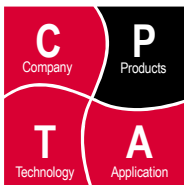
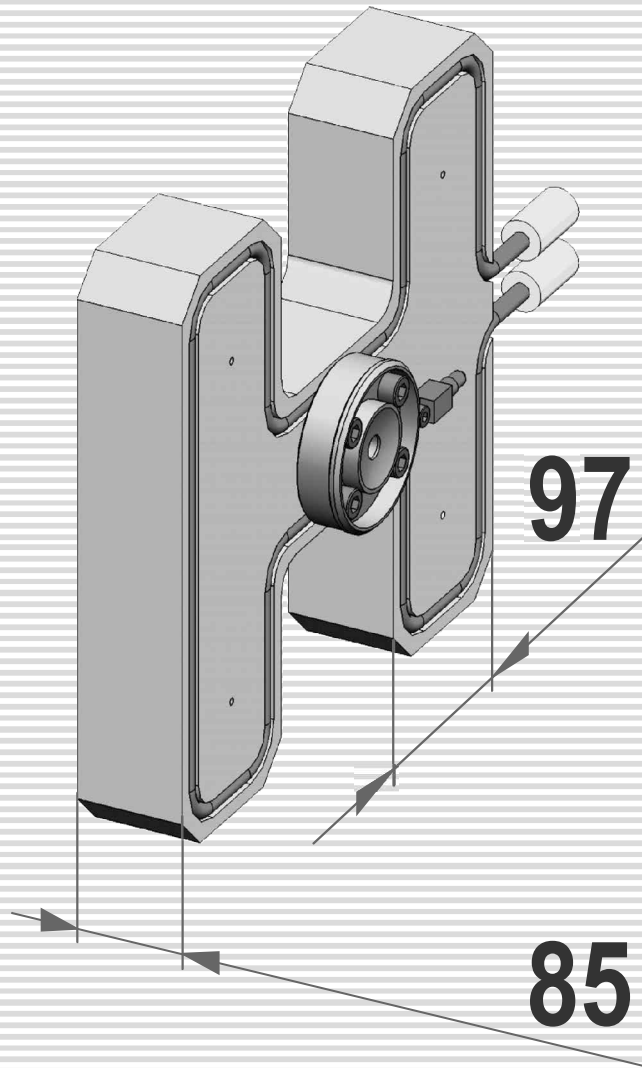


Series VI

Hot Runner Manifolds



Illustrations simplified, schematically drawn and not to scale.

Product type

Hot runner manifold of series VI which are characterised by the following dimensions:

- M** Thickness 85 mm
- M1** Width 97 mm
- J2** Flow bore Ø max. Ø25 mm

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

Components

Melt flow components

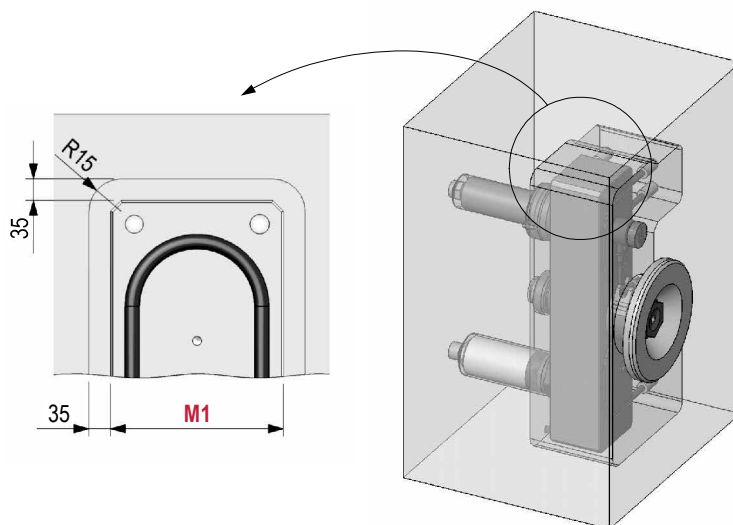
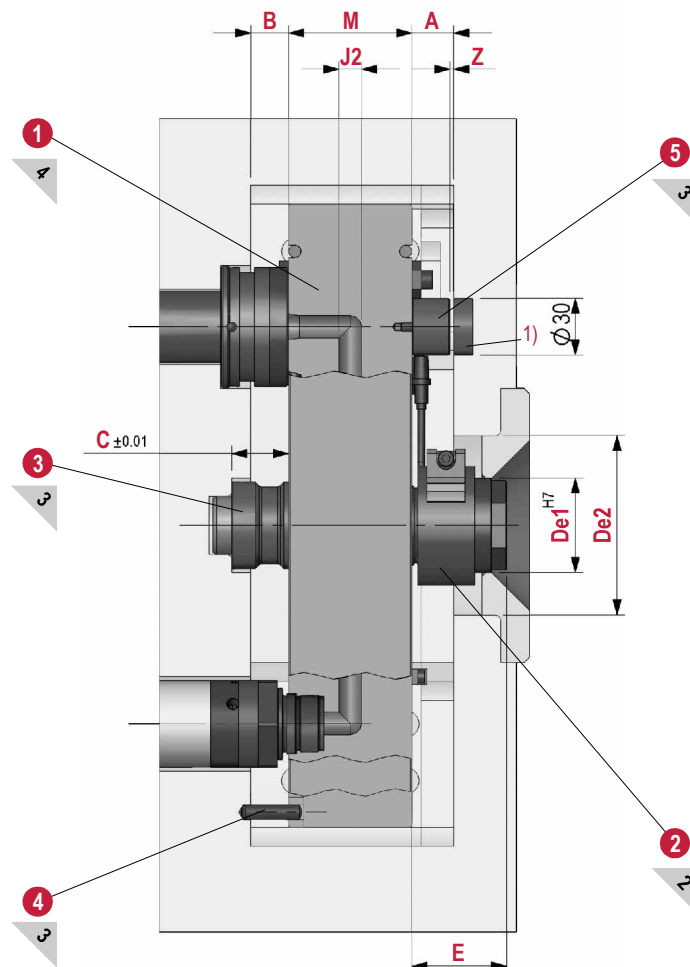
1. Manifold block including heaters, connections and thermocouple
2. Inlet bushing (including heater)

Attached parts and accessories

3. Centre support
4. Dowel
5. Support pad

Major dimensions (mm)

- A** Manifold cut out, right (above) 22²⁾
- B** Manifold cut out, left (below) 18 2)
- Z** Expansion gap 0...0.18²⁾
- C** Height centre support 20
- E** Height inlet bushing 25...200
- De1** Ø of contact inlet bushing Ø50
- De2** Ø of cut out inlet bushing Ø 60 / Ø95



☞ page no. of related data sheets

- 1) Hardened insert recommended; is not supplied with the hot runner system.
- 2) Values of these dimensions depend on the selected nozzle or on the selected material. They can be found in the Synventive Hot Runner Guide.

Inlet bushings which can be combined with hot runner manifolds of series VI:

