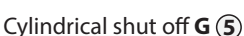




SEZ. D-D

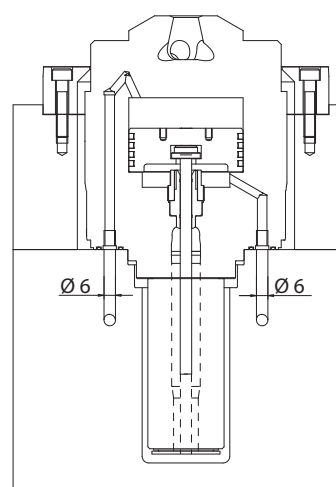
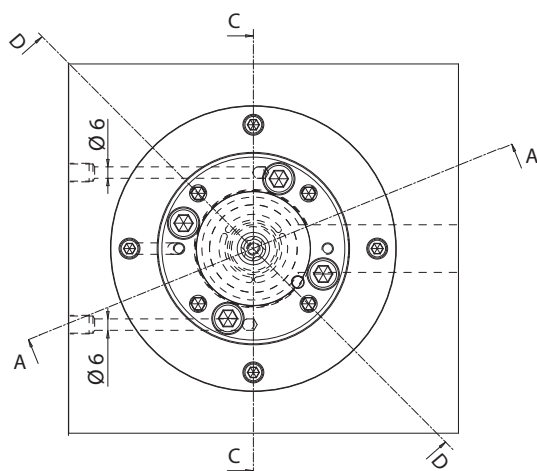


Chiusura cilindrica **G**

⑤ Conical shut off N

Chiusura conica N

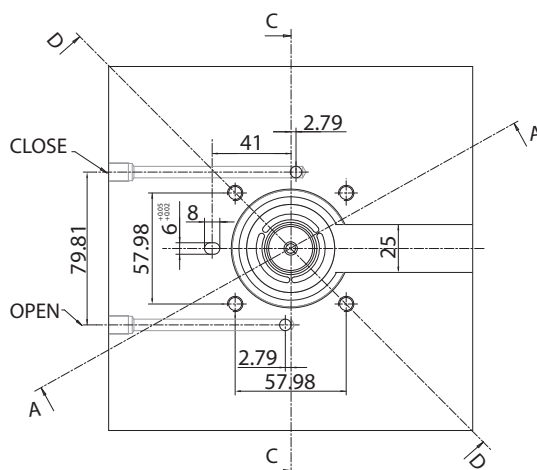
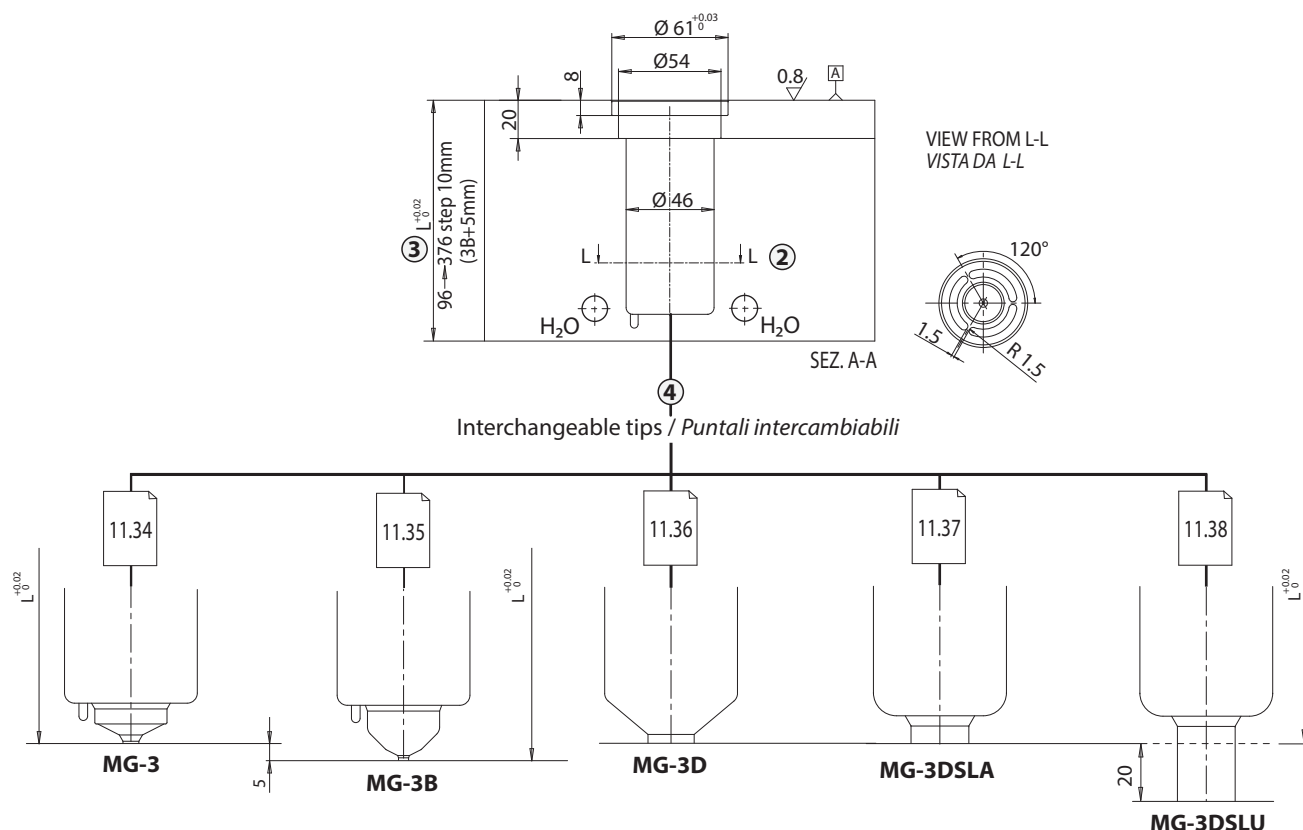
Idoneo solo per HDPE, LDPE, PP, PS



