

Multi-Gate Nozzle Axial Gating

Gate Options

- Two Gates (2A)
- Three Gates (3A)
- Four Gates (4A)

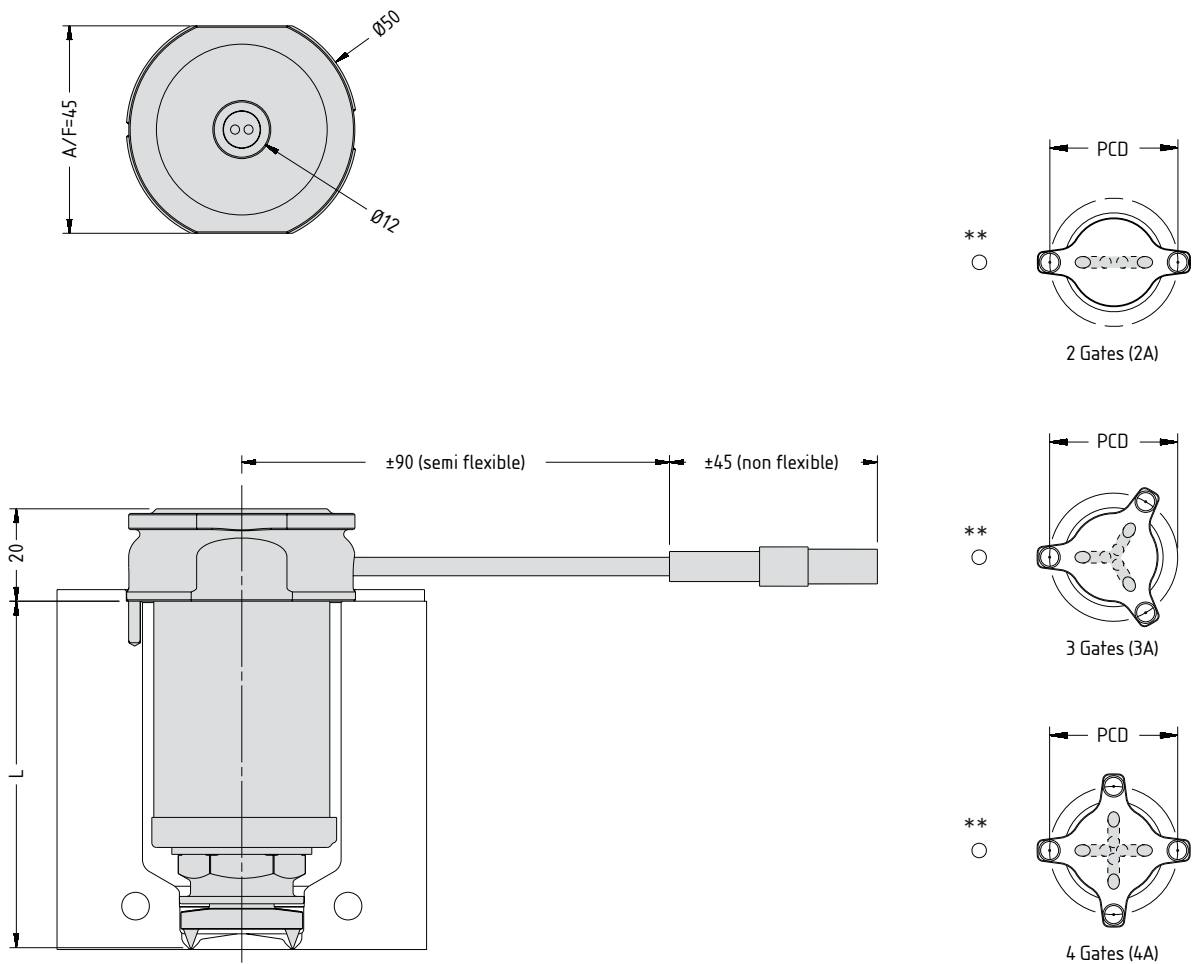
To order a nozzle assembly, provide the Nozzle Range, Number of Gates + Tip Style, Nozzle Series, Nozzle Length, Tip Grade, Nut Grade + PCD

Order example:

Nozzle Range	Number of Gates	+ Tip Styles	Nozzle Series	Nozzle Length	Tip Grade	Nut Grade + PCD*
BM	2A		27	095	G1	H1

