BOY 22 S dipronic®

Technical Data

Machine Model			BOY 22 S dipronic			
International Size			220-52			
Injection unit						
Screw diameter	mm	18	22	24	28	32
Screw L/D ratio		20	17,5	16	13,5	12
Max. stroke volume (theoretical)	cm^3	20	30	36	49	64
Max. shot weight in PS	g	18	27	32	44	57
Injection force	kN			66,82		
Max. spec. injection press.	bar	2587	1732	1455	1069	818
Plasticising rate	g/sec.	1,7	3,5	5,1	6,2	6,7
Max. screw stroke	mm			80		
Nozzle force	kN			48		
Nozzle retraction stroke	mm			180		
Screw torque	Nm			300		
Screw speed (continuously variable)	rpm			10-225		
Screw pullback force	kN			45,6		
Cylinder heating power	W			1330+1120+280		
Nozzle heating power	W			275		
Hopper capacity	litres			13		
Clamping unit						
Clamping force	kN			220		
Clearance between bars	mm			254		

Clamping unit			
Max. platen daylight	mm	400	
Max. opening stroke (adjustable)	mm	200	
Min. mould height	mm	200	
Mould opening force	kN	40	
Mould closing force	kN	17,6	
Ejector stroke (max.)	mm	80	
Ejector force pushing/pulling	kN	18,1/12	
General			
Installed driving power	kW	5,5	
Installed total power	kW	8,5	
Hydraulic system pressure	bar	160	
Oil tank capacity	litres	135	
Total weight net (without oil)	kg	760	
Total weight gross (without oil)	kg	910	
Length	mm	2260	
Width	mm	765	
Height	mm	1565	2540[1)]

1) With vertical injection unit

Review of Equipment

Injection Unit	
Cold start protection	■
Two injection speed steps	■
Two injection pressure steps	■
Holding pressure, stroke dependent	■
Holding pressure, time or stroke dependent	□
Production monitoring at the start of holding pressure	■
Thermocouple controlled nozzle zone	◪
Screw decompression with open nozzle	□
Hydraulically actuated needle shut-off nozzle	■
Automatic material loader	□
High wear-resistant plasticising cylinder or units	◪
Vented plasticising unit	◪
Thermoset processing unit	◪
Elastomer processing unit	◪
Liquid silicone rubber processing unit (LSR)	◪
Rigid PVC processing unit	◪
Adjustable nozzle force	□
Delayed nozzle retraction	□
Equipment for vertical inj. (inj. into mould parting line)	□
Cavity pressure-dependent start of holding pressure	□
Clamping Unit	
Three mould opening speed ranges with two adjustable speeds	□
Pulsating hydraulic ejector	◪
Puls. hydr. ejector with adjustable stroke (80 mm)	◪
Mechanical ejector	■
Hydraulic unscrewing device instead of hydraulic ejector	◪
Hydraulic unscrewing device, one direction of rotation with intermediate stop (2)	□
Hydraulic unscrewing device, with two directions of rotation , intermediate stop and counter (3)	□
Core pull control with 4/3 directional control valve and freely selectable alternative programs (1)	□
Possible combinations: (1) + (1), (1) + (2), (1) + (3)	□
Injection compression (coining) and mould degassing	□
Connector for safety switch to inhibit mould closing	□
Hydraulic guard safety device	□
Self-adjusting mechanical drop bar safety system	■
Air ejection, position dependent with timer	□
Trip chute balance flap with signal for mach. recycling	□
Electronics	
Digital time setting	■
Digital pressure and speed setting	■
Digital temperature setting	◪
Function indication by LED-display	■
Malfunction shut-down with fault display	■
Mould open timer	■
Hour meter	■
Cycle counter	■
Preselect cycle counter with auto shut-off	□
Single phase socket 220 V/6 A	■
Single phase socket with auto shut-down during fault 220 V/16 A	□
Three-phase socket 380 V/16 A	□
Cooling fan for control cabinet	□
Ammeter for each heating zone	□
Interface for weight checker	□
Standardized interface for robots	□
Additional temperature control for vented barrel	□
Hydraulics	
Electronically controlled variable displacement pump	■
Oil preheating circuit	□
Oil temperatur gauge	■
Thermostatic water-saver valve for oil cooling	■
Oil level and temperature monitoring	□
Oil level indication	■
General	
Cooling water distributor with electric shut-off valve	◪
6 zone cooling water distributor	◪
Tool kits	□
Spare part packages	□
Oil filling	□
Anti-vibration mounts	□

