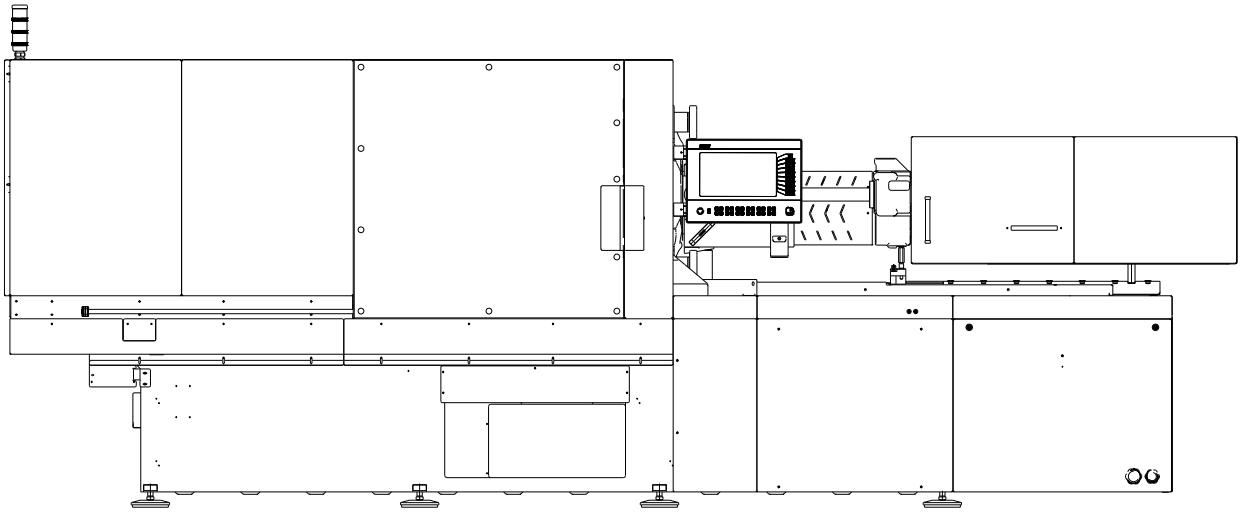
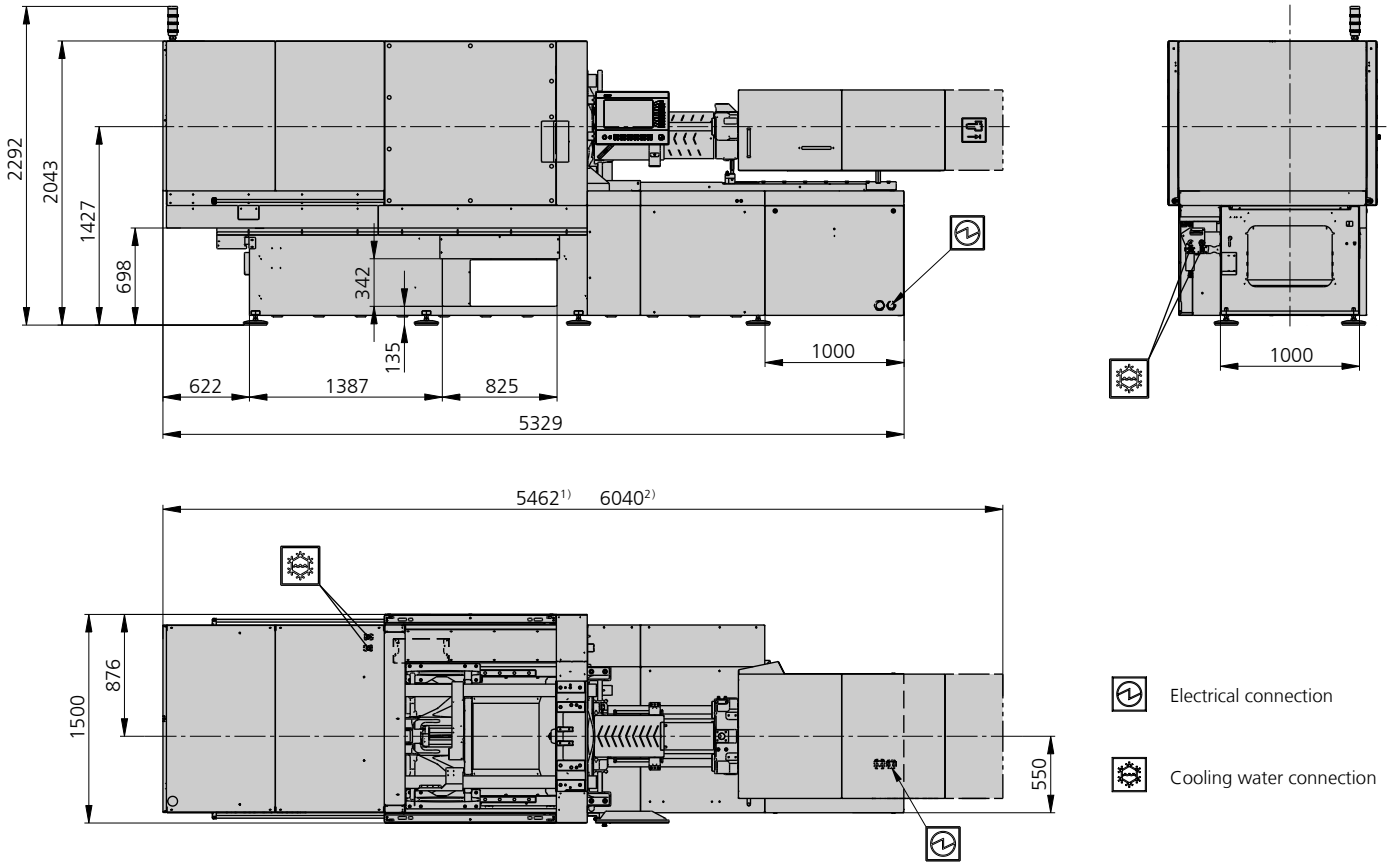


