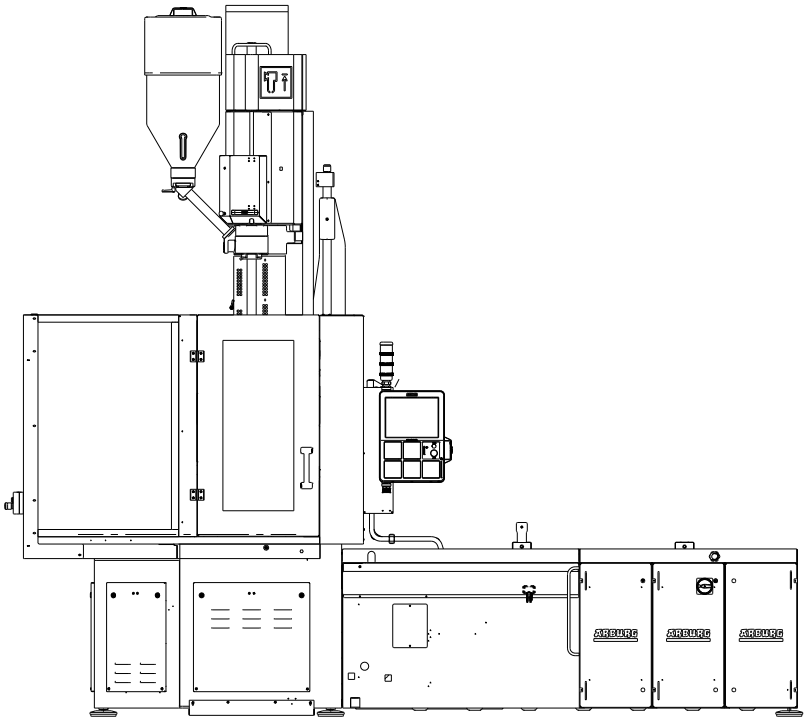
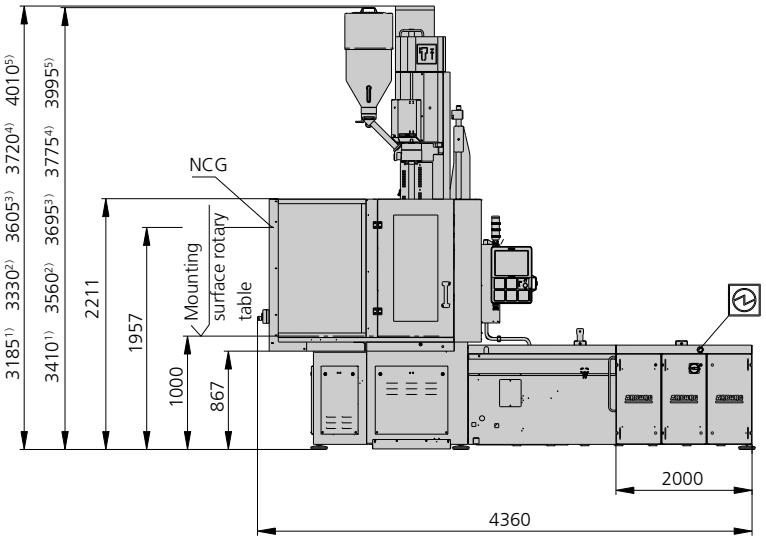


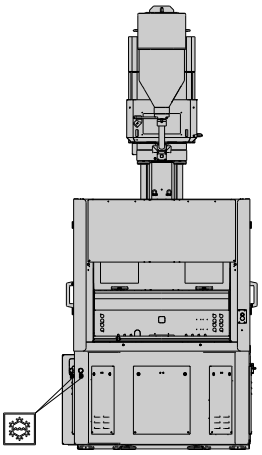

# ALLROUNDER 1200 T

Table diameter: 1200 mm
Clamping force: 800, 1000, 1600, 2000 kN
Injection unit (acc. to EUROMAP):
70, 100, 170, 290, 400, 800

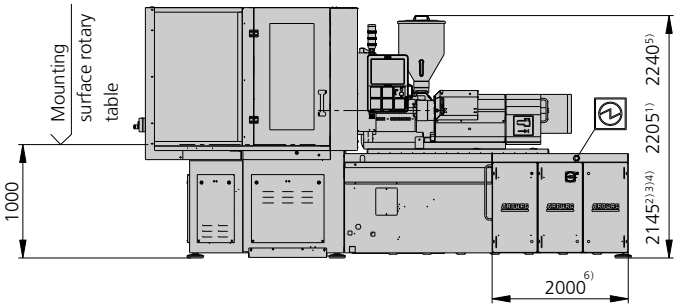
ARBURG

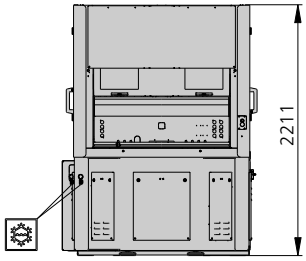
# MACHINE DIMENSIONS UP TO 1000 KN | 1200 T