■ = standard ◪ = option □ = additional

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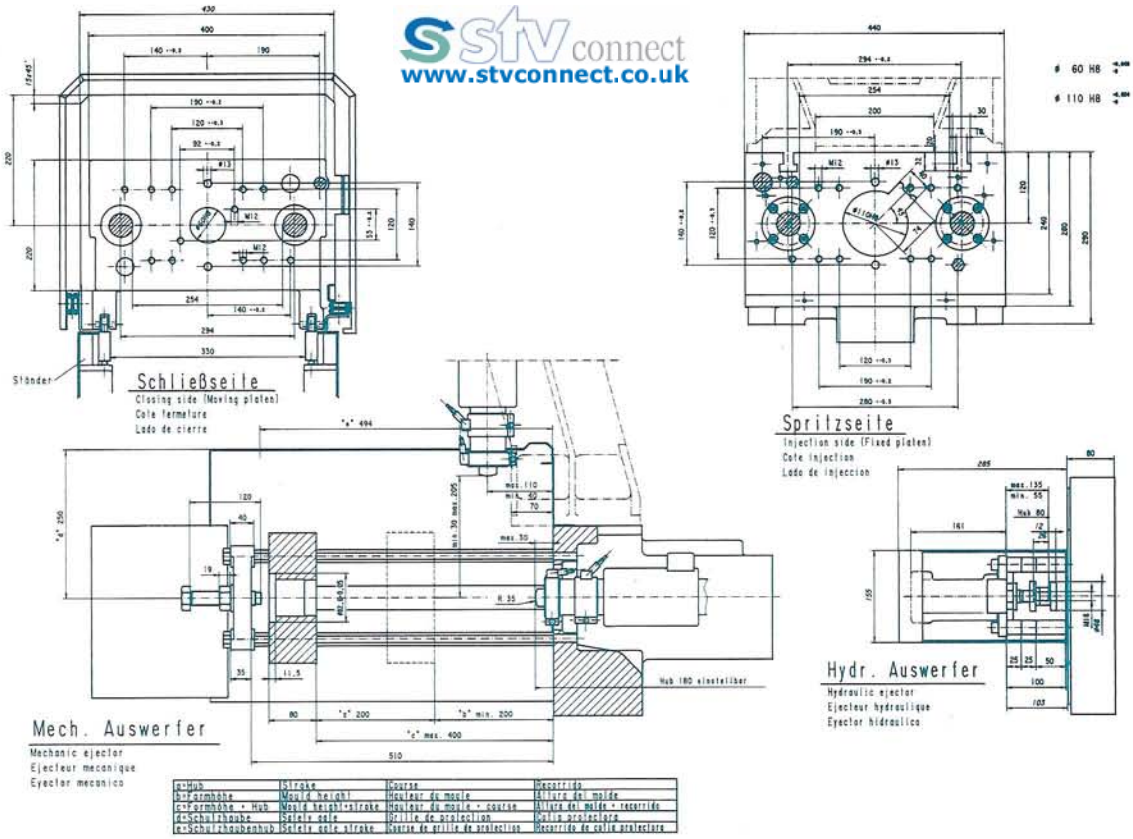
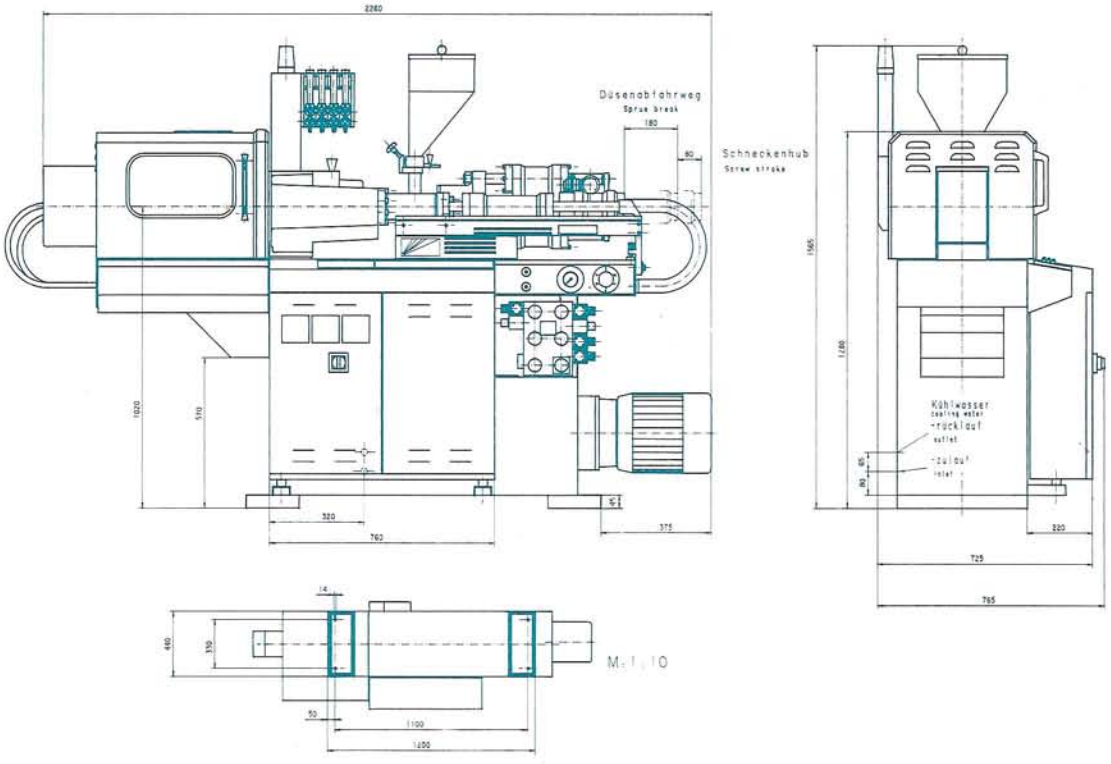
Einbaumaße / Platen Dimensions / Montage des moules / Montaje del molde



a=Hub	Stroke	Course	Recorrido
b=Formhöhe	Mould height	Hauteur du moule	Altura del molde
c=Formhöhe + Hub	Mould height+stroke	Hauteur du moule + course	Altura del molde + recorrido
d=Schutzhaube	Safety gate	Grille de protection	Cubia protectora
e=Schutzhaubenhub	Safety gate stroke	Course de grille de protection	Recorrido de cubia protectora

Raumbedarf / Space requirement / Plan d'encombrement / Dimensiones de maquina



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