ALLROUNDER 1800 e TREND

Distance between tie bars: 570 x 570 mm
Clamping force: 1800 kN
Injection unit (acc. to EUROMAP): 400 e, 800 e

ARBURG

MACHINE DIMENSIONS | 1800 e TREND



1) Injection unit 400 e
2) Injection unit 800 e

TECHNICAL DATA | 1800 e TREND

Clamping unit			**1800 e TREND**
with clamping force	max.	kN	1800 [2000]
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	570 x 570
Mould mounting platens (w x h)	max.	mm	795 x 795
Weight of movable mould half	max.	kg	1300
Ejector force | stroke	max.	kN | mm	60 | 200
Dry cycle time EUROMAP	min.	s - mm	1,9 - 399

Injection unit			**400 e**			**800 e**			
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 time [6]	max.	s - bar	45-2090	45-1600	45-1260	45-1970	45-1600	45-1320	
Injection flow [2]	max.	cm³/s	194	252	320	318	394	476	
Injection flow [7]	max.	cm³/s	[336]	[440]	[556]	[478]	[590]	[714]	
Injection flow [7]	max.	cm³/s	---	---	---	---	---	---	
Injection speed [5]	max.	mm/s		200			200		
Injection speed [8]	max.	mm/s		[350]			[300]		
Screw circumferential speed	max.	m/min	26 [53]	30 [60]	34 [68]	27 [54]	30 [60]	33 [66]	
Screw torque	max.	Nm	480	550	610	900	1000	1100	
Nozzle contact force | retraction stroke	max.	kN | mm		40 [60] | 300			50 [70] | 400		
Heating capacity | zones		kW		9,7 | 5			19,9 | 8		