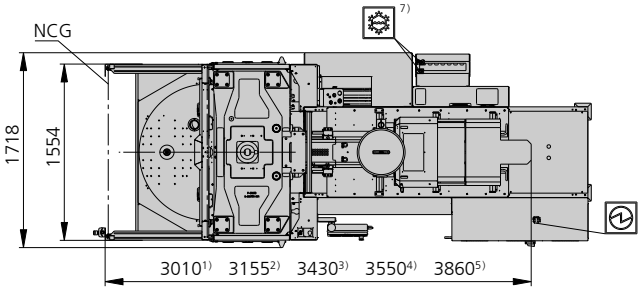


## Horizontal version



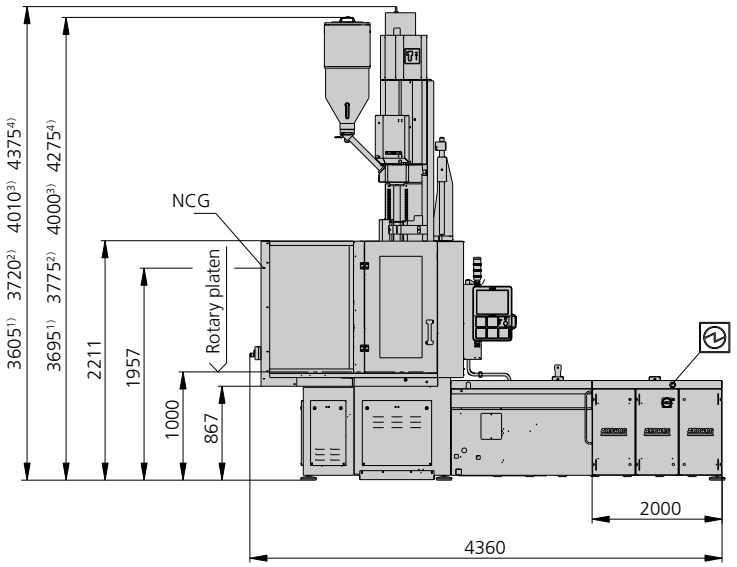



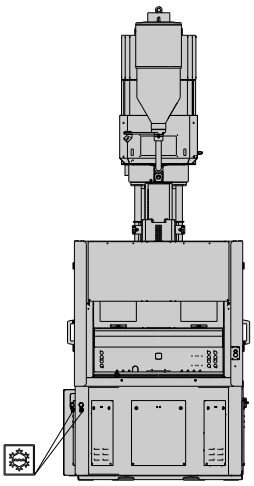

Electrical connection

Cooling water connection

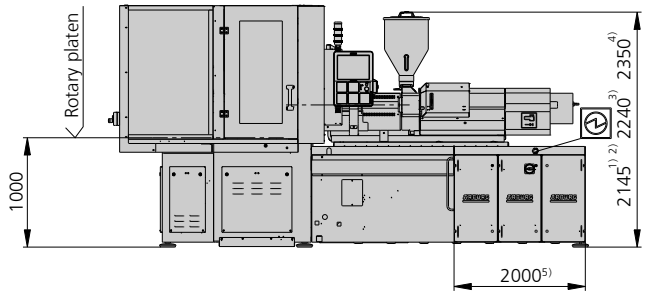
1) Injection unit 70
2) injection unit 100
3) injection unit 170
4) injection unit 290
5) Injection unit 400
6) The control cabinet length and position of the electrical connection can vary due to optional equipment
7) Position of cooling water connections can vary due to optional equipment
NCG - Non-contacting guard (photoelectric safety barrier)

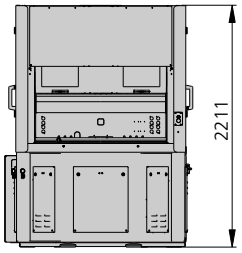
# MACHINE DIMENSIONS FROM 1600 KN | 1200 T

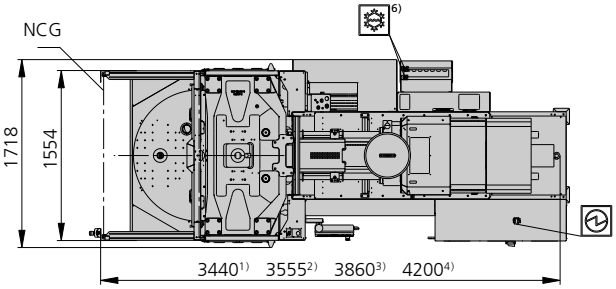


## Horizontal version




Electrical connection

Cooling water connection

1) Injection unit 170
2) injection unit 290
3) injection unit 400
4) injection unit 800
5) The control cabinet length and position of the electrical connection can vary due to optional equipment
6) Position of cooling water connections can vary due to optional equipment
NCG - Non-contacting guard (photoelectric safety barrier)

# TECHNICAL DATA | 1200 T

| **Clamping unit** | | | | **1200 T** |
|---|---|---|---|---|
| with clamping force | | max. | kN | 800 |
| Opening force \| stroke | | max. | kN \| mm | 115 \| 300 |
| Mould height, fixed \| variable | | min. | mm | 300 \| --- |
| Platen daylight fixed \| variable | | max. | mm | 600 \| --- |
| Table diameter | | | mm | 1200 |
| Angle of rotation, left/right | | | | 180° |
| Rotation time for 180° | | min. | s | 1,6 |
| Weight on rotary table | | max. | kg | 750 |
| Weight of movable mould half | | max. | kg | 400 |
| Ejector force \| stroke | | max. | kN \| mm | 45 \| 175 |
| Dry cycle time EUROMAP [2] | 2 pumps | min. | s - mm | 3,7 - 240 |
| | Accum. | min. | s - mm | --- |

