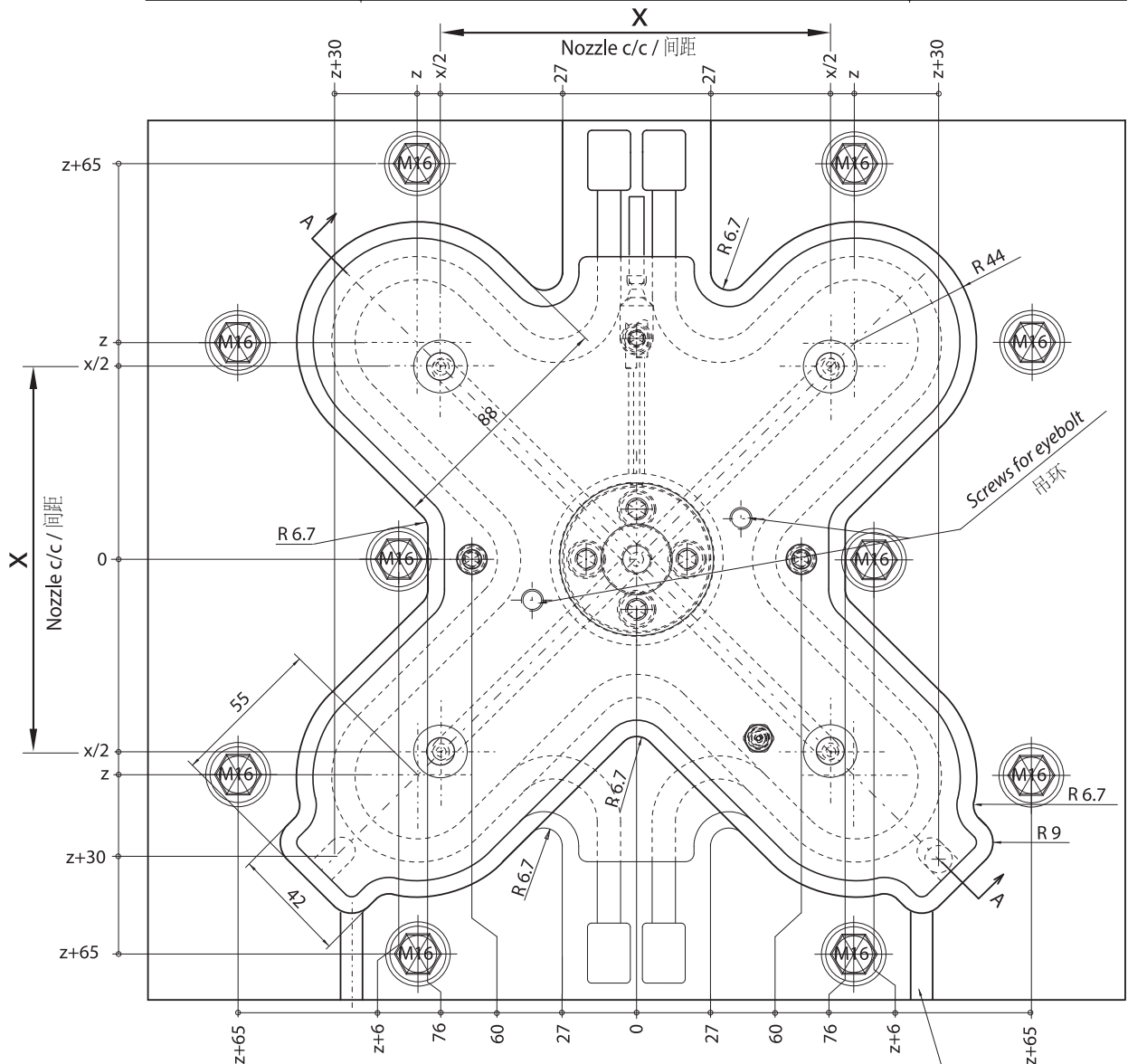
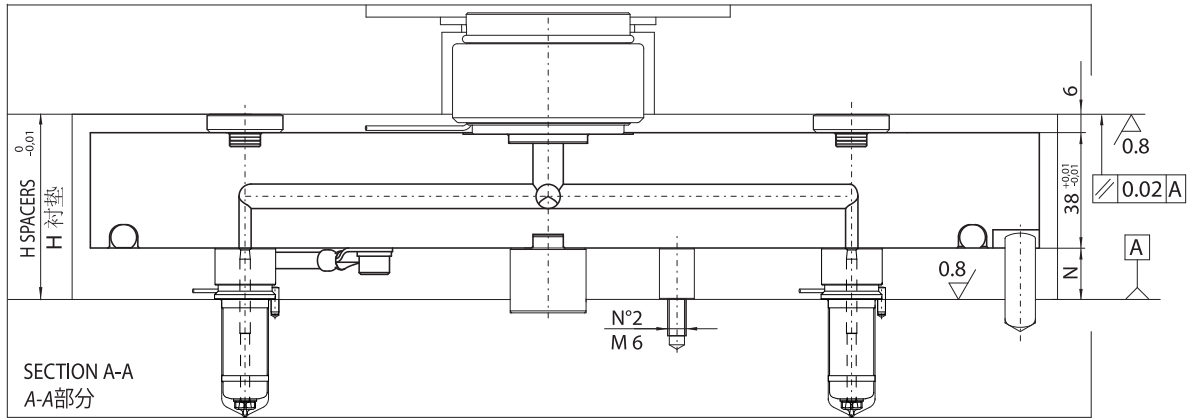




