











10.5.2 Inlet Bushing IB-50 Series

NOTICE

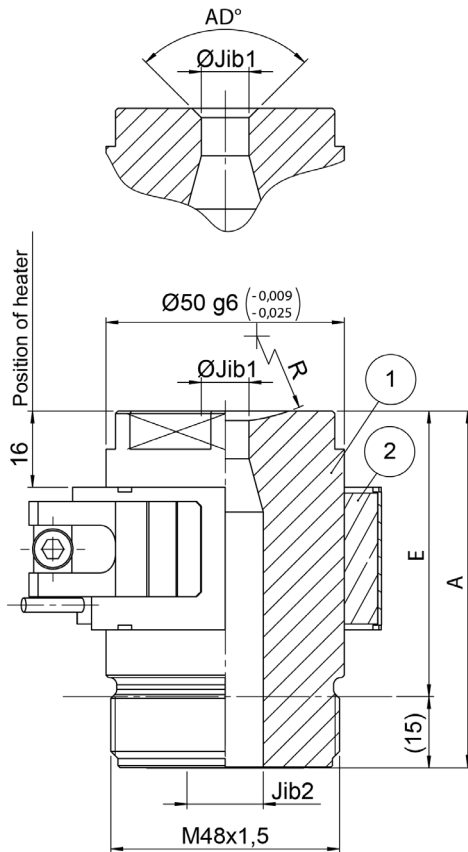
Use torque wrench with wrench insert and the torques indicated in the torque table (section 13).

! WARNING

	<p>Hot Surfaces Hazard</p> <p>Contact between the skin and hot surfaces could result in burns.</p> <p>Use personal protective equipment, such as gloves, apron, sleeves and face protection, to guard against burns.</p> <p>When servicing or handling the hot runner system outside the manifold plates or the injection molding machine, care must be taken to heed the hot surface exposure warnings.</p> <p>For first aid contact your medical / safety representing.</p>	  
	<p>Hazard of Pressurized Air</p> <p>Pressurized air blow can result in hot plastic or foreign bodies entering the eyes, causing vision damage.</p> <p>Use personal protective equipment: Face protection, hearing protection and gloves.</p> <p>For first aid contact your medical / safety representing.</p>	  



Technical Data IB-50



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Inlet bushing, threaded to the Manifold			
Thread Inlet bushing / Manifold	M48x1,5		
Inlet bushing body	Ø 50 mm		
ØJib1	10 mm		
ØJib2	20 mm / 24 mm		
R	0 - 50 mm		
AD	90° - 120°		
Inlet Bushing		Heater	
Type	E	A	Power
IB50-025	25	40	
IB50-050	50	65	400 W
IB50-075	75	90	450 W
IB50-100	100	115	500 W
IB50-140	140	155	630 W

Shown are standard dimensions.
For customer specific dimensions please contact Synventive.

10.5.2.1 Thermocouple

Color Coding of Thermocouples

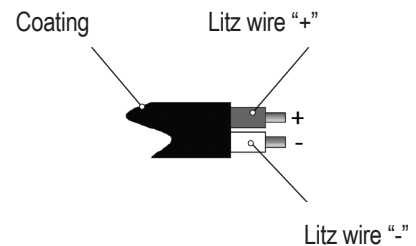
NOTICE

Take notice of the production and color identification of thermocouple cables.

Synventive uses J and K type thermocouples. Their color coding is given in the following table:

Table 1: International color coding for thermocouples

Type	International standard IEC 584-3	
J	Black	+ Black
		- White
K	Green	+ Green
		- White

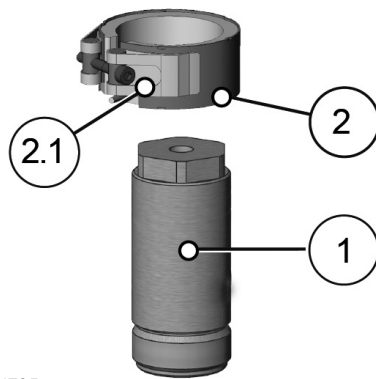




Service and Maintenance / Inlet Bushing IB-50 Series

10.5.2.2 Dismounting and Mounting of the Inlet Bushing on the Manifold

In this section the inlet bushing parts are identified with the numbers indicated in the following figure.



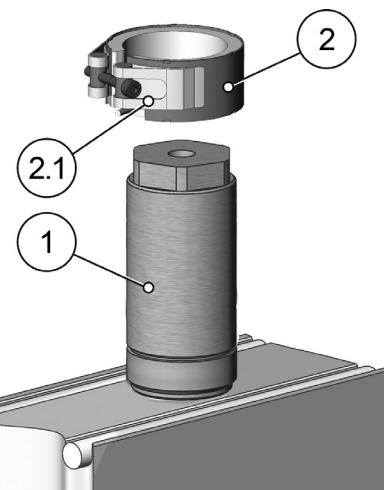
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Inlet Bushing Parts IB-50

Pos.	Qty.	Description	Item
1	1	Inlet bushing body	IB50B###01
2	1	Inlet bushing heater	HB50###
2.1	1	Heater Band J-Type	HB50###5
2.1	1	Heater Band K-Type	HB50###6

