

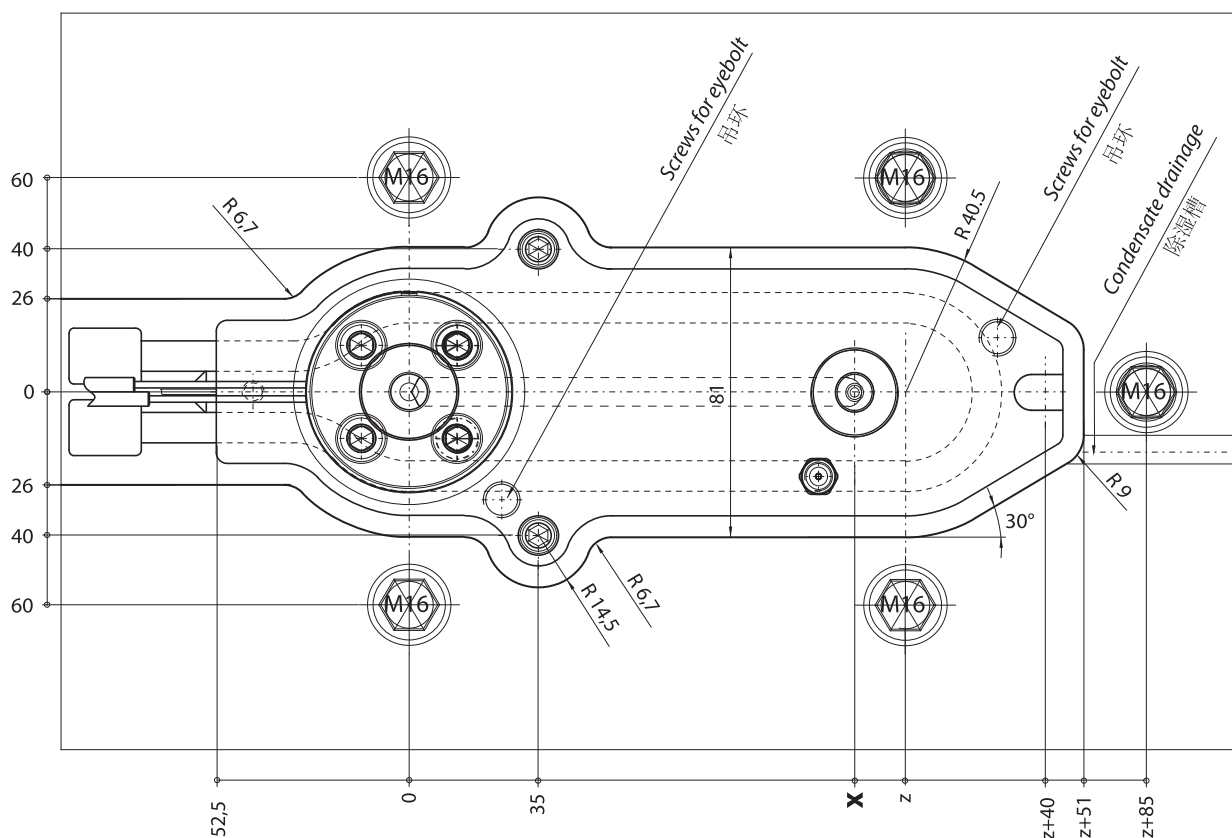
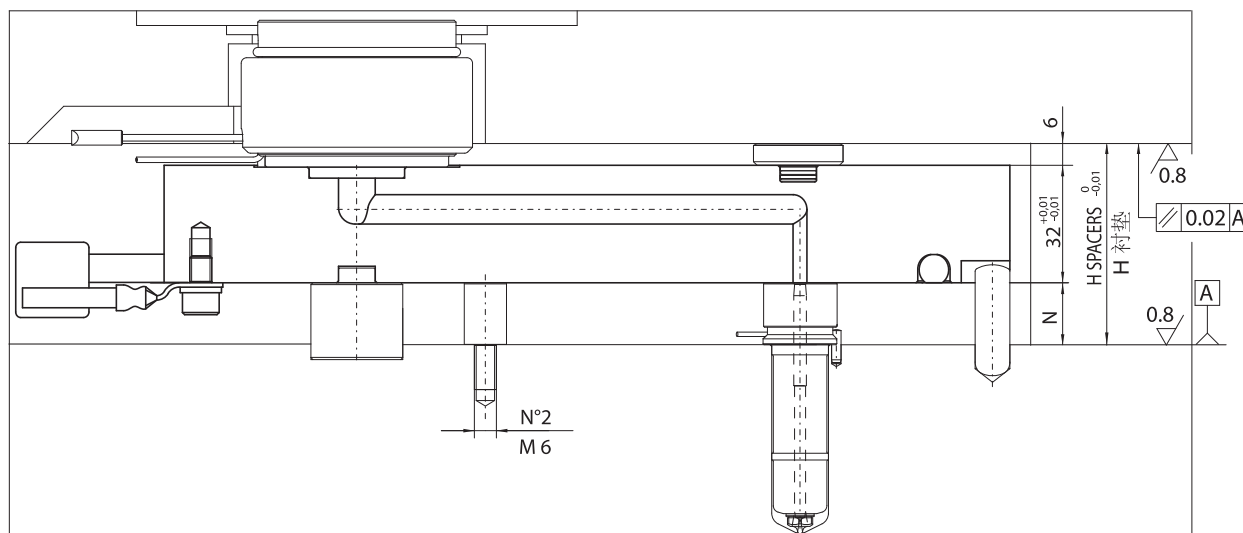


