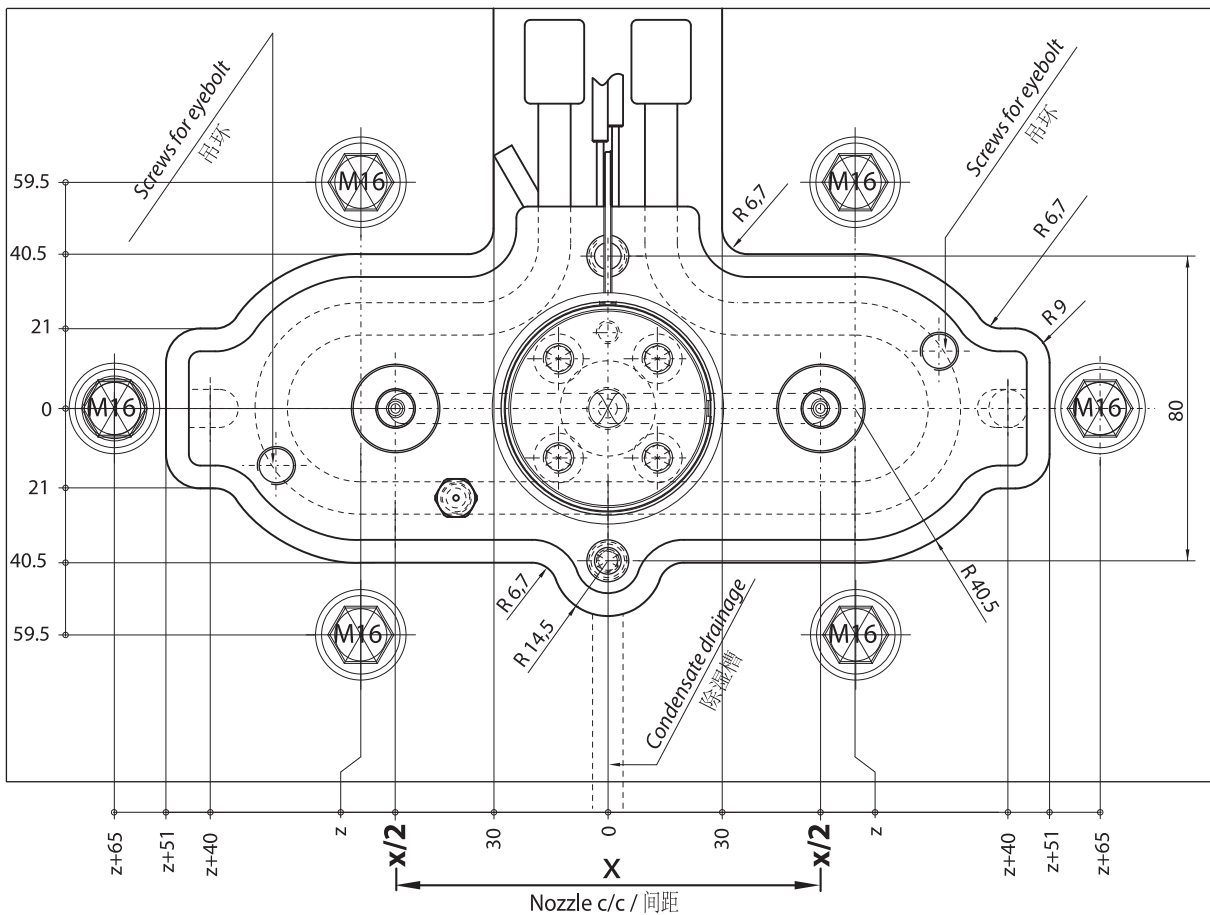
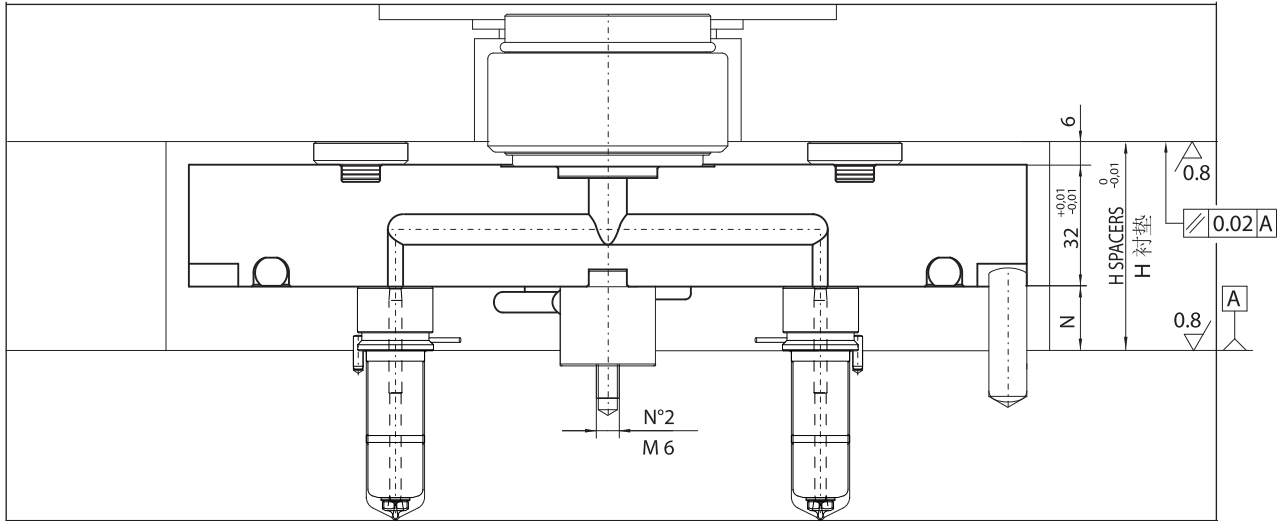