*PCD range 10-22

Nozzle Dimensions



Note

** Indicates dowel position relative to tip.

Gate Options

- Two Gates (2A)
- Three Gates (3A)
- Four Gates (4A)

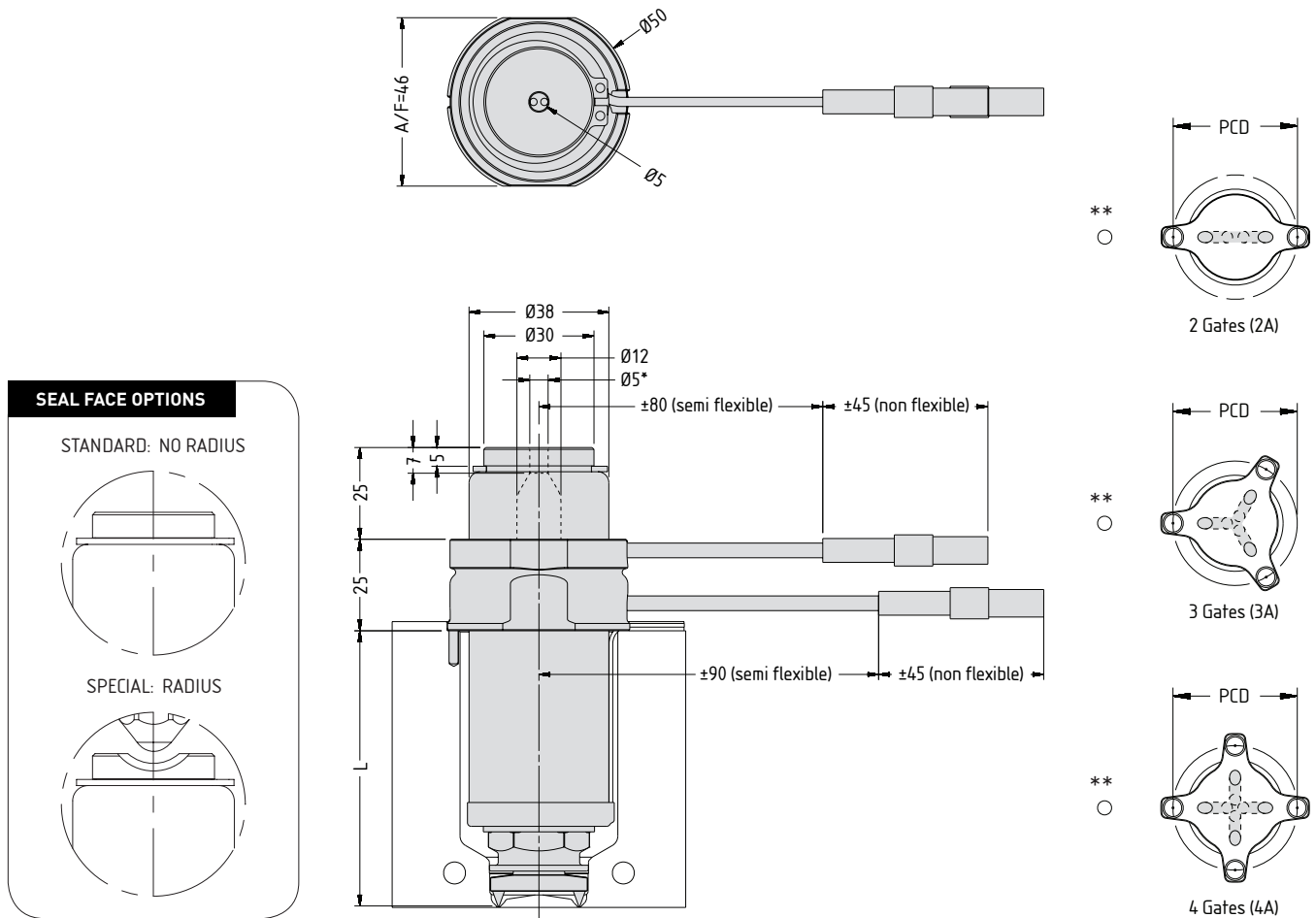
To order a nozzle assembly, provide the Nozzle Range, Number of Gates + Tip Style, Nozzle Series, Nozzle Length, Tip Grade, Nut Grade + PCD