CONFIGURABLE SYSTEMS

Create the configuration on [www.thermoplay.com](http://www.thermoplay.com)

可在线配置的热流道系统

填写配置信息在[www.thermoplay.com](http://www.thermoplay.com)



x = relative dimension to the position of nozzles / 喷嘴位置

z = relative dimension to the external shape of manifold / 流道板厚度

$$H \text{ Spacers} / H \text{ 衬垫} = (N + 32 + 6) + [(N + 32 + 6) \cdot \Delta T \cdot k] - 0.05 = \text{mm}$$

N = nozzle head / 喷嘴头

$\Delta t$  = Temperature difference between the hot runner and the mould / 热流道与模具间温差

K = Steel thermal expansion coefficient / 钢热膨胀系数 (= 0.0000125)



## CONFIGURABLE SYSTEMS 可在线配置的热流道系统

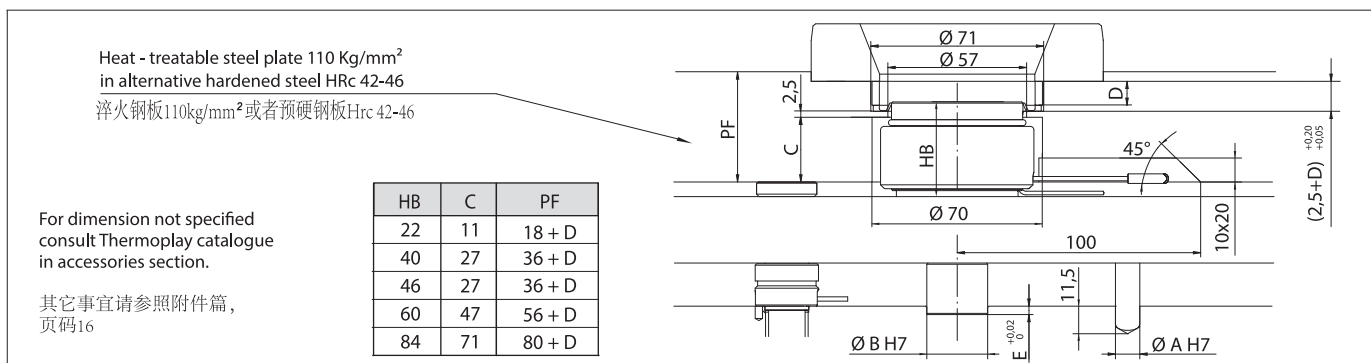
Manifold / 流道板			Heater / 加热器						Thermocouple / 温差电偶		
1 CODE 1 代码	Nozzle c/c 间距	Thermocouple type 热电偶类型	Heaters not armored 不内置的加热圈			Armored heaters 3 内置的加热圈 3			grounded 接地	insulated 绝缘	Qty / 数量
			CODE 代码	Power 2 功率 [W]	Qty 数量	CODE 代码	Power 2 功率 [W]	Qty 数量			
E90311	50 < x ≤ 60	JG= Grounded thermocouples J type / J型接地热电偶 JU = Insulated thermocouple J type / J型绝缘热电偶	TS056	1300	1	TS056	1300	1	E06145	E16058	1
E90312	60 < x ≤ 70		TS001	1200		TS001	1200				
E90313	70 < x ≤ 80		TS002	1200		TS002	1200				
E90314	80 < x ≤ 90		TS076	800		TS052	1300				
E90315	90 < x ≤ 100		TS077	800		TS045	1400				
E90316	100 < x ≤ 110		TS078	900		TS004	1800				
E90317	110 < x ≤ 120		TS079	900		TS058	1900				
E90318	120 < x ≤ 130		TS003	1300		TS003	1300				
E90319	130 < x ≤ 140		TS080	1000		TS047	1500				
E90320	140 < x ≤ 150		TS081	1000		TS059	2100				
E90321	150 < x ≤ 160		TS082	1100		TS007	2400				
E90322	160 < x ≤ 170		TS083	1100		TS060	2200				
E90323	170 < x ≤ 180		TS084	1200		TS008	2400				
E90324	180 < x ≤ 190		TS085	1200		TS046	2200				
