

The specified efficiency classification is achievable depending on the respective machine equipment.

## 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 / 35 / 55 VV / 35 HV / 2C M / L 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	-

### Clamping unit

Reduced mould height by 50 mm	□
Moving platen support to improve the precision when using large moulds	■
Number of set points of mould closing speed / opening speed	8/8
Number of reopening attempts after mould closing	■
Hydr. ejector with dig. adjustable pressure, speed, position + no. of strokes, intermediate stop position	■
Hydraulic ejector with adjustable stroke 80 mm (for XS = 50 mm)	-
Hydraulic ejector with adjustable stroke 130 mm	■
Hydraulic ejector with adjustable stroke 150 mm and 42,7 kN force	○
Hydraulic unscrewing device, one or two directions of rotation with intermediate stop	□
Hydraulic unscrewing device, two directions, proportional valve and pulse generator	□
Core pull control with 4/3 way directional control valve and freely selectable operational programmes	□
Injection compression (coining) and breathing	■
Injection compression (coining) and breathing with mould degassing control	□
Hydraulic guard safety device	■
Self adjusting mechanical drop bar safety system with electronic monitor	□
Safety gate for handling devices	■
Electronically operated safety gate	○
Selection flap	○
Air ejection	□
Mould lifting crane	□
Simultaneous ejector movement (with double pump)	□
Integrated sprue picker	□

### 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 / interval signal	■
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 3 x 400 V ~ / 3 x 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	□
Connector for safety switch to inhibit mould closing	□
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	-
Proportional action valve for the clamping unit	-
Proportional valve with stroke feedback and positioning action for clamp unit	■

### 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	■

■ standard ○ alternatively □ optional - not available

## Innovative into the Future – BOY-Injectioneering



A 000706

E 02716

Modification in design and equipment reserved

You would like to learn more about this BOY injection moulding machine?



Data and Equipment (complete overview)



Competence brochure





Great distances between tie bars and platens for mounting larger moulds

Simplest possibilities to integrate a four-axis industrial robot

Most efficient technology with servo-motor pump drive

- Fully controlled
- Four-tie bar, cantilevered **two-platen clamping system**
- Patented pressure intensifier with **integrated valve function**
- Most exact positioning of the moving platen via proportional valve and servo drive technology
- Divided safety gate for the clamping unit
- Easily accessible ejector
- Optimum L/D ratio of the screw
- **Different injection units** for thermoplastic, thermoset, LSR, and elastomer processing
- **Lateral swivel-out** injection unit
- Robust machine frame with integrated oil tank
- Optional with energy-efficient and high wear-resistant **EconPlast** unit

Some more of everything - that was the motto when the BOY 100 E was developed. A greater daylight between tie bars (430 x 360 mm) and larger platen distances of 725 mm up to an optional 900 mm, as well as a **clamping force of 1000 kN** characterize BOY's top model.

And as befits a **leader**, the BOY 100 E disposes of the same

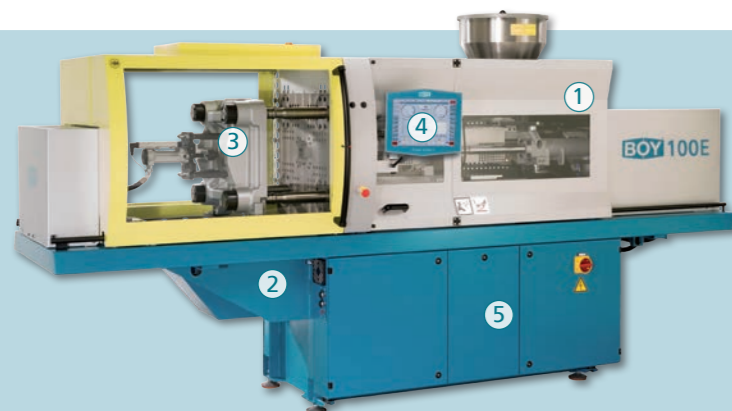
excellent characteristics of all BOY injection moulding machines feature.