Order example:

Nozzle Range	Number of Gates	Tip Styles	Nozzle Series	Nozzle Length	Tip Grade	Nut Grade + PCD*
SM	2A		27	095	G1	H1

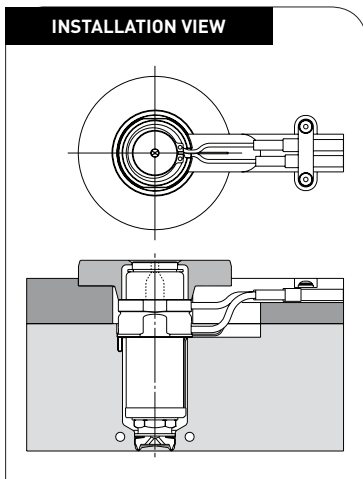
*PCD range 10-22

Nozzle Dimensions



Note

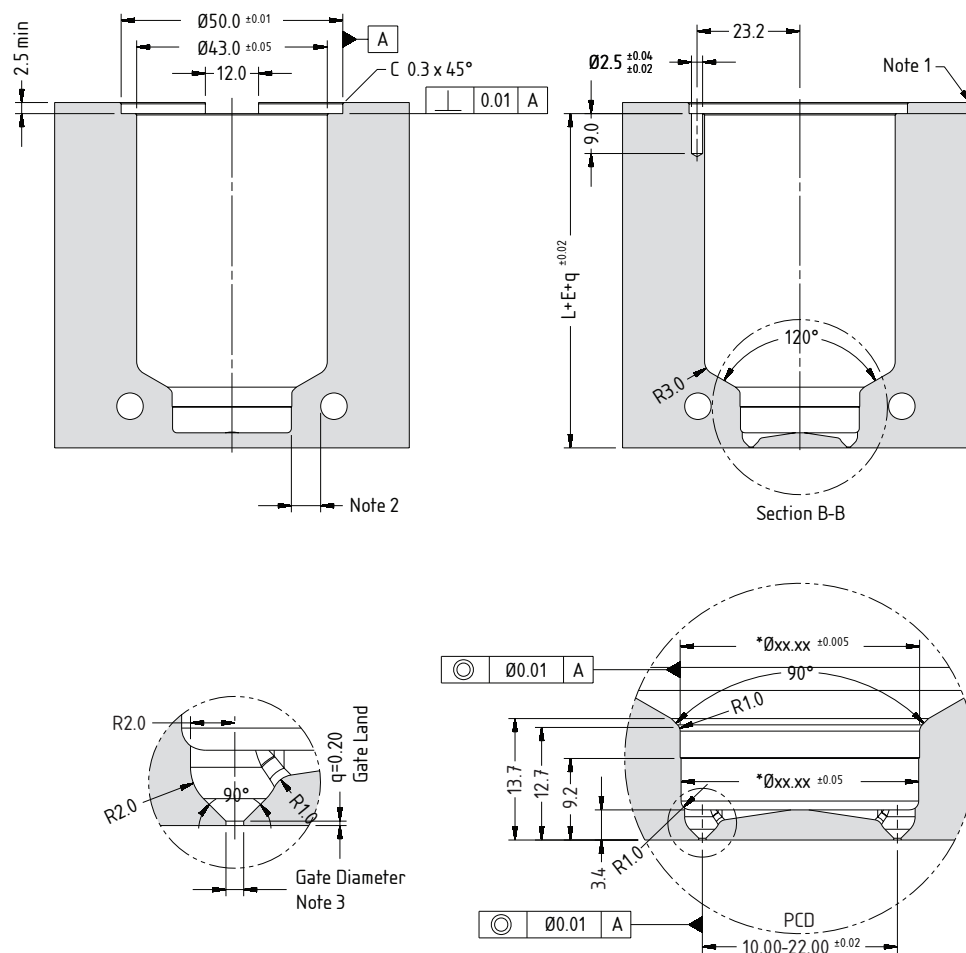
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.
- ** Indicates dowel position relative to tip.



