

Key data

Molded part	Terminal body
Application	Modular terminal
Part weight	5 g
Material	PA 6 V0
Mold type	Multi-cavity mold
No. of cavities	2

Illustrations simplified, schematically drawn and not to scale.
For a specific application, please consult Synventive.

Customer's requirements

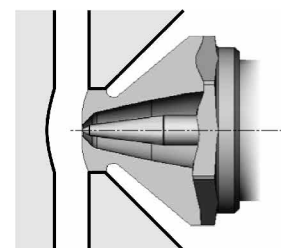
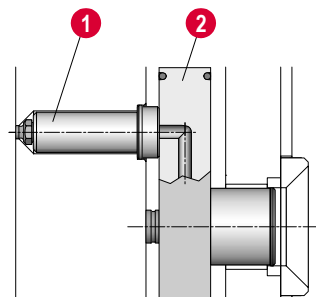
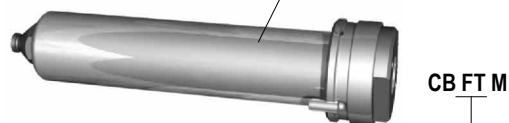
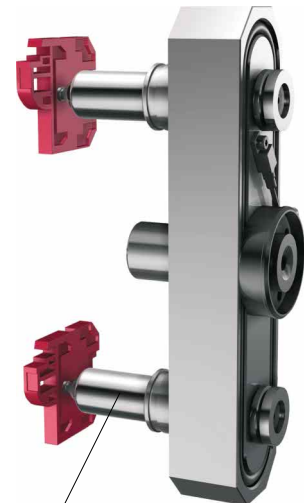
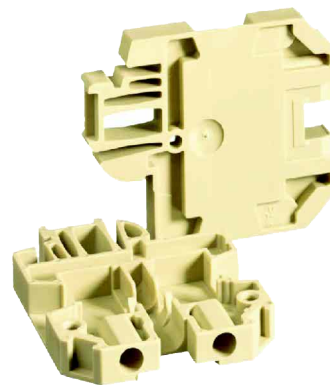
This application involved the production of modular terminals of PA 6 with V0 properties in a 2-cavity mold.

Solution

In the implementation of this application, an externally heated 2-port hot runner system with face fit manifold nozzles was employed. The manifold was of standard form (I) and its runners were naturally balanced. The cavity was directly gated with the hot runner to the molding surface via open nozzles with torpedo, whereby the gate was recessed in a dimple.

Benefits

- Production without sprue waste and without reworking
- Good gating quality with respect to separation and appearance
- Uniform supply and filling of all cavities with melt
- Good molding quality from all the cavities



Schematic product overview

1. Manifold nozzle, face fit
Series CB...M, Type FT
2. Manifold
Series VC

07 C + V C

F T