

Description

1. Technical data BOY 15 S

International size designation	
Standard design	46/15
Auxiliary equipment for 22 kN of locking force	46/22

Injection unit

Screw diameter	mm	22	24	28
Screw stroke	mm		80	
L/D ratio		18	17	14.5
Stroke volume	cm ³	30	36	49
Plasticizing capacity (PS) at 310 min ⁻¹	kg/h	14	16	19
Shot weight in PS	g	25	30	40
Specific injection pressure	bar	1510	1270	930
Injection force	kN		57	
Injection speed	mm/sec.		100	
Screw speed	min. ⁻¹		10–310	
Nozzle force	kN		42	
Sprue break	mm		180	
Heating zones			2	
Heating capacity, cylinder and nozzle	kW		3,2	
Hopper capacity	litre		13	

Locking unit

Mold locking force	kN	150–220*
Mold opening force	kN	35
Mold closing force	kN	9.3
Mold opening stroke adjustable	mm	200
Minimum mold height	mm	200
Distance between tie bars	mm	254
Maximum plates clearance	mm	400
Mold opening speed	mm/sec.	200
Mold closing speed	mm/sec.	330
Hydraulic ejector force (outwards)	kN	15.9
Hydraulic ejector force (inwards)	kN	10.0
Hydraulic ejector stroke	mm	80

Additional data

Dry cycle time	min. ⁻¹	44/40*	
Pump drive	kW	5.5	
Total installed power	kW	8.5	
Machine dimensions			
	Lenght	mm	2235
	Width	mm	720
	Heigth	mm	1440
Tank capacity	litre		125
Weight without oil filling	kg		690/700*

* = auxiliary equipment for 22 kN of locking force

10 kN ≈ 1 Mp