Nozzle Code 2 Gates	Nozzle Gates 3 Gates	Nozzle Gates 4 Gates	L	$E\Delta T$ =200°C
SM2A27075G1H1	SM3A27075G1H1	SM4A27075G1H1	75	0.20
SM2A27095G1H1	SM3A27095G1H1	SM4A27095G1H1	95	0.25
SM2A27115G1H1	SM3A27115G1H1	SM4A27115G1H1	115	0.30
SM2A27145G1H1	SM3A27145G1H1	SM4A27145G1H1	145	0.38
SM2A27175G1H1	SM3A27175G1H1	SM4A27175G1H1	175	0.46
SM2A27225G1H1	SM3A27225G1H1	SM4A27225G1H1	225	0.59
SM2A27275G1H1	SM3A27275G1H1	SM4A27275G1H1	275	0.73

Nozzle Fitment and Gate Dimensions

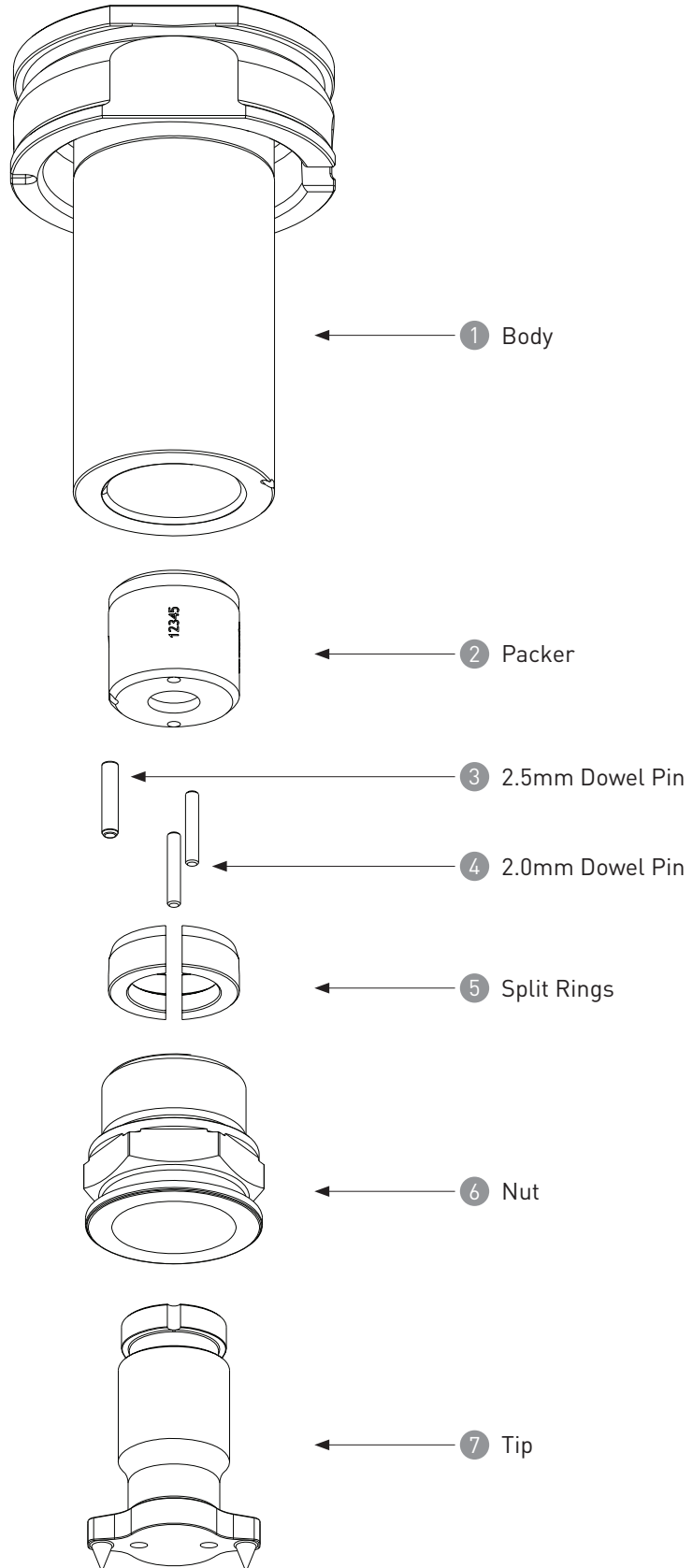
$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

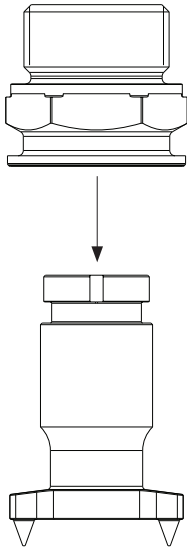
- Wire channel to suit mould.
 - Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 - Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ) of nozzle plate 800MPa.
 - * Ø xx.xx dimensions will be supplied on order with approval drawing.

