

HEATLOCK®

MARKET	:	ELECTRONICS
PROJECT NO.	:	E181-8420-8421
SOLUTION	:	2-KOMPONENT, SMALL SHOT WEIGHT
HR SYSTEM/GATE	:	VALVE GATE SYSTEM, GATE ON RUNNER
RESIN	:	POLYLAC® PA-726M(ABS) ALBIS ALCOM® PC 740/ 4 UV CC1322_08LG (PC)
PART WEIGHT	:	0.185g/0.08g
GATE TYPE	:	POINT EXTENDED SPRUE VALVE GATE (A3VGX)

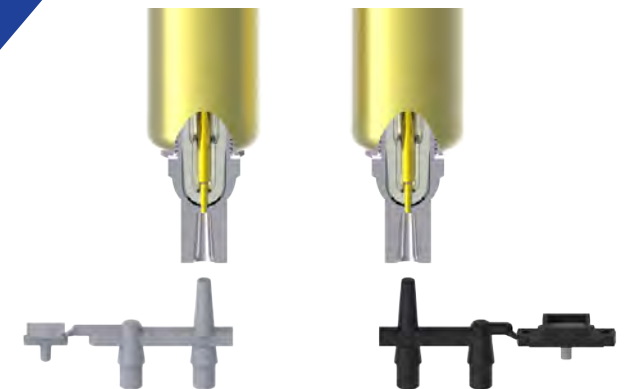


HEATLOCK Co., Ltd.

