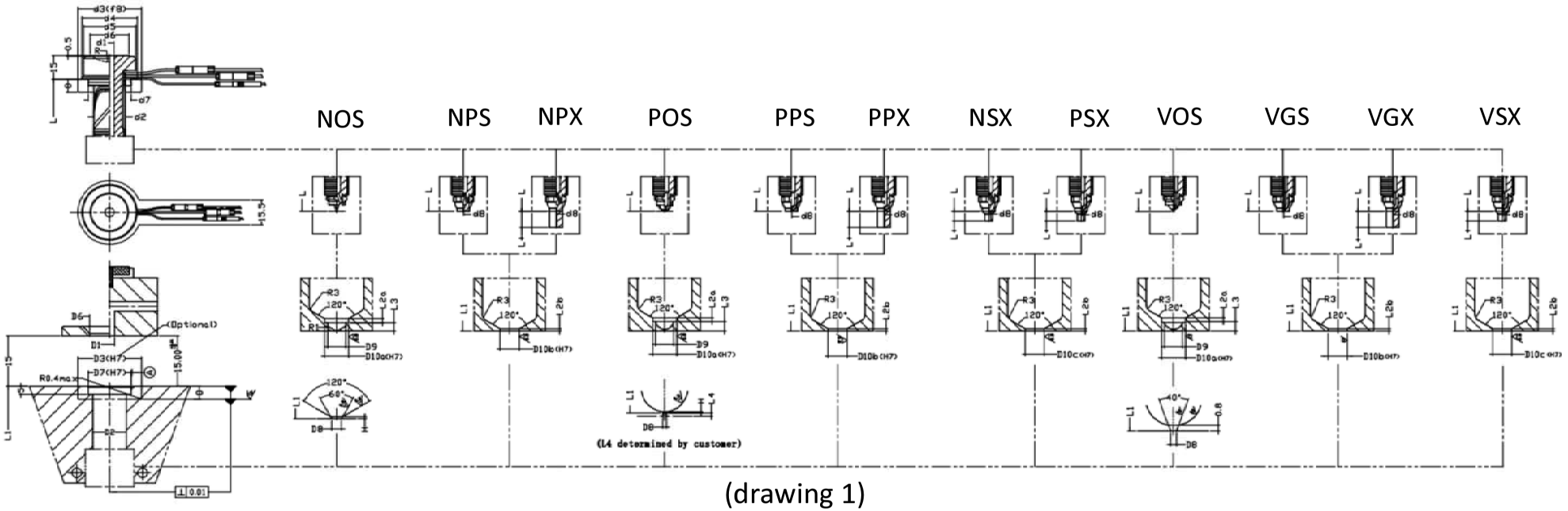


(drawing 1)

Size	04			
L	50	60	80	100
L1	50.13	60.15	80.18	100.22
d1	4			
d2	12			
d3	T23			
d4	23			
d5	21			
d6	14			
d7	17			
d8	1.5≥0.6			
H	0.2			
D2	13			
D3	T23			
D6	15			
D7	17			
D8	1.5≥0.6			
D9	4.5			
D10a	6			
D10b	6			
D10c	5			

Size	05					
L	40	50	60	80	100	120
L1	40.11	50.13	60.15	80.18	100.22	120.26
d1	5					
d2	16					
d3	C30,T30					
d4	29					
d5	27					
d6	18					
d7	23					
d8	2≥0.6					
H	0.2					
D2	18					
D3	C30,T30					
D6	20					
D7	23					
D8	2≥0.6					
D9	7.5					
D10a	10					
D10b	8					
D10c	5					

Size	07						
L	40	60	80	100	120	140	160
L1	40.12	60.15	80.19	100.23	120.27	140.31	160.34
d1	7						
d2	19						
d3	T36,T40,T50						
d4	35						
d5	33						
d6	24.5						
d7	27						
d8	3≥0.8						
H	0.2						
D2	21						
D3	T36,T40,T50						
D6	26.5						
D7	27						
D8	3≥0.8						
D9	9						
D10a	12						
D10b	10						
D10c	7						

* C= Ceramic; T= Titanium

Size	L3		L+		L2a	L2b	D10a	D10b	D10c	D9		D8	H	
	NOS	POS	PX	SX	ALL	ALL	ALL	ALL	ALL	NOS	POS	ALL	NOS	POS
04	1.7		5		1.1	1	6	6	5	4.5		1.5≥0.6	0.2	
05	3.5		10	6	2	1	10	8	5	7.5		2≥0.6	0.2	
07	3.5		15	7	2.5	1.5	12	10	7	9		3≥0.8	0.2	

(table 1)

HEATLOCK®

A2ST Nozzle Mould Machining
Dimensions Detail

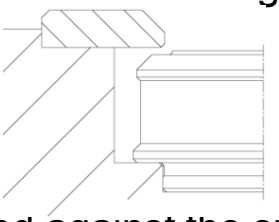
A2ST Nozzle mould Machining Dimensions Detail

The A2ST series can be designed for a single nozzle application or a multi-drop application utilizing a hot runner manifold.

The coil heater is designed to provide uniform heat distribution along the length of the nozzle. A concentration of heater windings at both ends of the nozzle compensate for heat losses that occur between the nozzle and mould steel.

Nozzle bore machining should follow the instructions in drawing 1. Pay attention to length L1. L1 is calculated by adding the nozzle length to the nozzle compensate for heat losses that occur between the nozzle and mould steel.

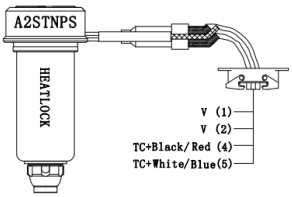
When using the A2ST in a single drop application, make sure that the back of the nozzle does not touch the locating ring. Contact with the locating ring will allow heat from the nozzle to dissipate into the mold.



If the force at which the machine nozzle is pressed against the sprue bushing is greater than that caused by the injection force on the front area of the bushing, no additional force is required to keep the bushing in place axially.

Wiring instructions

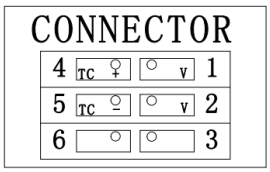
Attention: Only connectors designed to match the temperature controller are to be used.



6 Pin Connector

HEATLOCK connections as per illustration at right:

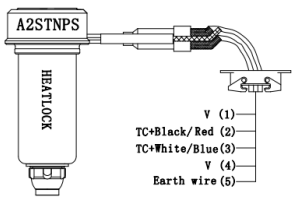
1. connect(1)(2) with heater.
2. connect T/C wire (black/ red) with (4).
3. connect T/C wire (white/blue) with (5).
4. Connect mould with ground wire & insert.

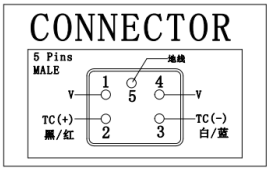


5 Pin Connector

HEATLOCK connections as per illustration at right:

1. connect(1)(4) with heater.
2. connect T/C wire (black/ red) with (2).
3. connect T/C wire (white/blue) with (3).
4. Connect mould with ground wire & insert





If there are any problems encountered during assembly, please call: (86) 757-2991 5868.