E90325	190 < x ≤ 200		TS086	1400		TS146	2000				
E90326	200 < x ≤ 210		TS087	1500		TS146	2000				
E90327	210 < x ≤ 220		TS088	1600		TS011	2700				
E90328	220 < x ≤ 230		TS089	1600		TS050	2500				
E90329	230 < x ≤ 240		TS090	1700		TS012	2500				
E90330	240 < x ≤ 250		TS091	1700		TS062	2500				
E90331	250 < x ≤ 260		TS092	1800		TS063	2700				
E90332	260 < x ≤ 270		TS093	1800		TS014	3300				
E90333	270 < x ≤ 280		TS094	1800		TS174	2400				
E90334	280 < x ≤ 290		TS095	1900		TS016	3200				
E90335	290 < x ≤ 300		TS096	2100		TS065	3100				
E90336	300 < x ≤ 310		TS097	2000		TS017	3100				
E90337	310 < x ≤ 320		TS098	2200		TS018	3300				
E90338	320 < x ≤ 330		TS099	2100		TS066	3200				
E90339	330 < x ≤ 340		TS100	2300		TS019	3200				
E90340	340 < x ≤ 350		TS101	2200		TS067	3200				
E90341	350 < x ≤ 360	TS102	2200	TS020	3200						
E90342	360 < x ≤ 370	TS103	2400	TS021	3200						
E90343	370 < x ≤ 380	TS104	2500	TS069	3300						
E90344	380 < x ≤ 390	TS105	2700	TS115	2900						
E90345	390 < x ≤ 400	TS106	3000	TS023	3200						
E90346	400 < x ≤ 410	TS107	3100	TS024	3300						
E90347	410 < x ≤ 420	TS108	3200	TS108	3200						
E90348	420 < x ≤ 430	TS109	2600	TS025	3300						
E90349	430 < x ≤ 440	TS110	2600	TS026	3400						
E90350	440 < x ≤ 450	TS111	2600	TS175	3400						

1 Not valid code for order / 无效订单编号

2 Nominal power referred to each single heater / 每个部件的理论功率

3 To be carried out at Thermoplay / 换件要送回Thermoplay

WARNING: according to the process temperature of the injected polymer, will be advised the suitable kind of manifold ( with or without armored heaters).  
A注意: 根据注塑材料所需温度不同, 建议客户选择内置或者非内置加热圈的流道板。



Further information have to be requested to Thermoplay's Technical Support - 更多信息咨询Thermoplay技术部



