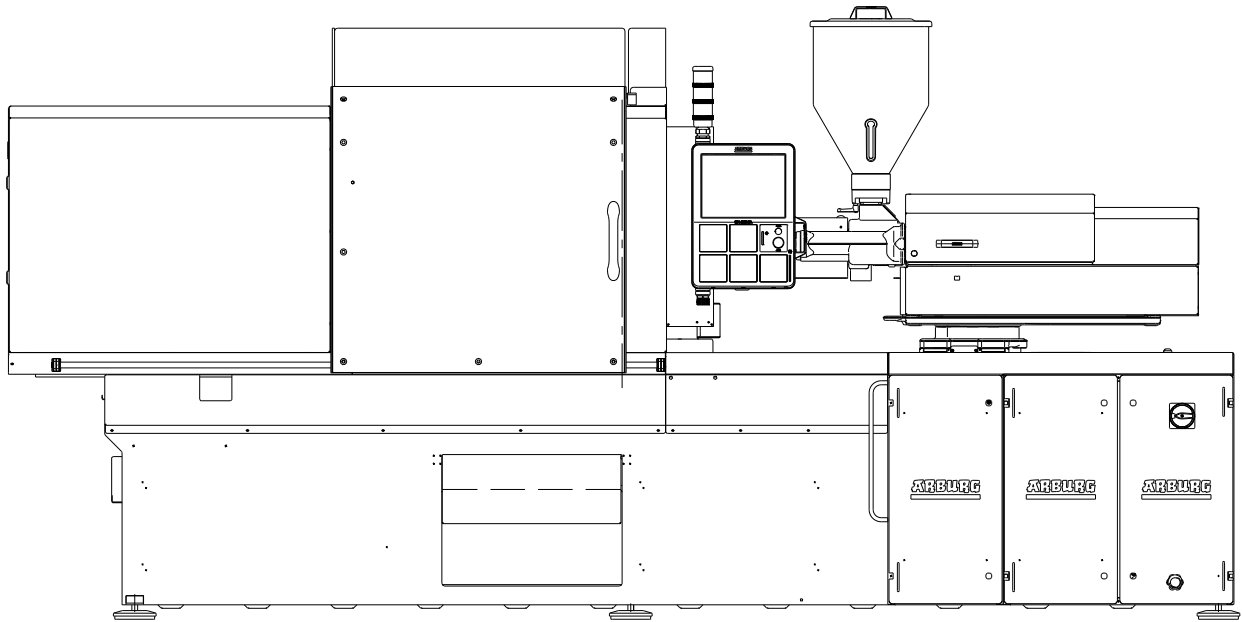




ALLROUNDER 470 E

GOLDEN ELECTRIC

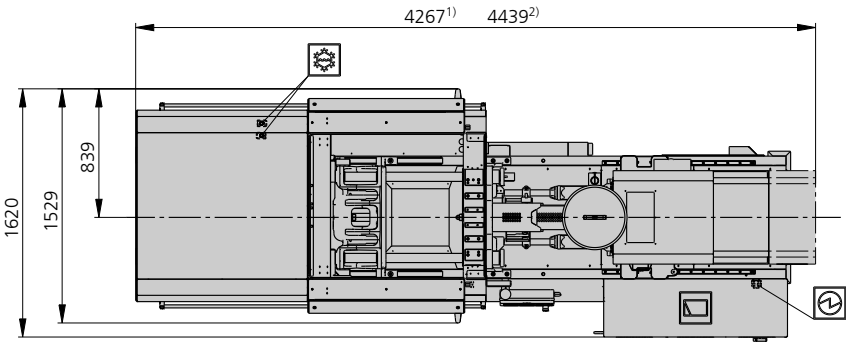
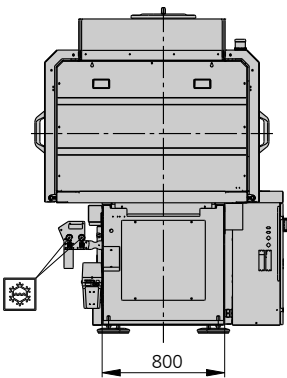
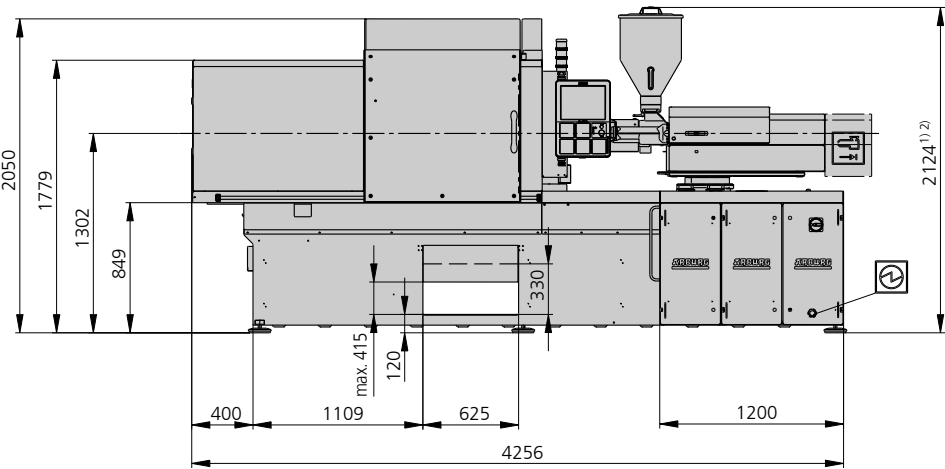
Distance between tie bars: 470 x 470 mm

Clamping force: 1000 kN

Injection unit (acc. to EUROMAP): 170, 290

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MACHINE DIMENSIONS | 470 E GOLDEN ELECTRIC



-  Electrical connection
-  Cooling water connection

1) Injection unit 170

2) Injection unit 290

TECHNICAL DATA | 470 E GOLDEN ELECTRIC

Clamping unit		470 E GOLDEN ELECTRIC
with clamping force	max. kN	1000
Opening force stroke	max. kN mm	--- 350
Mould height, fixed variable	min.-max. mm	--- 250-500
Platen daylight fixed variable	max. mm	--- 600-850
Distance between tie bars (w x h)	mm	470 x 470
Mould mounting platens (w x h)	max. mm	637 x 637
Weight of movable mould half	max. kg	760
Ejector force stroke	max. kN mm	40 175
Dry cycle time EUROMAP ²	min. s - mm	1,4 - 329

Injection unit		170			290			
with screw diameter	mm	25	30	35	30	35	40	
Effective screw length	L/D	24	20	17	23,3	20	17,5	