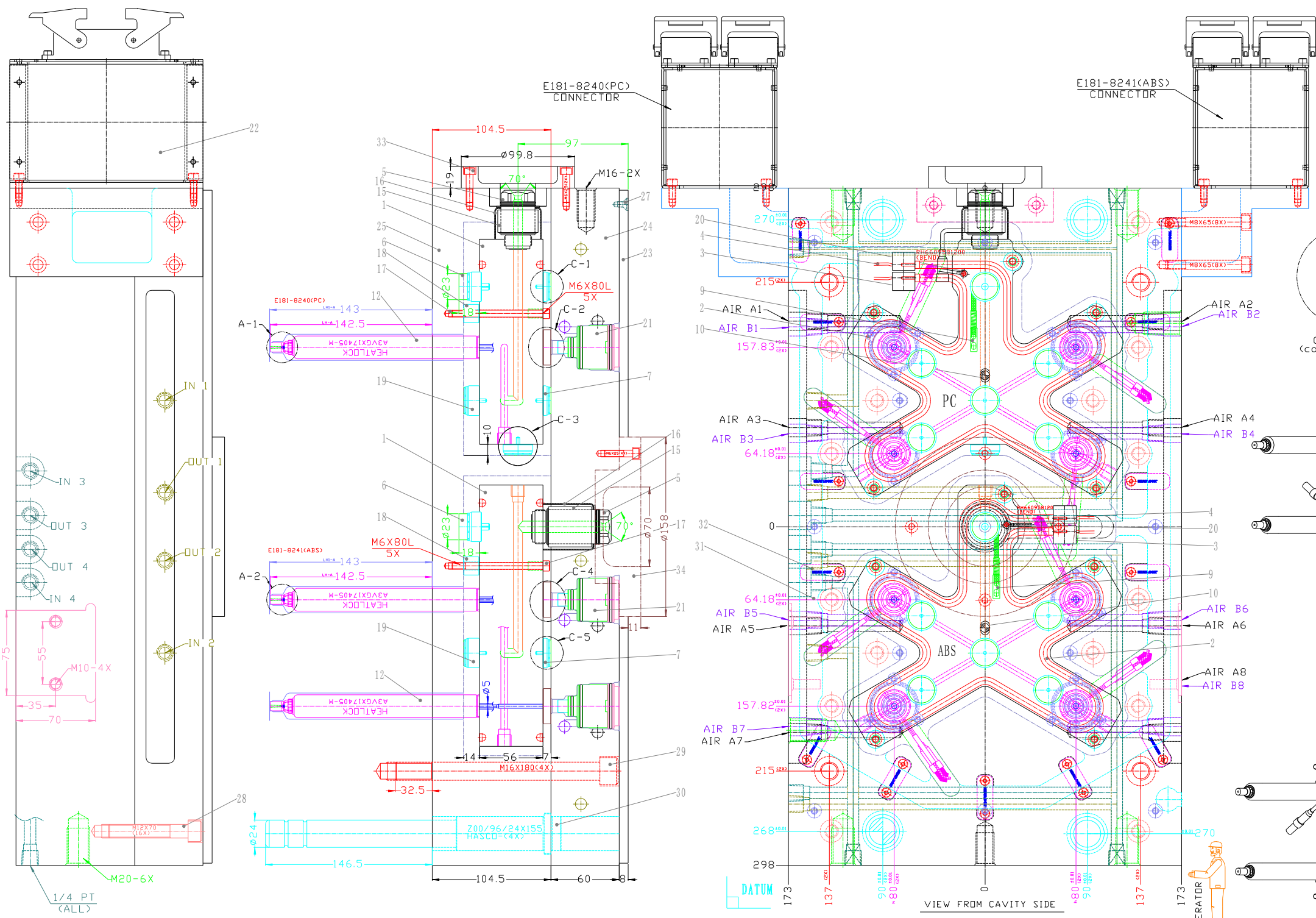
Order & Info

E : frontdesk@heatlock.com

For a complete list of our distributors around the world, please refer to our website www.heatlock.com



Rev No	Amount	Description	Date	Revisor	Approver
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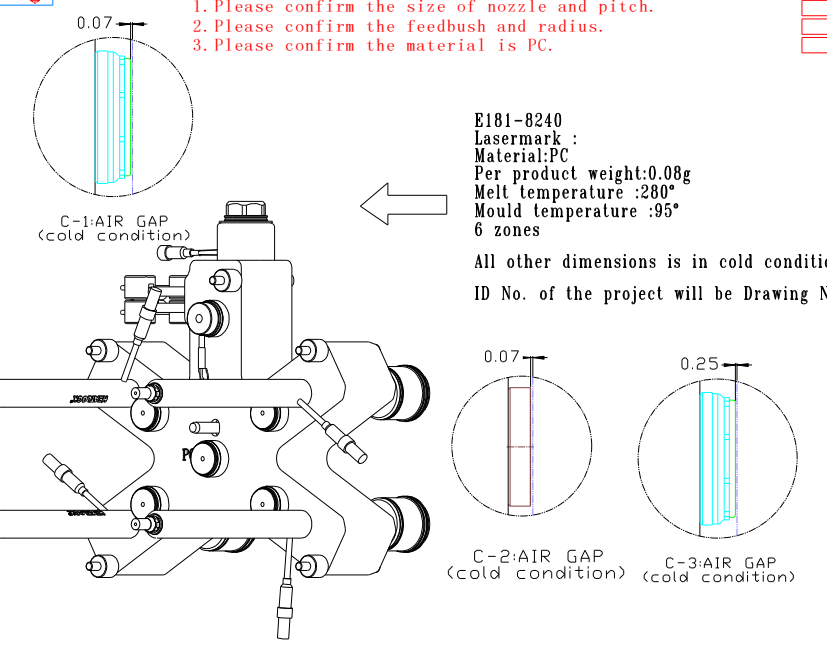


E181-8240-8241 HH
 Please confirm if the drawing is correct, check below important points, please fill OK in the blank when you confirm:
 1. Please confirm the operation side & datum.
 2. Please confirm the total thickness of hot half plates.
 3. Please confirm the position of screws and guide pins.
 4. Please confirm the position of connector box.
 5. Please confirm the wiring.
 6. Please confirm the thread type for your cooling connector.
 7. Please confirm the size of location ring.

E181-8240 4 DROP HRS(PC)
 Please confirm if the drawing is correct, check below important points, please fill OK in the blank when you confirm:
 1. Please confirm the size of nozzle and pitch.
 2. Please confirm the feedbush and radius.
 3. Please confirm the material is PC.