Given the easy handling of the machine, the users of the BOY 100 E enjoy **maximum flexibility**. All components - from the injection unit to the four-tie bar clamping system - are **easily accessible**. The divided safety gate of the clamping unit is easy to open and offers **optimum accessibility** of the mould, which entails short set-up times and a rapid start of production.

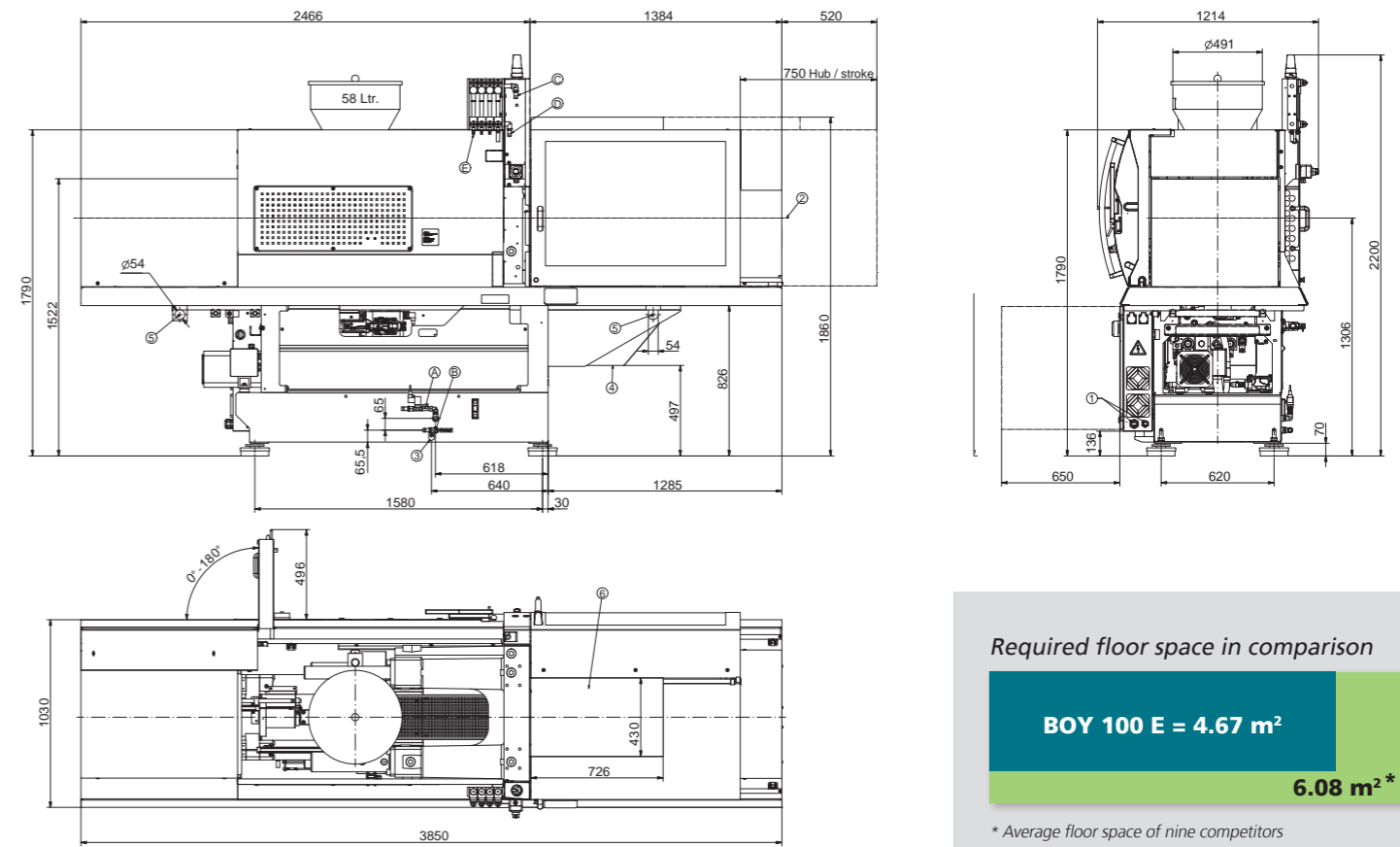
Powerful software applications of the **Procan** series can be chosen for the control of the injection moulding machine. Clearly designed menu structures offer **maximum ease of operation** with optimum results. A multitude of **thermo-plastics, elastomers, silicones** and **thermosets** as well as **metals** and **ceramics** (PIM-Technologie) can be processed trouble-free.