Screw stroke	max. mm	120			150			
Calculated stroke volume	max. cm ³	59	85	115	106	144	188	
Shot weight	max. g PS	54	77	105	97	132	172	
Material throughput	max. kg/h PS	10	13,5	16	17	20,5	24,5	
	max. kg/h PA6.6	5	7	8	8,5	10,5	12,5	
Injection pressure	max. bar	2500	2000	1470	2500	2000	1530	
Holding pressure time	max. s - bar	300-2300	300-1600	300-1170	300-2180	300-1600	300-1220	
Injection flow ²	max. cm ³ /s	78	114	154	98	134	176	
	max. cm ³ /s	[102]	[148]	[202]	[128]	[176]	[230]	
Injection speed ⁵	max. mm/s	160			140			
	max. mm/s	[210]			[180]			
Screw circumferential speed	max. m/min	31	37	44	28	33	37	
Screw torque	max. Nm	210	250	290	320	380	430	
Nozzle contact force retraction stroke	max. kN mm	50 300			50 300			
Heating capacity zones	kW	9,4 5			6,4 5			
Feed hopper	l	50			50			

Drive and connection			170	290	
with injection unit					
Net weight of machine	kg		4900	5000	
Sound press. level Insecurity ⁴	dB(A)			55 3	
Electrical connection ³	kW		21	21	
	Total	A	63	63	
	Machine	A	---	---	
	Heating	A	---	---	
Cooling water connection	max. °C			35	
	min. Δp bar			1,5 DN 25	