| **Injection unit** | | | | **70** | | | **100** | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| with screw diameter | | | mm | 18 | 22 | 25 | 20 | 25 | 30 | |
| Effective screw length | | | L/D | 24,5 | 20 | 17,5 | 25 | 20 | 16,7 | |
| Screw stroke | | max. | mm | | 90 | | | 100 | | |
| Calculated stroke volume | | max. | cm³ | 23 | 34 | 44 | 31 | 49 | 71 | |
| Shot weight | | max. | g PS | 21 | 31 | 40 | 29 | 45 | 65 | |
| Material throughput | | max. | kg/h PS | 4,1 | 5,5 | 6,5 | 5,5 | 8 | 9,5 | |
| | | max. | kg/h PA6.6 | 2,1 | 2,8 | 3,3 | 2,8 | 4 | 4,9 | |
| Injection pressure | | max. | bar | 2500 | 2000 | 1550 | 2500 | 2000 | 1390 | |
| Holding pressure | | max. | bar | 2500 | 2000 | 1550 | 2500 | 2000 | 1390 | |
| Injection flow [2] | 2 pumps | max. | cm³/s | 68 | 100 | 130 | 90 | 142 | 204 | |
| | Accum. | max. | cm³/s | 138 | 208 | 268 | 172 | 268 | 388 | |
| Screw circumferential | 2 pumps | max. | m/min | 45 | 55 | 62 | 32 | 40 | 48 | |
| speed [2] | Accum. | max. | m/min | 15 | 19 | 22 | 11 | 14 | 17 | |
| Screw torque | | max. | Nm | 90 | 110 | 120 | 120 | 150 | 180 | |
| Nozzle contact force \| retraction stroke | | max. | kN \| mm | | 50 \| 250 | | | 50 \| 280 | | |
| Heating capacity \| zones | | | kW | | 4,1 \| 4 | | | 4,9 \| 5 | | |
| Feed hopper | | | l | | 25 | | | 50 | | |

| **Drive and connection** | | | | **2 pumps** | | **Accum.** | |
|---|---|---|---|---|---|---|---|
| with injection unit | | | | 70 | 100 | 70 | 100 |
| Net weight of machine | | | kg | | 7200 | | --- |
| Sound press. level \| Insecurity [4] | | | dB(A) | | 70 \| 3 | | 70 \| 3 |
| Oil filling | | | l | | 260 | | 260 |
| Drive power [2] | | max. | kW | | 18,5 | | --- |
| Electrical connection [3] | | | kW | | 28 | | --- |
| | Total | | A | | 100 | | --- |
| | Machine | | A | | --- | | --- |
| | Heating | | A | | --- | | --- |
| Cooling water connection | | max. | °C | | 25 | | 25 |
| | | min. | Δp bar | | 1,5 \| DN 25 | | 1,5 \| DN 25 |

| **Machine type** |
|---|
| with EUROMAP size designation [1] |
| 1200 T 800-70 \| 100 |

**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) Emission sound pressure level at the workplace. Detailed information in the operating instructions.
[ ] Specifications apply to alternative equipment.

# TECHNICAL DATA | 1200 T

| **Clamping unit** | | | | **1200 T** |
|---|---|---|---|---|
| with clamping force | | max. | kN | 1000 |
| Opening force \| stroke | | max. | kN \| mm | 115 \| 300 |
| Mould height, fixed \| variable | | min. | mm | 300 \| --- |
| Platen daylight fixed \| variable | | max. | mm | 600 \| --- |
| Table diameter | | | mm | 1200 |
| Angle of rotation, left/right | | | | 180° |
| Rotation time for 180° | | min. | s | 1,6 |
| Weight on rotary table | | max. | kg | 750 |
| Weight of movable mould half | | max. | kg | 400 |
| Ejector force \| stroke | | max. | kN \| mm | 45 \| 175 |
| Dry cycle time EUROMAP [2] | 2 pumps | min. | s - mm | 3,7 - 240 |
| | Accum. | min. | s - mm | --- |

| **Injection unit** | | | | **170** | | | **290** | | | **400** | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| with screw diameter | | | mm | 25 | 30 | 35 | 30 | 35 | 40 | 35 | 40 | 45 |
| Effective screw length | | | L/D | 24 | 20 | 17 | 23,3 | 20 | 17,5 | 23 | 20 | 18 |
| Screw stroke | | max. | mm | | 120 | | | 150 | | | 160 | |
| Calculated stroke volume | | max. | cm³ | 59 | 85 | 115 | 106 | 144 | 188 | 154 | 201 | 254 |
| Shot weight | | max. | g PS | 54 | 77 | 105 | 97 | 132 | 172 | 141 | 184 | 232 |
| Material throughput | | max. | kg/h PS | 10 | 13,5 | 16 | 17 | 20,5 | 24,5 | 25 | 29 | 35 |
| | | max. | kg/h PA6.6 | 5 | 7 | 8 | 8,5 | 10,5 | 12,5 | 12,5 | 15 | 17,5 |
| Injection pressure | | max. | bar | 2500 | 2000 | 1470 | 2500 | 2000 | 1530 | 2500 | 2000 | 1580 |
| Holding pressure | | max. | bar | 2500 | 2000 | 1470 | 2500 | 2000 | 1530 | 2500 | 2000 | 1580 |
| Injection flow [2] | 2 pumps | max. | cm³/s | 94 | 136 | 186 | 130 | 178 | 232 | 128 | 168 | 212 |
| | Accum. | max. | cm³/s | 216 | 312 | 424 | 316 | 430 | 562 | 492 | 642 | 814 |
| Screw circumferential | 2 pumps | max. | m/min | 40 | 48 | 56 | 37 | 44 | 50 | 28 | 32 | 36 |
| speed [2] | Accum. | max. | m/min | 14 | 17 | 19 | 20 | 24 | 27 | 16 | 19 | 21 |
| Screw torque | | max. | Nm | 210 | 250 | 290 | 320 | 380 | 430 | 480 | 550 | 610 |
| Nozzle contact force \| retraction stroke | | max. | kN \| mm | | 50 \| 300 | | | 60 \| 300 | | | 60 \| 400 | |
| Heating capacity \| zones | | | kW | | 9,4 \| 5 | | | 6,4 \| 5 | | | 9,4 \| 5 | |
| Feed hopper | | | l | | 50 | | | 50 | | | 50 | |

