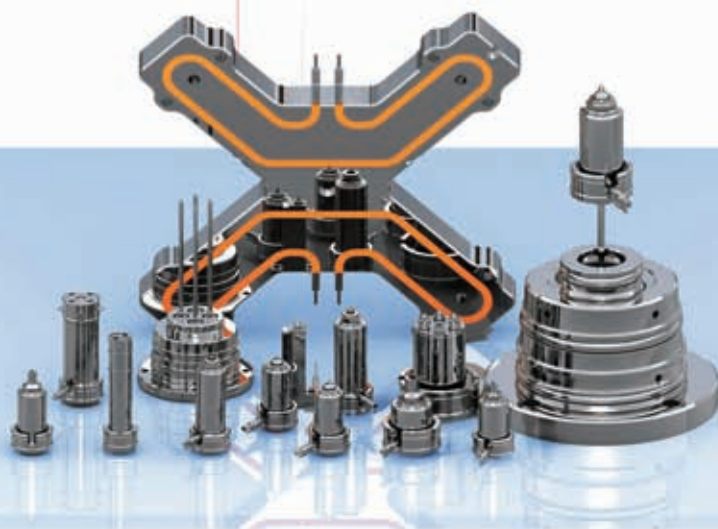




熱流道系統



模具成型技術

及系統化方案



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■ 信易牌熱流道系統的特徵和性價比 Features and Performance-price Ration

特徵

- 適用於多種塑膠材料。澆口直徑在 $\Phi 0.6\sim\Phi 8.0$ 的範圍內任意選擇。
- 模具熱嘴處可以開框到 $\Phi 12$ ，確保模具的強度和製品的特殊要求。
- 每套熱流道都經過專業的模流分析。
- 熱嘴長度可以做到40mm~500mm長。
- 擁有成熟的疊層技術。

Features

- Wide selection and plasticity. It's suitable for materials which is in the rang $\Phi 0.6\sim\Phi 8.0$.
- Mould hot nozzle to $\Phi 12$. Ensure the strength and the special requirements of products.
- Professional analysis of mold flow.
- The length of nozzle can be from 40mm to 500mm.
- Composite technology is mature.

性價比

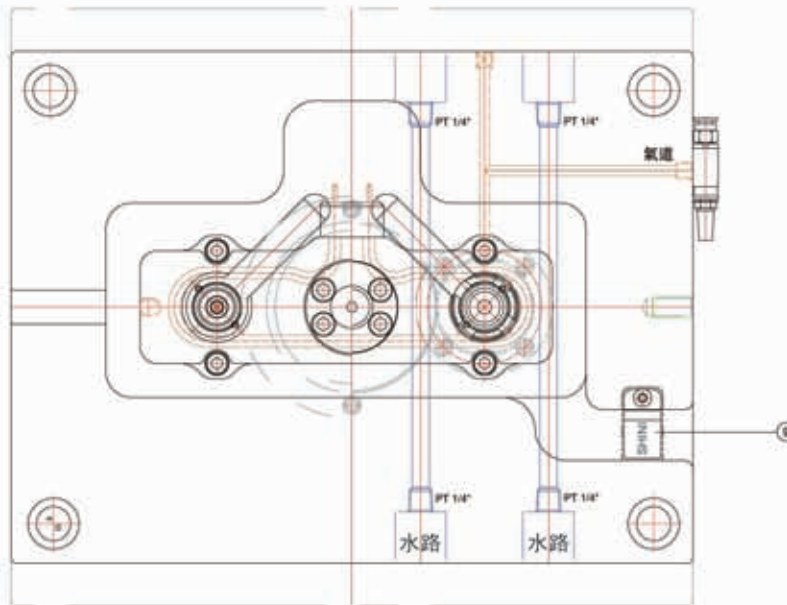
1. 品質。選擇適合熱流道所需鋼材，有不生銹、不斷裂、不變形等優點。
2. 服務。在全國乃至全球都有多家代理商和服務點，確保完善的售後服務。
3. 通用性。與國際接軌，融入創造性的設計理念，使信易熱流道成為國際性通用產品。
4. 技術。行業精英齊聚信易，整套系統從研發到使用均運用了先進的管理體系和技術設備。
5. 結構。提供開放式熱嘴、針閥式熱嘴、單點針閥式熱嘴等多種結構。

Performance-price Ration

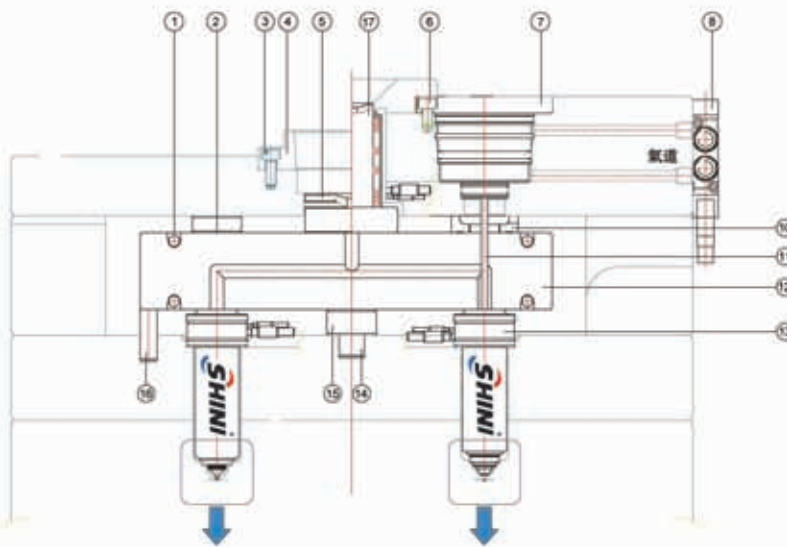
1. Quality. Appropriate steel with excellence of no rust, no broken, no distortion and so on.
2. Service. Many agents and service points of national and global to ensure the perfect after-sales service.
3. Popularity. With international standards and creative concepts to make the hot runner into a global generic products.
4. Technology. Industry elite gathered with the advanced management system and technical equipment.
5. Structure. Offering many structures such as open nozzle, valve nozzle, single valve nozzle and so on.