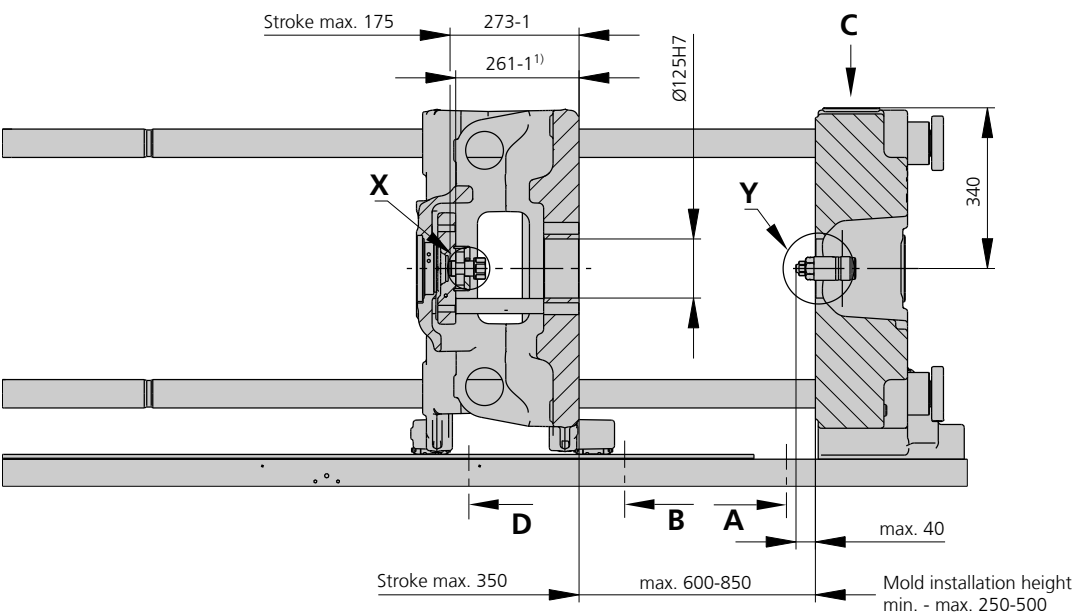
Machine type	
with EUROMAP size designation ¹	
470 E GOLDEN ELECTRIC 1000-170 290	

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.

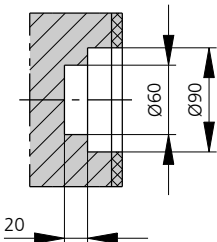
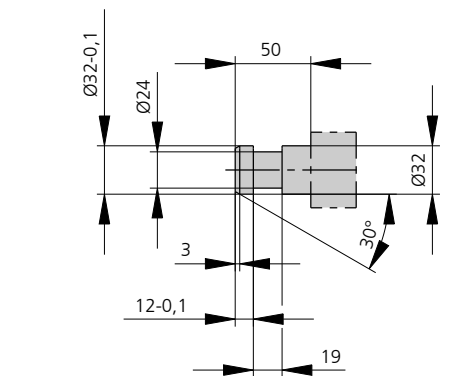
- 1) Clamping force (kN) - size of injection unit = max. stroke volume (cm³) x max. injection pressure (kbar)
 - 2) Specification of maximum injection flow at maximum injection pressure.
 - 3) Specifications relate to 400 V/50 Hz.
 - 4) Detailed info in the operating instr.
 - 5) Forward speed of plasticising screw at 1000 bar injection pressure.
- [] Specifications apply to alternative equipment.

