

(drawing 1)

Size	04			05			07			10				
	L	50	60	80	100	120	L	60	80	100	120	140	160	180
L1	50.13	60.15	80.18	100.22	120.25		60.25	80.32	100.38	120.44	140.50	160.56	180.62	
d1	4			5			d1							
d3	T23			C30, T30			d3							
d4	23			29			d4							
d5	13			20			d5							
d6	17			23			d6							
d7	14			18			d7							
D4	16			20			D4							
D5	4			5			D5							
D6	17			23			D6							
D7	23			30			D7							
D8	17			23			D8							

* C= Ceramic; T= Titanium

Size	L3		L+	L2a		L2b		D1a	D1b	D1c	D2		D3	H		H1
	NOX	POS		ALL	SX	ALL	ALL				NOX	POS		ALL	NOX	
04	-	1.7	5	1.1	1	1	6	6	5	4.5	4.5	1.5 ≥ 0.6	0.2	0.2	-	-
05	8.5	3.5	10	2	1	1	10	8	5	8	7.5	2 ≥ 0.6	0.2	0.2	1.5	1.5
07	8.5	3.5	15	2.5	1.5	1.5	12	10	7	9	9	3 ≥ 0.8	0.2	0.2	1.5	1.5
10	-	4.4	15	2.6	2	2	18	14	10	12.4	12.4	≥ 2	0.3	0.3	-	-

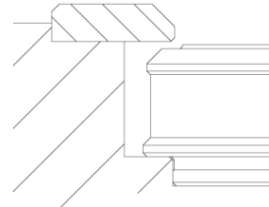
(table 1)

The A2 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 A2 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.

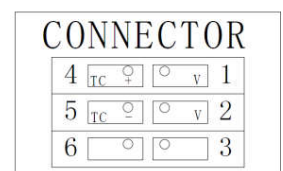
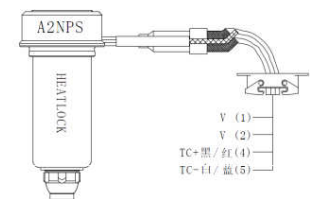
Wiring instructions

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

6 Pin Connector

HEATLOCK connections as per illustration at right:

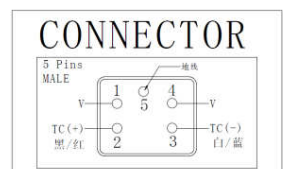
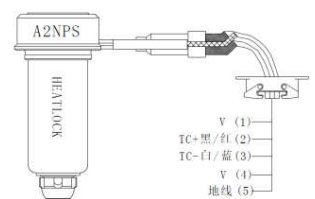
1. connect(1)(2) with heater.
2. connect T/C wire (black/ red) with (4).
3. connect T/C wire (white/blue) with (5).
4. Connect mould with ground wire & insert.



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.