Despite the many intelligent, balanced components and a multitude of optional equipment, the injection moulding machine from BOY makes do with **little floor space** (just under 4.7 square metres).

It also stands for **efficiency** and an unparalleled price/performance ratio. Compared to the competitors, the **material throughput** of the BOY 100 E is markedly higher than that of comparable machines. Available options include controls for handling devices, picker as well as brush units, unscrewing devices, core pulls, and integrated hot runner controls.



- 1 The machine design features the best ergonomics and efficient operation.
- 2 The ejector chute, open on three sides, guarantees optimum removal of the moulded parts.
- 3 Easy handling and flexibility with regard to additional equipment due to the cantilevered clamping system.
- 4 Optimum control technology with intuitive operation concept.
- 5 Stable machine design with integrated oil tank.



Required floor space in comparison

BOY 100 E = 4.67 m<sup>2</sup>

6.08 m<sup>2</sup>\*

\* Average floor space of nine competitors

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

		SP 370 (Standard)		
Screw diameter	mm	36	42	48
Screw- L/D-ratio		23	20	17
Max. stroke volume (theoretical)	cm <sup>3</sup>	157.8	214.7	280.5
Max. shot weight in PS (theoretical)	g	143.6	185.5	255.3
Injection force	kN	239	239	239
Injection flow (theoretical)	g/s	152.9	208.1	271.8
Max. spec. injection pressure	bar	2347	1724	1320
Max. screw stroke	mm	155	155	155
Nozzle force / contact pressure	kN	65	65	65
Nozzle retraction stroke	mm	250	250	250
Screw torque	Nm	500 <sup>2</sup> / 530 <sup>3</sup>	500 <sup>2</sup> / 530 <sup>3</sup>	500 <sup>2</sup> / 530 <sup>3</sup>
Screw speed (infinitely variable)	U / min.	280 <sup>2</sup> / 250 <sup>3</sup>	280 <sup>2</sup> / 250 <sup>3</sup>	280 <sup>2</sup> / 250 <sup>3</sup>
Screw pulback force	kN	53	53	53
Heating power (nozzle + cylinder)	W	11250	11250	11250
Hopper capacity	litre	58	58	58

Clamping unit				
Clamping force	kN	1000	1000	1000
Distance between tie bars	mm (h x v)	430 x 360	430 x 360	430 x 360
Max. daylight between platen	mm	725 (925)	725 (925)	725 (925)
Max. opening stroke (adjustable)	mm	475	475	475
Min. mould height	mm	250	250	250
Max. mould weight on moveable clamping side	kg	500	500	500
Mould opening force	kN	70	70	70
Mould closing force	kN	51.1	51.1	51.1
Ejector stroke (max.)	mm	130 (150)	130 (150)	130 (150)
Ejector force pushing / pulling	kN		20,4 / 13,5	(20,4 / 13,5) (42,7 / 30)

General				
Installed driving power / total power	kW	15 / 26.3 (400 V)	15 / 26.3 (400 V)	15 / 26.3 (400 V)
Duration of the dry cycle (EUROMAP 6)	s – mm	2.1 – 301	2.1 – 301	2.1 – 301
Hydraulic system pressure	bar	195	195	195
Oil tank capacity	litre	200	200	200

Dimensiones and weights				
Dimensions (LxWxH) / Footprint	mm / m <sup>2</sup>	3850 x 1214 x 2200 / 4.67		
Total weight net (without oil)	kg	3150		
Total weight gross (pallet & foil / wooden case)	kg	3300 / 3530		
Case dimensions (LxWxH) approx.	mm	3980 x 1280 x 2050		

1) more injection units see Technical Data and Equipment 2) using a hydraulic motor with 300 cm<sup>3</sup> stroke volume 3) using a hydraulic motor with 348 cm<sup>3</sup> stroke volume