

ALLROUNDER 630 S

Clamp-Design

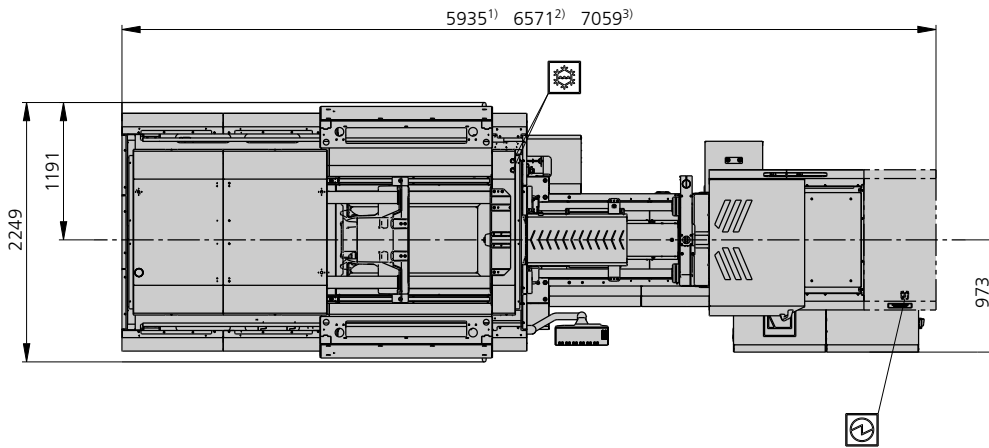
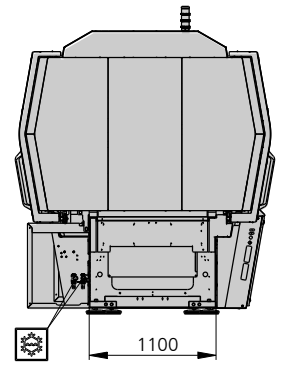
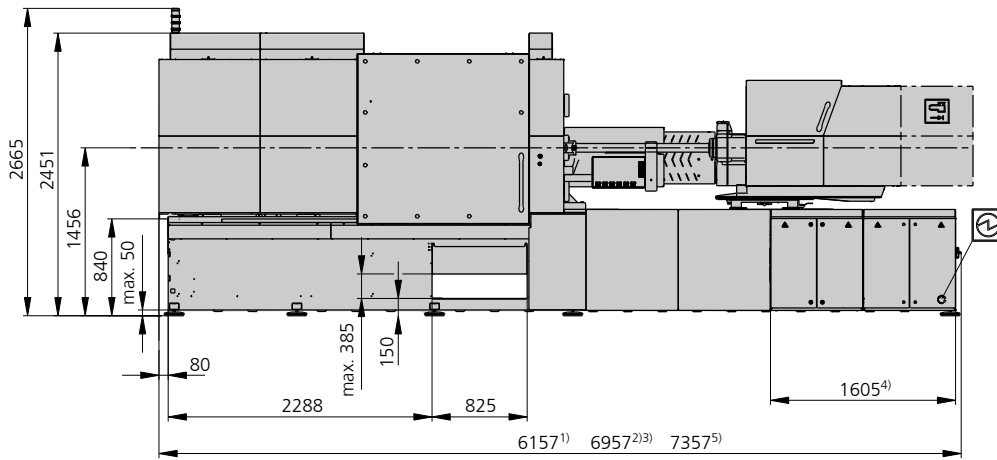
Distance between tie bars: 630 x 630 mm

Clamping force: 2500 kN

Injection unit (acc. to EUROMAP): 800, 1300, 2100

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MACHINE DIMENSIONS | 630 S



Electrical connection



Cooling water connection

- 1) Injection unit 800
- 2) Injection unit 1300
- 3) Injection unit 2100
- 4) Subject to performance variant and injection unit size
- 5) Injection unit 2100 and hydraulic accumulator

TECHNICAL DATA | 630 S

Clamping unit			630 S		
with clamping force	max. kN		2500		
Opening force stroke	max. kN mm		725 600		
Mould height, fixed variable	min. mm		700 [300-700]		
Platen daylight fixed variable	max. mm		1300 [900-1300]		
Distance between tie bars (w x h)	mm		630 x 630		
Mould mounting platens (w x h)	max. mm		900 x 900		
Weight of movable mould half	max. kg		2500		
Ejector force stroke	max. kN mm		90 225		
Dry cycle time EUROMAP ²	1 pump	min. s - mm	3,8 - 441		
	2 pumps	min. s - mm	2,3 - 441		
	Accum.	min. s - mm	1,7 - 441		

