

1. 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 $\nabla\sqrt{0.02}$
Surfaces: $\nabla\sqrt{0.02}$
模板加工尺寸如右圖所示
Template processing dimensions

2. 連接線

Connecting
氣管
耐壓 0.7~200MPA
耐溫 40°~100°
Gas pipe
Pressure-proof 0.7-200MPA
Temperature-resistant 40°-100°

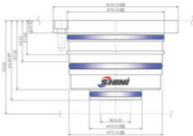
3. 技術規範

Questionnaire
氣缸為精密動力裝置,
氣缸結構可以按要求改裝成特殊結構。
The cylinder is a precision power
system.
The cylinder structure can be
created to a special one

4. 編碼原則 Code principle



SH60 氣缸 SH60 Cylinder



SH40 氣缸 SH40 Cylinder



氣缸與熱嘴的選擇 CYLINDER AND NOZZLE SELECTION

氣缸型號 Cylinder type	對應熱嘴 Correspond nozzle	閥針直徑 Valve pin diameter	澆口大小 Gate size
SHNC/NF40	SHNC/NF18	Ø6	Ø1.5
SHNC/NF40	SHNC/NF25	Ø6	Ø2.5
SHNC/NF60	SHNC/NF35	Ø8	Ø3.0
SHNC/NF60	SHNC/NF45	Ø10	Ø5.0

分流板用途

熱流道板的主要任務是恒溫地將熔體從主流道送入各個單獨噴嘴。在熔體傳送過程中，熔體壓力應盡可能小，熔體到各噴嘴的流程應儘量一致。為節省加熱功率，其體積以小為宜，但過小則熱容量太小，溫度不易穩定。熱流道板應採用厚板整體加工方式。與熔體接觸的流道表面，鑽孔後需用鉋刀鉋後再拋光。流道的端點不允許有盲孔，轉角的地方應與流道平滑過渡。

Usefulness Of Manifold Block

Hot runner's main task is loading the melt from the mainstream into each individual nozzle with heated. In the transmission process, the melt pressure should be as small as possible, and the process should be the same. In order to save heating power, it's better if the size of the melt is small. However, the heat capacity will be too small and it's difficult to stabilize the temperature if it's undersize. Hot runner plate should be made with the whole thick plate. After drilling, the runner surface which is cut with the reamer and in touch with the melt should be polished. The endpoint of the runner dose not allow blind holes. And the corner should be a smooth transition of flow passage.

編碼原則 Code principle



"I" 形



"Y" 形



"H" 形



"X" 形