| **Drive and connection** | | | | **2 pumps** | | | **Accum.** | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| with injection unit | | | | 170 | 290 | 400 | 170 | 290 | 400 | |
| Net weight of machine | | | kg | 7300 | 7400 | 7600 | | --- | | |
| Sound press. level \| Insecurity [4] | | | dB(A) | | 70 \| 3 | | | 70 \| 3 | | |
| Oil filling | | | l | | 260 | | | 260 | | |
| Drive power [2] | | max. | kW | 18,5 | 18,5 | 22 | | --- | | |
| Electrical connection [3] | | | kW | 33 | 30 | 36 | | --- | | |
| | Total | | A | | 100 | | | --- | | |
| | Machine | | A | | --- | | | --- | | |
| | Heating | | A | | --- | | | --- | | |
| Cooling water connection | | max. | °C | | 25 | | | 25 | | |
| | | min. | Δp bar | | 1,5 \| DN 25 | | | 1,5 \| DN 25 | | |

| **Machine type** |
|---|
| with EUROMAP size designation [1] |
| 1200 T 1000-170 \| 290 \| 400 |

**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) Emission sound pressure level at the workplace. Detailed information in the operating instructions.
[ ] Specifications apply to alternative equipment.

# TECHNICAL DATA | 1200 T

| **Clamping unit** | | | **1200 T** | **1200 T** |
|---|---|---|---|---|
| with clamping force | | max. kN | 1600 | 2000 |
| Opening force \| stroke | | max. kN \| mm | 115 \| 300 | 115 \| 300 |
| Mould height, fixed \| variable | | min. mm | 300 \| --- | 300 \| --- |
| Platen daylight fixed \| variable | | max. mm | 600 \| --- | 600 \| --- |
| Table diameter | | mm | 1200 | 1200 |
| Angle of rotation, left/right | | | 180° | 180° |
| Rotation time for 180° | | min. s | 1,6 | 1,6 |
| Weight on rotary table | | max. kg | 750 | 750 |
| Weight of movable mould half | | max. kg | 400 | 400 |
| Ejector force \| stroke | | max. kN \| mm | 45 \| 175 | 45 \| 175 |
| Dry cycle time EUROMAP [2] | 2 pumps | min. s - mm | 3,7 - 240 | 3,7 - 240 |
| | Accum. | min. s - mm | --- | --- |

| **Injection unit** | | | | **400** | | | **800** | |
|---|---|---|---|---|---|---|---|---|
| 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 | | max. | bar | 2500 | 2000 | 1580 | 2470 | 2000 | 1650 |
| Injection flow [2] | 2 pumps | max. | cm³/s | 128 | 168 | 212 | 174 | 214 | 260 |
| | Accum. | max. | cm³/s | 492 | 642 | 814 | 530 | 656 | 792 |
| Screw circumferential | 2 pumps | max. | m/min | 28 | 32 | 36 | 54 | 60 | 66 |
| speed [2] | Accum. | max. | m/min | 16 | 19 | 21 | 15 | 17 | 19 |
| Screw torque | | max. | Nm | 480 | 550 | 610 | | 880 | |
| Nozzle contact force \| retraction stroke | | max. | kN \| mm | | 60 \| 400 | | | 70 \| 400 | |
| Heating capacity \| zones | | | kW | | 9,4 \| 5 | | | 19,9 \| 8 | |
| Feed hopper | | | l | | 50 | | | 50 | |

| **Drive and connection** | | | **2 pumps** | | **Accum.** | |
|---|---|---|---|---|---|---|
| with injection unit | | | 400 | 800 | 400 | 800 |
| Net weight of machine | | kg | 9200 | 9600 | | --- |
| Sound press. level \| Insecurity [4] | | dB(A) | | 71 \| 3 | | 71 \| 3 |
| Oil filling | | l | | 260 | | 260 |
| Drive power [2] | | max. kW | 22 | 30 | | --- |
| Electrical connection [3] | | kW | 36 | 55 | | --- |
| | Total | A | 100 | 125 | | --- |
| | Machine | A | | --- | | --- |
| | Heating | A | | --- | | --- |
| Cooling water connection | | max. °C | | 25 | | 25 |
| | | min. Δp bar | | 1,5 \| DN 25 | | 1,5 \| DN 25 |

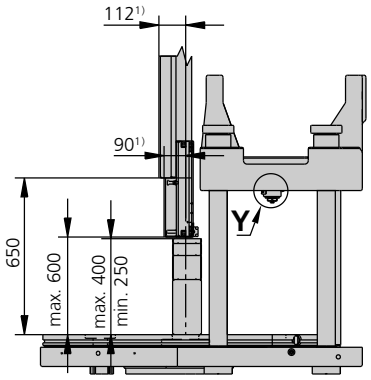
| **Machine type** |
|---|
| with EUROMAP size designation [1] |
| 1200 T 1600-400 |
| 1200 T 2000-800 |

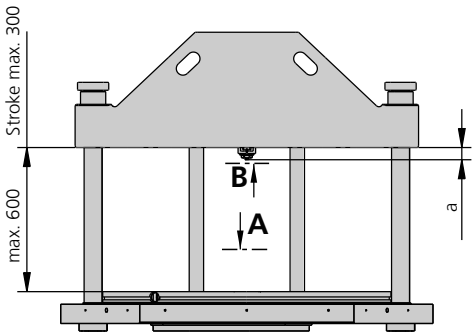
**Upon request: other machine types and mould installation heights, screws, drive powers etc.**
All specifications relate to the basic machine version. Deviations are possible depending on variants, process settings and material type. Depending on the drive, certain combinations, e.g. max. injection 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) Emission sound pressure level at the workplace. Detailed information in the operating instructions.
[ ] Specifications apply to alternative equipment.