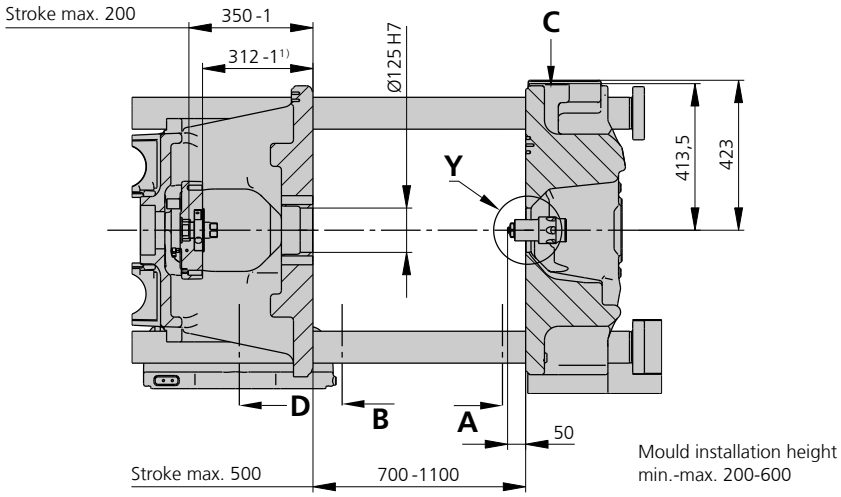
Drive and connection					
with injection unit				400 e	800 e
Net weight of machine			kg	6250	6900
Sound press. level | Insecurity [4]			dB(A)	58 | 3	
Electrical connection [3]			kW	30 [32]	49 [50]
	Total		A	63 [80]	80 [100]
	Machine		A	---	
	Heating		A	---	
Cooling water connection		max.	°C	35	
		min.	Δp bar	1,5 | DN 25	

Machine type (according to EUROMAP) [1]
ALLROUNDER 1800 e TREND 400 e | 800 e

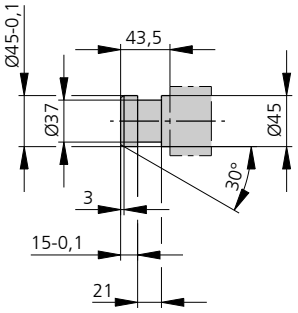
Upon request: other machine types and mould installation heights, screws, drive powers etc.
All specifications relate to the basic machine version. Deviations are possible depending on variants, process settings and material type. Depending on the drive, certain combinations, e.g. max. injection pressure 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.

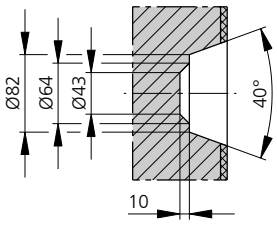
MOULD INSTALLATION DIMENSIONS | 1800 e TREND



