

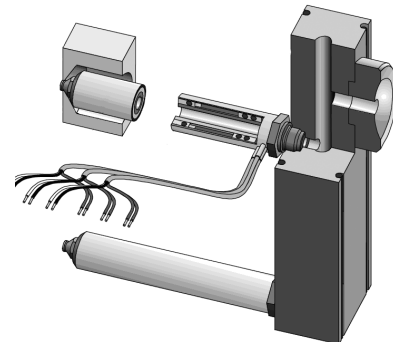


Product Description

2.1.5 Threaded Nozzles

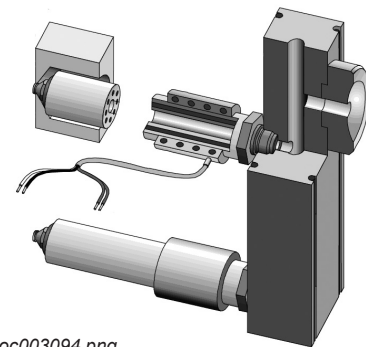
Threaded nozzles are hot runner nozzles screwed into the manifold.

Threaded nozzles , API type



Doc003093.png

Threaded nozzles , APT type – Doc003094.png



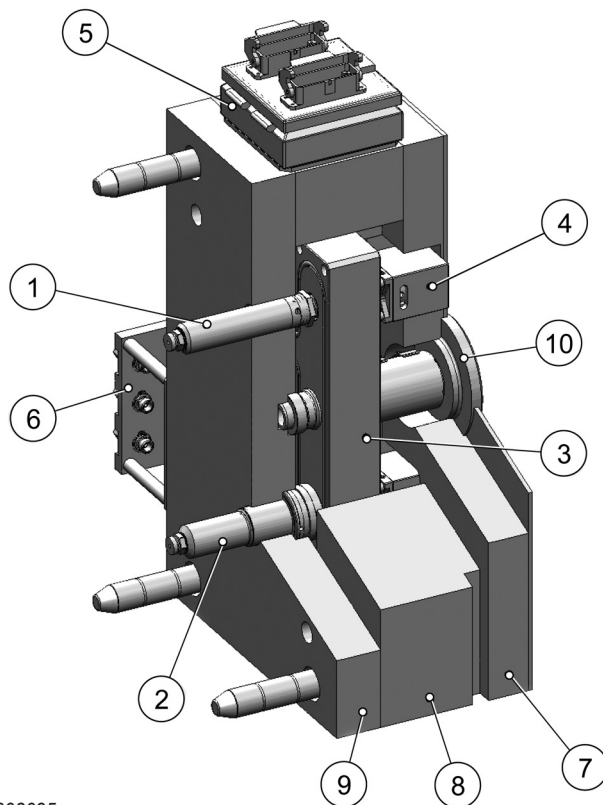
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Product Description

2.2 Hot Half

Synventive can also supply Hot Runner Systems as a complete hot half. Hot half is a preliminary stage for the fixed mold half and, as such, is supplied inclusive of the respective plates. The plates are fitted with cables and, if applicable, hose connections (hydraulics and pneumatics, if applicable), fully mounted and ready for assembly. Hot halves are designed and built to the customer's mold specifications.



Doc003095.png

Components

- (1) Threaded nozzle
- (2) Support ring nozzle
- (3) Manifold
- (4) Valve gate actuator
- (5) Connection box (electricity)
- (6) Hose connections
- (7) Clamping plate
- (8) Spacer plate
- (9) Cavity plate
- (10) Inlet bushing

2.2.1 Hot Half Installation with Nozzles Hot Straight

This system has been designed with the nozzles to be straight in the hot condition. The nozzle locations have been offset to allow for the thermal expansion of the manifold. The nozzle tips will align with the gate locations in the mold after the manifold has reached operating temperature. To install the system onto the mold the manifold and inlet must be preheated.

WARNING

Hot Surfaces Hazard

As the manifold is heated any plastic inside will expand. It is important to also heat the inlet to allow the plastic to expand out the inlet orifice and avoid any buildup of pressure in the manifold.

NOTICE

Refer to the Synventive Instruction Manual for complete instructions for Hot Runner installation and Servicing. These instructions are in addition only to the Synventive Instruction Manual.

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Product Description

Additional Installation Procedure:

- 1) Pre heat the manifold to 220°C by using all manifold heating zones and the inlet zone. Refer to the Synventive Instruction manual for proper procedure.
- 2) Do not heat the nozzles.
- 3) Allow the manifold to soak for 15 minutes to be sure it is fully expanded.
- 4) Install the hot half onto the mold and secure with the required screws.

Additional Procedure to remove the Hot Half from the mold:

- 1) Remove the screws that secure the Hot Half to the mold.
- 2) Separate the hot half from the mold.
- 3) No preheating is needed to separate the Hot Half from the mold.