MOULD INSTALLATION DIMENSIONS | 470 E GOLDEN ELECTRIC



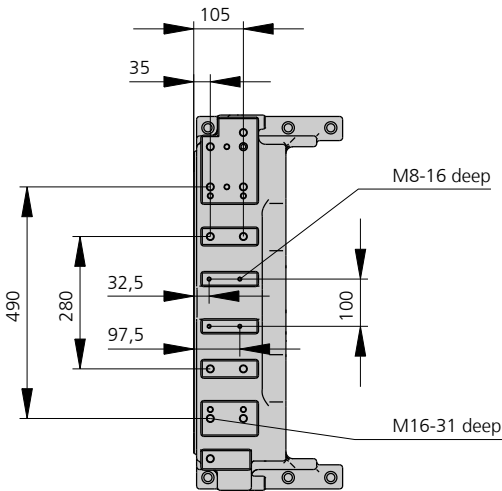
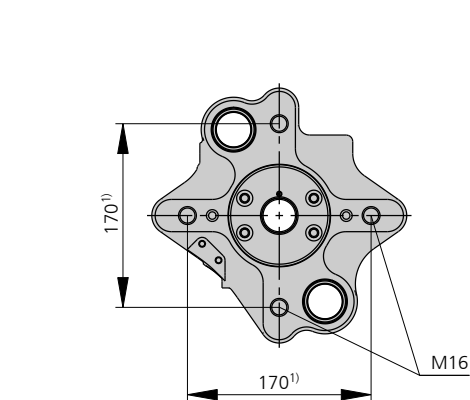
Ejector bolt | X