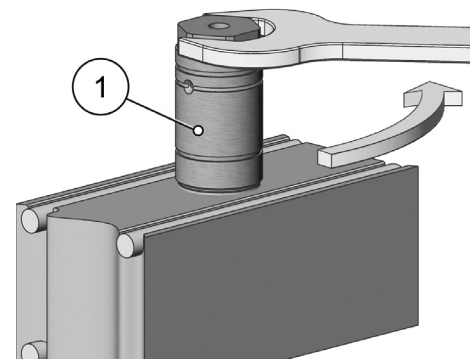
Dismounting of the Inlet Bushing IB-50

- 1) Loosen the socket cap screw from the inlet bushing heater (2.1).
- 2) Lift up the inlet bushing heater (2) from the inlet bushing body (1).



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- 3) Unscrew the inlet bushing body (1) by using a wrench (HEX46) from the manifold.

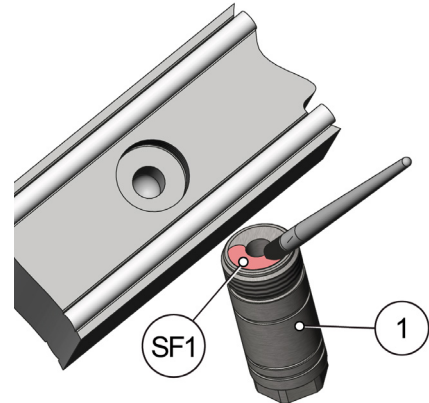


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Mounting of the Inlet Bushing IB-50

- 1) Apply spotting ink on the inlet bushing body (1) bottom surface (SF1).
- 2) Screw in the inlet bushing body (1) hand-tight into the manifold thread until seated.
- 3) Unscrew the inlet bushing body (1) from the manifold.



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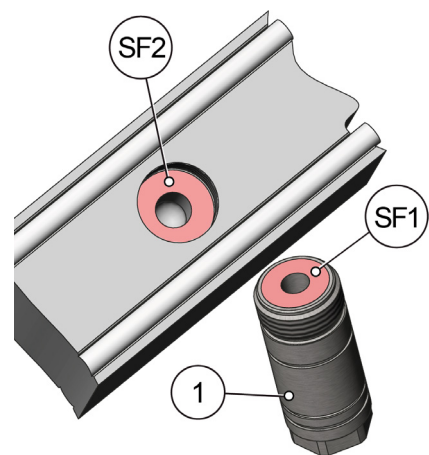
- 4) Check the matching between the manifold bottom surfaces (SF2) and the inlet bushing body (1) surface (SF1).

NOTICE

The manifold must bear on all surfaces uniformly and flatly, in particular on the inlet bushing body contact face.

In case of any uncertainty, clean the surfaces with a cleaning cloth. If the next ink test is still unsatisfactory, please - contact the Synventive Customer Service or Technical Support.

- 5) With a positive ink test clean the surfaces and proceed to the next step.

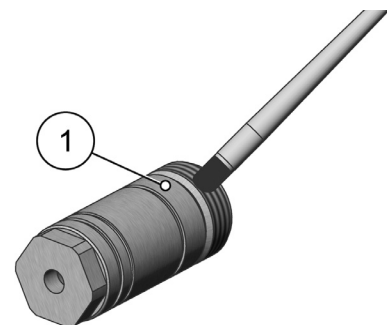


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- 6) Lubricate the thread (not the face) of the nozzle body with high-temperature assembly paste (anti-seize compound).

NOTICE

This is an important measure to prevent thread corrosion due to aggressive gases, which could be released during plastics processing.



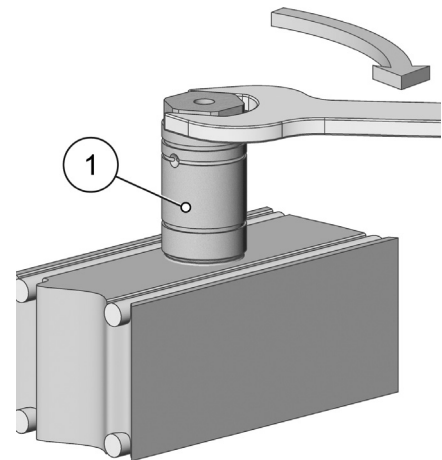
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- 7) Tighten the inlet bushing body (1) on the manifold.

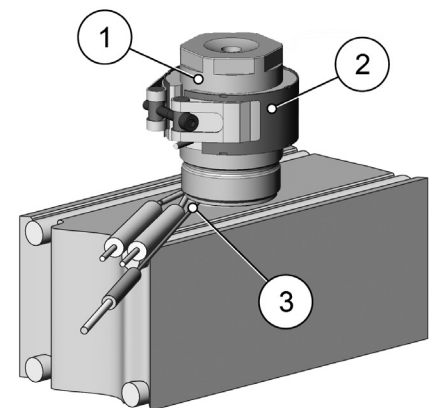
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- 8) Push the inlet bushing heater (2) along the Inlet bushing body (1).
9) Tighten the heater (2) at the Inlet bushing body (1) with the socket cap screw.



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