SEZ. C-C



GATE AREA / SEDE UGELLO



Suffix Suffisso ⑦	R
../R000	R 0
../R095	R 9.5
../R100	R 10
../R105	R 10.5
../R110	R 11
../R127	R 12.7
../R130	R 13
../R135	R 13.5
../R150	R 15
../R155	R 15.5
../R160	R 16
../R165	R 16.5
../R195	R 19.5
../R200	R 20
../R210	R 21
../R220	R 22
../R250	R 25
../R300	R 30
../R350	R 35
../R400	R 40
../A070	A 70°
../A090	A 90°
../A120	A 120°

Ordering code example / Esempio d'ordine ugello:

①	②	③		④		⑤		⑥		⑦		⑧									
M	G	4	6	0	9	6	-	3	B	-	N	-	3	3	R	1	9	5	-	J	G

- ① **M G** : Single nozzle with 4 head flow bores (nozzle head) (**MG**) / Tipo monougello con 4 canali di portata nella testa (**MG**)
- M G C** : 1 flowbore (nozzle head) option, optimized for color changes (**MGC**) / Opzione 1 foro nella testa, ottimizzato per cambio colore (**MGC**)
- ② **4 6** : Nozzle Ø (**Ø46**) / Diametro ugello (**Ø46**)
- ③ **0 9 6** : Length (**L=96 nozzle lengths: see table**) / Lunghezza ugello (**L=96 lunghezze ugelli: vedi tabella**)
- ④ **3 B** : Tip type / Tipo puntale (**3-3B-3D-3DSLA-3DSLU**)
- ⑤ **N** : Closure type (**N conical - G cylindrical**) / Tipo chiusura (**N conica - G cilindrica**)
- ⑥ **3 3** : Closing ØDi (**3.3 mm; range: see table**) / Diametro chiusura ØDi (**3.3 mm; range: vedi tabella**)
- ⑦ **R 1 9 5** : Radius (**R=19.5**) / Raggio testa (**R=19.5**)
- ⑧ **J G** : Thermocouple type (**JG grounded - JU insulated**) / Tipo termocoppia (**JG a massa - JU isolata**)

