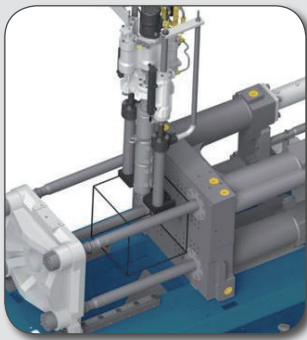


## Innovative into the Future – BOY-Injectioneering

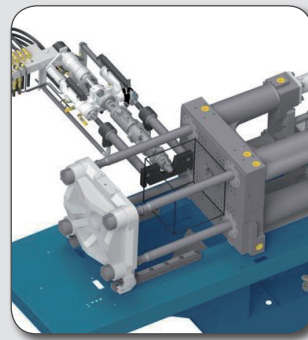


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Injection units BOY 2C M



**Injection unit in vertical / inclined position on top of the mould**



**Horizontal mounting at the side of the mould (L – Position)**

The injection unit for the 2nd component is equipped with its own hydraulic drive and control. Depending on the execution this unit offers a plasticizing volume of up to 141.8 cm<sup>3</sup>.

The drive unit, which includes the control, is positioned next to the basic machine. Fixed wheels make the unit easy to move to other BOY injection moulding machines or machines from other suppliers that are processing a 2nd component. The controls of both machines communicate with each other via I/O-interface or special adapter cable. This assures a seamless process during the entire injection moulding cycle.

Depending on the application, the 2nd injection unit can be arranged in various positions. This is done space-saving in vertical position on horizontal machines; also a lateral

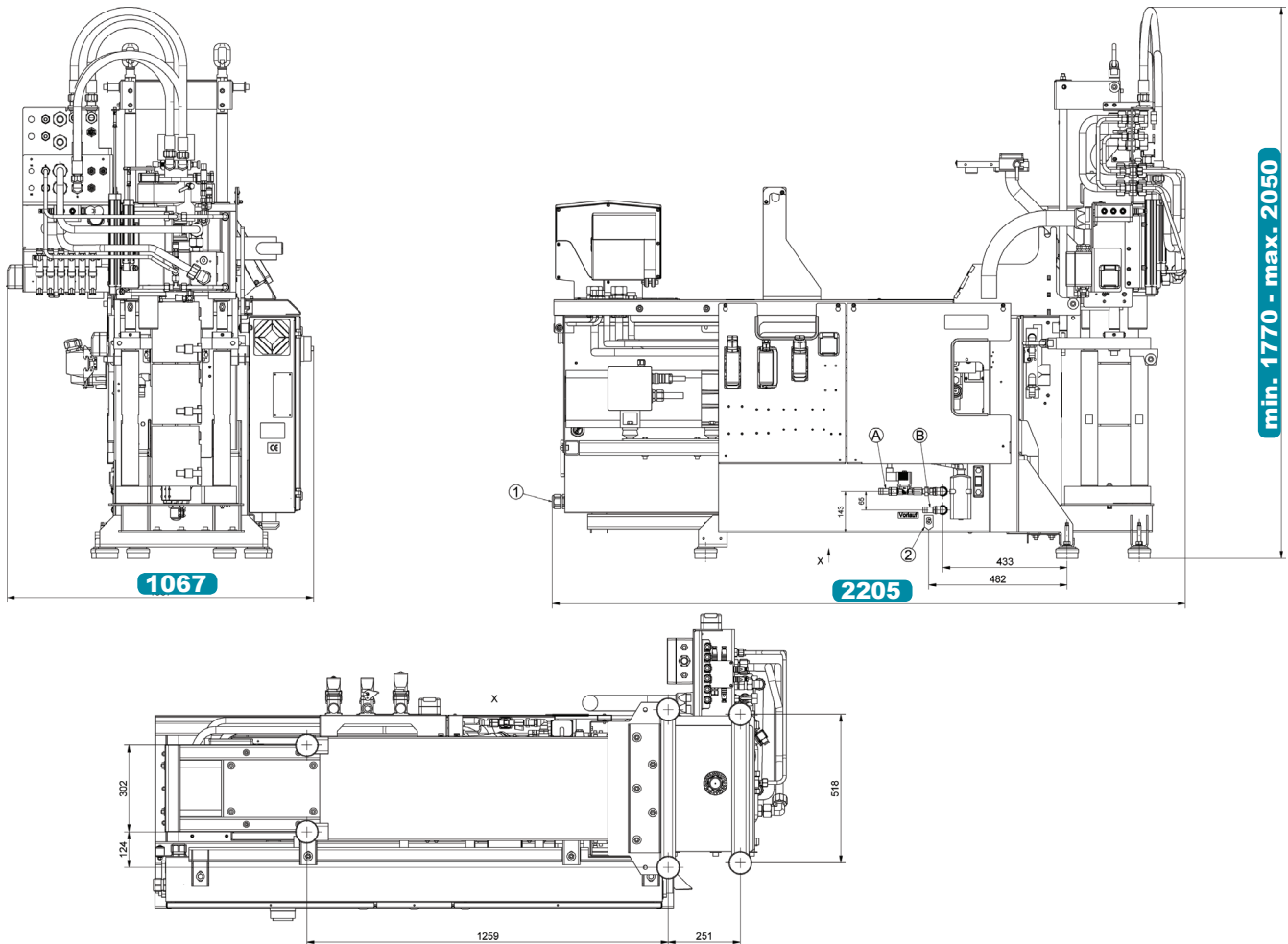
mounting of the injection unit is possible (see graphic representation above).