Injection unit			800			1300			2100		
with screw diameter	mm		45	50	55	55	60	70	60	70	80
Effective screw length	L/D		22	20	18	22	20	17	23	20	17,5
Screw stroke	max. mm		200			240			280		
Calculated stroke volume	max. cm ³		318	392	474	558	664	904	792	1078	1407
Shot weight	max. g PS		291	359	434	510	607	826	723	984	1286
Material throughput	max. kg/h PS		46	53	59	86	96	115	125	145	175
	max. kg/h PA6.6		23	27	30	43	48	58	62	74	88
Injection pressure	max. bar		2470	2000	1650	2380	2000	1470	2500	2000	1530
Holding pressure	max. bar		2470	2000	1650	2380	2000	1470	2500	2000	1530
Injection flow ²	1 pump	max. cm ³ /s	242	300	364	238	284	388	---		
	2 pumps	max. cm ³ /s	242	300	364	238	284	388	224	306	400
	Accum.	max. cm ³ /s	530	656	792	714	848	1156	1132	1540	2012
Screw circumferential speed ²	1 pump	max. m/min	54	60	66	40	43	51	---		
	2 pumps	max. m/min	54	60	66	40	43	51	43	51	58
	Accum.	max. m/min	15	17	19	19	21	25	21	25	28
Screw torque	max. Nm		880			1510	1640	1920	2140	2500	2550
Nozzle contact force retraction stroke	max. kN mm		70 400			90 550			110 600		
Heating capacity zones	kW		19,9 8			22,9 8			31,1 8		

Drive and connection			1 pump (servo)		2 pumps			Accum.		
with injection unit			800	1300	800	1300	2100	800	1300	2100
Net weight of machine	kg		12200	12500	12200	12500	13200	---		
Sound press. level Insecurity ⁴	dB(A)		< 65		73 3			< 70		
Oil filling	l		330	410	330	410	410	360	460	530
Drive power ²	max. kW		45	45	45	45	55	30	37	45
Electrical connection ³	kW		68	74	68	71	89	53	63	70
	Total	A	---		---			---		
	Machine	A	125	125	100	100	125	80	100	125
Cooling water connection	max. °C		30		30			30		
	min. Δp bar		1,5 DN 25		1,5 DN 25			1,5 DN 32		

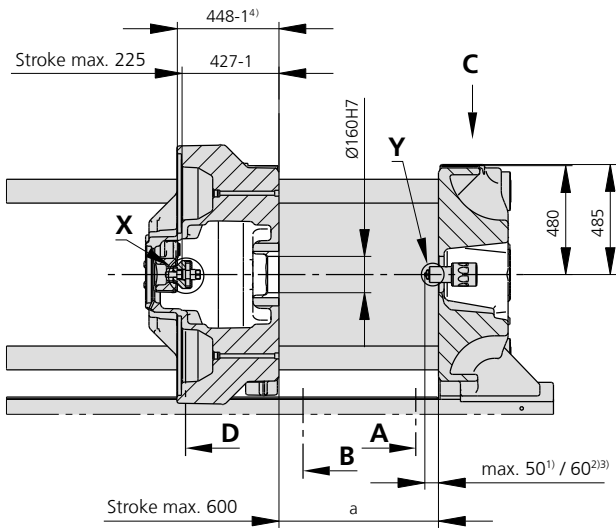
Machine type	
with EUROMAP size designation ¹	Drive
630 S 2500-800	1 2 Accum.
630 S 2500-1300	1 2 -
630 S 2500-2100	1 2 Accum.

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) 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.