CONFIGURABLE SYSTEMS
Create the configuration on www.thermoplay.com

可在线配置的热流道系统

填写配置信息在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 Spacers / H 衬垫 = (N + 32 + 6) + [(N + 32 + 6) · 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 (= 0.0000125)



CONFIGURABLE SYSTEMS 可在线配置的热流道系统

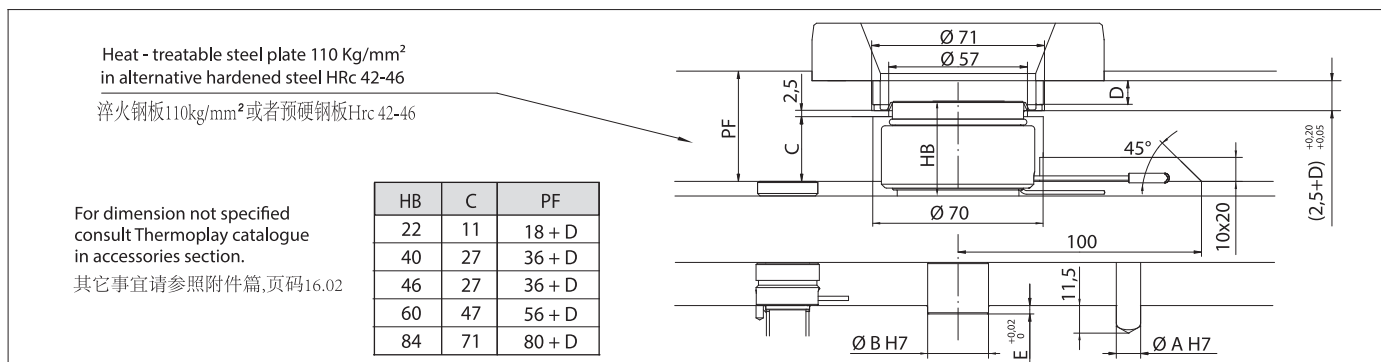
Manifold / 流道板				Heater / 加热器						Thermocouple / 温差电偶		
1 CODE 1 代码	Nozzle c/c 间距	Thermocouple type 热电偶类型	z	Heaters not armored 不内置的加热圈			Armored heaters ³ 内置的加热圈 ³			grounded 接地	insulated 绝缘	Qty / 数量
				CODE 代码	Power ² 功率 [W]	Qty 数量	CODE 代码	Power ² 功率 [W]	Qty 数量			
E90100	90 < x ≤ 100	JG= Grounded thermocouples J type / J型接地热电偶 JU = Insulated thermocouple J type / J型绝缘热电偶	50	TS076	800	1	TS052	1300	1	E06145	E16058	
E90101	100 < x ≤ 110		55	TS077	800		TS045	1400				
E90102	110 < x ≤ 120		60	TS078	900		TS057	1600				
E90103	120 < x ≤ 130		65	TS079	900		TS058	1900				
E90108	130 < x ≤ 140		70	TS112	900		TS005	2300				
E90112	140 < x ≤ 150		75	TS080	1000		TS047	1500				
E90116	150 < x ≤ 160		80	TS081	1000		TS059	2100				
E90117	160 < x ≤ 170		85	TS082	1100		TS007	2400				
E90121	170 < x ≤ 180		90	TS083	1100		TS060	2200				
E90298	180 < x ≤ 190		95	TS084	1200		TS008	2400				
E90125	190 < x ≤ 200		100	TS085	1200		TS046	2200				
E90299	200 < x ≤ 210		105	TS086	1400		TS009	2400				
E90129	210 < x ≤ 220		110	TS087	1500		TS146	2000				
E90300	220 < x ≤ 230		115	TS088	1600		TS061	2400				
