CANALI ISOLATI

INSULATED RUNNERS

COMAT srl

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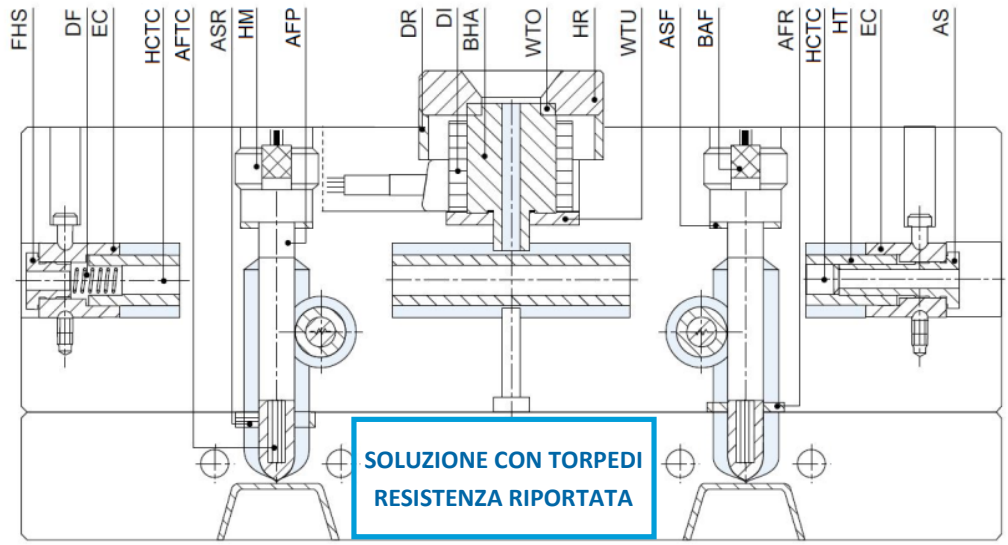
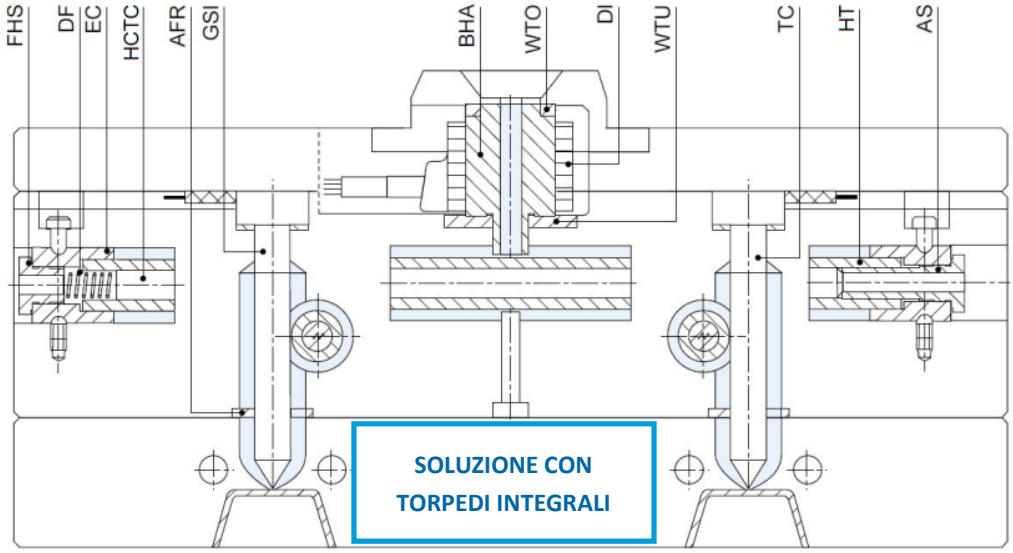
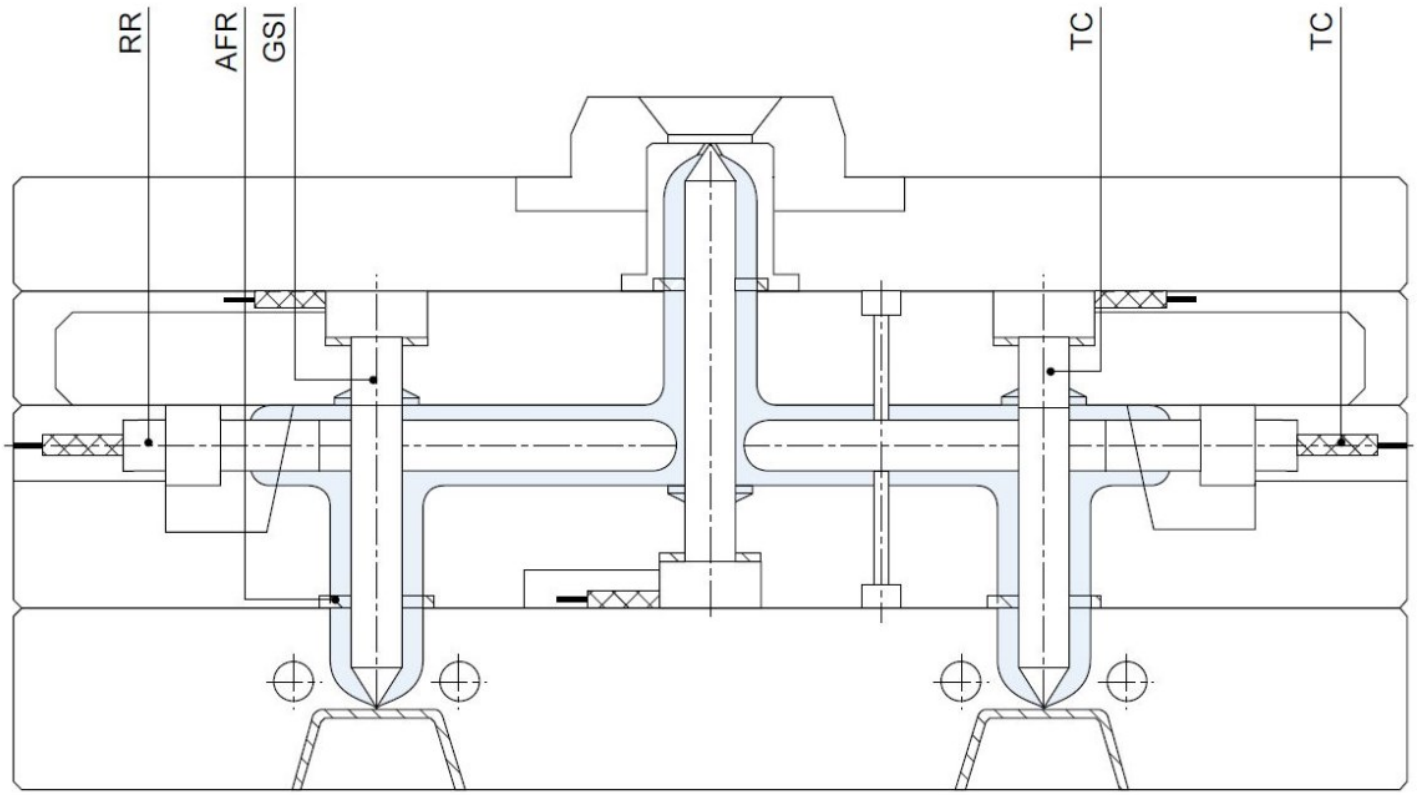