TIPO MG-3D: Ugello per l'iniezione con gruppo otturazione idoneo allo stampaggio di particolari dove è richiesto un ottimo aspetto estetico del punto di iniezione. E' idoneo anche allo stampaggio di materiali con cariche abrasive. A differenza dell'ugello MG-3 la lavorazione della matrice per la tenuta dell'ugello può essere eseguita dal lato cavità stampo. Sul particolare stampato rimarrà il segno del puntale.

④	Type / Tipo	Code / Codice
	MG-3D	E18889-ØY

Poligonal key / Chiave poligonale **E18765**
 ⌀ 27 Tightening torque 85 Nm
 ⌀ 27 Coppia di serraggio 85 Nm

Ø Y	Suffix <i>Suffixo</i>
3.5	35
3.6	36
3.7	37
3.8	38
3.9	39
4.0	40
4.1	41
4.2	42
4.3	43
4.4	44
4.5	45

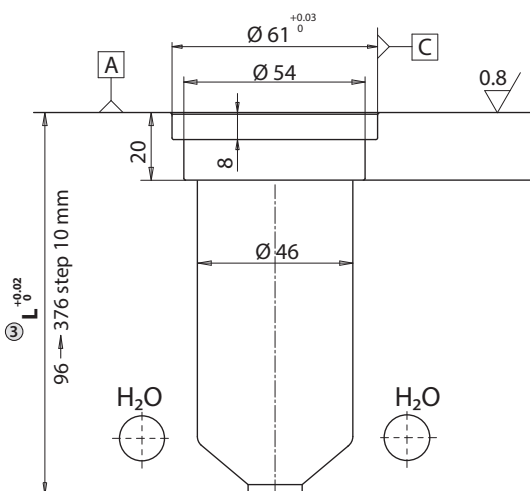
Indicare il Ø iniezione in fase d'ordine inserendo il suffisso prescelto dopo il tipo di puntale.

Es. MG46286-A-3D**35**-JG

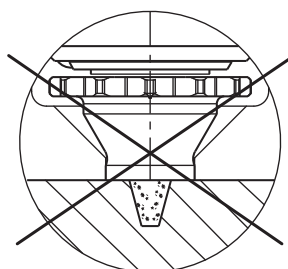
Technical drawing of a nozzle (Fig. 11.39) showing dimensions and tolerances. The drawing includes a side view and a top view. The side view shows a nozzle with a cylindrical body of diameter $\varnothing 46$ and a conical section with a 40° angle. The top view shows a circular base with a diameter of $\varnothing 16$ and a central hole with a diameter of $\varnothing 0.02$. The drawing also includes a dimension of 3 for the height of the conical section and a dimension of 0.4 for the radius of the conical section. The drawing is labeled with 'Nozzle lengths on page 11.39' and 'Lunghezze ugelli pag. 11.39'.

Dimensions and Tolerances:

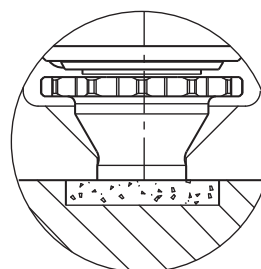
- Overall length: 3 (tolerance: $0_{-0.1}$)
- Top view diameter: $\varnothing 16$ (tolerance: $^{+0.012}_0$)
- Side view diameter: $\varnothing 46$ (tolerance: $^{-0.1}_{-0.3}$)
- Conical section angle: 40°
- Conical section radius: 0.4
- Central hole diameter: $\varnothing 0.02$ (tolerance: $^{+0.02}_0$)



L'ugello in fase di esercizio non deve andare in battuta sull'acciaio della parte mobile dello stampo.