E90133	230 < x ≤ 240		120	TS089	1600		TS011	2700				
E90141	240 < x ≤ 250		125	TS090	1700		TS012	2500				
E90145	250 < x ≤ 260		130	TS091	1700		TS062	2500				
E90297	260 < x ≤ 270		135	TS092	1800		TS063	2700				
E90149	270 < x ≤ 280		140	TS093	1800		TS014	3300				
E90301	280 < x ≤ 290		145	TS094	1800		TS174	2200				
E90120	290 < x ≤ 300		150	TS095	1900		TS015	3100				
E90302	300 < x ≤ 310		155	TS096	2100		TS016	3200				
E90157	310 < x ≤ 320		160	TS097	2000		TS065	3100				
E90303	320 < x ≤ 330		165	TS098	2200		TS017	3100				
E90161	330 < x ≤ 340		170	TS099	2100		TS018	3300				
E90165	340 < x ≤ 350	175	TS114	2200	TS176	3000						
E90169	350 < x ≤ 360	180	TS101	2200	TS067	3200						
E90304	360 < x ≤ 370	185	TS102	2200	TS020	3200						
E90173	370 < x ≤ 380	190	TS103	2400	TS068	3300						
E90351	380 < x ≤ 390	195	TS021	3200	TS021	3200						
E90177	390 < x ≤ 400	200	TS115	2900	TS022	3200						
E90352	400 < x ≤ 410	205	TS106	3000	TS070	3200						
E90353	410 < x ≤ 420	210	TS023	3200	TS023	3200						
E90354	420 < x ≤ 430	215	TS107	3100	TS024	3300						
E90355	430 < x ≤ 440	220	TS116	2600	TS071	3300						
E90181	440 < x ≤ 450	225	TS109	2600	TS025	3300						
E90356	450 < x ≤ 460	230	TS118	3000	TS175	3400						
E90357	460 < x ≤ 470	235	TS027	3300	TS177	3500						
E90358	470 < x ≤ 480	240	TS119	3400	TS119	3400						
E90359	480 < x ≤ 490	245	TS028	3300	TS140	3500						
E90150	490 < x ≤ 500	250	TS029	3300	TS029	3300						