Il canale isolato chiuso è un sistema integrato di alta affidabilità per lo stampaggio senza materozza.
La tecnologia alla base del “sistema chiuso” sfrutta le caratteristiche isolanti del materiale plastico che viene riscaldato sempre dal suo interno lungo tutto il sistema di distribuzione dall’ugello della pressa ai gates.
La conseguenza logica di questa tecnologia è la possibilità di mantenere tutte le parti dello stampo alla temperatura ottimale richiesta per il raffreddamento dei pezzi da stampare.
In questo modo si eliminano i ben noti problemi di accoppiamento fra parte mobile e parte fissa dello stampo.
La standardizzazione dei componenti rende modulare il sistema e consente di posizionare le iniezioni esattamente dove è necessario.
Possibilità di avere i componenti di iniezione e di portata materiale plastico con resistenze separate o con resistenze integrali.
La prima soluzione favorisce la sostituzione di esse in caso di rottura, la seconda favorisce il profilo termico più costante .

The closed insulated runners is an integrated system high reliability for molding without cold runners.
The technology behind the "closed system" exploits the insulating properties of the plastic material that is always heated from inside throughout the distribution system from the injection machine nozzle to the gate.
The logical consequence of this technology is the possibility to keep all mold parts at the optimal temperature required for cooling the pieces to be moulding.
In this way the most known problems of coupling between the moving part and the fixed part of the mold are eliminated.
The standardization of the components makes the system modular and allows to position the injections exactly where it is needed.
Possibility to have plastic injection and flow components with separate heaters or integral heaters.
The first solution favors replacement of them in case of breakage, the second favors the more constant thermal profile.