E181-8240
 Lasermark :
 Material:PC
 Per product weight:0.08g
 Melt temperature :280°
 Mould temperature :95°
 6 zones

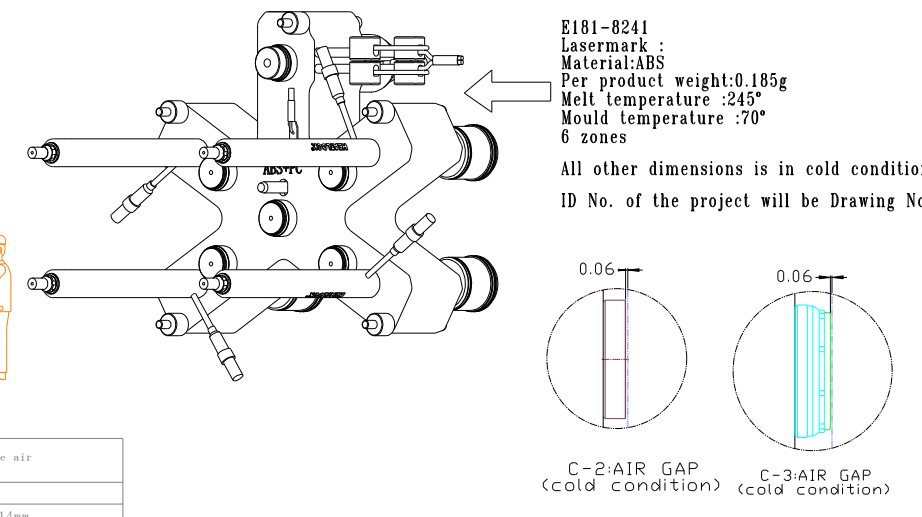
All other dimensions is in cold condition
 ID No. of the project will be Drawing No.



E181-8241 4 DROP HRS(ABS)
 Please confirm if the drawing is correct, check below important points, please fill OK in the blank when you confirm:
 1. Please confirm the size of nozzle and pitch.
 2. Please confirm the feedbush and radius.
 3. Please confirm the material is ABS.

E181-8241
 Lasermark :
 Material:ABS
 Per product weight:0.185g
 Melt temperature :245°
 Mould temperature :70°
 6 zones

All other dimensions is in cold condition
 ID No. of the project will be Drawing No.



E181-8240 4 DROP HRS(PC)

21	Assembly cylinder	ACCP25350	4	Assembly cylinder in clamp plate use air pressure for 02.5 L350 valve pin
20	Screw "Ground wire"	MSCX-004-008	1	Screw "Ground wire", M4X8
19	Ceramic Bottom Spacer	KEA0260314	5	Assembled bottom spacer 026X14mm
18	Titanium Bottom Spacer	DSP0160714	5	A3 Titanium bottom spacer, 016x14
17	Screw "Manifold"	MSCX-006-080	5	Screw "Manifold", M6X80 12.9
16	Feed Bush Reflector	RFT438200-21	1	Feed bush Reflector 038x21.5mm
15	Feed Bush Heater	BS230020250	1	Feed bush heater 030x20 250W
12	Assembly Nozzle	A3VGX17405-M	4	Size05 A3 Nozzle, Assembly extended front with VG tip,Torque 15Nm, L=174mm 500W
10	Dowel Pin	DW08X30	1	Dowel for center line location 08x30mm
9	Thermocouple	TC00040180	1	Thermocouple L=12mm
7	Ceramic Back Spacer	KEA0260307	2	Assembled back spacer 026X7mm
6	Ceramic Centre Spacer	KEA0260620	1	Ceramic center spacer 026x20mm
5	Feed Bush	DSP5202408	1	Manifold feedbush032x52mm, M24, Radius=70°
4	Wires for heater	MHWIRE100	4	Wires for heaters L=1M 1.5sqmm RHH
3	Ceramic Connector	MHCONN001	4	Ceramic connectors for tubular heaters
2	Tubular Heater	Z-MH-E181-8240	2	Tubular heater 06.6x858, 1250W 230V
1	Manifold	Z-M-E181-8240	1	Complete manifold for pressed in heaters
Notes	Part Name	Item Code	Qty.	Description