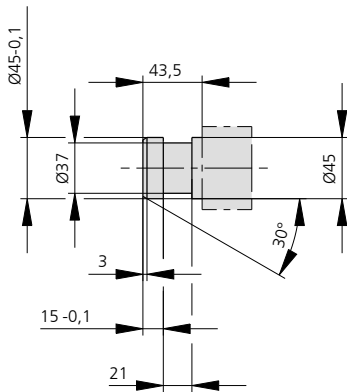
MOULD INSTALLATION DIMENSIONS | 630 S



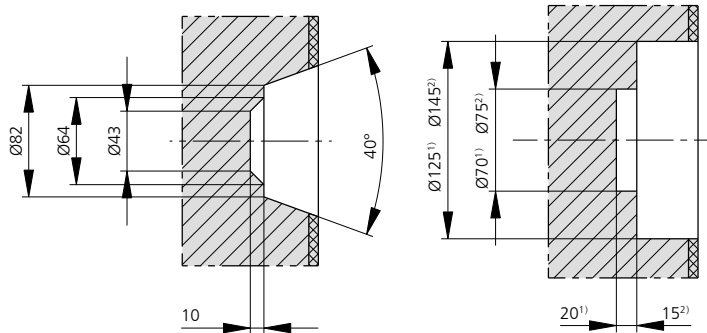
Mould installation height	a min.	a max.
Fixed	700	1300
variable, manually	[400, 500, 600]	[1000, 1100, 1200]
variable, automatically	300-700	900-1300

[] Specifications apply to alternative equipment

Ejector bolt | X

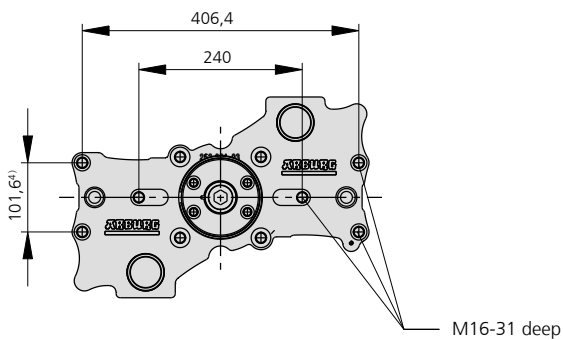


Bore in mould (if required) | Y

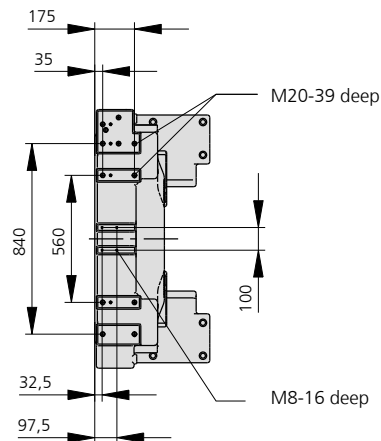


Injection unit 800¹⁾ and 1300²⁾
Thermoset execution -
2100 injection unit on request