**CONFIGURABLE SYSTEMS**

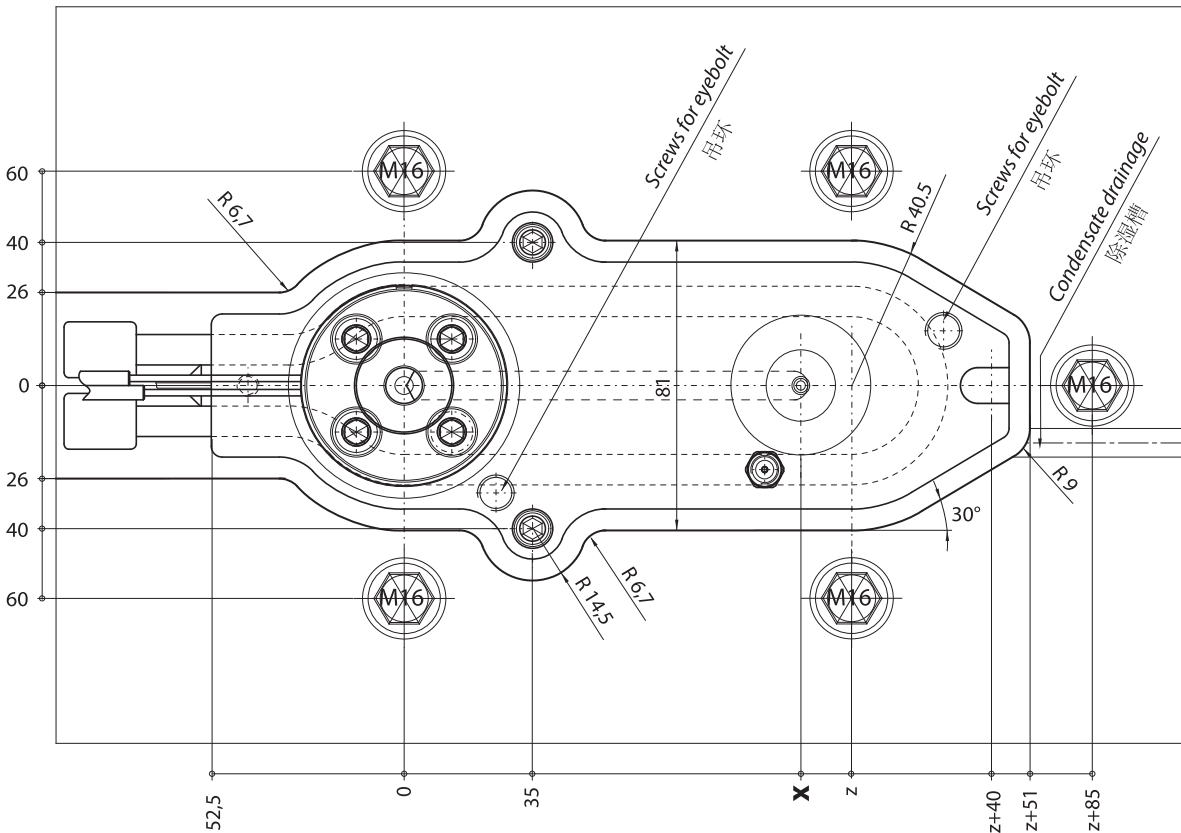
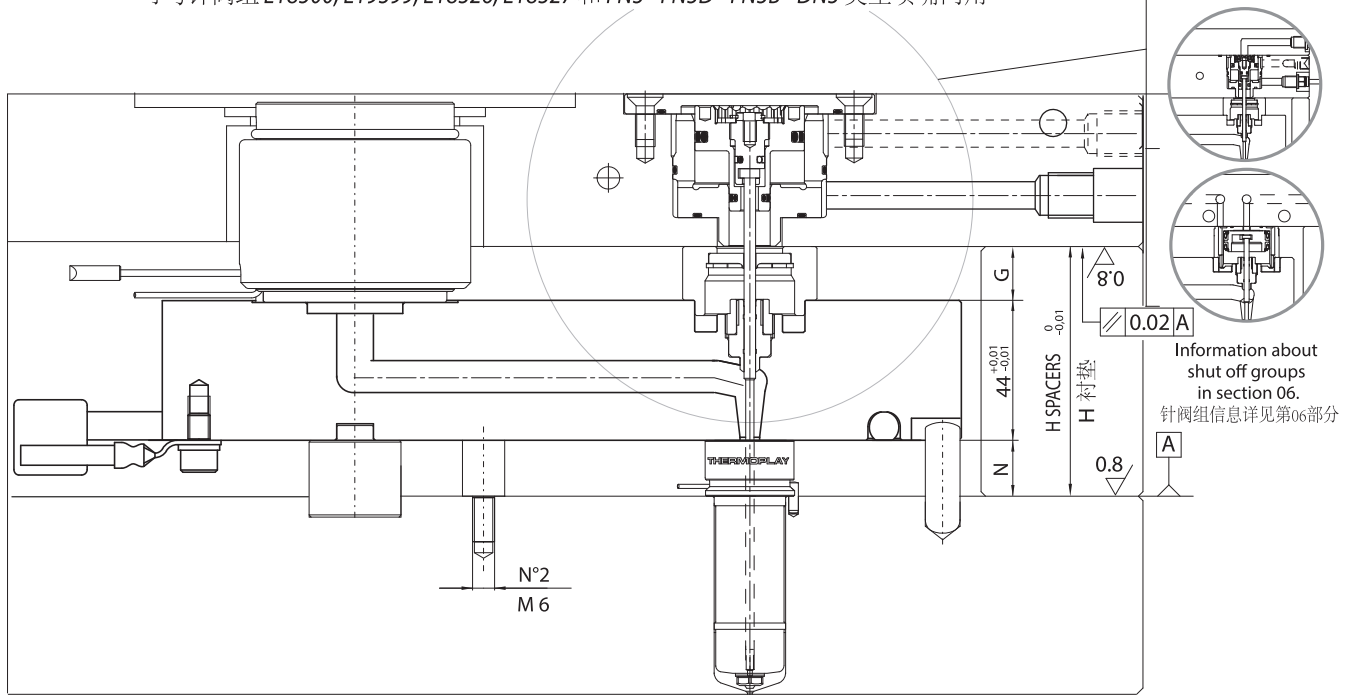
Create the configuration on [www.thermoplay.com](http://www.thermoplay.com)