■ 信易牌熱流道結構展示 Structure Show








- ① 發熱管
Heater
- ② 隔熱墊
Titanium pad
- ③ 定位環螺絲
Locating ring screw
- ④ 定位環
Locating ring
- ⑤ 主射嘴
Main sprue
- ⑥ 氣缸螺絲
Cylinder screw
- ⑦ 氣缸
Cylinder
- ⑧ 電磁閥
Solenoid valve
- ⑨ 壓線塊
Line pressing pad
- ⑩ 導銷
Guide pin
- ⑪ 頂針
Thimble
- ⑫ 分流板
Manifold block
- ⑬ 熱嘴
Nozzle
- ⑭ 中心釘
Center pin
- ⑮ 中心墊
Center pad
- ⑯ 防轉銷
Dowel pin
- ⑰ 加熱式主射嘴
Heating type main sprue



SHO SHI SHS SHMU SHMG SHF SHPR SHMS SHNC SHMV SHNF

我們可以為您的製品要求提供特殊的嘴型，並不局限在此11種嘴型上，請聯繫我們設計人員！
We can provide the special nozzle type for your parts, not limmit to the 11 types above,
Please consult us!







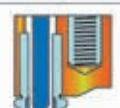



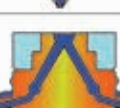











部份嘴型的選擇 Some Nozzle Types Selection

澆口形式 Gate type 塑膠材料 Material range						狀態轉化溫度 Tg	成型溫度 Processing temp	模溫 Mold temp
型號 Type	SHS	SHO	SHI	SHNF	SHNC			
結晶性塑膠 Crystalline materials								
LDPE	☆	✓	✓	✓	✓	140	200-250	20-40
HDPE	×	✓	✓	✓	✓	140	240-300	20-60
PP	☆	☆	☆	☆	☆	165	220-290	20-60
PA6	✓	×	✓	✓	✓	220	230-260	40-100
PA66	✓	×	✓	☆	✓	255	270-295	50-120
POM	✓	×	☆	✓	☆	180	185-215	80-120
PBT	✓	×	✓	☆	✓	225	230-270	40-80
PPS	✓	×	✓	✓	×	290	300-360	20-150
PI	✓	☆	×	✓	☆	290	300-450	80-150
LCP	✓	×	×	☆	×	330	280-450	30-160
PEEK	✓	×	×	✓	×	335	360-400	175-205
PET	☆	✓	✓	☆	✓	245	260-280	50-140
非結晶性塑膠 Amorphous materials								
PS	☆	✓	☆	☆	☆	100	160-230	20-60
PVC	×	✓	×	✓	✓	100	160-180	20-60
ABS	☆	☆	☆	☆	☆	110	180-260	40-85
PMMA	✓	☆	✓	☆	✓	100	220-250	60-110
PC	×	×	✓	✓	✓	220	280-320	60-120
PPO	✓	✓	✓	☆	✓	120	240-290	70-120
PSF	✓	✓	✓	✓	✓	280	240-300	80-140
PES	✓	✓	×	✓	✓	230	340-390	120-200
PEI	×	✓	✓	✓	✓	215	340-425	100-175
PAI	☆	✓	×	✓	×	250	350-500	120-200
PAR	☆	✓	×	✓	✓	280	240-300	80-140
CAB	☆	✓	✓	☆	☆	140	160-190	30-60
PSX	☆	✓	☆	☆	☆	200	320-390	100-160
SAN	✓	✓	☆	✓	✓	115	200-260	40-80
hSTg	✓	✓	✓	✓	✓	100	160-250	20-60
TPU	☆	✓	×	☆	☆	150	190-240	20-40
添加劑 Addition								
防火劑 FR	×	☆	✓	☆	✓	220	240-290	40-120
纖維 GF	☆	☆	✓	☆	✓	220	240-280	130-150

優 Recommend ☆ 良 Accept ✓ 差 Not Recommend ×

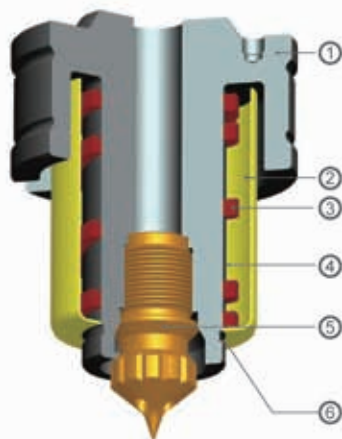
熱嘴介紹

Nozzle Introduction

開放系統 Open System			
SHS		 一個針點痕跡 A pin mark	用於多種塑膠, 澆口痕跡; 適用範圍廣; Suitable for kinds of plastics and small gate mark on part surface; Wide range of application;
SHO		 一個圓錐形痕跡 A cone mark	適用於進澆口在斜面上的產品; 適用於大型產品; Suitable for the system that has side gates; Suitable for large parts;
SHI		 一個針點痕跡 A pin mark	具有點澆口的效果; 可直接換色, 流量大換色能力佳 Effective tip gate; Big flow;excellent color-change;
SHF		 一個針點痕跡 A pin mark	最小間距可達7.5mm; 適用於工程塑料; Min Space is 7.5mm; Suitable for engineering plastics;
SHPR		 一個針點痕跡 A pin mark	熱傳導效果好; 安裝、維修方便; 標準配件更換容易; 無料柄, 注塑時間短; 適合於瓶類、蓋類產品; Excellent heat conduction;easy to install and maintain; No cold slug and short ejection time;suitable for bottles and caps;
SHMS		 一個針點痕跡 A pin mark	澆口痕跡小, 無料柄; 進膠點在產品側面; Small gate mark,no cold slug; Gate mark is on the side of part;
SHMU		 兩個針點痕跡 Two pin mark	良好的換色效果; 適用於小型產品和環保產品; 一出多點, 無需分流板, 無水口料; Excellent color-change;suitable for small part and ring part; One main sprue with nozzles,no manifold and cold slug;
SHMG		 兩個針點痕跡 Two pin mark	適用於精小、環保型產品; 一出多點, 適用於醫療類產品; Suitable for the small and Eco-Product; One main sprue with nozzles,suitable for medical products;
針閥系統 Valve System			
SHNF		 圓整平滑的澆口痕跡 Smooth gate mark	可直接換色; 為延長澆口壽命, 澆口需熱處理; Color-change valve system; Gate area should be heat treated to prolong its life;
SHNC		 一個圓錐形痕跡 A cone mark	使用壽命長; 結構簡易適用, 減少模具加工; 適用於進澆口在斜面上的產品; Long service life; simple structure;less mold processing; Suitable for the system that has side gates;
SHMV		 圓整平滑的澆口痕跡 Smooth gate mark	進膠口美觀; 使用壽命長; 適用於一模多腔的小產品; Excellent appearance;long service life; One-main sprue with nozzles;suitable for small part