CONFIGURABLE SYSTEMS
 Create the configuration on www.thermoplay.com
可在线配置的热流道系统
 填写配置信息在www.thermoplay.com



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 + 38 + 6) + [(N + 38 + 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					Heaters not armored 不内置的加热圈						Armored heaters ³ 内置的加热圈 ³					
1 CODE 1 代码	Nozzle c/c 间距	Thermocouple type 热电偶类型	Drawing / 图纸	z	Heater / 加热器			Thermocouple 温差电偶			Heater / 加热器			Thermocouple 温差电偶		
					CODE 代码	Power ² 功率 ² [W]	Qty / 数量	grounded 接地	insulated 绝缘	Qty / 数量	CODE 代码	Power ² 功率 ² [W]	Qty / 数量	grounded 接地	insulated 绝缘	Qty / 数量
E90188	90 < x ≤ 100	JG= Grounded thermocouples J type / 型接地热电偶 JU = Insulated thermocouple J type / 型绝缘热电偶	SPARE PARTS / 备用零件	A	50	TS120	2200	E06143	E16055	1	1	TS090	1700	E06143 - E06145	E16055 - E16058	1+1
E90305	100 < x ≤ 110			A	55	TS121	2300					TS092	1800			
E90192	110 < x ≤ 120			A	60	TS122	2500					TS179	2000			
E90105	120 < x ≤ 130			A	65	TS123	2700					TS098	2200			
E90199	130 < x ≤ 140			A	70	TS124	2800					TS101	2200			
E90203	140 < x ≤ 150			A	75	TS125	3000					TS103	2400			
E90207	150 < x ≤ 160			A	80	TS023	3200					TS023	3200			
E90306	160 < x ≤ 170			B	85	TS126	1800					TS126	1800			
E90211	170 < x ≤ 180			B	90	TS046	2200					TS046	2200			
E90307	180 < x ≤ 190			B	95	TS127	1900					TS086	1400			
E90215	190 < x ≤ 200			B	100	TS128	2000					TS113	1600			
E90308	200 < x ≤ 210			B	105	TS129	2100					TS089	1600			
E90219	210 < x ≤ 220			B	110	TS012	2500					TS012	2500			
E90309	220 < x ≤ 230			B	115	TS121	2300					TS092	1800			
E90223	230 < x ≤ 240			B	120	TS130	2300					TS093	1800			
E90227	240 < x ≤ 250			B	125	TS122	2400					TS179	2000			
E90231	250 < x ≤ 260			B	130	TS132	2500					TS096	2100			
E90310	260 < x ≤ 270			B	135	TS133	2600					TS181	2200			
E90235	270 < x ≤ 280			B	140	TS134	2600					TS099	2100			
E90360	280 < x ≤ 290			B	145	TS135	2600					TS100	2300			
E90239	290 < x ≤ 300			B	150	TS136	2600					TS102	2200			
E90361	300 < x ≤ 310			B	155	TS021	3200					TS103	2400			
E90243	310 < x ≤ 320			B	160	TS115	2900					TS115	2900			
E90362	320 < x ≤ 330			B	165	TS106	3000					TS106	3000			
E90247	330 < x ≤ 340			B	170	TS107	3100					TS107	3100			
E90251	340 < x ≤ 350			B	175	TS137	3000					TS071	3300			
E90255	350 < x ≤ 360			B	180	TS138	3000					TS026	3400			
E90363	360 < x ≤ 370			B	185	TS139	3000					TS175	3400			
E90259	370 < x ≤ 380			B	190	TS119	3400					TS119	3400			
E90364	380 < x ≤ 390			B	195	TS140	3500					TS140	3500			
E90134	390 < x ≤ 400			B	200	TS072	3300					TS072	3300			
E90365	400 < x ≤ 410			B	205	TS141	3500					TS141	3500			
E90366	410 < x ≤ 420			B	210	TS142	3500					TS178	2400			
E90367	420 < x ≤ 430			B	215	TS143	3500					TS049	2600			
E90368	430 < x ≤ 440			B	220	TS144	3500					TS073	3200			
E90266	440 < x ≤ 450			B	225	TS145	3500					TS074	3200			