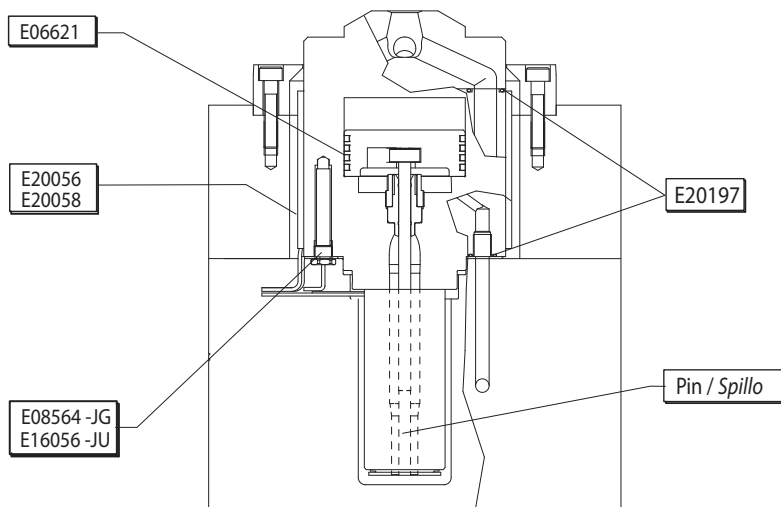
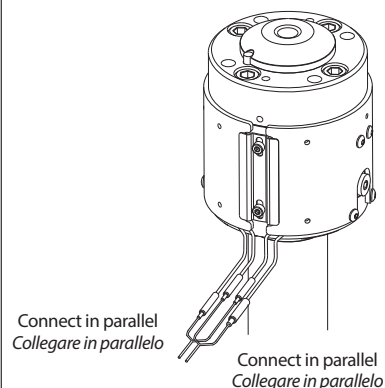


NO
NO



YES
SI

Edition 03/2020 - Edizione 03/2020


HEAD HEATER WIRING
CABLAGGIO RESISTENZA TESTA


REPLACEMENT PARTS / PARTI DI RICAMBIO

Code / Codice	Description / Descrizione			
E06621	Seal 60x3 / Fascia elastica 60x3			
E20197	Compleat set OR / Set completo OR			
E20056	Head heater / Resistenza testa 230 V 700 Watt	cables / cavi	White / Red-White	Bianco / Rosso-Bianco
E20058	Head heater / Resistenza testa 230 V 700 Watt	cables / cavi	White / Red-White	Bianco / Rosso-Bianco
E08564	Grounded thermocouple / Termocoppia testa a massa (-JG)	cables / cavi	Red / Rosso	TC+
E16056	Insulated thermocouple / Termocoppia testa isolata (-JU)	cables / cavi	Blue / Blu	TC-
E20060-..	Needle for nozzle MG Ø46 / Spillo per MG Ø 46			

Ordering NEEDLE code example / Esempio d'ordine SPILLO:

E20060	M	G	4	6	0	9	6	-	3	T	-	N	-	3	3
---------------	----------	----------	----------	----------	----------	----------	----------	----------	----------	----------	----------	----------	----------	----------	----------

⑪ : Nozzle Ø / Diametro ugello (Ø 46)

⑫ : Length / Lunghezza ugello (L=96)

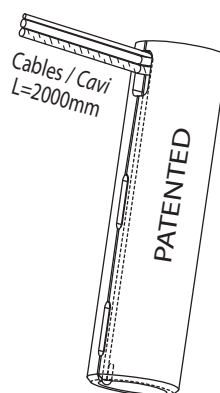
⑬ : Tip type / Tipo puntale (3-3B-3D-3DSL-3DSLU)

⑭ : Closure type (N conical - G cylindrical) / Tipo chiusura (N conica - G cilindrica)

⑮ : Closing ØDi (3.3 mm) / Diametro chiusura ØDi (3.3 mm)