E181-8241 4 DROP HRS(ABS)

21	Assembly cylinder	ACCP25350	4	Assembly cylinder in clamp plate use air pressure for 02.5 L350 valve pin
20	Screw "Ground wire"	MSCX-004-008	1	Screw "Ground wire", M4X8
19	Ceramic Bottom Spacer	KEA0260314	5	Assembled bottom spacer 026X14mm
18	Titanium Bottom Spacer	DSP0160714	5	A3 Titanium bottom spacer, 016x14
17	Screw "Manifold"	MSCX-006-080	5	Screw "Manifold", M6X80 12.9
16	Feed Bush Reflector	RFT438200-41	1	Feed bush Reflector 038x41.5mm
15	Feed Bush Heater	BS230036400	1	Feed bush heater 030x36 400W
12	Assembly Nozzle	A3VGX17405-M	4	Size05 A3 Nozzle, Assembly extended front with VG tip,Torque 15Nm, L=174mm 500W
10	Dowel Pin	DW08X30	1	Dowel for center line location 08x30mm
9	Thermocouple	TC00040180	1	Thermocouple L=12mm
7	Ceramic Back Spacer	KEA0260307	1	Assembled back spacer 026X7mm
6	Ceramic Centre Spacer	KEA0260620	1	Ceramic center spacer 026x20mm
5	Feed Bush	DSP7003010	1	Manifold feedbush032x70mm, M30, Radius=70°
4	Wires for heater	MHWIRE100	4	Wires for heaters L=1M 1.5sqmm RHH
3	Ceramic Connector	MHCONN001	4	Ceramic connectors for tubular heaters
2	Tubular Heater	Z-MH-E181-8241	2	Tubular heater 06.6x858, 1250W 230V
1	Manifold	Z-M-E181-8241	1	Complete manifold for pressed in heaters
Notes	Part Name	Item Code	Qty.	Description

E181-8240-8241 (HH)

34	Location Ring	Z-L-E181-8241	1	Location ring 0158x40
33	Location Ring	Z-L-E181-8240	1	Location ring 099.8x35
32	Wire slot clamp	COMW-00154	13	Wire slot clamp 3x14x39
31	Water Line connector		8	1/4" PT
30	Guide Pin	Z00/96/24X155	4	Guide pin for hot half
29	Screw "Manifold Plate"	MSCX-016-180	4	Screw "Manifold Plate", M16X180 12.9
28	Screw "Clamp Plate"	MSCX-012-070	16	Screw "Clamp Plate", M12X70 12.9
27	Screw "Insulation Plate"	MSBX-005-012	12	Screw "Insulation Plate" M5X12
26	Cavity Plate		1	Cavity Plate
25	Manifold Plate	Z-H-E181-8240-8241-2	1	Manifold Plate
24	Clamp Plate	Z-H-E181-8240-8241-1	1	Clamp Plate
23	Insulation Plate	Z-108-E181-8240-8241	1	Insulation Plate
22	Connector Box	ACONNB-2X16PIN	2	2X16 Pins connector box
Notes	Part Name	Item Code	Qty.	Description

E181-8240-8241(05)

1ST ANGLE PROJECTION
 View from cavity side

HEATLOCK
 HOT RUNNER SYSTEMS
 South China Building 1-2 Shuang Street, Central, Hong Kong
 Phone: (852) 2428 8888 Fax: (852) 2428 8888
 Email: info@heatlock.com.hk

Scale: 1:1
 Date: 2019-1-11
 Drawing No: E181-8240-0011
 Part No: 005

4+4 Drops HH

ID Card

A0 rev.01

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HEATLOCK®
ID NO:E181-8240
WIRE CODE:MOLTEC
HEATER:240V TC-J
VIEW:FROM CAVITY PLATE

