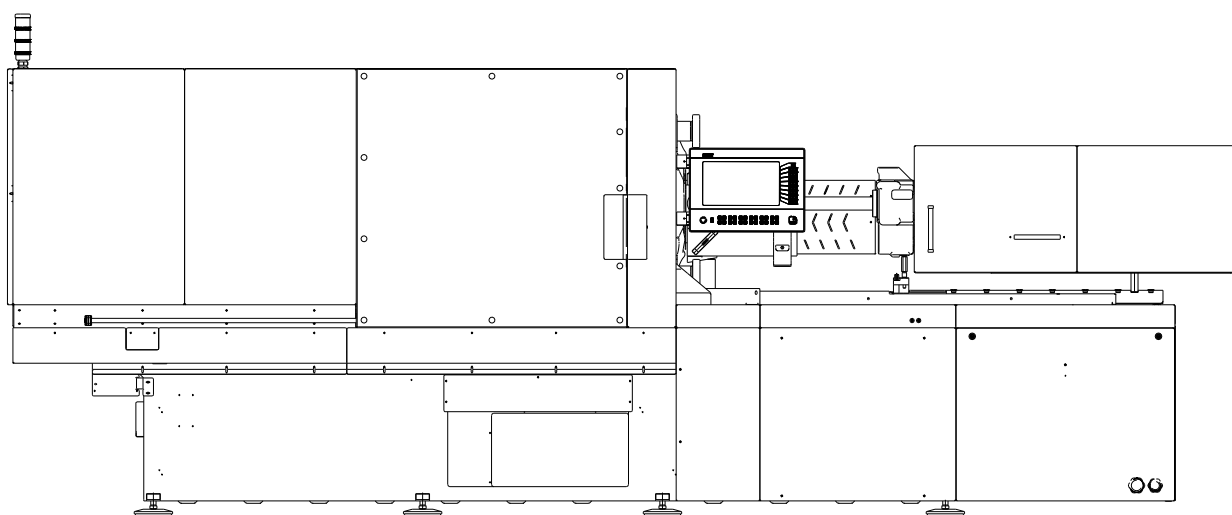




ALLROUNDER 1800 e TREND

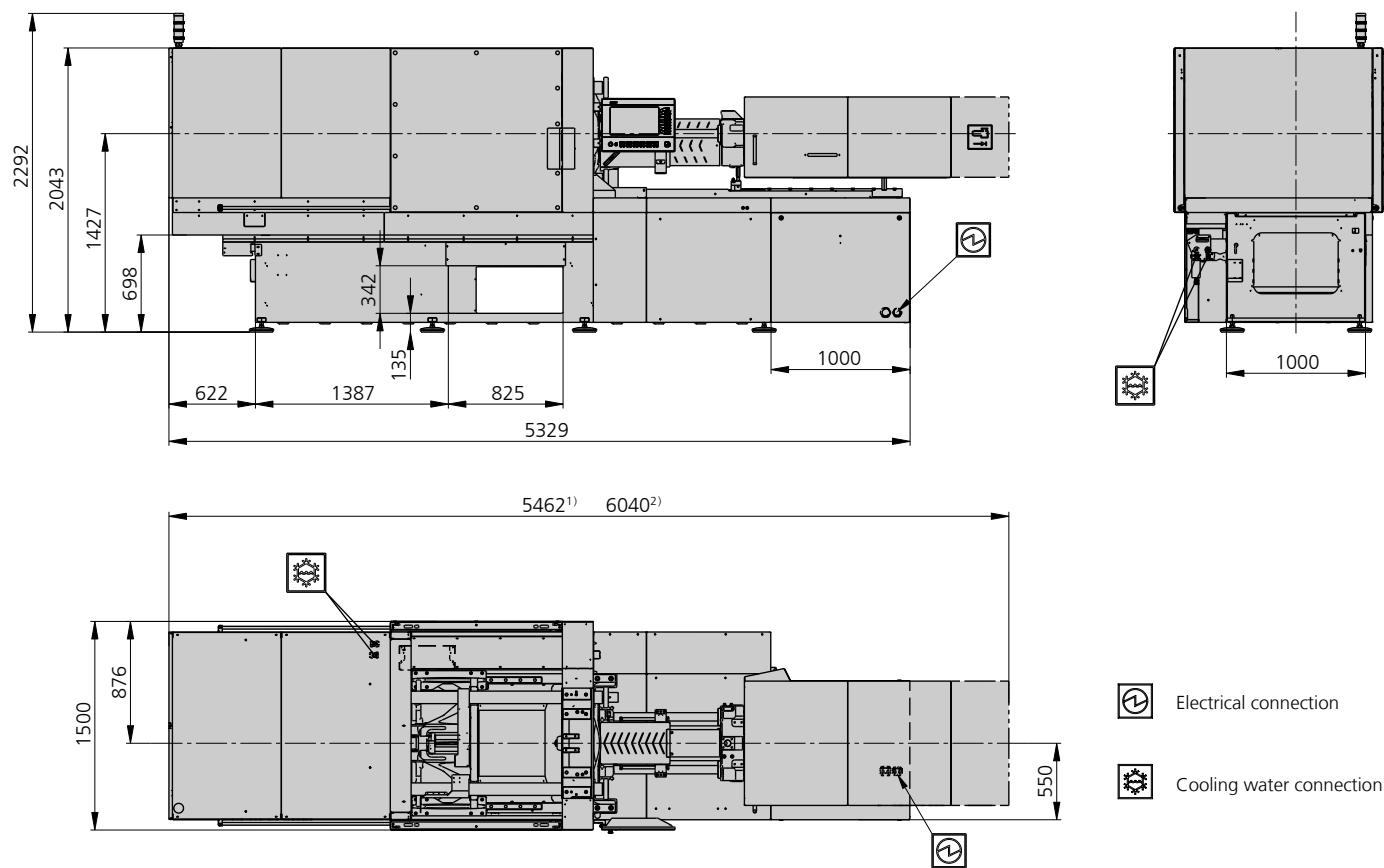
Distance between tie bars: 570 x 570 mm

Clamping force: 1800 kN

Injection unit (acc. to EUROMAP): 400 e, 800 e

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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. cm ³	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. cm ³ /s	336	439	556	447	589	712
Injection flow ⁷	max. cm ³ /s	[192]	[251]	[318]	[318]	[392]	[475]
Injection flow ⁷	max. cm ³ /s	---	---	---	---	---	---
Injection speed ⁵	max. mm/s	350			300		
Injection speed ⁸	max. mm/s	[200]			[200]		
Screw circumferential speed	max. m/min	53 [26]	60 [30]	68 [34]	54 [27]	60 [30]	66 [33]