¹ Not valid code for order / 无效订单编号

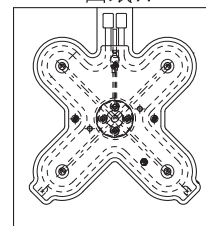
² Nominal power referred to each single heater / 每个部件的理论功率

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

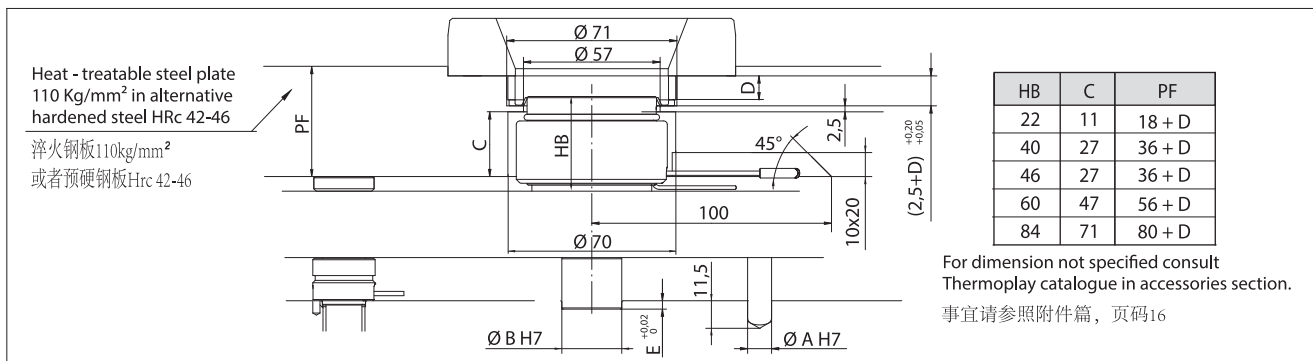
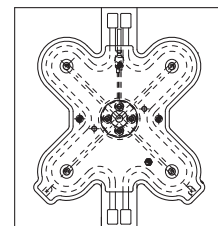
WARNING: according to the process temperature of the injected polymer, will be advised the suitable kind of manifold (with or without armored heaters).

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。

Drawing A
图纸 A



Drawing B
图纸 B



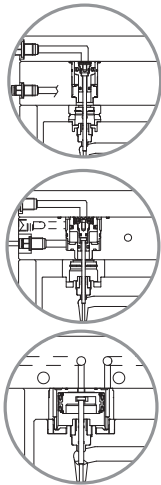
Further information have to be requested to Thermoplay's Technical Support - 更多信息咨询Thermoplay技术部