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).
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



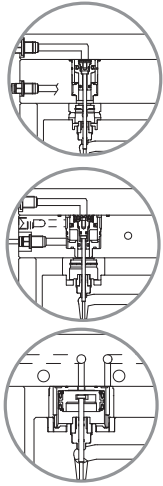
CONFIGURABLE SYSTEMS
Create the configuration on www.thermoplay.com

可在线配置的热流道系统

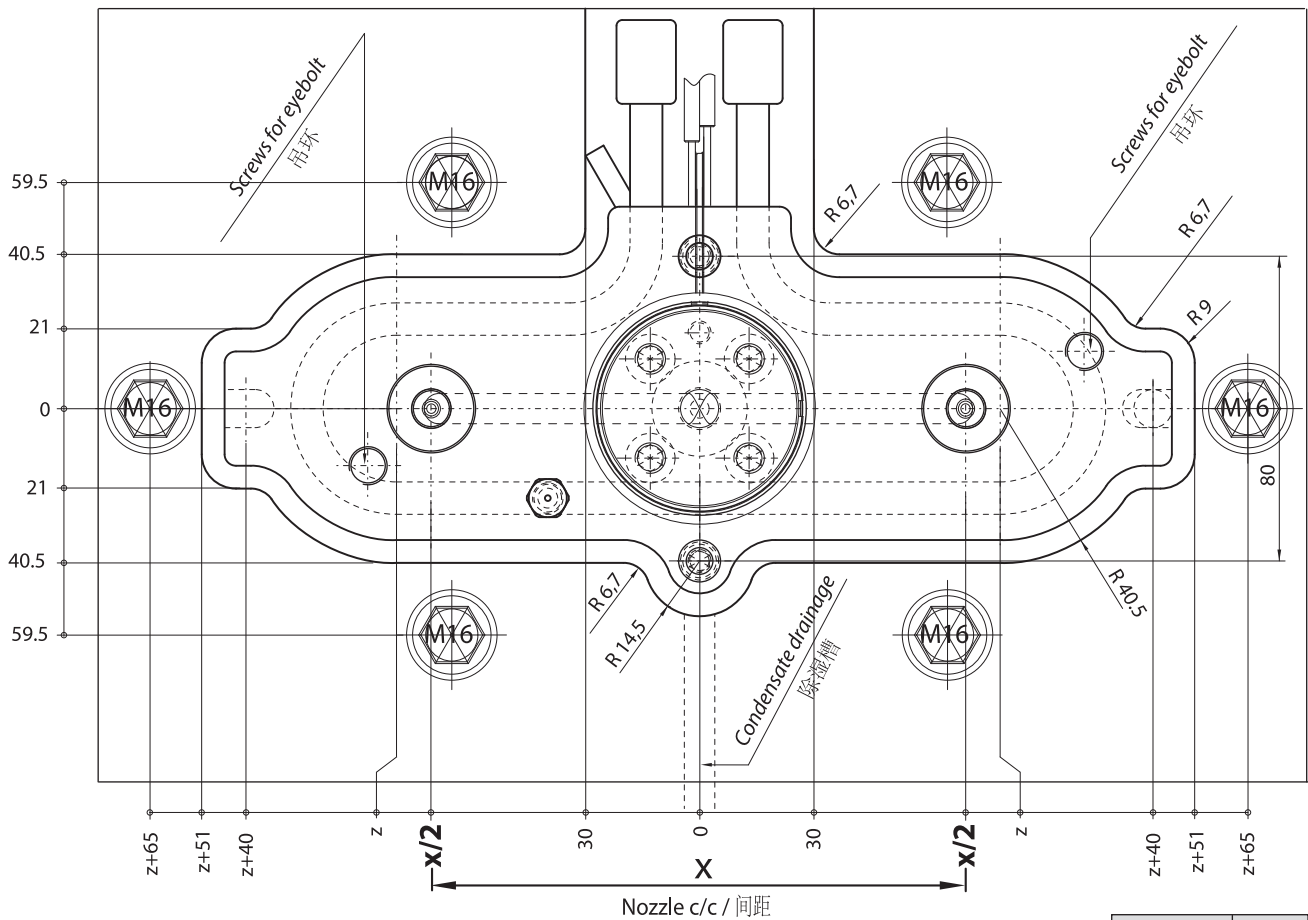
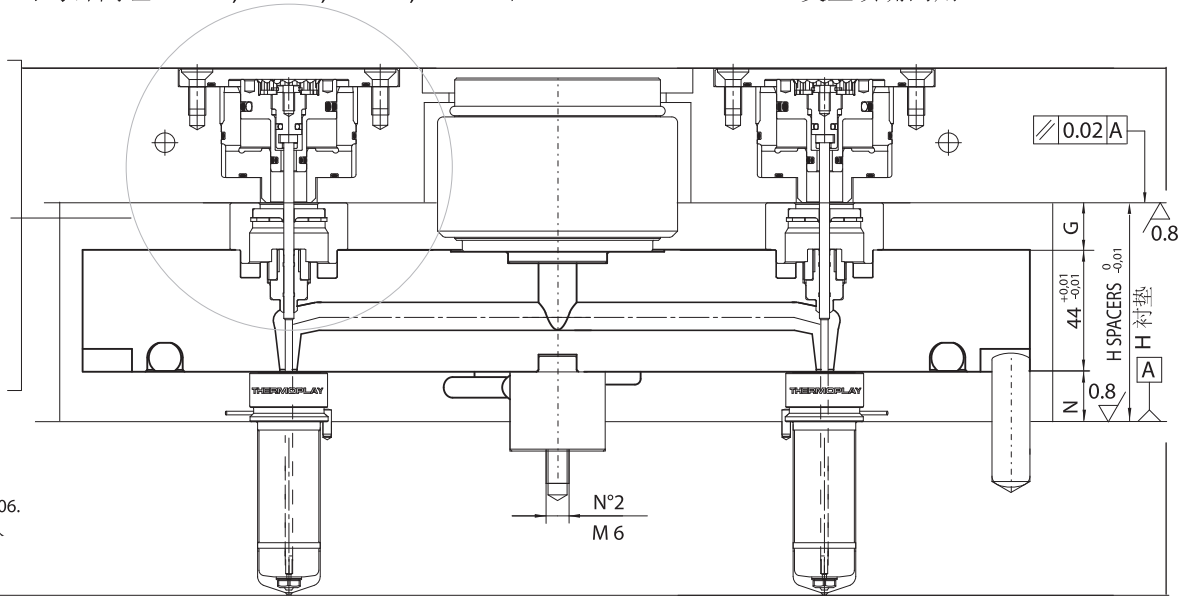
填写配置信息在www.thermoplay.com