**可在线配置的热流道系统**

填写配置信息在[www.thermoplay.com](http://www.thermoplay.com)

Compatible with shut off groups E18500, E19399, E18326, E18327 and nozzles types FN3 - FN3D - FN3B - DN3

可与针阀组 E18500, E19399, E18326, E18327 和 FN3 - FN3D - FN3B - DN3 类型喷嘴同用



x = relative dimension to the position of nozzles / 喷嘴位置

z = relative dimension to the external shape of manifold / 流道板厚度

**H Spacers / H 衬垫 = (N + 44 + G) + [(N + 44 + G) · ΔT · k] - 0.05 = mm**

N = nozzle head / 喷嘴头

Δt = Temperature difference between the hot runner and the mould / 热流道与模具间温差

K = Steel thermal expansion coefficient / 钢热膨胀系数 (= 0.000125)

Shut off groupe 截流组	G
E18500	16
E18323	
E18325	20
E18327	
E18326	21.5



## CONFIGURABLE SYSTEMS 可在线配置的热流道系统

Compatible with shut off groups E18500, E19399, E18326, E18327 and nozzles types FN3 - FN3D - FN3B - DN3  
可与针阀组 E18500, E19399, E18326 E18327 和 FN3 - FN3D - FN3B - DN3 类型喷嘴同用