**1200 T**

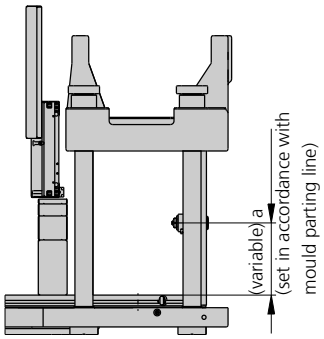
# MOULD INSTALLATION DIMENSIONS UP TO 1000 KN | 1200 T



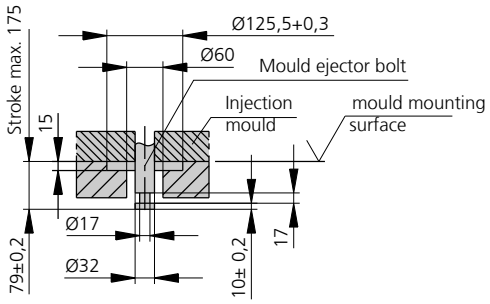




| a max. | Injection unit | |
|---|---|---|
| | 70 / 100 / 170 / 290 | 400 |
| Standard | 35 | 50 |
| Thermoset | 15 | 50 |

## Horizontal version

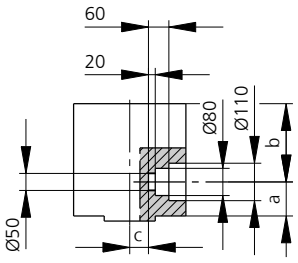



## Ejector bolt

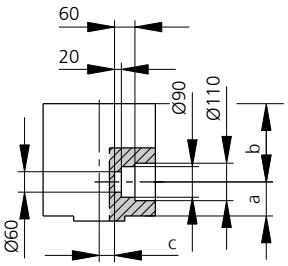



| | Injection unit | |
|---|---|---|
| | 70 / 100 / 170 / 290 | 400 |
| a min. | 200 | 300 |
| a max. | 320 | 400 |
| b min. | 100 | 100 |
| c min. | 135 | 145 |

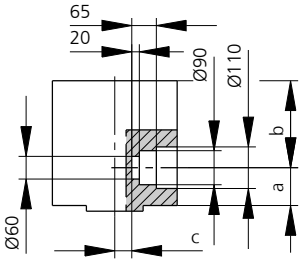
## Bore in mould (if required)