MANIFOLD & GATE

www.heatlock.com

ID NO:E181-8240
WIRE CODE:MOLTEC

CONNECTOR-POWER
VIEW:CONNECTOR FRONT-MALE

1	V ● ● V	9	ZONE1
2	V ● ● V	10	ZONE2
3	V ● ● V	11	ZONE3
4	V ● ● V	12	ZONE4
5	V ● ● V	13	ZONE5
6	V ● ● V	14	ZONE6
7	V ● ● V	15	
8	V ● ● V	16	

HEATLOCK®
ID NO:E181-8240
WIRE CODE:MOLTEC
HEATER:240V TC-J
VIEW:CONNECTOR FRONT-MALE

CONNECTOR-POWER

1	V ● ● V	9	ZONE1
2	V ● ● V	10	ZONE2
3	V ● ● V	11	ZONE3
4	V ● ● V	12	ZONE4
5	V ● ● V	13	ZONE5
6	V ● ● V	14	ZONE6
7	V ● ● V	15	
8	V ● ● V	16	

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HEATLOCK®
ID NO:E181-8240

Air Switch

www.heatlock.com

CONNECTOR-T/C
VIEW:CONNECTOR FRONT-FEMALE

9	TC+ ○ ○ TC-	1	ZONE1
10	TC+ ○ ○ TC-	2	ZONE2
11	TC+ ○ ○ TC-	3	ZONE3
12	TC+ ○ ○ TC-	4	ZONE4
13	TC+ ○ ○ TC-	5	ZONE5
14	TC+ ○ ○ TC-	6	ZONE6
15	TC+ ○ ○ TC-	7	
16	TC+ ○ ○ TC-	8	

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HEATLOCK®
ID NO:E181-8240
WIRE CODE:MOLTEC
HEATER:240V TC-J
VIEW:CONNECTOR FRONT-FEMALE

CONNECTOR-T/C

9	TC+ ○ ○ TC-	1	ZONE1
10	TC+ ○ ○ TC-	2	ZONE2
11	TC+ ○ ○ TC-	3	ZONE3
12	TC+ ○ ○ TC-	4	ZONE4
13	TC+ ○ ○ TC-	5	ZONE5
14	TC+ ○ ○ TC-	6	ZONE6
15	TC+ ○ ○ TC-	7	
16	TC+ ○ ○ TC-	8	

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HEATLOCK®
ID NO:E181-8241
WIRE CODE:MOLTEC
HEATER:240V TC-J
VIEW:FROM CAVITY PLATE

MANIFOLD & GATE

www.heatlock.com

ID NO:E181-8241
WIRE CODE:MOLTEC

CONNECTOR-POWER
VIEW:CONNECTOR FRONT-MALE

1	V ● ● V	9	ZONE1
2	V ● ● V	10	ZONE2
3	V ● ● V	11	ZONE3
4	V ● ● V	12	ZONE4
5	V ● ● V	13	ZONE5
6	V ● ● V	14	ZONE6
7	V ● ● V	15	
8	V ● ● V	16	

HEATLOCK®
ID NO:E181-8241
WIRE CODE:MOLTEC
HEATER:240V TC-J
VIEW:CONNECTOR FRONT-MALE

CONNECTOR-POWER

1	V ● ● V	9	ZONE1
2	V ● ● V	10	ZONE2
3	V ● ● V	11	ZONE3
4	V ● ● V	12	ZONE4
5	V ● ● V	13	ZONE5
6	V ● ● V	14	ZONE6
7	V ● ● V	15	
8	V ● ● V	16	

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HEATLOCK®
ID NO:E181-8241

Air Switch

www.heatlock.com

CONNECTOR-T/C
VIEW:CONNECTOR FRONT-FEMALE

9	TC+ ○ ○ TC-	1	ZONE1
10	TC+ ○ ○ TC-	2	ZONE2
11	TC+ ○ ○ TC-	3	ZONE3
12	TC+ ○ ○ TC-	4	ZONE4
13	TC+ ○ ○ TC-	5	ZONE5
14	TC+ ○ ○ TC-	6	ZONE6
15	TC+ ○ ○ TC-	7	
16	TC+ ○ ○ TC-	8	