Screw torque	max. Nm	480	550	610	900	1000	1100
Nozzle contact force retraction stroke	max. kN mm	60 [40] 300			70 [50] 400		
Heating capacity zones	kW	9,7 5			19,9 8		

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

Machine type (according to EUROMAP) ¹

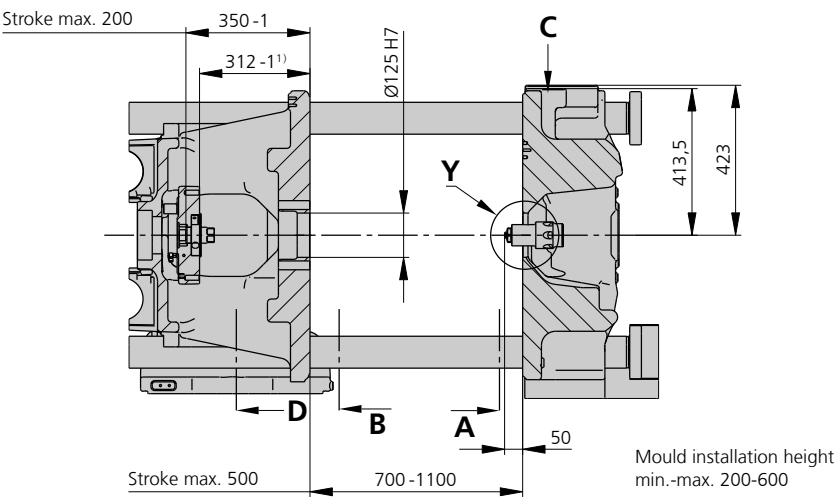
ALLROUNDER 1800 e TREND 400 e | 800 e

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

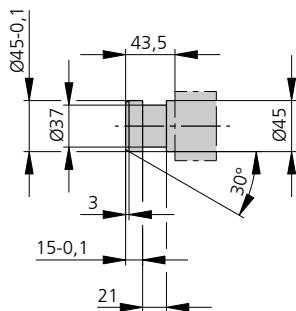
All specifications relate to the basic machine version. Deviations are possible depending on variants, process settings and material type. Depending on the drive, certain combinations, e.g. max. injection pressure and max. injection flow may be mutually exclusive.

- 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.

