

**5 g PS metallic + 7g PS custom color**  
**Fork for aircraft cutlery**

**Key data**

Molded parts	Fork: Prongs and handle
Application	Aircraft cutlery
Part weight	5 g + 7 g
Material	PS: metallic & cust. color
Mold type	Turntable mold
No. of cavities	16 + 16

**Customer's requirements**

This application involved the production of forks of PS for aircraft cutlery using the 2-component process with a 16+16-cavity turntable mold. The plastic cutlery is to replace the metal cutlery used to date.

**Solution**

In the implementation of this application, two identical externally heated 16-gate hot runner systems with nozzles sliding on the manifold were employed. The runner systems each consisted of two T-shaped runners linked by an I-shaped runner. The cavity was directly gated with the hot runner to the molding surface via valve gate nozzles with 4 nozzles being actuated by one actuator. The system was supplied as hot half, i.e. including mold plates, ready installed and adjusted as well as wired ready for plugging in and with the necessary hose connections.

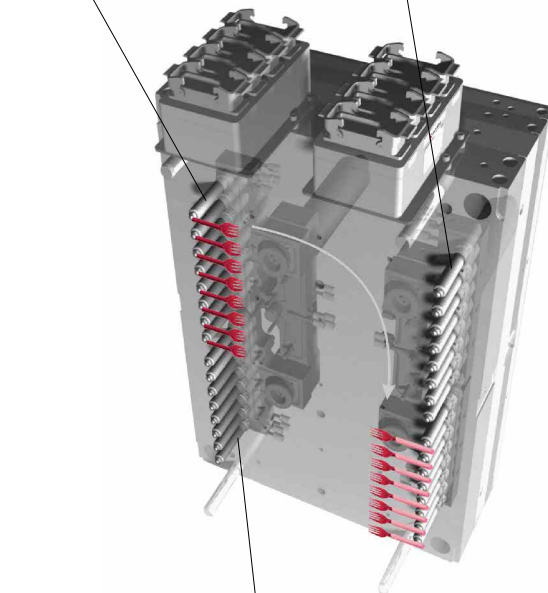
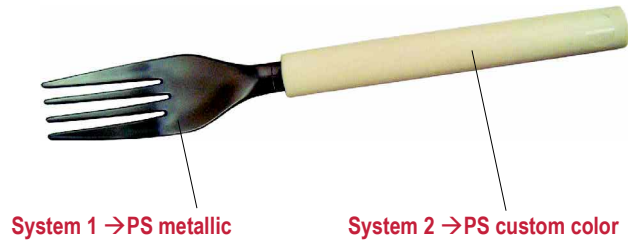
**Benefits**

- Savings in time and costs thanks to the "hot half concept" as the preliminary stage to the finished mold side
- Production without sprue waste and without reworking
- Production with a large number of cavities
- Good gating quality
- Uniform supply and filling of all cavities with melt
- Good molding quality from all the cavities

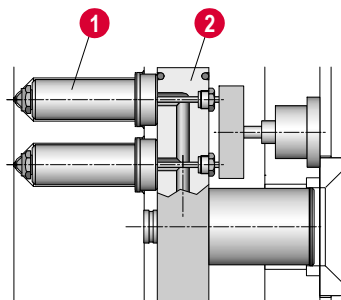
**Schematic product overview**

1. Manifold nozzle, face fit  
**Series N CB...M, Type WV**
2. Manifold  
**Series VF**
3. Actuator, pneumatic, in mold platen  
**Series LCP 4008 02**

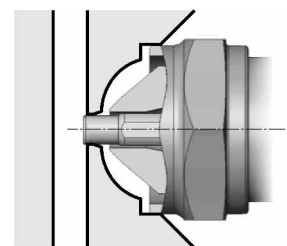
Illustrations simplified, schematically drawn and not to scale.  
For a specific application, please consult Synventive.



N CB W M



07 C + V F



W V