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HEATLOCK®
ID NO:E181-8241
WIRE CODE:Kostal
HEATER:240V TC-J
VIEW:CONNECTOR FRONT-FEMALE

CONNECTOR-T/C

9	TC+ ○ ○ TC-	1	ZONE1
10	TC+ ○ ○ TC-	2	ZONE2
11	TC+ ○ ○ TC-	3	ZONE3
12	TC+ ○ ○ TC-	4	ZONE4
13	TC+ ○ ○ TC-	5	ZONE5
14	TC+ ○ ○ TC-	6	ZONE6
15	TC+ ○ ○ TC-	7	
16	TC+ ○ ○ TC-	8	

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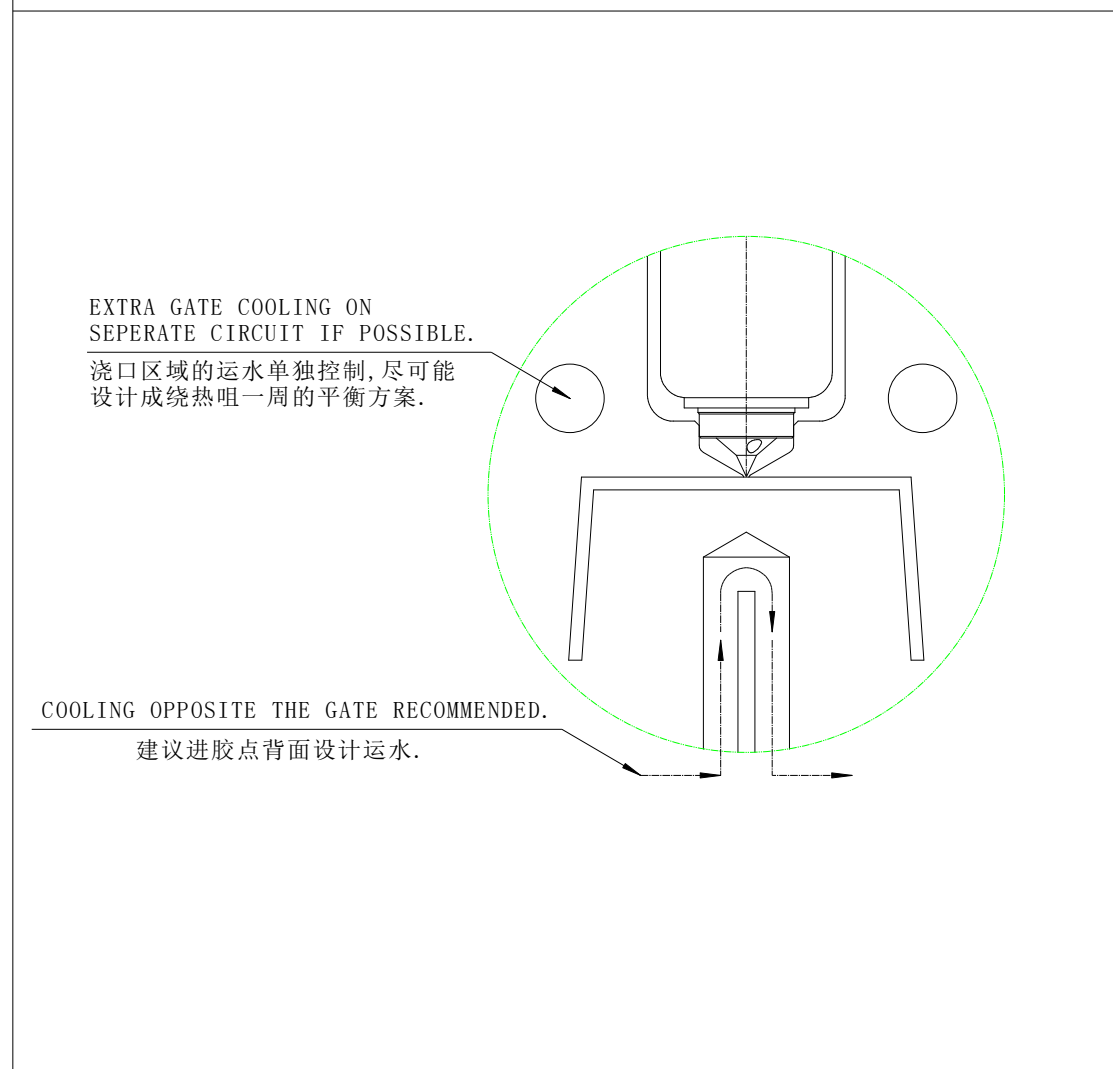
E181-8240-8241(05)