The open nozzle plasticizing unit is connected to the injection unit for the 2nd component through a corresponding adjustable high-pressure hose line (6 m or 10 m).

The TFT display of the 2nd injection unit is equipped with a 10 m long cable. Therefore, the placement of the monitor can be arranged at the user-side of the basic machine - directly next to the basic machine's Procan ALPHA® monitor.



- 1 The machine design features the best ergonomics and efficient operation.
- 2 Flexible positioning of the injection unit on the basic machine.
- 3 Optimum control technology with intuitive operation concept and flexible placement.
- 4 Robust machine design with integrated oil tank.



#### Additional machine types available:

Model	2C XS			2C S			
Injection unit	SP 14	SP 11	SP 16	SP 45	SP 56	SP 81	SP 96
Screw diameter in mm	12	12	14	18	18	22	24
	14			22			28
	16						32

### Technical Data – standard version<sup>1)</sup>

#### Injection unit for processing thermoplastics

#### SP 215

Screw diameter	mm	28	32	38
Screw- L/D-ratio		22.7	20	16.7
Max. stroke volume (theoretical)	cm <sup>3</sup>	76.9	100.5	141.8
Max. shot weight in PS (theoretical)	g	70.0	91.4	129.0
Injection force	kN	172	172	172
Injection flow (theoretical)	g/s	84.0	110.0	155.0
Max. spec. injection pressure	bar	2800	2143	1520
Max. screw stroke	mm	125	125	125
Nozzle force / contact pressure	kN	31	31	31
Nozzle retraction stroke	mm	215	215	215
Screw torque	Nm	280 (162 cm <sup>3</sup> 130 bar) / 350 (204 cm <sup>3</sup> 130 bar)		
Screw speed (infinitely variable)	U / min.	410 (162 cm <sup>3</sup> ) / 325 (204 cm <sup>3</sup> )		
Screw pulback force	kN	29.7	29.7	29.7
Heating power (nozzle + cylinder)	W	8430	8430	8430
Hopper capacity	litre	–	–	–
Max. height of the injection unit	mm	1882	1882	1882
Weight of the injection unit	kg	45	445	445

