



Metering Technology



**DOPAG Metering and Mixing Systems
for processing Liquid Silicone Rubber
silcomix**



Hilger u. Kern / Dopag Group

silcomix Metering and Mixing Systems

Products made of liquid silicone rubber (LSR) are versatile in use due to their specific material properties. They are naturally translucent and pigment can easily be added as required.

These products can be used in many different application areas and industries, such as

- Automotive and automotive suppliers
- Electrical and electronic
- White goods
- Aerospace
- Medical
- Sanitary engineering
- and many more

Two different types of silcomix Metering and Mixing systems are available:

Piston pump metering and mixing systems

- silcomix P20
- silcomix L200
- silcomix H200

This type of system is used to process all common liquid silicone rubbers with a fixed mixing ratio of 100:100.

Piston pumps are used to accurately meter and supply the material directly from their original containers. The components are kept separate until they enter the mixing block; which is where an optional pigment injection metering process would take place, if required. The proximity of the static steel mixer to the injection moulding machine ensures homogeneous mixing of the components.

The metering and mixing system is operated and controlled by means of a PLC in combination with a touch screen. The control unit is fitted with an interface to the injection moulding system.

Electronic metering and mixing systems

- silcomix V200

This type of system is used to process all common liquid silicone rubbers with a mixing ratio of 100:100 to 100:10. The mixing ratio is permanently monitored and controlled by use of volume counters.

Piston pumps are used to supply the two components directly from their original containers. The components are kept separate until they enter the mixing block; which is where an optional pigment injection metering process would take place, if required.

Electronic volume counters, located before the mixing block, accurately meter the two components at the selected mixing ratio into a pre-mixing chamber.

Firstly, the two components are coarsely mixed in this pre-mixing chamber along with any pigments, if required.

The proximity of the static steel mixer to the injection moulding machine subsequently ensures homogeneous mixing of the components.

The metering and mixing system is operated and controlled by means of a metering computer with an interface to the injection moulding machine.

Material balancing system to empty the drums simultaneously

With every change of a 200 litre drum approximately 4% of the material will remain in the drum.

With the newly developed balancing system from DOPAG it is now possible to reduce this quantity to just around 1%.

This can lead to potentially significant savings.

Exact, simple, economical.

Sample calculations of possible savings per year

Note: These economy calculation examples are based on 3 shift / 365 days working

Part shot weight approx. 0.06 gram

- Per mould 128 parts / shot
- Drum change approx. every 14 days
- Possible cost savings approx. € 3,350 / year

Part shot weight approx. 4.5 gram

- Per mould 8 parts / shot
- Drum change approx. every 4 days
- Possible cost savings approx. € 11,650 / year

Part shot weight approx. 190 gram

- Per mould 1 parts / shot
- Drum change approx. every 1,5 days
- Possible cost savings approx. € 31,150 / year

The material balancing system to empty the drums simultaneously is optionally available for the silcomix ranges L200 and H200.

Metering and Mixing System silcomix P20

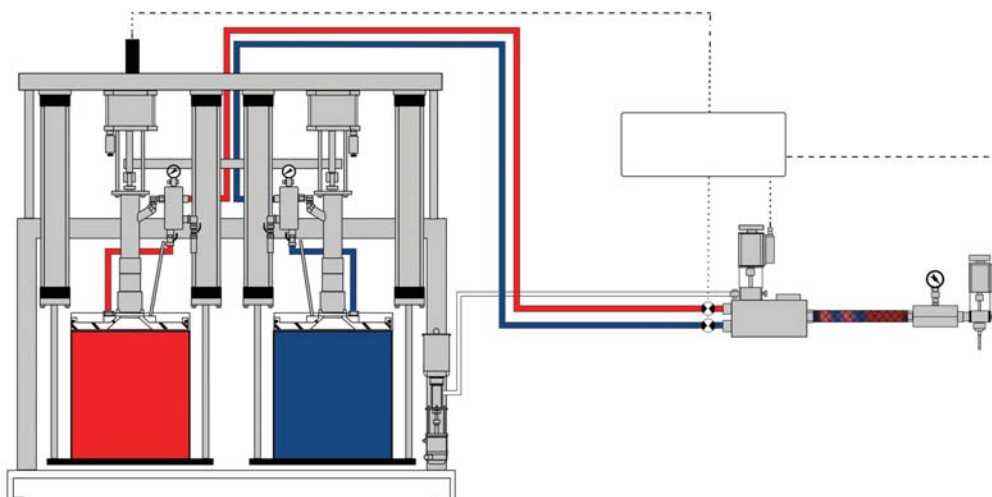


Equipment

- Compact chassis, transportable by fork lift
- Pneumatic container elevator rams
- Pneumatically driven piston pumps
- Control unit PLC
- Touch screen terminal
- Level control
- Mixing block, static steel mixer, material pressure regulator, dispensing valve
- Material pressure control through sensors

Options

- Alternative follower plate sizes
- Pigment injection metering - up to 4 colours possible
- Material pressure control for pigment injection metering
- Volume counters
- Additional dispensing units
- Alternative power supplies
- Further options on request