1ST ANGLE PROJECTION
View from cavity side

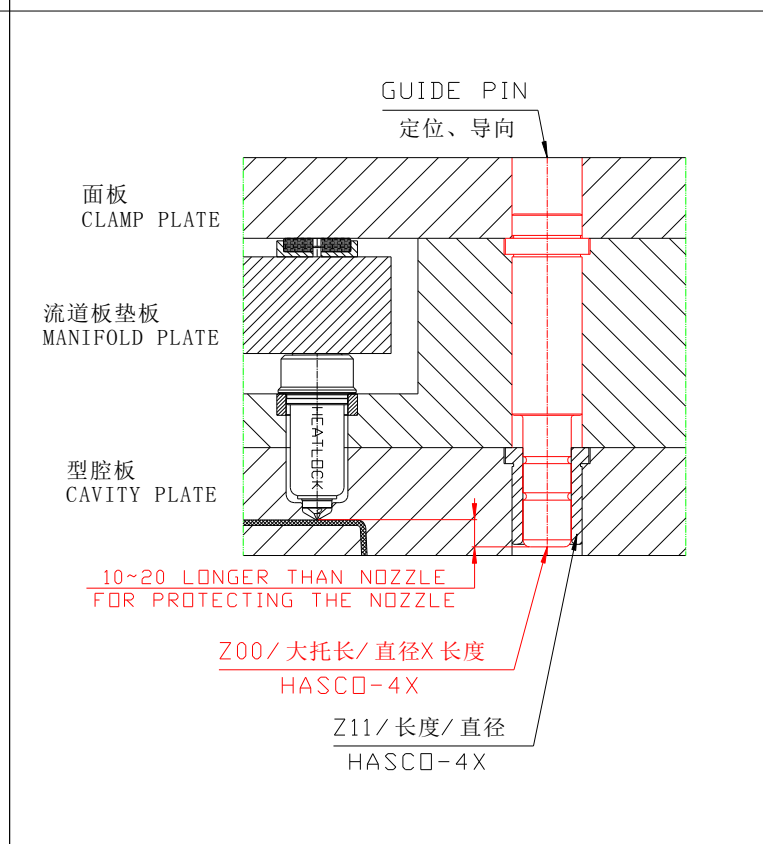
Material		Dimension otherwise stated		Drawing by		Engineer	
Size	ISO 2768-1	Surface	Ra 3.2	Checked by	Issued by	Scale	1:1
				South China Building 2-8 Shuang Street, Central, Hong Kong Phone: (852) 3128 8888 Fax: (852) 2603 5338 E-mail: front@heatlock.com			
ID Card				Drawing No: HSD1-0000-0011-005			