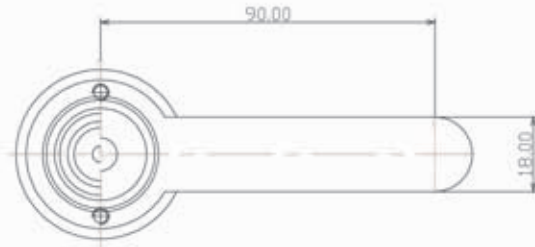
尖嘴/Sharp



- | | | |
|---|-----|-----------------|
| ① | 本體 | Body |
| ② | 隔熱套 | Thermal lagging |
| ③ | 發熱圈 | Heater |
| ④ | 感溫線 | Thermocouple |
| ⑤ | 小頭 | Sharp |
| ⑥ | 卡環 | Snap ring |



1. 編碼原則 Code principle



2. 熱嘴局部圖

Cut out for the nozzle

公差標準: DIN ISO 2768-MK

General tolerances: DIN ISO 2768-MK

表面粗糙度 $\nabla \nabla \nabla 0.02$

Surfaces: $\nabla \nabla \nabla 0.02$

模板加工尺寸如右圖所示

Template processing dimensions as shown on the right



3. 連接線

Connecting

電源 230V

Power 230V

感溫線

Thermocouple

4. 技術規範

Questionnaire

相同的本體類型，有不同的嘴尖

The same nozzle bodies, have different nozzle sharp

嘴尖的尺寸如圖所示

Nozzle sharp dimensions as shown on the right

5. 尺寸的選擇

Size selection

'L 熱嘴長度

'L Nozzle length

HD 澆口的直徑範圍: $\varnothing 0.4 \sim \varnothing 1.8$

HD Gate diameter range: $\varnothing 0.4 \sim \varnothing 1.8$

HC 球頭半徑

HC Ball head radius: R10, R15, R19, R21

相關信息:

Information regarding:

→ 公差和表面局部要求
Tolerances and surfaces

→ 形狀和位置公差
Shape and position tolerance

→ 冷卻要求:
澆口區域、嘴頭區域
Cooling required: Gate bush and nozzle sharp

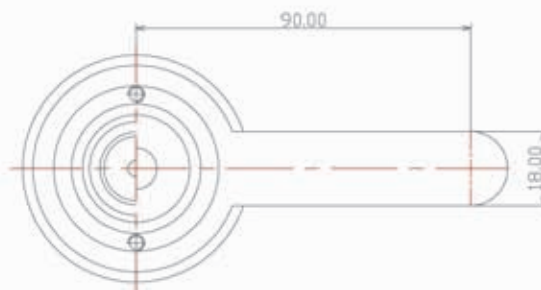
→ 封膠處的要求
The front of nozzle sharp must be against plastic

6. 熱嘴尺寸與功率的選擇 Nozzle size and power selection

熱嘴尺寸 Nozzle size (L)	熱嘴膨脹量 (單位:mm) Nozzle expansion (Unit:mm)			加熱器功率 Heater (Watt)	感溫線型號 T/C (J/K)
	200°C	250°C	300°C		
SHS18045	0.015	0.063	0.076	SHCH18025200	SHT10100J/K
SHS18065	0.098	0.123	0.148	SHCH18045250	SHT10100J/K
SHS18085	0.146	0.183	0.220	SHCH18065300	SHT10100J/K
SHS18105	0.196	0.243	0.292	SHCH18085450	SHT10100J/K
SHS18125	0.242	0.303	0.364	SHCH18105600	SHT10150J/K
SHS18145	0.290	0.363	0.436	SHCH18125700	SHT10150J/K



1. 編碼原則 Code principle



2. 熱嘴局部圖

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公差標準: DIN ISO 2768-MK

General tolerances: DIN ISO 2768-MK

表面粗糙度 $\nabla\nabla\nabla 0.02$

Surfaces: $\nabla\nabla\nabla 0.02$

模板加工尺寸如右圖所示

Template processing dimensions as shown on the right

3. 連接線/控制器

Connecting/Controller

電源 230V

Power 230V

感溫線

Thermocouple

溫控箱

Temp-controller

4. 技術規範

Questionnaire

不同的產品要求, 有不同的嘴尖

Different part requirements, have different nozzle sharp

嘴尖的尺寸如圖所示

Nozzle sharp dimensions as shown on the right

5. 尺寸的選擇

Size selection

'L 熱嘴長度

'L Nozzle length

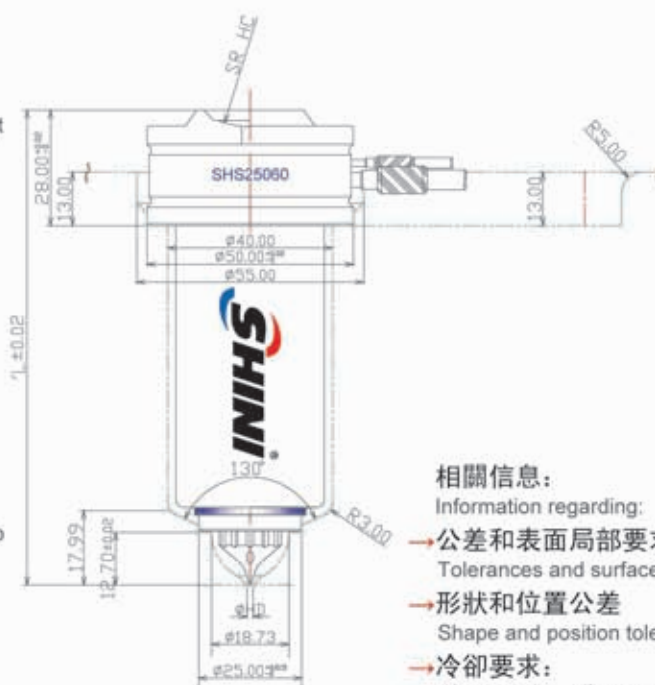
HD 澆口的直徑範圍: $\varnothing 0.8 \sim \varnothing 2.5$

HD Gate diameter range: $\varnothing 0.8 \sim \varnothing 2.5$

HC 球頭半徑

HC Ball head radius: R10, R15, R19, R21

6. 熱嘴尺寸與功率的選擇 Nozzle size and power selectiion



相關信息:

Information regarding:

→ 公差和表面局部要求
Tolerances and surfaces

→ 形狀和位置公差
Shape and position tolerance

→ 冷卻要求:
澆口區域、嘴頭區域
Cooling required: Gate bush and nozzle sharp

→ 封膠處的要求
The front of nozzle sharp must be against plastic

熱嘴尺寸 Nozzle size (L)	熱嘴膨脹量 (單位:mm) Nozzle expansion (Unit:mm)			加熱器功率 Heater (Watt)	感溫線型號 T/C (J/K)
	200°C	250°C	300°C		
SHS25060	0.070	0.087	0.105	SHCH25030200	SHT15100J/K
SHS25080	0.118	0.147	0.177	SHCH25050350	SHT15100J/K
SHS25100	0.166	0.207	0.249	SHCH25070450	SHT15100J/K
SHS25120	0.214	0.267	0.321	SHCH25090600	SHT15150J/K
SHS25140	0.262	0.327	0.393	SHCH25110700	SHT15150J/K
SHS25160	0.310	0.387	0.465	SHCH25130850	SHT15150J/K

1. 編碼原則 Code principle



2. 熱嘴局部圖

Cut out for the nozzle

公差標準: DIN ISO 2768-MK

General tolerances: DIN ISO 2768-MK

表面粗糙度 $\nabla\nabla\nabla 0.02$

Surfaces: $\nabla\nabla\nabla 0.02$

模板加工尺寸如右圖所示

Template processing dimensions as shown on the right

3. 連接線/控制器

Connecting/Controller

電源230V

Power 230V

感溫線

Thermocouple

溫控箱

Temp-controller

4. 技術規範

Questionnaire

不同的產品要求, 有不同的嘴尖

Different part requirements, have different nozzle sharp

嘴尖的尺寸如圖所示

Nozzle sharp dimensions as shown on the right

5. 尺寸的選擇

Size selection

L 熱嘴長度

L Nozzle length

HD 澆口的直徑範圍: $\varnothing 1.0 \sim \varnothing 2.8$

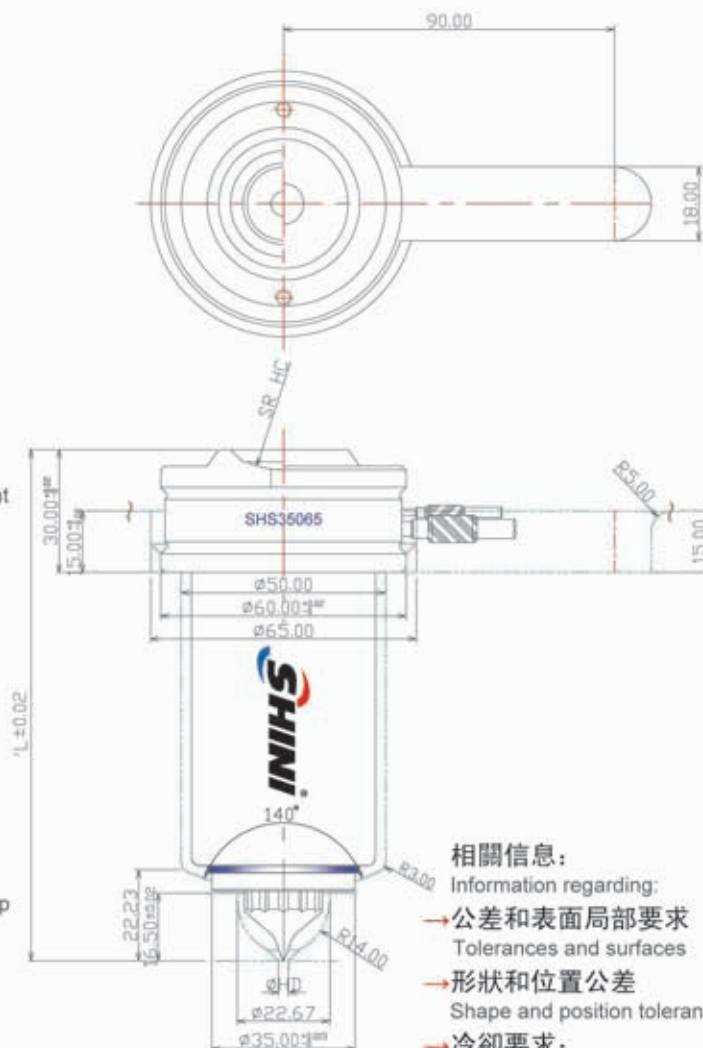
HD Gate diameter range: $\varnothing 1.0 \sim \varnothing 2.8$

HC 球頭半徑

HC Ball head radius: R10, R15, R19, R21

6. 熱嘴尺寸與功率的選擇 Nozzle size and power selection

熱嘴尺寸 Nozzle size (L)	熱嘴膨脹量 (單位:mm) Nozzle expansion (Unit:mm)			加熱器功率 Heater (Watt)	感溫線型號 T/C (J/K)
	200°C	250°C	300°C		
SHS35065	0.065	0.081	0.098	SHCH35027300	SHT15100J/K
SHS35085	0.113	0.141	0.170	SHCH35047450	SHT15100J/K
SHS35105	0.161	0.201	0.242	SHCH35067700	SHT15100J/K
SHS35125	0.209	0.261	0.314	SHCH35087850	SHT15150J/K
SHS35145	0.257	0.321	0.386	SHCH35107950	SHT15150J/K
SHS35165	0.305	0.381	0.458	SHCH35127950	SHT15150J/K



相關信息:

Information regarding:

→ 公差和表面局部要求
Tolerances and surfaces

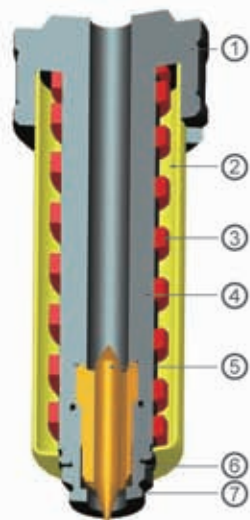
→ 形狀和位置公差
Shape and position tolerance

→ 冷卻要求:
澆口區域、嘴頭區域
Cooling required: Gate bush and nozzle sharp

→ 封膠處的要求
The front of nozzle sharp must be against plastic



換色嘴/Color Change



- | | | |
|---|-----|-----------------|
| ① | 本體 | Body |
| ② | 隔熱套 | Thermal lagging |
| ③ | 發熱圈 | Heater |
| ④ | 感溫線 | Thermocouple |
| ⑤ | 小頭 | Sharp |
| ⑥ | 卡環 | Snap ring |
| ⑦ | 澆口司 | Gate bush |