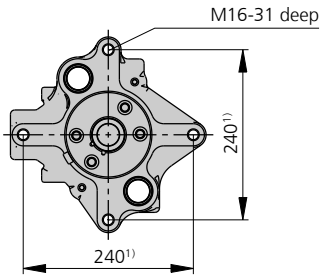
Ejector bolt | X



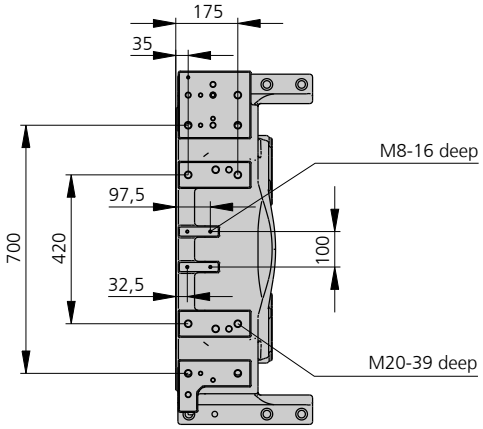
Bore in mould (if required) | Y



Ejector plate | D



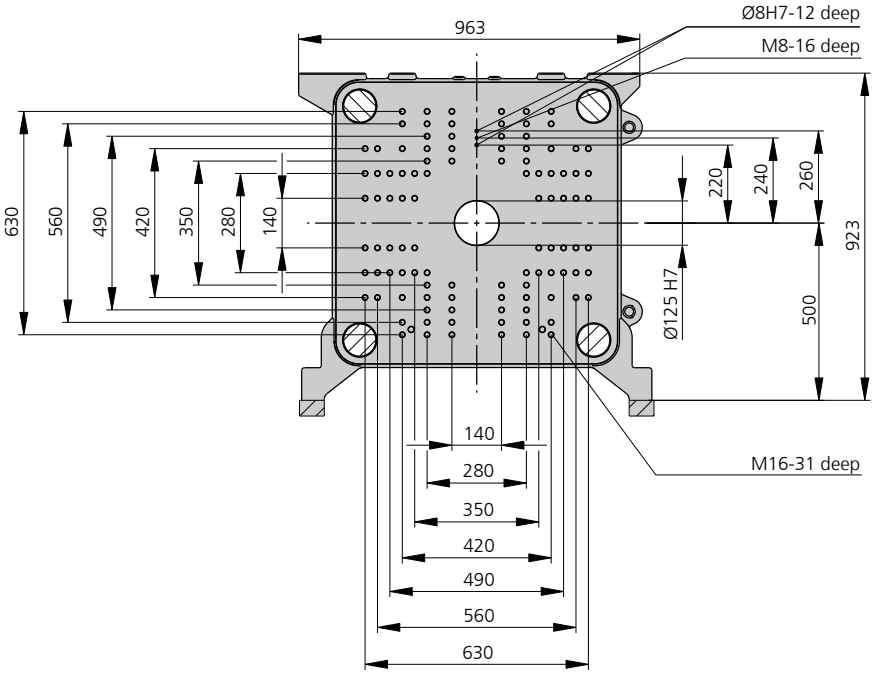
Robotic system mounting | C



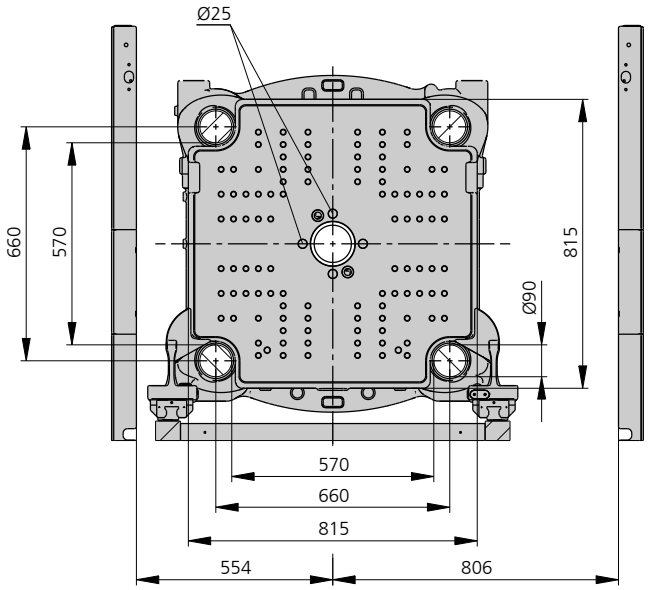
1) Position of ejector plate

MOULD INSTALLATION DIMENSIONS | 1800 e TREND

Fixed mould mounting platen | A



Moving mould mounting platen | B



SHOT WEIGHTS | 1800 e TREND

Theoretical shot weights for the most important injection moulding materials

Injection units according to EUROMAP			400			800			
Screw diameter		mm	35	40	45	45	50	55	
Polystyrene	max. g	PS	141	184	232	291	359	434	
Styrene heteropolymerizates	max. g	SB	137	179	227	284	350	424	
	max. g	SAN, ABS[1)]	135	176	223	278	344	416	
Cellulose acetate	max. g	CA[1)]	158	207	262	327	404	488	
Celluloseacetobutyrate	max. g	CAB[1)]	147	192	243	304	375	454	
Polymethyl methacrylate	max. g	PMMA	145	190	240	300	371	449	
Polyphenylene ether, mod.	max. g	PPE	131	171	216	270	333	403	
Polycarbonate	max. g	PC	148	193	244	305	377	456	
Polysulphone	max. g	PSU	153	199	252	316	390	471	
Polyamides	max. g	PA 6.6 | PA 6[1)]	140	183	231	289	357	431	
	max. g	PA 6.10 | PA 11[1)]	131	171	216	270	333	403	
Polyoximethylene (Polyacetal)	max. g	POM	174	227	287	359	443	536	
Polyethylene terephthalate	max. g	PET	167	219	277	346	427	517	
Polyethylene	max. g	PE-LD	106	139	176	219	271	328	
	max. g	PE-HD	110	143	181	227	280	339	
Polypropylene	max. g	PP	112	146	185	232	286	346	
Fluorpolymerides	max. g	FEP, PFA, PCTFE[1)]	225	294	372	465	574	695	
	max. g	ETFE	196	256	324	408	504	609	
Polyvinyl chloride	max. g	PVC-U	170	222	281	351	434	525	
	max. g	PVC-P[1)]	157	205	260	324	401	485	

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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