1. BC 025 50

- short inlet bushing, not heated
- screwed into manifold

2. BC ... 50

- heated inlet bushing of different heights
- screwed into manifold

Here you can configure your inlet bushing

1. Complete the inlet bushing description

BC **50**
Part code ↑ Length code ↑ Size ↑

2. Selection of variables

E=↑ R= ↑ AD=↑

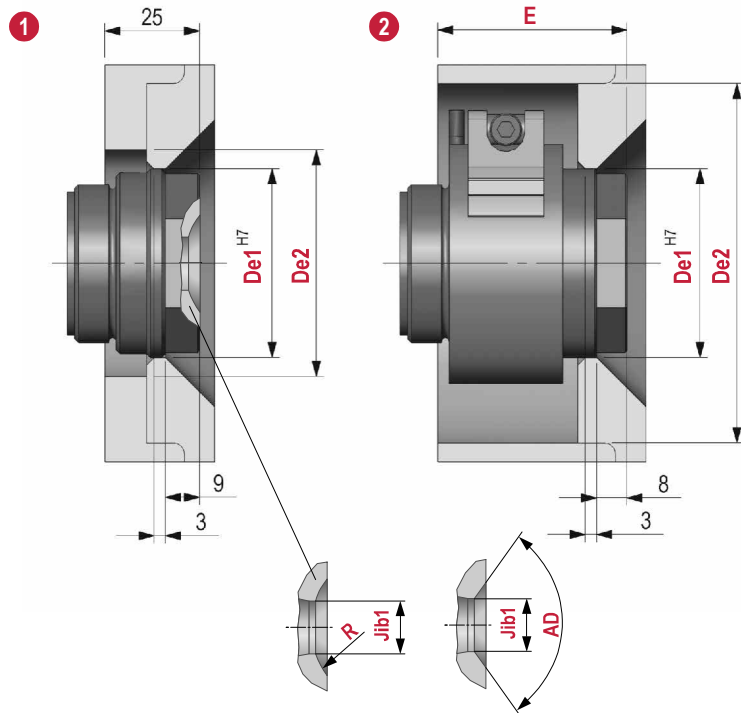
Example and explanations

Inlet bushing Position in length chart
↓ ↓
BC **100** **50**
 Part code ↑ Length code ↑ Size ↑

65 **16** **-**
E=↑ R= ↑ AD=↑

↑ Variables for precise part specification from the drawings and tables shown here

Illustrations simplified, schematically drawn and not to scale.



Length code	E (mm)	De1 (mm)	De2 (mm)	Jib1 (mm)	R (mm)	AD (°)	Heater power (Watt)
025	25	Ø50	Ø60	Ø5...Ø25	max. 40	90 / 120	-
060	50...59.9	Ø50	Ø95	Ø5...Ø25	max. 40	90 / 120	630
100	60...99.9	Ø50	Ø95	Ø5...Ø25	max. 40	90 / 120	500
140	100...139.9	Ø50	Ø95	Ø5...Ø25	max. 40	90 / 120	500
180	140...179.9	Ø50	Ø95	Ø5...Ø25	max. 40	90 / 120	630
200	180...200	Ø50	Ø95	Ø5...Ø25	max. 40	90 / 120	750

Attached parts and accessories for hot runner manifolds of series VI:

1. MCS 46 ...

Centre support	Lcs (mm)	B ²⁾ (mm)
MCS 46 20	20	max. 20

C (mm)
for nozzle size 24
≥ B

2. DIN 6325: 12 m6

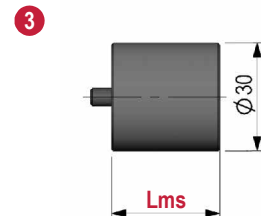
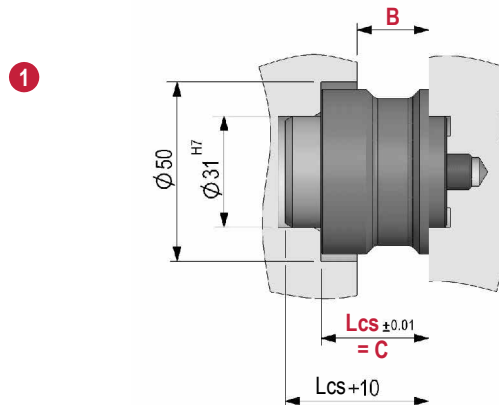
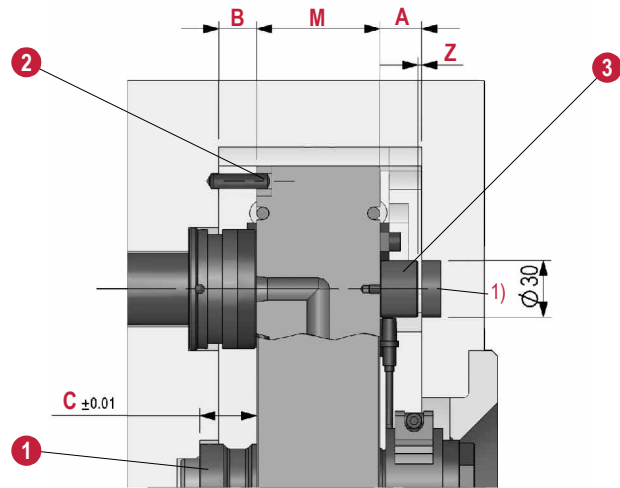
→ Dowel