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



Information about shut off groups in section 06.
针阀组信息详见第06部分



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 group 截流组	G
E18500	16
E18323	16
E18325	16
E18327	20
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			
CODE ¹ 代码 ¹	Nozzle c/c 间距	Thermocouple type 热电偶类型	z	Heaters not armored 不内置的加热圈			Armored heaters ³ 内置的加热圈			grounded 接地	insulated 绝缘	Q.ty / 数量
				CODE 代码	Power ² 功率 ² [W]	Q.ty 数量	CODE 代码	Power ² 功率 ² [W]	Q.ty 数量			
E94101 *	110	JG= Grounded thermocouples J type / J型接地热电偶 JU = Insulated thermocouple J type / J型绝缘热电偶	55	TS077	800	1	TS045	1400	1	E06145	E16058	1
E94102 *	110 < x ≤ 120		60	TS078	900		TS057	1600				
E94103 **	120 < x ≤ 130		65	TS079	900		TS058	1900				
E94108 **	130 < x ≤ 140		70	TS112	900		TS005	2300				
E94112 **	140 < x ≤ 150		75	TS080	1000		TS047	1500				
E94116 ***	150 < x ≤ 160		80	TS081	1000		TS059	2100				
E94117 ***	160 < x ≤ 170		85	TS082	1100		TS007	2400				
E94121 ***	170 < x ≤ 180		90	TS083	1100		TS060	2200				
E94298 ***	180 < x ≤ 190		95	TS084	1200		TS008	2400				
E94125	190 < x ≤ 200		100	TS085	1200		TS046	2200				
E94299	200 < x ≤ 210		105	TS086	1400		TS009	2400				
E94129	210 < x ≤ 220		110	TS087	1500		TS146	2000				
E94300	220 < x ≤ 230		115	TS113	1600		TS061	2400				
E94133	230 < x ≤ 240		120	TS089	1600		TS011	2700				
E94141	240 < x ≤ 250		125	TS090	1700		TS012	2500				
E94145	250 < x ≤ 260		130	TS091	1700		TS062	2500				
E94297	260 < x ≤ 270		135	TS092	1800		TS063	2700				
E94149	270 < x ≤ 280		140	TS093	1800		TS014	3300				
E94301	280 < x ≤ 290		145	TS094	1800		TS174	2200				
E94120	290 < x ≤ 300		150	TS095	1900		TS015	3100				
E94302	300 < x ≤ 310		155	TS096	2100		TS016	3200				
E94157	310 < x ≤ 320		160	TS097	2000		TS065	3100				
E94303	320 < x ≤ 330		165	TS098	2200		TS017	3100				
E94161	330 < x ≤ 340		170	TS099	2100		TS018	3300				
E94165	340 < x ≤ 350		175	TS114	2200		TS176	3000				
E94169	350 < x ≤ 360	180	TS101	2200	TS067	3200						
E94304	360 < x ≤ 370	185	TS102	2200	TS020	3200						
E94173	370 < x ≤ 380	190	TS103	2400	TS068	3300						
E94351	380 < x ≤ 390	195	TS021	3200	TS021	3200						
E94177	390 < x ≤ 400	200	TS115	2900	TS022	3200						
E94352	400 < x ≤ 410	205	TS106	3000	TS070	3200						
E94353	410 < x ≤ 420	210	TS023	3200	TS023	3200						
E94354	420 < x ≤ 430	215	TS107	3100	TS024	3300						
E94355	430 < x ≤ 440	220	TS116	2600	TS071	3300						
E94181	440 < x ≤ 450	225	TS109	2600	TS025	3300						
E94356	450 < x ≤ 460	230	TS118	3000	TS175	3400						
E94357	460 < x ≤ 470	235	TS027	3300	TS177	3500						
E94358	470 < x ≤ 480	240	TS119	3400	TS119	3400						
E94359	480 < x ≤ 490	245	TS028	3300	TS140	3500						
E94150	490 < x ≤ 500	250	TS029	3300	TS029	3300						

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

* For this distance, the E19399, E18326 and E18327 shut off groups are not available. / 此间距无法应用 E19399, E18326和E18327 针阀组

** 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).
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。

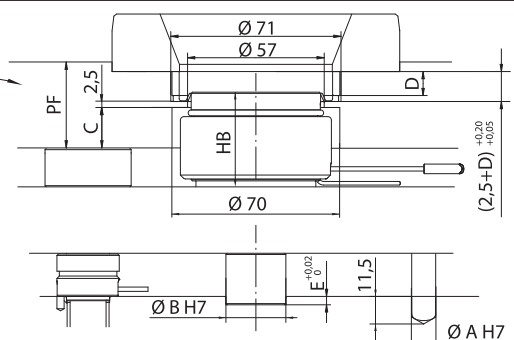
In the section 06
- Seat of shut off groups
- Pin tip machining
- Pin length calculation

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/mm²
in alternative hardened steel Hrc 42-46
淬火钢板110kg/mm²或者预硬钢板Hrc 42-46

Shut off group 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



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