SPARE PARTS MG - RICAMBI MG

L	Type 3B Tipo 3B	Heater code Codice resistenza	Watt	Thermocouple Codice termocoppia ugello	
				grounded - a massa .. - JG	insulated - isolata .. - JU
96	101	E15521	480	E05505-F46	E16037-F46
106	111	E15522	480		
116	121	E15147	540		
126	131	E15148	540		
136	141	E15149	540		
146	151	E15150	580	E15206-F46	E16771-F46
156	161	E15151	580		
166	171	E15152	580		
176	181	E15153	640		
186	191	E15154	640		
196	201	E15155	640	E15223-F46	E16772-F46
206	211	E15156	720		
216	221	E15157	720		
226	231	E15158	720		
236	241	E15159	760		
246	251	E15160	760	E15224-F46	E16773-F46
256	261	E15161	760		
266	271	E15162	790		
276	281	E15163	790		
286	291	E15164	790		
296	301	E15165	810	E15225-F46	E16774-F46
306	311	E15166	810		
316	321	E15167	810		
326	331	E15168	840		
336	341	E15169	840		
346	351	E15170	840	E15226-F46	E16775-F46
356	361	E15171	880		
366	371	E15172	880		
376	381	E15173	880		



Suffix Suffisso	Description Descrizione
.. - JG	Grounded thermocouple with J type calibration Termocoppia ugello a massa tipo J
.. - JU	Insulated thermocouple with J type calibration Termocoppia ugello isolata tipo J

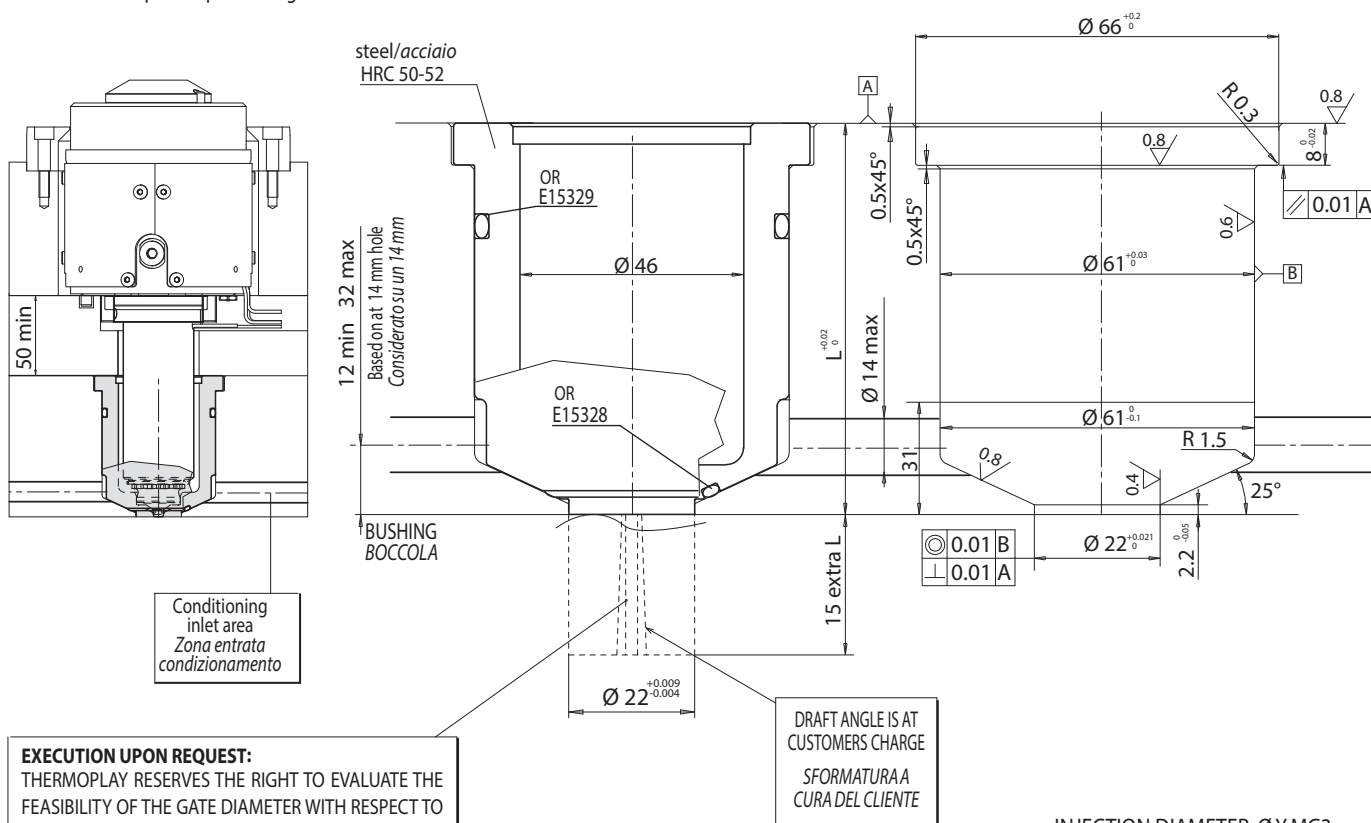
HEATER / RESISTENZA	
White / Red-White Bianco / Rosso-Bianco	230 V
THERMOCOUPLE TERMOCOPPIA	
Red / Rosso	TC+
Blue / Blu	TC-