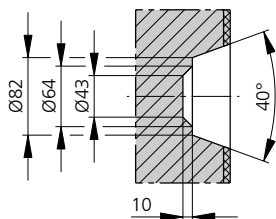
MOULD INSTALLATION DIMENSIONS | 1800 e TREND



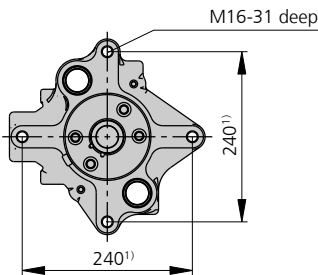
Ejector bolt | X



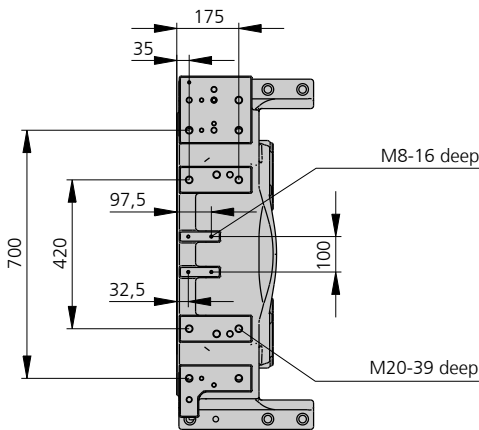
Bore in mould (if required) | Y



Ejector plate | D



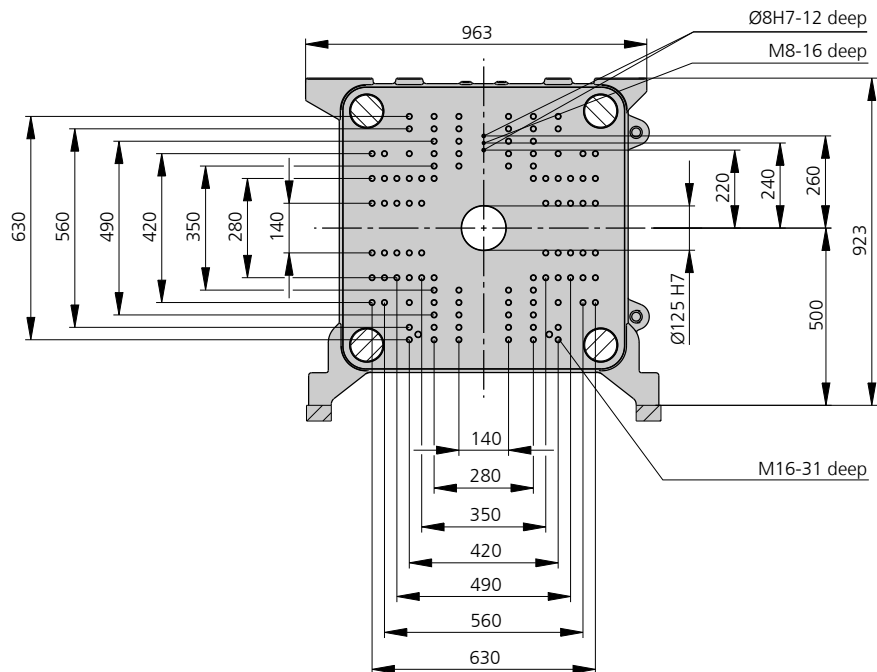
Robotic system mounting | C



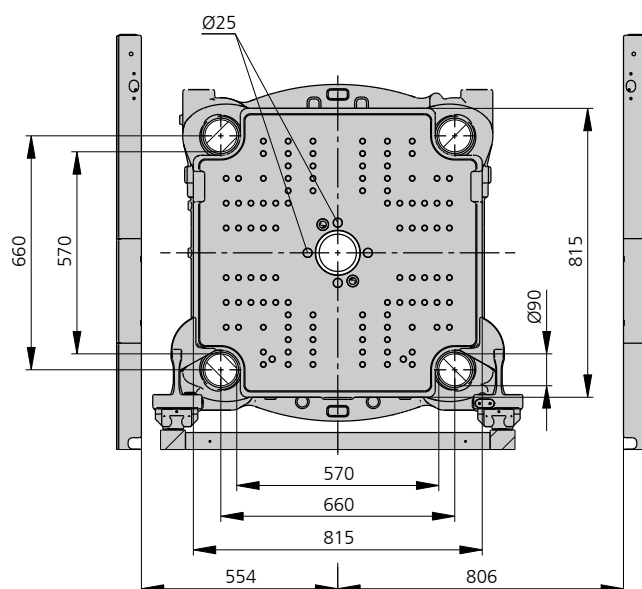
1) Position of ejector plate

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	
Fluoropolymerides	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

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