Product Type

V-42 manifold for open flow bore.

Hot runner manifold of series V-42 which are characterised by the following dimensions:

J2   M

Flow bore (Standard)  Ø 9 mm  42 mm
Flow bore (optional / max.)  Ø 10 mm  45 mm

The manifolds can be supplied in standard shapes (I, H, X, Y) and in any realizable customized shape.

The runners of standard manifolds are mechanically balanced.

Components

Melt flow components

1  Manifold block including heaters, connections and thermocouple.
2  Inlet bushing (including heater).

Attached parts and accessories

3  Center support
4  Dowel
5  Thrust pad

Major Dimensions (mm)

A  Manifold cutout, right (above)  10
B  Manifold cutout, left (below)  15
C  Height center support  15

IB24

De1  Ø of contact inlet bushing  Ø24
De2  Ø of cutout inlet bushing  Ø40
E  Height inlet bushing  15/45/ 65/85

IB32

De1  Ø of contact inlet bushing  Ø32
De2  Ø of cutout inlet bushing  Ø50
E  Height inlet bushing  15/45/ 65/85

1) Hardened insert recommended; is not supplied with the hot runner system.
Inlet bushings which can be combined with hot runner manifolds of series V-42:

1. IB24...15...45...65...85
2. IB32...15...45...65...85

→ all length’s heated
→ threaded into manifold

<table>
<thead>
<tr>
<th>Type</th>
<th>E (mm)</th>
<th>De1 (mm)</th>
<th>De2 (mm)</th>
<th>R (mm)</th>
<th>Jib1 (mm)</th>
<th>Heater power (Watt)</th>
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</thead>
<tbody>
<tr>
<td>IB24-015</td>
<td>15</td>
<td>24</td>
<td>40</td>
<td>max. 40</td>
<td>6</td>
<td>-</td>
</tr>
<tr>
<td>IB24-045</td>
<td>45</td>
<td>24</td>
<td>40</td>
<td>max. 40</td>
<td>6</td>
<td>220W</td>
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<td>IB24-065</td>
<td>65</td>
<td>24</td>
<td>40</td>
<td>max. 40</td>
<td>6</td>
<td>300W</td>
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<tr>
<td>IB24-085</td>
<td>85</td>
<td>24</td>
<td>40</td>
<td>max. 40</td>
<td>6</td>
<td>380W</td>
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<tr>
<td>IB32-015</td>
<td>15</td>
<td>32</td>
<td>50</td>
<td>max. 40</td>
<td>6 / 8 / 10</td>
<td>-</td>
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<tr>
<td>IB32-045</td>
<td>45</td>
<td>32</td>
<td>50</td>
<td>max. 40</td>
<td>6 / 8 / 10</td>
<td>400W</td>
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<td>IB32-065</td>
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<td>50</td>
<td>max. 40</td>
<td>6 / 8 / 10</td>
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<td>IB32-085</td>
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<td>32</td>
<td>50</td>
<td>max. 40</td>
<td>6 / 8 / 10</td>
<td>445W</td>
</tr>
</tbody>
</table>

Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

If R < 11.9 then RD = Jib1 + 8
If R ≥ 11.9 then RD = Jib1 + 10
Attached parts and accessories for hot runner manifolds of series V-42

1. MCS30-15-03
   - Center support
   - Lcs (mm): 15

2. Thrust Pad
   - Thrust pad
   - Lmp (mm): 10, 15

3. Dowel
   - DIN7979: 6 m6
**Manifold Types and Styles**

1. **Manifolds in Standard Shape**

Manifolds in standard shape have been designed by implementing the standard cavity and runner layouts which are widely used in practice: I, H, X and Y.

Shown on the right there are several examples for manifolds in standard shape based on the components of series V-42. They are designed and made according to the customer’s specification.

Using capital letters to describe the different manifold types does not only refer to the shape of the manifold but also to the runner layout inside the manifold. The number represents the number of nozzles attached to the manifold.

2. **Manifolds in Customised Shape**

Manifolds in customised shape are designed and made according to the customer’s specification by using components of the selected manifold series.

3. **Bridge Manifolds**

Bridge manifolds make it possible to combine several manifolds to one feed system. They are designed and made according to the customer’s specification by using components of the selected manifold series.