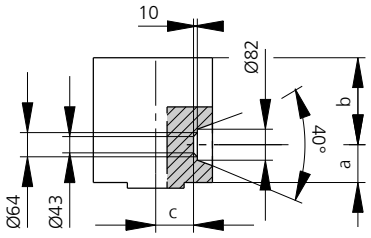

Injection unit 70




Injection unit 100

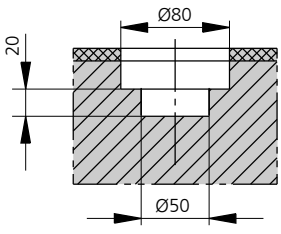



Injection unit 170 / 290

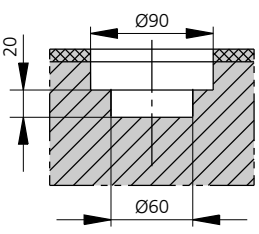



Injection unit 400

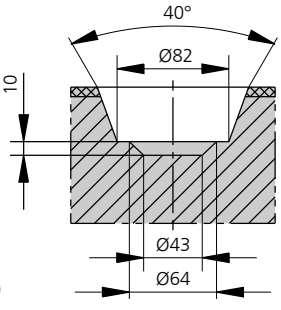
## Bore in mould (if required) | Y



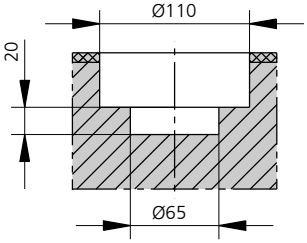

Injection unit 70




Injection unit 100 / 170 / 290




Injection unit 400

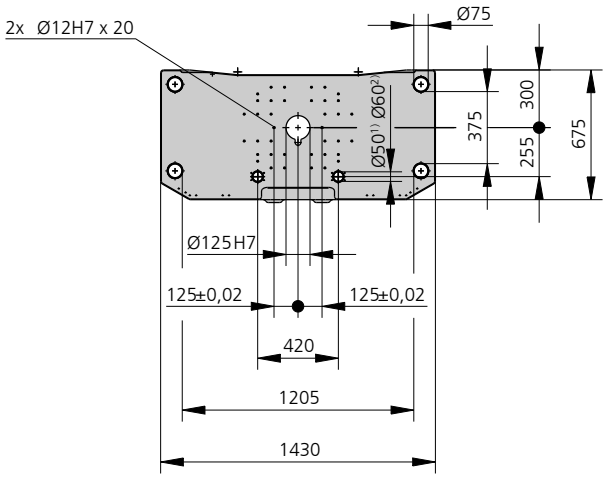



Injection unit 400
Thermoset version

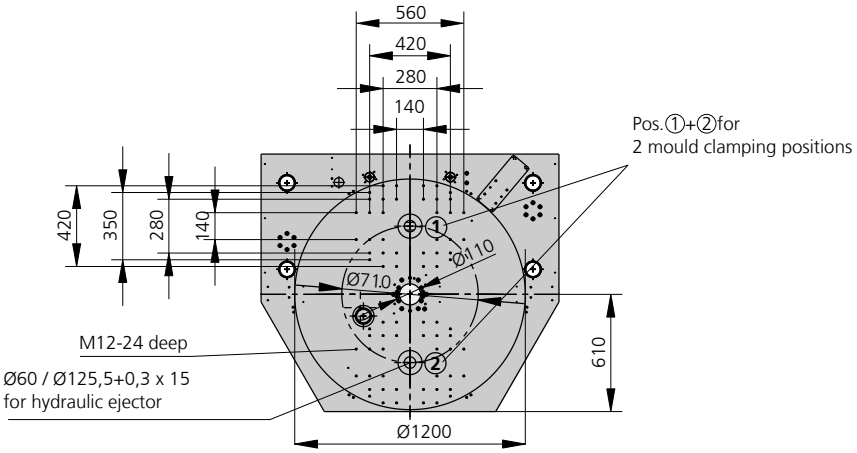
1) Dimension from table centre (projecting edge protection + sliding guard)

# MOULD INSTALLATION DIMENSIONS UP TO 1000 KN | 1200 T

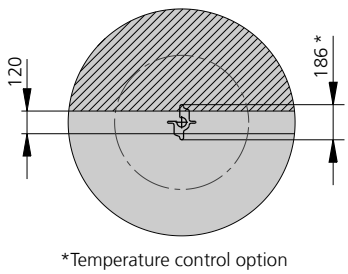
## Moving mould mounting platen | B




## Mould mounting platen (rotary table) | A

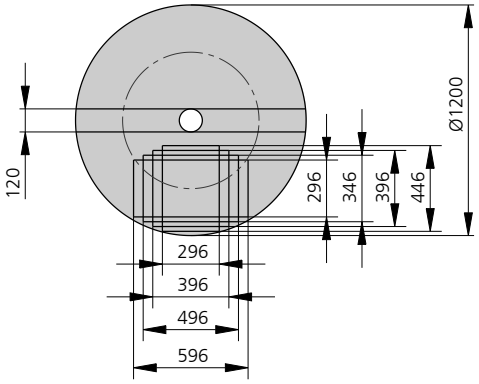



## Useable clamping surface



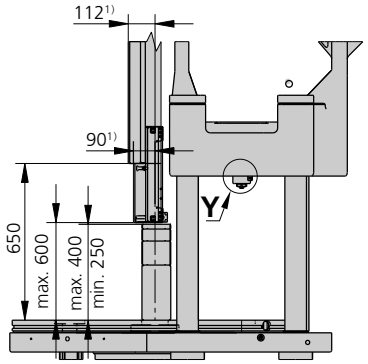

*Temperature control option

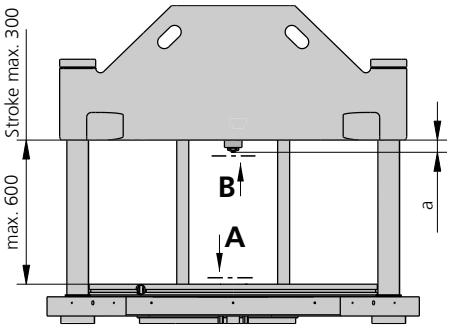
## Mould grid dimensions 2-station mould




1) Injection unit 70 / 100 / 170 / 290
2) Injection unit 400

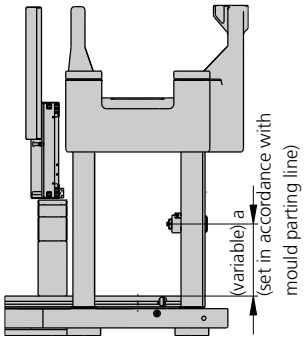
# MOULD INSTALLATION DIMENSIONS UP TO 1600 KN | 1200 T



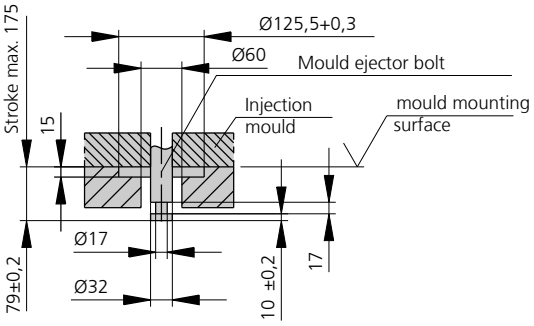




| a max. | Injection unit | |
|---|---|---|
| | 170 / 290 | 400 / 800 |
| Standard | 35 | 50 |
| Thermoset | 15 | 50 |