1. 編碼原則 Code principle



2. 熱嘴局部圖

Cut out for the nozzle

公差標準: DIN ISO 2768-MK

General tolerances: DIN ISO 2768-MK

表面粗糙度 $\sqrt{\sqrt{\sqrt{0.02}}}$

Surfaces: $\sqrt{\sqrt{\sqrt{0.02}}}$

模板加工尺寸如右圖所示

Template processing dimensions as shown on the right

3. 連接線/控制器

Connecting/Controller

電源230V

Power 230V

感溫線

Thermocouple

溫控箱

Temp-controller

4. 技術規範

Questionnaire

不同的產品要求, 有不同的嘴尖

Different part requirements, have different nozzle sharp

嘴尖的尺寸如圖所示

Nozzle sharp dimensions as shown on the right

5. 尺寸的選擇

Size selection

L 熱嘴長度

L Nozzle length

HD 澆口的直徑範圍: $\varnothing 0.5 \sim \varnothing 1.8$

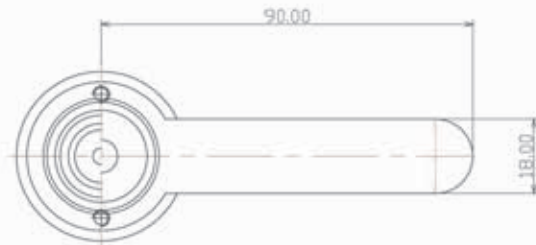
HD Gate diameter range: $\varnothing 0.5 \sim \varnothing 1.8$

HC 球頭半徑

HC Ball head radius: R10, R15, R19, R21

6. 熱嘴尺寸與功率的選擇 Nozzle size and power selection

熱嘴尺寸 Nozzle size (L)	熱嘴膨脹量 (單位:mm) Nozzle expansion (Unit:mm)			加熱器功率 Heater (Watt)	感溫線型號 T/C (J/K)
	200°C	250°C	300°C		
SHI18055	0.070	0.088	0.106	SHCH18030200	SHT15100J/K
SHI18075	0.118	0.148	0.178	SHCH18050250	SHT15100J/K
SHI18095	0.166	0.208	0.250	SHCH18070300	SHT15100J/K
SHI18115	0.214	0.268	0.322	SHCH18090450	SHT15150J/K
SHI18135	0.262	0.328	0.394	SHCH18110600	SHT15150J/K
SHI18155	0.310	0.388	0.466	SHCH18130700	SHT15150J/K



相關信息:

Information regarding:

→ 公差和表面局部要求

Tolerances and surfaces

→ 形狀和位置公差

Shape and position tolerance

→ 冷卻要求:

澆口區域、嘴頭區域

Cooling required: Gate

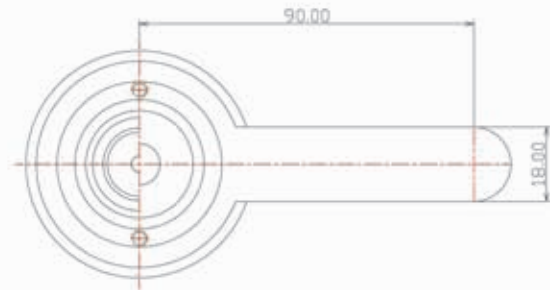
bush and nozzle sharp

→ 封膠處的要求

The front of nozzle sharp

must be against plastic

1. 編碼原則 Code principle



2. 熱嘴局部圖

Cut out for the nozzle

公差標準: DIN ISO 2768-MK

General tolerances: DIN ISO 2768-MK

表面粗糙度 $\sqrt{\sqrt{\sqrt{0.02}}$

Surfaces: $\sqrt{\sqrt{\sqrt{0.02}}$

模板加工尺寸如右圖所示

Template processing dimensions as shown on the right

3. 連接線/控制器

Connecting/Controller

電源230V

Power 230V

感溫線

Thermocouple

溫控箱

Temp-controller

4. 技術規範

Questionnaire

不同的產品要求, 有不同的嘴尖

Different part requirements, have different nozzle sharp

嘴尖的尺寸如圖所示

Nozzle sharp dimensions as shown on the right

5. 尺寸的選擇

Size selection

L 熱嘴長度

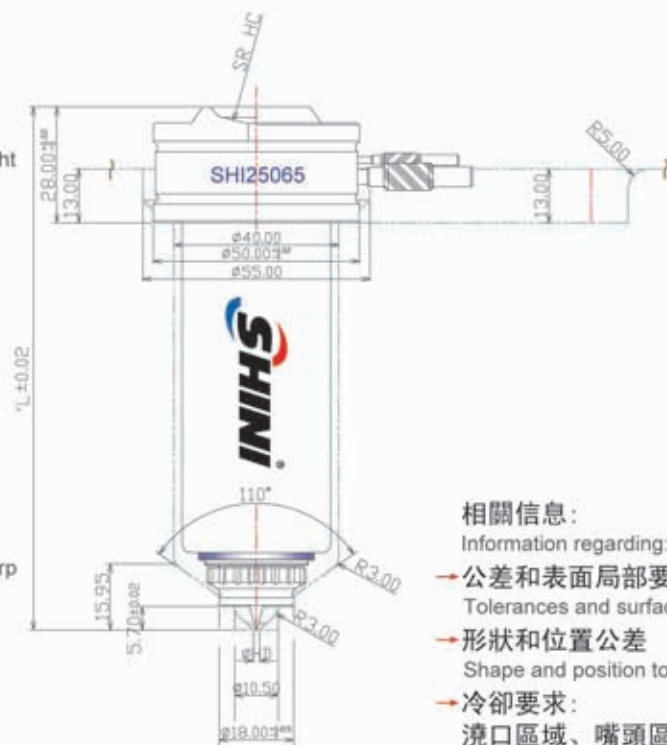
L Nozzle length

HD 澆口的直徑範圍: $\varnothing 0.8 \sim \varnothing 2.0$

HD Gate diameter range: $\varnothing 0.8 \sim \varnothing 2.0$

HC 球頭半徑

HC Ball head radius: R10, R15, R19, R21



相關信息:

Information regarding:

→ 公差和表面局部要求
Tolerances and surfaces

→ 形狀和位置公差
Shape and position tolerance

→ 冷卻要求:
澆口區域、嘴頭區域
Cooling required: Gate bush and nozzle sharp

→ 封膠處的要求
The front of nozzle sharp must be against plastic

6. 熱嘴尺寸與功率的選擇 Nozzle size and power selection

熱嘴尺寸 Nozzle size(L)	熱嘴膨脹量(單位:mm) Nozzle expansion(Unit:mm)			加熱器功率 Heater(Watt)	感溫線型號 T/C(J/K)
	200℃	250℃	300℃		
SHI25065	0.082	0.102	0.123	SHCH25035200	SHT15100J/K
SHI25085	0.130	0.162	0.195	SHCH25055350	SHT15100J/K
SHI25105	0.178	0.222	0.267	SHCH25075450	SHT15100J/K
SHI25125	0.226	0.282	0.339	SHCH25095600	SHT15150J/K
SHI25145	0.274	0.342	0.411	SHCH25115700	SHT15150J/K
SHI25165	0.322	0.402	0.483	SHCH25135850	SHT15150J/K



1. 編碼原則 Code principle



2. 熱嘴局部圖

Cut out for the nozzle

公差標準: DIN ISO 2768-MK

General tolerances: DIN ISO 2768-MK

表面粗糙度 $\nabla\nabla\nabla 0.02$

Surfaces: $\nabla\nabla\nabla 0.02$

模板加工尺寸如右圖所示

Template processing dimensions as shown on the right

3. 連接線/控制器

Connecting/Controller

電源230V

Power 230V

感溫線

Thermocouple

溫控箱

Temp-controller

4. 技術規範

Questionnaire

不同的產品要求, 有不同的嘴尖

Different part requirements, have different nozzle sharp

嘴尖的尺寸如圖所示

Nozzle sharp dimensions as shown on the right

5. 尺寸的選擇

Size selection

L 熱嘴長度

L Nozzle length

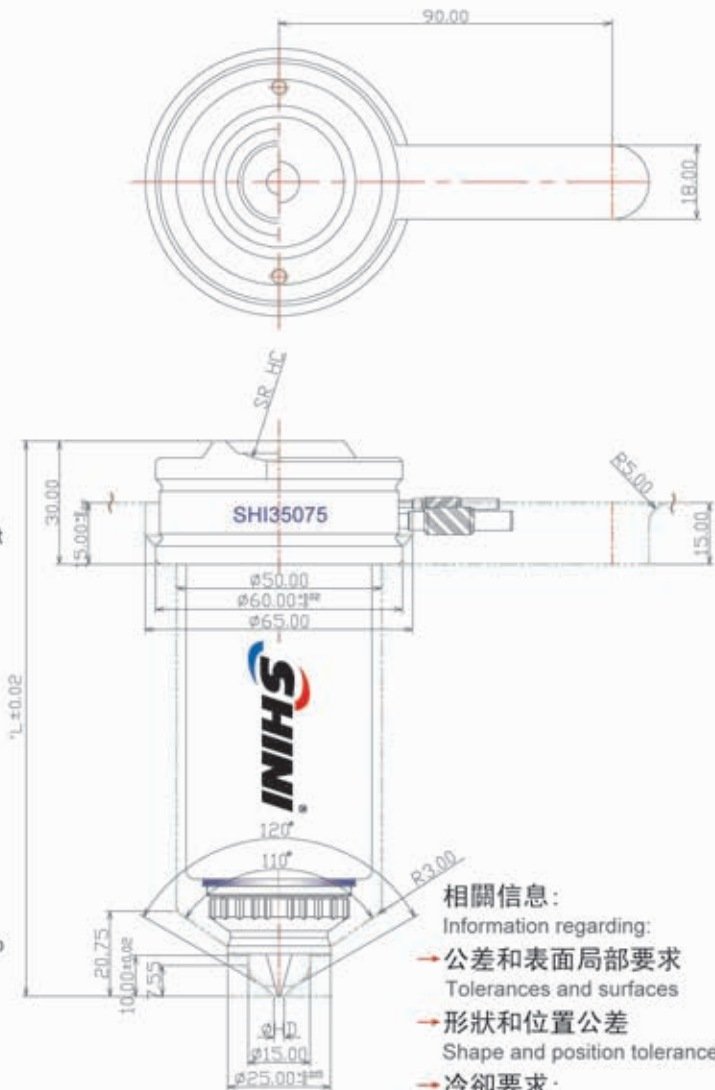
HD 澆口的直徑範圍: $\varnothing 1.0 \sim \varnothing 2.8$

HD Gate diameter range: $\varnothing 1.0 \sim \varnothing 2.8$

HC 球頭半徑

HC Ball head radius: R10, R15, R19, R21

6. 熱嘴尺寸與功率的選擇 Nozzle size and power selection



相關信息:

Information regarding:

→ 公差和表面局部要求

Tolerances and surfaces

→ 形狀和位置公差

Shape and position tolerance

→ 冷卻要求:

澆口區域、嘴頭區域

Cooling required: Gate

bush and nozzle sharp

→ 封膠處的要求

The front of nozzle sharp

must be against plastic.

熱嘴尺寸 Nozzle size (L)	熱嘴膨脹量 (單位:mm) Nozzle expansion (Unit:mm)			加熱器功率 Heater (Watt)	感溫線型號 T/C (J/K)
	200°C	250°C	300°C		
SHI35075	0.100	0.125	0.150	SHCH35030350	SHT15100J/K
SHI35095	0.148	0.185	0.223	SHCH35050450	SHT15100J/K
SHI35115	0.196	0.245	0.295	SHCH35070700	SHT15100J/K
SHI35135	0.244	0.305	0.367	SHCH35090850	SHT15150J/K
SHI35155	0.292	0.365	0.439	SHCH35110950	SHT15150J/K
SHI35175	0.316	0.395	0.475	SHCH35130950	SHT15150J/K

