

Key data

Moulded part	Cap insert
Application	Housing cover
Part weight	1 g
Material	PP
Mould type	Multi-cavity mould
No. of cavities	64

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

Customer requirements

In this particular application, it was a question of manufacturing PP caps in a 64-cavity mould with fast delivery of the complete, pre-wired and adjusted system, including mould plates, connection box and connector-ready, pre-configured temperature controller.

Solution

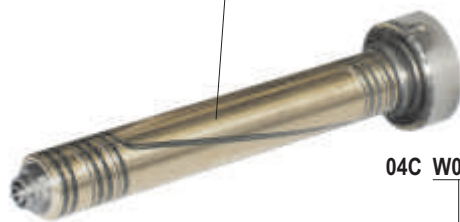
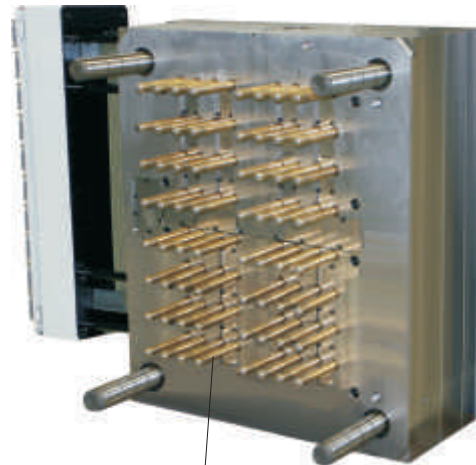
This application was implemented using an externally heated, 64-cavity hot runner system with face fit between nozzles and manifold. The manifold system consisted of 2 block manifolds with 32 nozzles each, fed by an H-manifold. All runners are naturally balanced. Gating with the hot runner was direct, in the centre of the moulded part. To suit this system with a large number of cavities, a mobile temperature controller was supplied, ready to plug in.

Benefits

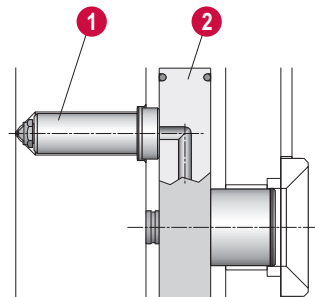
- Saving of time and manufacturing resources through the "hot half concept" as initial stage of the finished mould half
- Manufacture without sprue waste and post-processing
- Production with high number of cavities
- Good gating quality regarding gate mark and appearance
- Equal supply and filling of all cavities with melt
- Good moulded part quality from all cavities

Schematic product overview

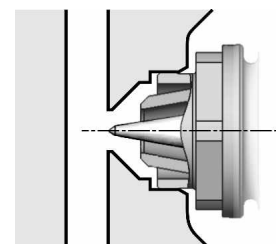
1. Manifold nozzle, face fit
Nozzle class 04 C
2. Manifold
Series VC



04C W01T



04 C + V C



W T