CONFIGURABLE SYSTEMS Create the configuration on www.thermoplay.com

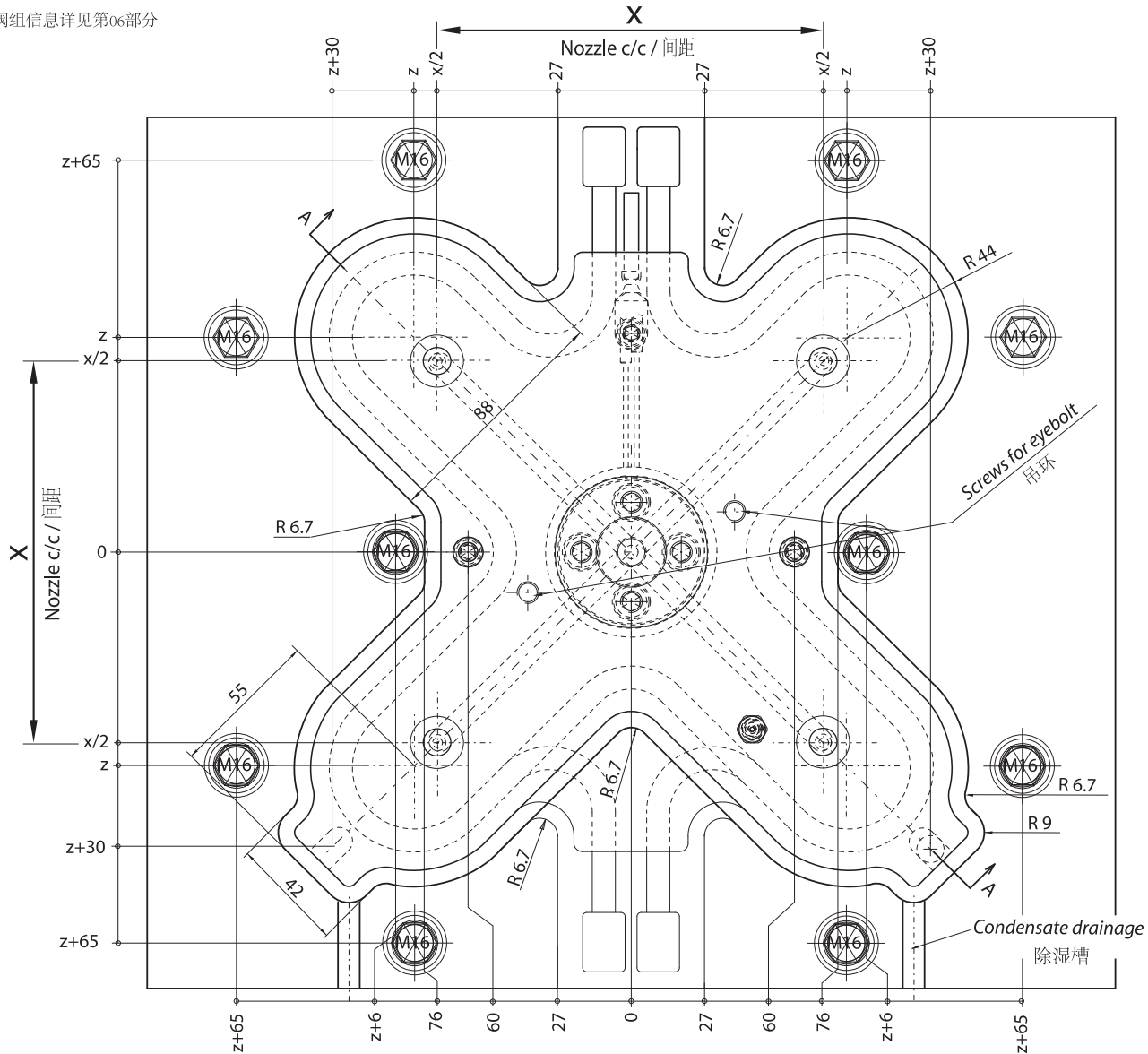
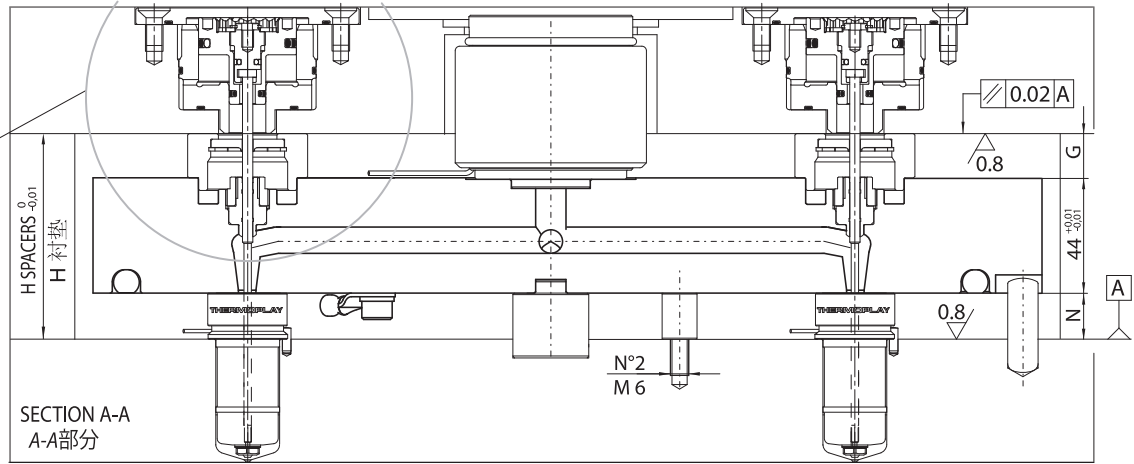
可在线配置的热流道系统 填写配置信息在www.thermoplay.com