#### General

Installed driving power / total power	kW	16.6 / 29.2	16.6 / 29.2	16.6 / 29.2
Duration of the dry cycle (EUROMAP 6)	s – mm	–	–	–
Hydraulic system pressure	bar	180	180	180
Oil tank capacity	litre	70	70	70

#### Dimensiones and weights

#### BOY 2C M

Dimensions (LxWxH) / Footprint	mm / m <sup>2</sup>	2205 x 1067 x 1770 <sup>2</sup> / 2.35
Total weight net (without oil)	kg	1105
Total weight gross (pallet & foil / wooden case)	kg	1175 / 1405
Transport dimensions / case (LxWxH) approx.	m	2.3 x 1.06 x 2.3 / 2.3 x 1.2 x 2.25

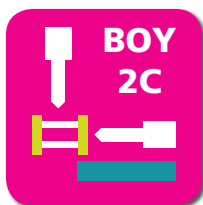
1) more injection units see Technical Data and Equipment 2) max. 2050 mm



Servo – Drive



Procan ALPHA®



Multi Component



Made in Germany

## Equipment

### Injection unit

Pivoting injection unit	–
Preset screw speed values with ramping transition	■
Cold start protection	■
Number of set points of injection speed	8
Number of set points of injection pressure	2
Start of holding pressure dependent on hydraulic pressure, stroke and time	■
Start of holding pressure, cavity pressure-dependent	□
Number of set points of holding pressure	8
Production monitoring at start of holding pressure	■
Closed loop control for the complete injection profile and back pressure	■
Control for intrusion-injection	■
PID microprocessor-controlled heating zones for cylinder + nozzle set and temp. display	5
Hydraulically actuated needle shut-off nozzle (pneumatic for XS-LSR)	○
Slide-away for quick material change (25 VV / 35 VV / 60 VV without hopper)	■
Automatic material loader / feeder	□
Adjustable nozzle force	■
Delayed nozzle retraction	■
Servo-electric screw drive (separate feed line required)	–
High wear-resistant plasticizing units	■
High wear-resistant EconPlast unit	–
Speed injection	–

### General

Cooling water distributor with electric shut-off valve for injection mould	○
Temperature control for feed throat	□
6- / 8-zone water distributor	○
Tool kit	□
Spare parts package	□
Oil filling	□
Anti-vibration mounts	■

### Electronics

USB interface for access and data exchange	■
Interface kit: Serial/Temperature device, USB/Printer and Ethernet	□
OPC interface	□
4 freely programmable inputs/outputs	□
Piece counter	–
Preselect cycle counter with auto shut-off	–
Grounded socket outlet 230 V ~ / 10 A (alternatively can be switched off)	■(○)
CEE socket outlet 400 V ~ / 16 A (alternatively can be switched off)	– (–)
Socket distributor 400 V ~ / 230 V ~ switched (separate feed line required)	□
Energy distributor with four fixed connections, up to 5 x 400 V CEE + 3 x 230 V (sockets can be switched off optionally). Standard supply 125 A / 5 x 50 mm²	–
Switch cabinet ventilation	■
Standardized interface for handling units (EUROMAP 67)	–
Separate feeder (heating and motor current)	○
7-day timer	■
Additional temperature control	□
Brush control	–
Integrated hot runner control, 8/16-fold (separate feed line required)	□
Air conditioning unit for control cabinet	–
Alarm signal with sound	□

### Hydraulics

Electronically controlled variable pump	–
Servo-motor pump drive (Servo-drive)	■
Oil preheating circuit automatic	■
Oil temperature gauge / Controlled oil cooling / Oil level indicator	■
Oil level and temperature monitoring	■
Optical oil filter contamination indicator	–

■ standard    ○ alternatively    □ optional    – not available

You would like to learn more about this BOY injection unit?



Data and Equipment (complete overview)



Competence brochure

**BOY**  
Spritzgiessautomaten

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BOY-APP  
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<http://app.dr-boy.de>