## Horizontal version

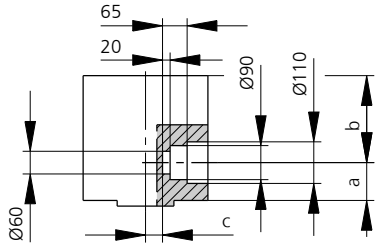



## Ejector bolt

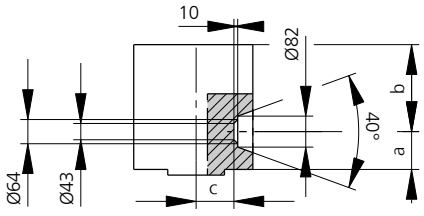



| | Injection unit | | |
|---|---|---|---|
| | 170 / 290 | 400 | 800 |
| a min. | 200 | 300 | 300 |
| a max. | 320 | 400 | 500 |
| b min. | 100 | 100 | 120 |
| c min. | 145 | 145 | 125 |

## Bore in mould (if required)

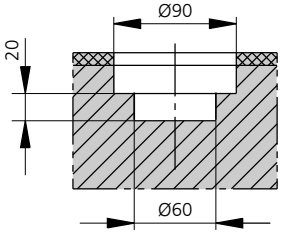



Injection unit 170 / 290

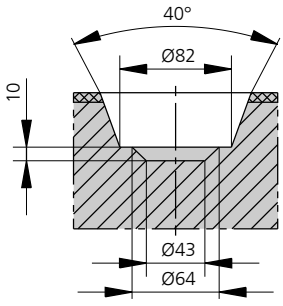



Injection unit 400 / 800

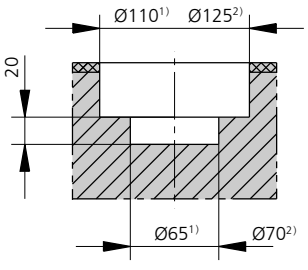
## Bore in mould (if required) | Y




Injection unit 170 / 290




Injection unit 400 / 800

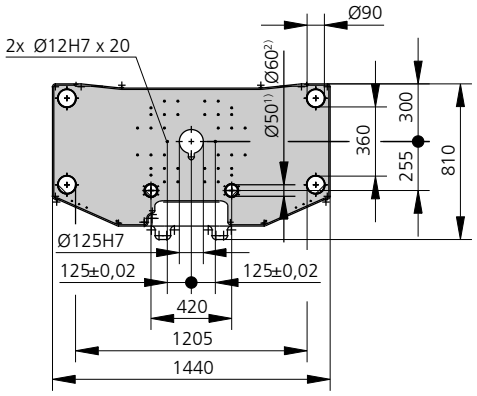



Injection unit 400¹⁾ / 800²⁾
Thermoset version

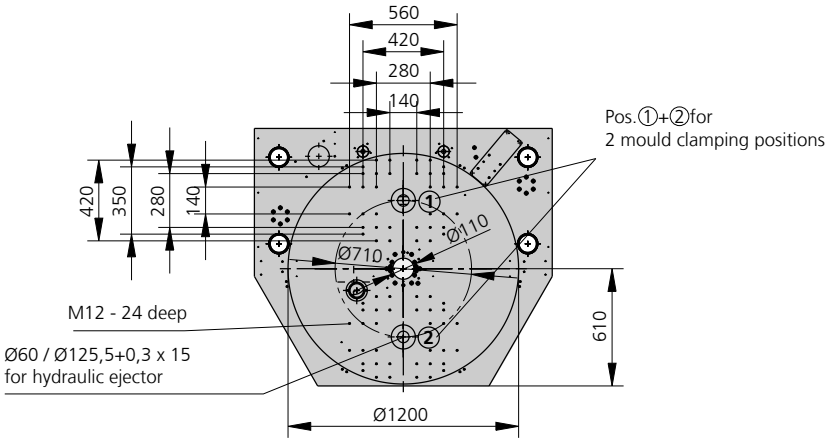
1) Dimension from table centre (projecting edge protection + sliding guard)
2) Injection unit 400
3) Injection unit 800