Ejector plate | D



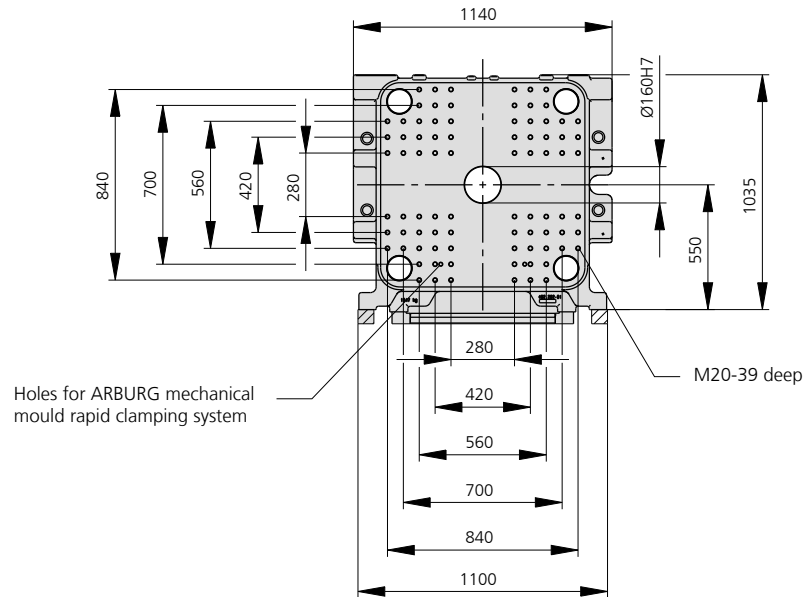
Robotic system mounting | C



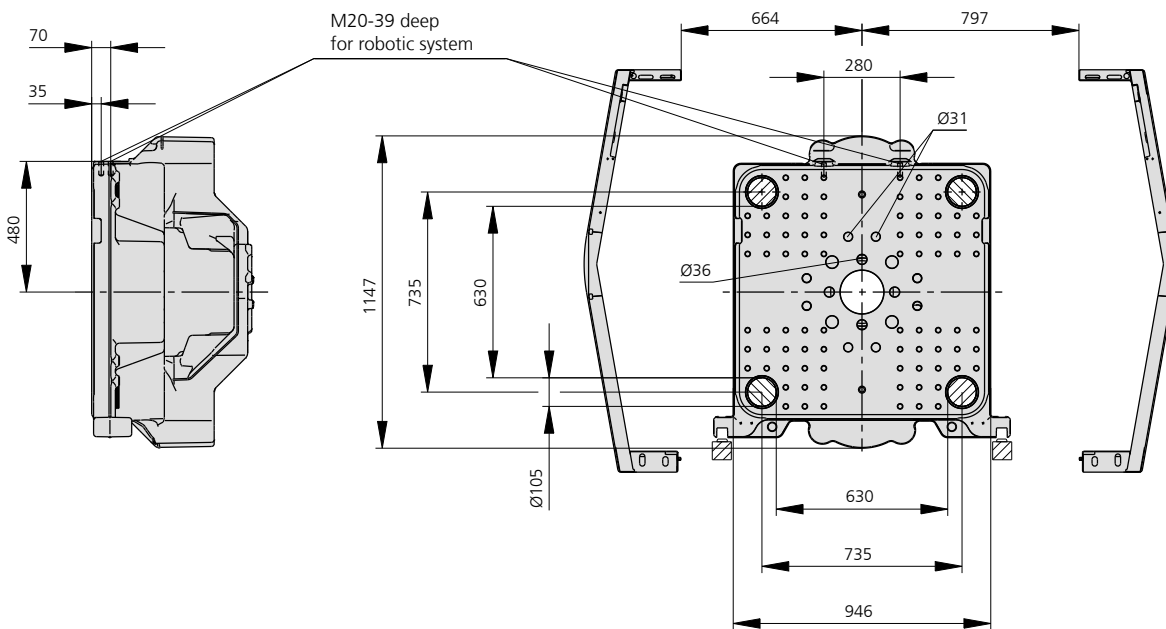
- 1) Injection unit 800
- 2) Injection unit 1300
- 3) Injection unit 2100
- 4) Positions of ejector plate

MOULD INSTALLATION DIMENSIONS | 630 S

Fixed mould mounting platen | A



Moving mould mounting platen | B



SHOT WEIGHTS | 630 S

Theoretical shot weights for the most important injection moulding materials

Injection units according to EUROMAP		800			1300			2100		
Screw diameter	mm	45	50	55	55	60	70	60	70	80
Polystyrene	max. g PS	291	359	434	510	607	826	723	984	1286
Styrene heteropolymerizates	max. g SB	284	350	424	498	593	807	707	962	1256
	max. g SAN, ABS ¹⁾	278	344	416	488	581	791	693	943	1231
Cellulose acetate	max. g CA ¹⁾	327	404	488	574	683	930	814	1108	1447
Celluloseacetobutyrate	max. g CAB ¹⁾	304	375	454	534	635	865	757	1030	1346
Polymethyl methacrylate	max. g PMMA	300	371	449	527	627	854	747	1017	1329
Polyphenylene ether, mod.	max. g PPE	270	333	403	473	563	767	671	914	1194
Polycarbonate	max. g PC	305	377	456	536	638	868	760	1034	1351
Polysulphone	max. g PSU	316	390	471	554	659	897	785	1069	1396
Polyamides	max. g PA 6.6 PA 6 ¹⁾	289	357	431	507	603	821	719	978	1278
	max. g PA 6.10 PA 11 ¹⁾	270	333	403	473	563	767	671	914	1194
Polyoximethylene (Polyacetal)	max. g POM	359	443	536	630	749	1020	893	1215	1588
Polyethylene terephthalate	max. g PET	346	427	517	607	723	984	861	1172	1531
Polyethylene	max. g PE-LD	219	271	328	385	458	624	546	744	971
	max. g PE-HD	227	280	339	398	473	644	564	768	1003
Polypropylene	max. g PP	232	286	346	406	484	658	576	784	1025
Fluoropolymerides	max. g FEP, PFA, PCTFE ¹⁾	465	574	695	816	971	1322	1157	1575	2058
	max. g ETFE	408	504	609	716	852	1160	1015	1382	1805
Polyvinyl chloride	max. g PVC-U	351	434	525	616	734	998	874	1190	1554
	max. g PVC-P ¹⁾	324	401	485	569	678	922	808	1099	1436

1) average value

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