3. MS 30 ...

→ Support pads

Z (mm) ²⁾
0 ... 0.18

Illustrations simplified, schematically drawn and not to scale.



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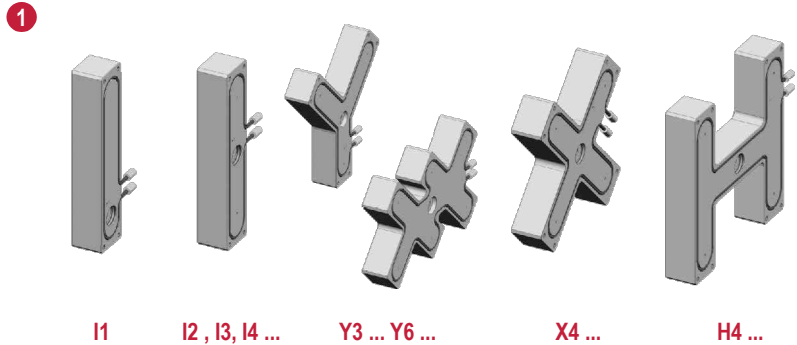
Illustrations simplified, schematically drawn and not to scale.

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 VI. They are designed and made according to the customer's specification

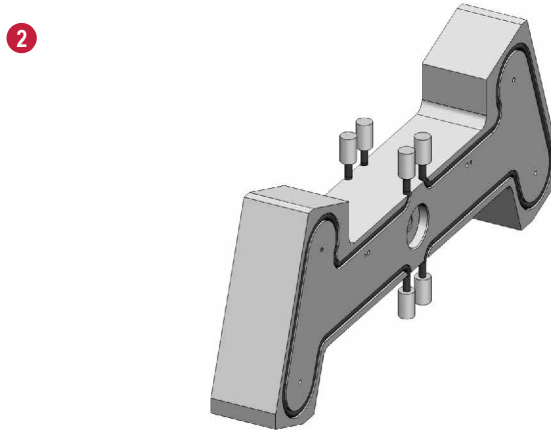
Using capital letters to describe the different manifold types does not only refer to the shape of the manifold but also to the runner layout inside the manifold. The number represents the number of nozzles attached to the manifold.



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.

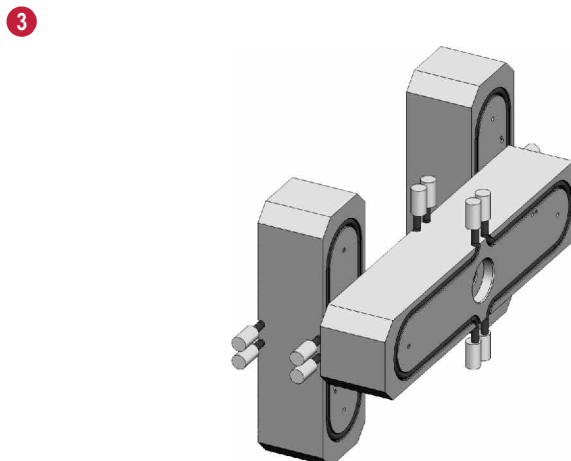
Shown on the right there is a manifold in customised shape which has been designed by using components of series VI.



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.

Shown on the right there is a bridge manifold which has been designed by using components of series VI.



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