Manifold / 流道板			Heater / 加热器						Termocouple / 温差电偶		
1 CODE 1 代码	Nozzle c/c 间距	Thermocouple type 热电偶类型	Heaters not armored 不内置的加热圈			Armored heaters <sup>3</sup> 内置的加热圈 <sup>3</sup>			grounded 接地	insulated 绝缘	Qty / 数量
			CODE 代码	Power <sup>2</sup> 功率 <sup>2</sup> [W]	Qty 数量	CODE 代码	Power <sup>2</sup> 功率 <sup>2</sup> [W]	Qty 数量			
E94311 *	60	JG= Grounded thermocouples J type / 型接地热电偶 JU = Insulated thermocouple J type / 型绝缘热电偶	TS056	1300	1	TS056	1300	1	E06145	E16058	1
E94312 *	60 < x ≤ 70		TS001	1200		TS001	1200				
E94313 **	70 < x ≤ 80		TS002	1200		TS002	1200				
E94314 **	80 < x ≤ 90		TS076	800		TS052	1300				
E94315 **	90 < x ≤ 100		TS077	800		TS045	1400				
E94316	100 < x ≤ 110		TS078	900		TS004	1800				
E94317	110 < x ≤ 120		TS079	900		TS058	1900				
E94318	120 < x ≤ 130		TS003	1300		TS003	1300				
E94319	130 < x ≤ 140		TS080	1000		TS047	1500				
E94320	140 < x ≤ 150		TS081	1000		TS059	2100				
E94321	150 < x ≤ 160		TS082	1100		TS007	2400				
E94322	160 < x ≤ 170		TS083	1100		TS060	2200				
E94323	170 < x ≤ 180		TS084	1200		TS008	2400				
E94324	180 < x ≤ 190		TS085	1200		TS046	2200				
E94325	190 < x ≤ 200		TS086	1400		TS146	2000				
E94326	200 < x ≤ 210		TS087	1500		TS146	2000				
E94327	210 < x ≤ 220		TS088	1600		TS011	2700				
E94328	220 < x ≤ 230		TS089	1600		TS050	2500				
E94329	230 < x ≤ 240		TS090	1700		TS012	2500				
E94330	240 < x ≤ 250		TS091	1700		TS062	2500				
E94331	250 < x ≤ 260		TS092	1800		TS063	2700				
E94332	260 < x ≤ 270		TS093	1800		TS014	3300				
E94333	270 < x ≤ 280		TS094	1800		TS174	2400				
E94334	280 < x ≤ 290		TS095	1900		TS016	3200				
E94335	290 < x ≤ 300		TS096	2100		TS065	3100				
E94336	300 < x ≤ 310		TS097	2000		TS017	3100				
E94337	310 < x ≤ 320		TS098	2200		TS018	3300				
E94338	320 < x ≤ 330		TS099	2100		TS066	3200				
E94339	330 < x ≤ 340		TS100	2300		TS019	3200				
E94340	340 < x ≤ 350		TS101	2200		TS067	3200				
E94341	350 < x ≤ 360		TS102	2200		TS020	3200				
E94342	360 < x ≤ 370		TS103	2400		TS021	3200				
E94343	370 < x ≤ 380		TS104	2500		TS069	3300				
E94344	380 < x ≤ 390		TS105	2700		TS115	2900				
E94345	390 < x ≤ 400		TS106	3000		TS023	3200				
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E94347	410 < x ≤ 420	TS108	3200	TS108	3200						
E94348	420 < x ≤ 430	TS109	2600	TS025	3300						
E94349	430 < x ≤ 440	TS110	2600	TS026	3400						
E94350	440 < x ≤ 450	TS111	2600	TS175	3400						

<sup>1</sup> Not valid code for order / 无效订单编号

<sup>2</sup> Nominal power referred to each single heater / 每个部件的理论功率

<sup>3</sup> To be carried out at Thermoplay / 换件要送回Thermoplay

\* For this distance, the E19399 and E18327 shut off groups are not available. / 此间距无法应用E19399 和 E18327针阀组

\*\* For this distance, the E18327 shut off group is not available. / 此间距无法应用 E18327针阀组

WARNING: according to the process temperature of the injected polymer, will be advised the suitable kind of manifold (with or without armored heaters).  
A注意: 根据注塑材料所需温度不同, 建议客户选择内置或者非内置加热圈的热道板。

In the section 06  
- Seat of shut off groups  
- Pin tip machining  
- Pin length calculation  
第06部分  
- 针阀组位置  
- 阀针头部加工  
- 阀针长度计算

For dimension not specified  
consult Thermoplay catalogue  
in accessories section.  
其它事宜请参照附件篇,  
页码16.02

Heat - treatable steel plate 110 Kg/mm<sup>2</sup>  
in alternative hardened steel Hrc 42-46  
淬火钢板110kg/mm<sup>2</sup>或者预硬钢板Hrc 42-46

Shut off groups 截流组	HB	C	PF	
			D=0	D≠0
E18500	84	61	78.5	70 + D
E18323	60	37	46	46 + D
E18325	84	61	78.5	70 + D
E18327	84	57	66	66 + D
E18326	60	31.5	42	42 + D