1. 編碼原則 Code principle



2. 熱嘴局部圖

Cut out for the nozzle

公差標準: DIN ISO 2768-MK

General tolerances: DIN ISO 2768-MK

表面粗糙度 $\nabla\nabla\nabla 0.02$

Surfaces: $\nabla\nabla\nabla 0.02$

模板加工尺寸如右圖所示

Template processing dimensions as shown on the right

3. 連接線/控制器

Connecting/Controller

電源230V

Power 230V

感溫線

Thermocouple

溫控箱

Temp-controller

4. 技術規範

Questionnaire

不同的產品要求, 有不同的嘴尖

Different part requirements, have different nozzle sharp

嘴尖的尺寸如圖所示

Nozzle sharp dimensions as shown on the right

5. 尺寸的選擇

Size selection

L 熱嘴長度

L Nozzle length

HD 澆口的直徑範圍: $\varnothing 1.2 \sim \varnothing 3.0$

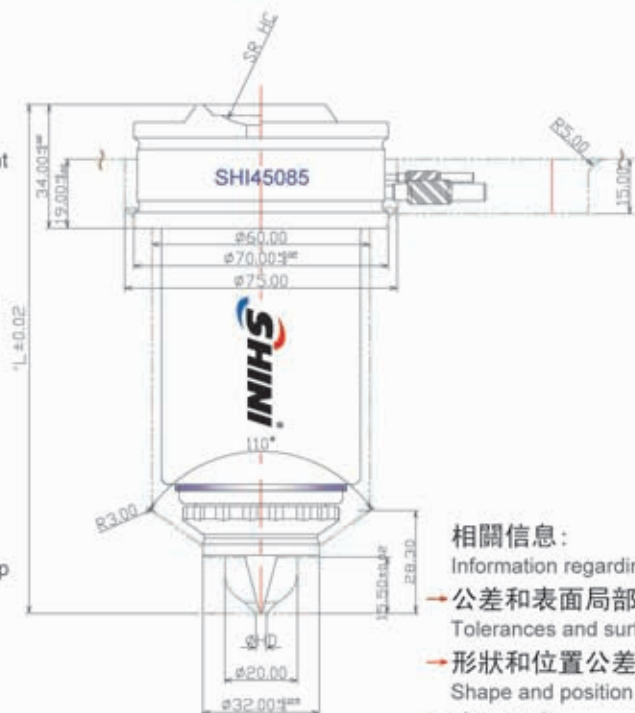
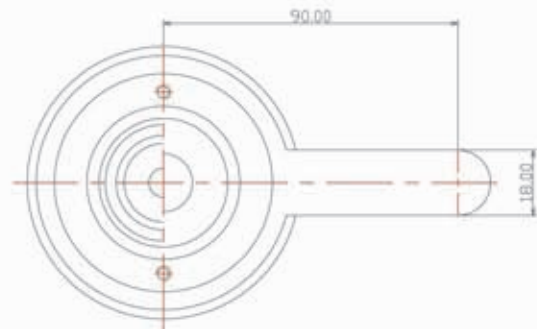
HD Gate diameter range: $\varnothing 1.2 \sim \varnothing 3.0$

HC 球頭半徑

HC Ball head radius: R10, R15, R19, R21

6. 熱嘴尺寸與功率的選擇 Nozzle size and power selection

熱嘴尺寸 Nozzle size (L)	熱嘴膨脹量 (單位:mm) Nozzle expansion (Unit:mm)			加熱器功率 Heater (Watt)	感溫線型號 T/C (J/K)
	200°C	250°C	300°C		
SHI45085	0.072	0.090	0.109	SHCH45030350	SHT15100J/K
SHI45105	0.120	0.150	0.181	SHCH45050450	SHT15100J/K
SHI45125	0.168	0.210	0.253	SHCH45070700	SHT15100J/K
SHI45145	0.216	0.270	0.325	SHCH45090850	SHT15150J/K
SHI45165	0.264	0.330	0.397	SHCH45110950	SHT15150J/K
SHI45185	0.312	0.390	0.469	SHCH45130950	SHT15150J/K



相關信息:

Information regarding:

→ 公差和表面局部要求

Tolerances and surfaces

→ 形狀和位置公差

Shape and position tolerance

→ 冷卻要求:

澆口區域、嘴頭區域

Cooling required: Gate

bush and nozzle sharp

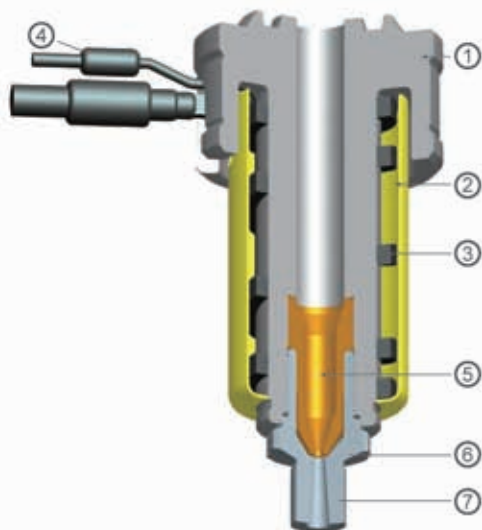
→ 封膠處的要求

The front of nozzle sharp

must be against plastic



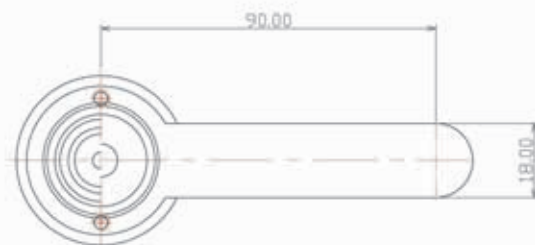
加長熱嘴/Lengthened Nozzle



- | | |
|-------|-----------------|
| ① 本體 | Body |
| ② 隔熱套 | Thermal lagging |
| ③ 發熱圈 | Heater |
| ④ 感溫線 | Thermocouple |
| ⑤ 小頭 | Sharp |
| ⑥ 卡環 | Snap ring |
| ⑦ 澆口司 | Gate bush |



1. 編碼原則 Code principle



2. 熱嘴局部圖

Cut out for the nozzle

公差標準: DIN ISO 2768-MK

General tolerances: DIN ISO 2768-MK

表面粗糙度 $\nabla\nabla\nabla 0.02$

Surfaces: $\nabla\nabla\nabla 0.02$

模板加工尺寸如右圖所示

Template processing dimensions as shown on the right



3. 連接線/控制器

Connecting/Controller

電源230V

Power 230V

感溫線

Thermocouple

溫控箱

Temp-controller

4. 技術規範

Questionnaire

不同的產品要求, 有不同的嘴尖

Different part requirements, have different nozzle sharp

嘴尖的尺寸如圖所示

Nozzle sharp dimensions as shown on the right

5. 尺寸的選擇

Size selection

L 熱嘴長度

L Nozzle length

HD 澆口的直徑範圍: $\varnothing 1.0 \sim \varnothing 2.0$

HD Gate diameter range: $\varnothing 1.0 \sim \varnothing 2.0$

HC 球頭半徑

HC Ball head radius: R10, R15, R19, R21

相關信息:

Information regarding:

→ 公差和表面局部要求

Tolerances and surfaces

→ 形狀和位置公差

Shape and position tolerance

→ 冷卻要求:

澆口區域、嘴頭區域

Cooling required: Gate

bush and nozzle sharp

→ 封膠處的要求

The front of nozzle sharp

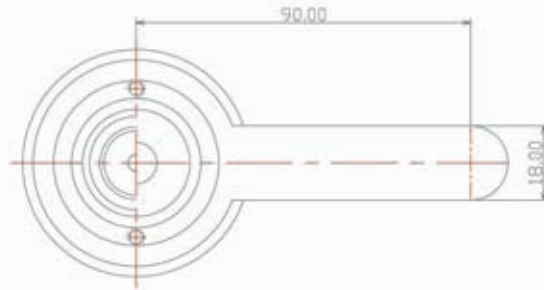
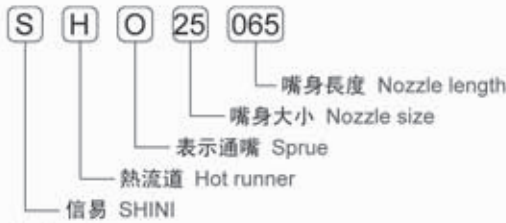
must be against plastic

6. 熱嘴尺寸與功率的選擇 Nozzle size and power selection

熱嘴尺寸 Nozzle size (L)	熱嘴膨脹量 (單位:mm) Nozzle expansion (Unit:mm)			加熱器功率 Heater (Watt)	感溫線型號 T/C (J/K)
	200°C	250°C	300°C		
SHO18055	0.066	0.082	0.099	SHCH18030200	SHT15100J/K
SHO18075	0.114	0.142	0.171	SHCH18050250	SHT15100J/K
SHO18095	0.162	0.202	0.243	SHCH18070300	SHT15100J/K
SHO18115	0.210	0.262	0.315	SHCH18090450	SHT15100J/K
SHO18135	0.258	0.322	0.387	SHCH18110600	SHT15150J/K
SHO18155	0.306	0.382	0.459	SHCH18130700	SHT15150J/K



1. 編碼原則 Code principle



2. 熱嘴局部圖

Cut out for the nozzle

公差標準: DIN ISO 2768-MK

General tolerances: DIN ISO 2768-MK

表面粗糙度 $\nabla\nabla\nabla 0.02$

Surfaces: $\nabla\nabla\nabla 0.02$

模板加工尺寸如右圖所示

Template processing dimensions as shown on the right

3. 連接線/控制器

Connecting/Controller

電源230V

Power 230V

感溫線

Thermocouple

溫控箱

Temp-controller

4. 技術規範

Questionnaire

不同的產品要求, 有不同的嘴尖

Different part requirements, have different nozzle sharp

嘴尖的尺寸如圖所示

Nozzle sharp dimensions as shown on the right

5. 尺寸的選擇

Size selection

L 熱嘴長度

L Nozzle length

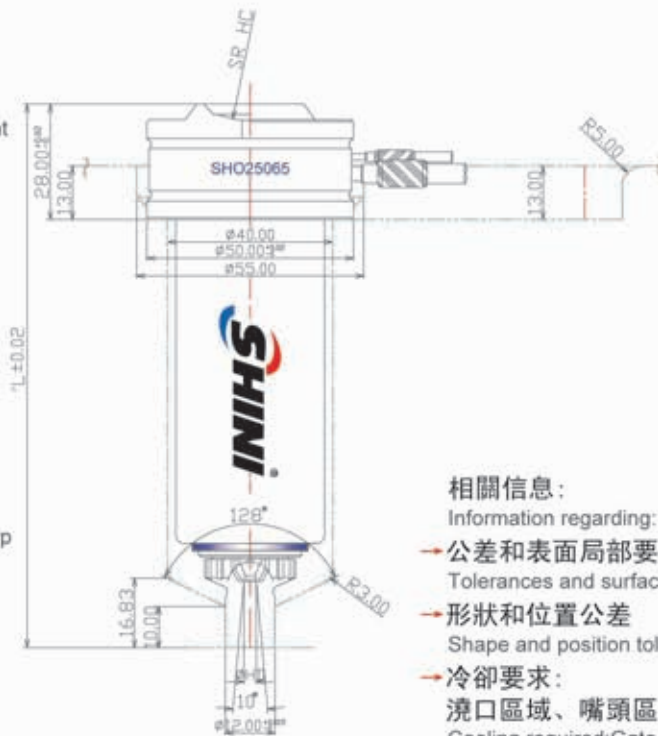
HD 澆口的直徑範圍: $\varnothing 1.0 \sim \varnothing 2.5$

HD Gate diameter range: $\varnothing 1.0 \sim \varnothing 2.5$

HC 球頭半徑

HC Ball head radius: R10, R15, R19, R21h

6. 熱嘴尺寸與功率的選擇 Nozzle size and power selection



相關信息:

Information regarding:

→ 公差和表面局部要求

Tolerances and surfaces

→ 形狀和位置公差

Shape and position tolerance

→ 冷卻要求:

澆口區域、嘴頭區域

Cooling required: Gate

bush and nozzle sharp

→ 封膠處的要求

The front of nozzle sharp

must be against plastic

熱嘴尺寸 Nozzle size (L)	熱嘴膨脹量 (單位:mm) Nozzle expansion (Unit:mm)			加熱器功率 Heater (Watt)	感溫線型號 T/C (J/K)
	200°C	250°C	300°C		
SHO25065	0.066	0.083	0.099	SHCH25027200	SHT15100J/K
SHO25085	0.114	0.143	0.171	SHCH25047350	SHT15100J/K
SHO25105	0.162	0.203	0.243	SHCH25067450	SHT15100J/K
SHO25125	0.210	0.263	0.315	SHCH25087600	SHT15100J/K
SHO25145	0.258	0.323	0.387	SHCH25107700	SHT15150J/K
SHO25165	0.306	0.383	0.459	SHCH25127850	SHT15150J/K