Metering and Mixing Systems silcomix L200 / H200

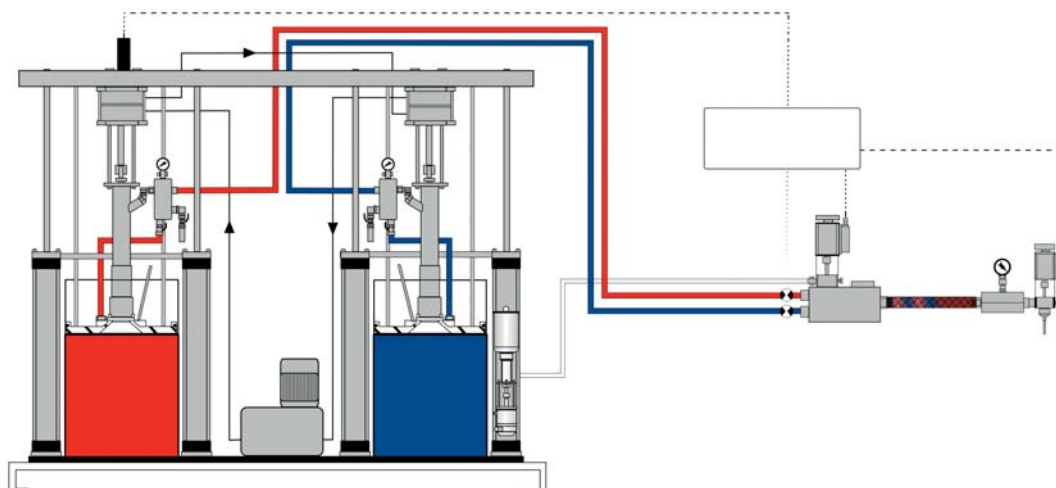


Equipment

- Compact chassis, transportable by fork lift
- Pneumatically driven rams with L200
- Hydraulically driven rams with H200
- Hydraulically driven piston pumps
- Hydraulic power pack
- Control unit PLC
- Touch screen terminal
- Level control
- Mixing block, static steel mixer, material pressure regulator, dispensing valve
- Material pressure control through sensors

Options

- Drum roll-in mechanism
- Alternative follower plate sizes
- Pigment injection metering - up to 4 colours possible
- Material pressure control for pigment injection metering
- Volume counters
- Additional dispensing units
- Alternative power supplies
- Material balancing system
- Further options on request



Metering and Mixing System silcomix V200



Equipment

- Pneumatically driven rams
- Pneumatically driven piston pumps
- Metering computer
- Level control
- Electronic volume counters, mixing block with VOLU-MIX principle, static steel mixer, material pressure regulator, dispensing valve

Options

- Drum roll-in mechanism
- Alternative follower plate sizes
- Pigment injection metering - up to 2 colours possible
- Material pressure control for pigment injection metering
- Additional dispensing units with metering computer
- Larger mixing chamber
- Alternative power supplies
- Further options on request

Technical Data

	silcomix P20	silcomix L200-30	silcomix L200-150	silcomix H200-150	silcomix H200-300	silcomix V200-150
Flow rate l/min / double strokes*	up to 1.2 / 20	up to 0.7 / 12	up to 3.6 / 12	up to 6 / 20	up to 12 / 20	up to 3 / 20
Mixing ratio	100:100	100:100	100:100	100:100	100:100	100:100–100:10
Pigment injection metering	0.2–5 %	0.2–5 %	0.2–5 %	0.2–5 %	0.2–5 %	0.2–5 %
Maximum working pressure	355 bar	355 bar	355 bar	355 bar	355 bar	355 bar
Material supply	20 l	20–80 / 200 l	20–80 / 200 l	20–80 / 200 l	200 l	20–80 / 200 l
Viscosity range	up to 2,500,000 mPa s	up to 2,500,000 mPa s	up to 2,500,000 mPa s	up to 5,000,000 mPa s	up to 5,000,000 mPa s	up to 2,500,000 mPa s
Power supply	110–480 V, 1 Ph, 50/60 Hz, 230 W	110–480 V, 3 Ph, 50/60 Hz, 230 W	110–480 V, 3 Ph, 50/60 Hz, 230 W	110–480 V, 3 Ph, 50/60 Hz, 230 W	110–480 V, 3 Ph, 50/60 Hz, 230 W	110–480 V, 1 Ph, 50/60 Hz, 230 W
Maximum air inlet pressure	6 bar	6 bar	6 bar	6 bar	6 bar	6 bar
Dimensions, L x W x H (mm)	680 x 1100 x 1800	1600 x 1200 x 2500	1600 x 1200 x 2500	1600 x 1200 x 2500	1600 x 1200 x 2500	1800 x 600 x 2500
Weight	approx. 300 kg	approx. 680 kg	approx. 700 kg	approx. 780 kg	approx. 800 kg	approx. 650 kg
Material balancing system	No	Yes	Yes	Yes	Yes	No

* The number of double strokes depends on the viscosity

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The Hilger u. Kern / Dopag Group, with more than 300 employees,

8 subsidiaries and 24 distributors, is one of the leading manufacturers

of metering and mixing systems in the world for plural component

polymers and single component media such as greases, oils and pastes.

For more than 30 years the group has developed systems and

components to suit your individual needs.