Bore in mould (if required) | Y



Ejector plate | D

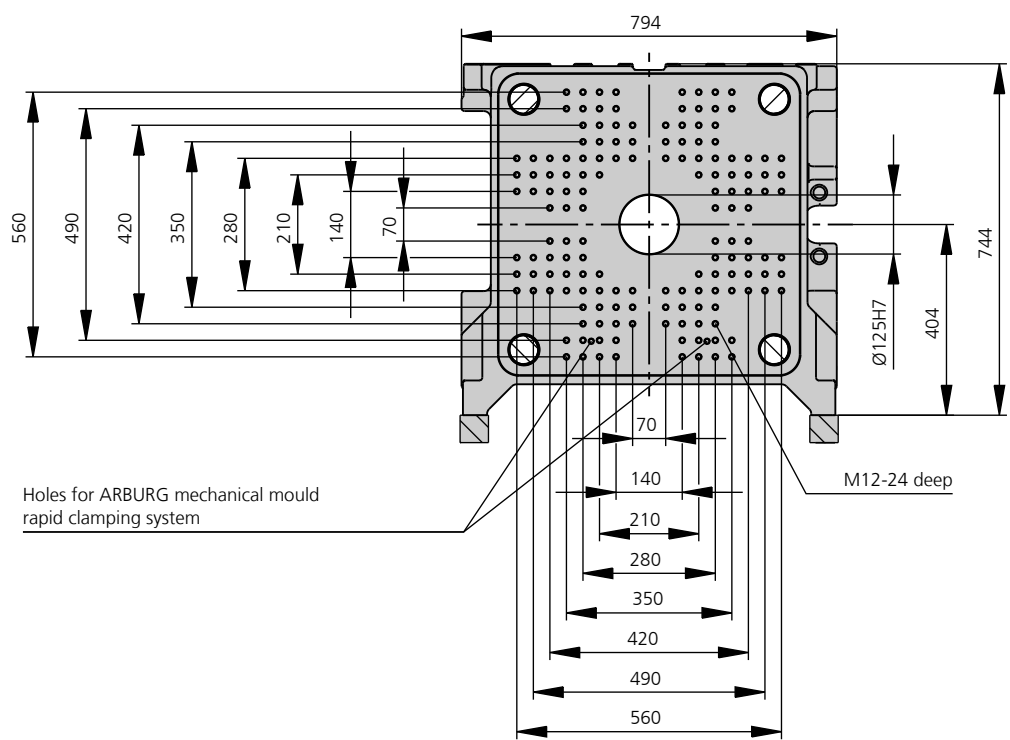
Robotic system mounting | C



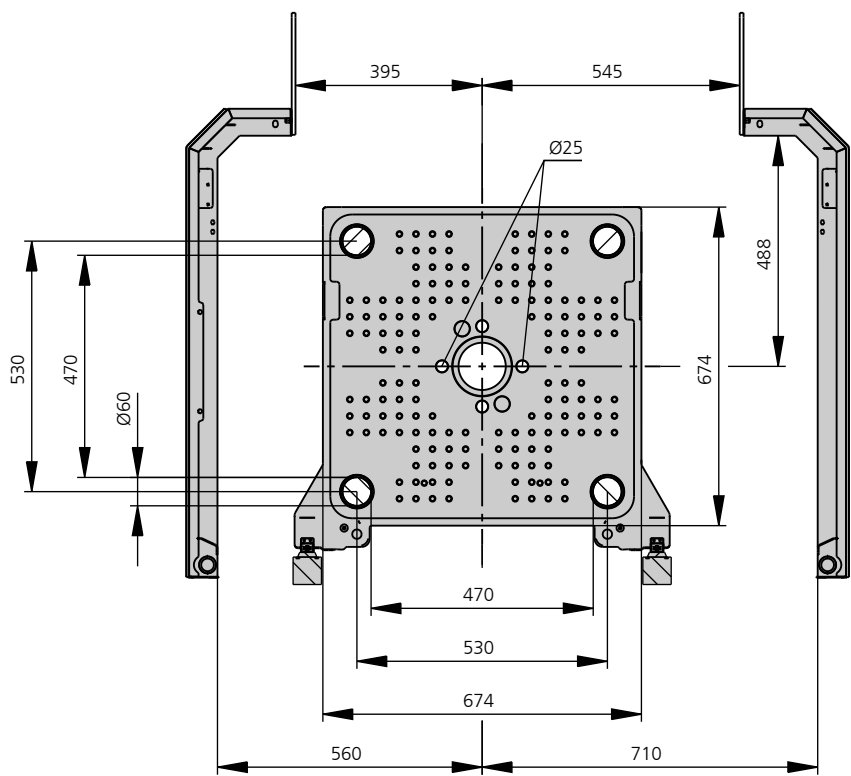
1) Position of ejector plate

MOULD INSTALLATION DIMENSIONS | 470 E GOLDEN ELECTRIC

Fixed mould mounting platen | A



Moving mould mounting platen | B



SHOT WEIGHTS | 470 E GOLDEN ELECTRIC

Theoretical shot weights for the most important injection moulding materials

Injection units according to EUROMAP		170			290			
Screw diameter	mm	25	30	35	30	35	40	
Polystyrene	max. g PS	54	77	105	97	132	172	
Styrene heteropolymerizates	max. g SB	53	76	103	95	129	168	
	max. g SAN, ABS ¹⁾	52	74	101	93	126	165	
Cellulose acetate	max. g CA ¹⁾	61	87	119	109	148	194	
Celluloseacetobutyrate	max. g CAB ¹⁾	56	81	110	101	138	180	
Polymethyl methacrylate	max. g PMMA	56	80	109	100	136	178	
Polyphenylene ether, mod.	max. g PPE	50	72	98	90	122	160	
Polycarbonate	max. g PC	57	81	111	102	139	181	
Polysulphone	max. g PSU	58	84	115	105	143	187	
Polyamides	max. g PA 6.6 PA 6 ¹⁾	53	77	104	96	131	171	
	max. g PA 6.10 PA 11 ¹⁾	50	72	98	90	122	160	
Polyoximethylene (Polyacetal)	max. g POM	66	96	130	120	163	213	
Polyethylene terephthalate	max. g PET	64	92	126	115	157	205	
Polyethylene	max. g PE-LD	41	59	80	73	100	130	
	max. g PE-HD	42	60	82	76	103	134	
Polypropylene	max. g PP	43	62	84	77	105	137	
Fluoropolymerides	max. g FEP, PFA, PCTFE ¹⁾	86	124	169	155	211	276	
	max. g ETFE	76	109	148	136	185	242	
Polyvinyl chloride	max. g PVC-U	65	94	127	117	159	208	
	max. g PVC-P ¹⁾	60	87	118	108	147	192	

1) average value

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