MOLD DETAILS AND DIMENSION

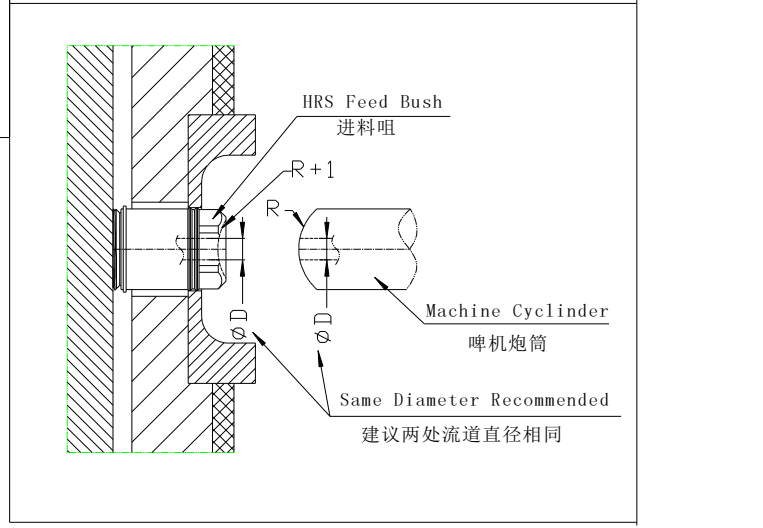
浇口区域的运水设计 GATE COOLING SOLUTION



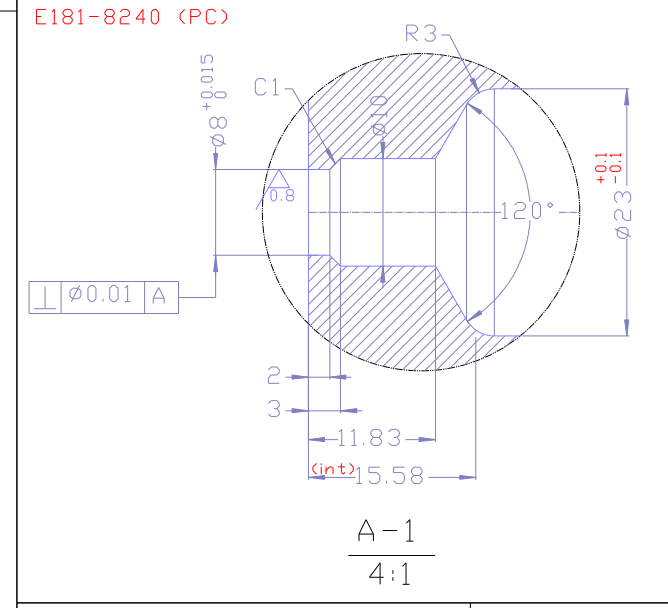
定位导向装置 GUIDE PIN



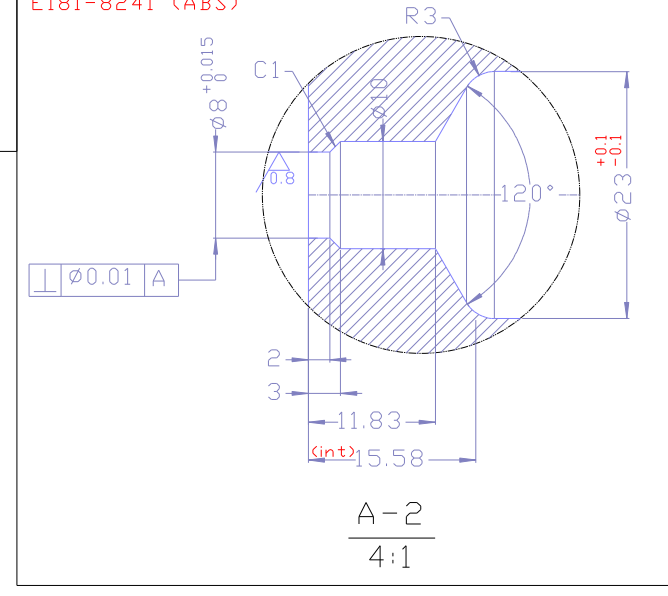
炮筒方案 CYCLINDER SOLUTION



A3VGX-05热咀孔加工图 BORE FOR A3VGX-05 NOZZLE



A3VGX-05热咀孔加工图 BORE FOR A3VGX-05 NOZZLE



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