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 groupe 截流组	G
E18500 E18323 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					Heaters not armored 不内置的加热圈						Armored heaters ³ 内置的加热圈 ³						
1 CODE 1 代码	Nozzle c/c 间距	Thermocouple type 热电偶类型	Drawing / 图纸	z	Heater / 加热器			Thermocouple 温差电偶			Heater / 加热器			Thermocouple 温差电偶			
					CODE 代码	Power ² 功率 ² [W]	Qty / 数量	grounded 接地	insulated 绝缘	Qty / 数量	CODE 代码	Power ² 功率 ² [W]	Qty / 数量	grounded 接地	insulated 绝缘	Qty / 数量	
E94188*	90 < x ≤ 100	JG = Grounded thermocouples J type / J 型接地热电偶 JU = Insulated thermocouple J type / 型绝缘热电偶	SPARE PARTS / 备用零件	A	50	TS120	2200	E06143	E16055	1	1	TS120	2200	E06143	E16055	1	1
E94305*	100 < x ≤ 110			A	55	TS121	2300					TS121	2300				
E94192**	110 < x ≤ 120			A	60	TS122	2500					TS122	2500				
E94105**	120 < x ≤ 130			A	65	TS123	2700					TS123	2700				
E94199	130 < x ≤ 140			A	70	TS124	2800					TS124	2800				
E94203	140 < x ≤ 150			A	75	TS125	3000					TS125	3000				
E94207	150 < x ≤ 160			A	80	TS023	3200					TS023	3200				
E94306	160 < x ≤ 170			B	85	TS126	1800					TS126	1800				
E94211	170 < x ≤ 180			B	90	TS046	2200					TS046	2200				
E94307	180 < x ≤ 190			B	95	TS127	1900					TS127	1900				
E94215	190 < x ≤ 200			B	100	TS128	2000					TS128	2000				
E94308	200 < x ≤ 210			B	105	TS129	2100					TS129	2100				
E94219	210 < x ≤ 220			B	110	TS012	2500					TS012	2500				
E94309	220 < x ≤ 230			B	115	TS121	2300					TS121	2300				
E94223	230 < x ≤ 240			B	120	TS130	2300					TS130	2300				
E94227	240 < x ≤ 250			B	125	TS122	2400					TS122	2400				
E94231	250 < x ≤ 260			B	130	TS132	2500					TS132	2500				
E94310	260 < x ≤ 270			B	135	TS133	2600					TS133	2600				
E94235	270 < x ≤ 280			B	140	TS134	2600					TS134	2600				
E94360	280 < x ≤ 290			B	145	TS135	2600					TS135	2600				
E94239	290 < x ≤ 300			B	150	TS136	2600					TS136	2600				
E94361	300 < x ≤ 310			B	155	TS021	3200					TS021	3200				
E94243	310 < x ≤ 320			B	160	TS115	2900					TS115	2900				
E94362	320 < x ≤ 330			B	165	TS106	3000					TS106	3000				
E94247	330 < x ≤ 340			B	170	TS107	3100					TS107	3100				
E94251	340 < x ≤ 350			B	175	TS137	3000					TS137	3000				
E94255	350 < x ≤ 360			B	180	TS138	3000					TS138	3000				
E94363	360 < x ≤ 370			B	185	TS139	3000					TS139	3000				
E94259	370 < x ≤ 380			B	190	TS119	3400					TS119	3400				
E94364	380 < x ≤ 390			B	195	TS140	3500					TS140	3500				
E94134	390 < x ≤ 400			B	200	TS072	3300					TS072	3300				
E94365	400 < x ≤ 410			B	205	TS141	3500					TS141	3500				
E94366	410 < x ≤ 420			B	210	TS142	3500					TS142	3500				
E94367	420 < x ≤ 430			B	215	TS143	3500					TS143	3500				
E94368	430 < x ≤ 440			B	220	TS144	3500					TS144	3500				
E94266	440 < x ≤ 450			B	225	TS145	3500					TS145	3500				

¹ Not valid code for order / 无效订单编号

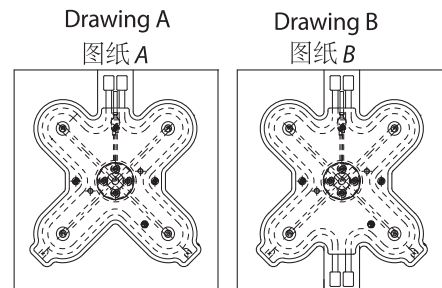
² Nominal power referred to each single heater / 每个部件的理论功率

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

* For this distance, the E19399 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

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 groupe 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

For dimension not specified consult Thermoplay catalogue in accessories section.

其它事宜请参照附件篇，页码16.02