Description / Descrizione	Code / Codice
Stop thermocouple ring Anello ferma termocoppia	E18746



• COOLING BUSHING / BOCCOLA CONDIZIONATA

Execution upon request / Eseguita su richiesta



EXECUTION UPON REQUEST:

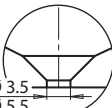
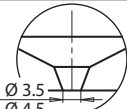
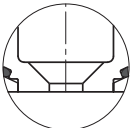
THERMOPLAY RESERVES THE RIGHT TO EVALUATE THE FEASIBILITY OF THE GATE DIAMETER WITH RESPECT TO THE EXTRA LENGTH.

ESECUZIONE SU RICHIESTA:

THERMOPLAY SI RISERVA IN FASE D'ORDINE DI VALUTARE LA FATTIBILITÀ DEL DIAMETRO DEL FORO RISPETTO ALL' ALTEZZA DELL'EXTRALUNGHEZZA

INJECTION DIAMETER Ø Y MG3 DIAMETRO DI INIEZIONE Ø Y MG3

Suffix Suffisso	CYLINDRIC CILINDRICO	CONIC CONICO
35	3.5	3.5
36	3.6	3.6
37	3.7	3.7
38	3.8	3.8
39	3.9	3.9
40	4.0	4.0
41	4.1	4.1
42	4.2	4.2
43	4.3	4.3
44	4.4	4.4
45	4.5	4.5
46	4.6	--
47	4.7	--
48	4.8	--
49	4.9	--
50	5.0	--
51	5.1	--
52	5.2	--
53	5.3	--
54	5.4	--
55	5.5	--

	Type Tipo	Code/suffix Codice/suffisso	L	Type Tipo	Code/suffix Codice/suffisso	L+ExtraL
3	CYLINDRIC CILINDRICO	E15533/ØY	76		E15535/ØY	76+15
		E15276/ØY	86		E15277/ØY	86+15
	CONIC CONICO	E15534/ØY	76		E15536/ØY	76+15
		E15278/ØY	86		E15279/ØY	86+15
3D		E15610	76		--	--
		E15284	86			

Ordering code example:

E15533/40 = Cooling bushing for nozzles type 3 total length (L) 76 mm, without extra length and with cylindric injection hole 4.0 mm.

Esempio ordine:

E15533/40 = Boccia porta ugello condizionata per ugello tipo 3 chiusura cilindrica lunghezza totale L=76 mm senza extralunghezza e con foro di iniezione 4.0 mm.

Spacers are not provided with cooling bushes.
Available lengths are 76 and 86 as mentioned above.
Le boccole portaugello condizionate sono prive di distanziali e vengono fornite alle lunghezze 76 e 86 mm.