

**Key data**

Moulded part	G-frame
Application	Mobile phone
Part weight	4.7 g+0.9 g
Material	PARA GF50+TPU
Mould type	2K mould
No. of cavities	2+2

**Customer's requirements**

This application involved the production of G-frame of PARA GF50 and TPU for mobile phone in a 2+2-cavity 2K mould .

**Solution**

In the implementation of this application, a rheologically balanced, externally heated 4+4 port hot runner system with 04C face fit manifold nozzles and 07E screw fit manifold nozzles were employed. Manifold form and nozzle lengths were specially adapted to the part contour and the required injection points. The cavity was directly gated via cold sub-runners that were fed by open nozzles with torpedo.

**Benefits**

- Production without sprue waste and without reworking
- Good gating quality with respect to separation and appearance

**Schematic product overview**

1. Manifold nozzle , face fit  
**Series 04C01, Type WT, Class 04 C**
2. Manifold  
**Series VC**
3. Manifold nozzle , screw fit  
**Series 07E01, Type YT, Class 07 E01**
4. Manifold  
**Series VD**