# MOULD INSTALLATION DIMENSIONS UP TO 1600 KN | 1200 T

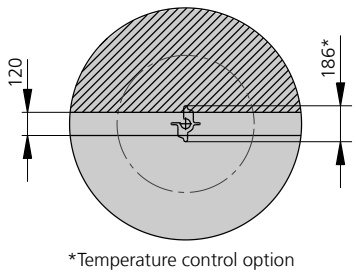
## Moving mould mounting platen | B




## Mould mounting platen (rotary table) | A

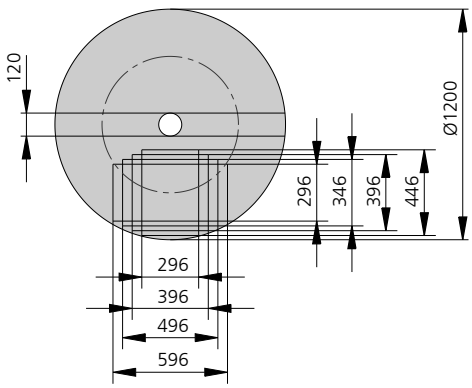



## Useable clamping surface




*Temperature control option

## Mould grid dimensions 2-station mould




1) Injection unit 170 / 290
2) Injection unit 400 / 800

# SHOT WEIGHTS | 1200 T

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

| Injection units according to EUROMAP | | 70 | | | 100 | | | 170 | | |
|---|---|---|---|---|---|---|---|---|---|---|
| Screw diameter | mm | 18 | 22 | 25 | 20 | 25 | 30 | 25 | 30 | 35 |
| Polystyrene | max. g PS | 21 | 31 | 40 | 29 | 45 | 65 | 54 | 77 | 105 |
| Styrene heteropolymerizates | max. g SB | 20 | 31 | 39 | 28 | 44 | 63 | 53 | 76 | 103 |
| | max. g SAN, ABS[1)] | 20 | 30 | 39 | 27 | 43 | 62 | 52 | 74 | 101 |
| Cellulose acetate | max. g CA[1)] | 24 | 35 | 45 | 32 | 50 | 73 | 61 | 87 | 119 |
| Celluloseacetobutyrate | max. g CAB[1)] | 22 | 33 | 42 | 30 | 47 | 68 | 56 | 81 | 110 |
| Polymethyl methacrylate | max. g PMMA | 22 | 32 | 42 | 30 | 46 | 67 | 56 | 80 | 109 |
| Polyphenylene ether, mod. | max. g PPE | 19 | 29 | 37 | 27 | 42 | 60 | 50 | 72 | 98 |
| Polycarbonate | max. g PC | 22 | 33 | 42 | 30 | 47 | 68 | 57 | 81 | 111 |
| Polysulphone | max. g PSU | 23 | 34 | 44 | 31 | 49 | 70 | 58 | 84 | 115 |
| Polyamides | max. g PA 6.6 \| PA 6[1)] | 21 | 31 | 40 | 28 | 44 | 64 | 53 | 77 | 104 |
| | max. g PA 6.10 \| PA 11[1)] | 19 | 29 | 37 | 26 | 41 | 60 | 50 | 72 | 98 |
| Polyoximethylene (Polyacetal) | max. g POM | 26 | 39 | 50 | 35 | 55 | 80 | 66 | 96 | 130 |
| Polyethylene terephthalate | max. g PET | 25 | 37 | 48 | 34 | 53 | 77 | 64 | 92 | 126 |
| Polyethylene | max. g PE-LD | 16 | 24 | 30 | 22 | 34 | 49 | 41 | 59 | 80 |
| | max. g PE-HD | 16 | 24 | 31 | 22 | 35 | 50 | 42 | 60 | 82 |
| Polypropylene | max. g PP | 17 | 25 | 32 | 23 | 36 | 51 | 43 | 62 | 84 |
| Fluorpolymerides | max. g FEP, PFA, PCTFE[1)] | 33 | 50 | 65 | 46 | 72 | 103 | 86 | 124 | 169 |
| | max. g ETFE | 29 | 44 | 57 | 40 | 63 | 91 | 76 | 109 | 148 |
| Polyvinyl chloride | max. g PVC-U | 25 | 38 | 49 | 35 | 54 | 78 | 65 | 94 | 127 |
| | max. g PVC-P[1)] | 23 | 35 | 45 | 32 | 50 | 72 | 60 | 87 | 118 |

| Injection units according to EUROMAP | | 290 | | | 400 | | | 800 | | |
|---|---|---|---|---|---|---|---|---|---|---|
| Screw diameter | mm | 30 | 35 | 40 | 35 | 40 | 45 | 45 | 50 | 55 |
| Polystyrene | max. g PS | 97 | 132 | 172 | 141 | 184 | 232 | 291 | 359 | 434 |
| Styrene heteropolymerizates | max. g SB | 95 | 129 | 168 | 137 | 179 | 227 | 284 | 350 | 424 |
| | max. g SAN, ABS[1)] | 93 | 126 | 165 | 135 | 176 | 223 | 278 | 344 | 416 |
| Cellulose acetate | max. g CA[1)] | 109 | 148 | 194 | 158 | 207 | 262 | 327 | 404 | 488 |
| Celluloseacetobutyrate | max. g CAB[1)] | 101 | 138 | 180 | 147 | 192 | 243 | 304 | 375 | 454 |
| Polymethyl methacrylate | max. g PMMA | 100 | 136 | 178 | 145 | 190 | 240 | 300 | 371 | 449 |
| Polyphenylene ether, mod. | max. g PPE | 90 | 122 | 160 | 131 | 171 | 216 | 270 | 333 | 403 |
| Polycarbonate | max. g PC | 102 | 139 | 181 | 148 | 193 | 244 | 305 | 377 | 456 |
| Polysulphone | max. g PSU | 105 | 143 | 187 | 153 | 199 | 252 | 316 | 390 | 471 |
| Polyamides | max. g PA 6.6 \| PA 6[1)] | 96 | 131 | 171 | 140 | 183 | 231 | 289 | 357 | 431 |
| | max. g PA 6.10 \| PA 11[1)] | 90 | 122 | 160 | 131 | 171 | 216 | 270 | 333 | 403 |
| Polyoximethylene (Polyacetal) | max. g POM | 120 | 163 | 213 | 174 | 227 | 287 | 359 | 443 | 536 |
| Polyethylene terephthalate | max. g PET | 115 | 157 | 205 | 167 | 219 | 277 | 346 | 427 | 517 |
| Polyethylene | max. g PE-LD | 73 | 100 | 130 | 106 | 139 | 176 | 219 | 271 | 328 |
| | max. g PE-HD | 76 | 103 | 134 | 110 | 143 | 181 | 227 | 280 | 339 |
| Polypropylene | max. g PP | 77 | 105 | 137 | 112 | 146 | 185 | 232 | 286 | 346 |
| Fluorpolymerides | max. g FEP, PFA, PCTFE[1)] | 155 | 211 | 276 | 225 | 294 | 372 | 465 | 574 | 695 |
| | max. g ETFE | 136 | 185 | 242 | 196 | 256 | 324 | 408 | 504 | 609 |
| Polyvinyl chloride | max. g PVC-U | 117 | 159 | 208 | 170 | 222 | 281 | 351 | 434 | 525 |
| | max. g PVC-P[1)] | 108 | 147 | 192 | 157 | 205 | 260 | 324 | 401 | 485 |

1) average value

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