

INFORMATION FOR THE USE OF HOT RUNNER SYSTEM

Manifold type: Nozzle type: Delivery date:
 Material injected:..... Mineral charges and %: Grade/Melt index:.....
 Additives: Ø injection points:
 Type of piece:..... Weight of piece (single): Sprue weight:
 Thickness of walls:..... Type of injection: direct indirect

Injection press type:..... Ø screws: Foreseen production:.....
 Type of regulation:.....
 Heating time: of the hot runner of the nozzle (*)
 (*) optional (unless problems are found).

Main regulations

t° mould: fixed part: mobile part: t° nozzles: t° hot runner system:.....
 t° injection cylinder: zone 1 = zone 2 = zone 3 = zone 4 = zone 5 =
 Injection pressure: (bar) Post pressure: (bar) Injection time:
 Post pressure time: Cooling time:
 Total time for cycle of moulding: Injection speed:

Problem discovered on date:

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Intervention carried out or advised

date	description	result
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