Exploded Diagram



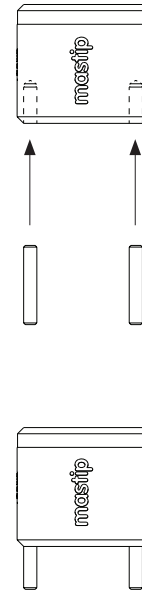
Installation

ONE



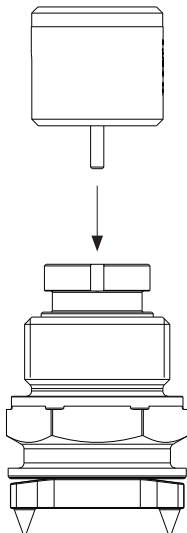
Place a small amount of supplied heat resistant nickel based anti-seize grease on the thread of the **Nut** ⑥. Fit the **Nut** ⑥ over the **Tip** ⑦.

TWO



Insert the 2 x 2.0mm **Dowel Pins** ④ into the **Packer** ②.

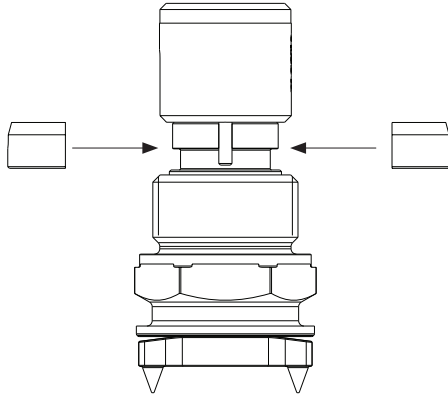
THREE



Fit the assembled **Packer** ② and 2.0mm **Dowel Pins** ④ into the slots in the **Tip** ⑦. Ensure the 2.0mm **Dowel Pins** ④ are not preventing the **Packer** ② from making contact with the **Tip** ⑦.

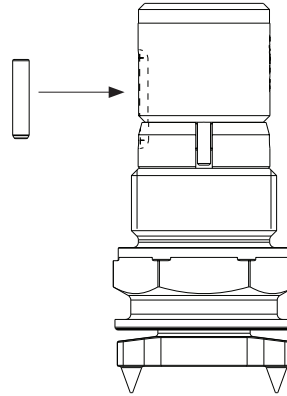
INSTALLATION CONT.....

FOUR



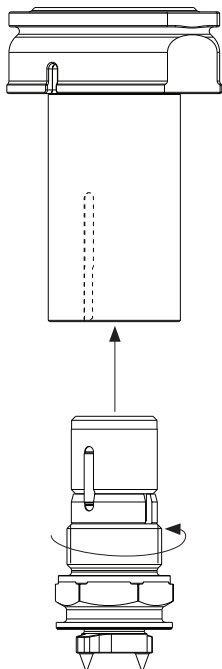
Fit the 2 x **Split Rings** ⑤ into the groove in the **Tip** ⑦ thereby retaining the **Nut** ⑥.

FIVE



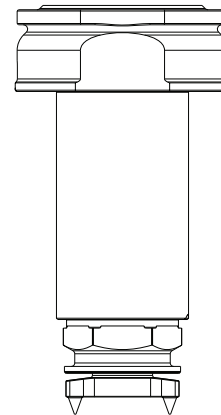
Fit the 2.5mm **Dowel Pin** ③ into the **Packer** ② and **Split Rings** ⑤.

SIX



Align the 2.5mm **Dowel Pin** ③ with the slot in the **Body** ① and insert until the thread of the **Nut** ⑥ comes into contact with the **Body** ①. Screw the **Nut** ⑥ into the **Body** ① Tighten the **Nut** ⑥ to a torque setting of 30Nm.

SEVEN



Multi-Gate Nozzle Assembly complete. Complete Heater and Thermocouple assembly, see Technical Specifications Guide.



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