Il canale isolato aperto ha le medesime caratteristiche tecniche del precedente ma grazie al suo differente “montaggio” nello stampo viene utilizzato nelle applicazioni in cui viene richiesta la possibilità di effettuare una pulizia totale del sistema dal materiale plastico.

The open insulated runners is has the same technical features as the previous one, but thanks to its different "assembly" in the mold it is used in applications where the possibility of performing a total cleaning of the system from the plastic material is requested.

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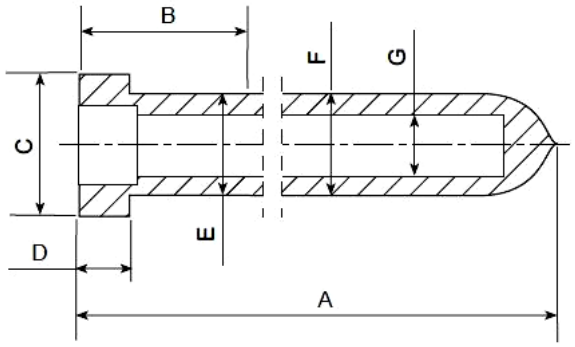
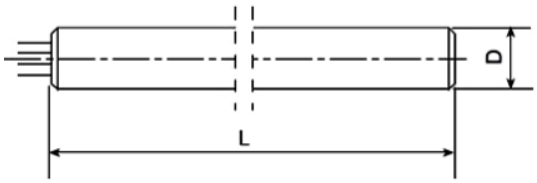
AFP—AFTC

TORPEDO / *PROBE*

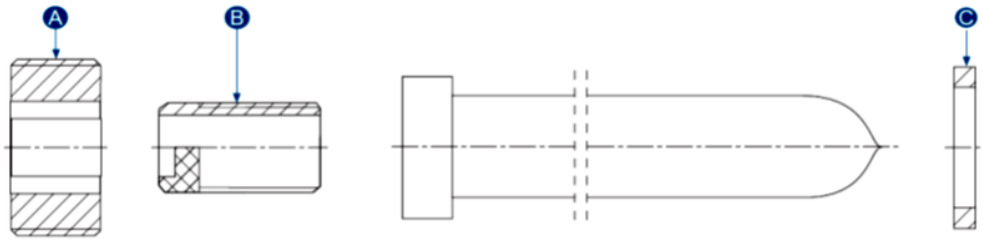


Cod/Ref	Serie	A	B	ØC	ØD	ØE	ØF	ØG
AFP201N	03	65	20	18	7	14,0	13,5	8,00
AFP251N	03	80	20	18	7	14,0	13,5	8,00
AFP271N	03	100	20	18	7	14,0	13,5	8,00
AFP291N	03	125	20	18	7	14,0	13,5	8,00
AFP301N	04	83	25	22	9	15,9	15,5	9,52
AFP401N	04	100	25	22	9	15,9	15,5	9,52
AFP501N	04	127	25	22	9	15,9	15,5	9,52
AFP601N	04	152	25	22	9	15,9	15,5	9,52
AFP502N	05	127	35	28	12	22,0	21,5	12,50
AFP602N	05	152	35	28	12	22,0	21,5	12,50
AFP702N	05	180	35	28	12	22,0	21,5	12,50
AFP802N	05	210	35	28	12	22,0	21,5	12,50
AFP902N	05	260	35	28	12	22,0	21,5	12,50
AFP1002N	05	332	35	28	12	22,0	21,5	12,50
AFP1102N	05	382	35	28	12	22,0	21,5	12,50

RESISTENZA / *HEATER*



Cod/Ref	Serie	ØD	L
AFTC0825E	03	8,00	50
AFTC0826E	03	8,00	65
AFTC0827E	03	8,00	85
AFTC0828E	03	8,00	110
AFTC302-2E	04	9,52	66
AFTC303-2E	04	9,52	83
AFTC304-2E	04	9,52	110
AFTC305-2E	04	9,52	136
AFTC1210-E	05	12,50	104
AFTC1212E	05	12,50	130
AFTC1215E	05	12,50	162
AFTC1218E	05	12,50	190
AFTC1223E	05	12,50	242
AFTC1230E	05	12,50	312
AFTC1236E	05	12,50	362



Questi componenti (A-B-C) sono venduti insieme al TORPEDO /
These components (A-B-C) are sold together with the PROBE

Cod/Ref	Serie
HM22	03
HM27	04
HM32X1,5	05

A

Cod/Ref	Serie
BAF10	03
BAF12	04
BAF16	05

B

Codice/Ref	Serie
ASF3	03
ASF4	04
ASF5	05

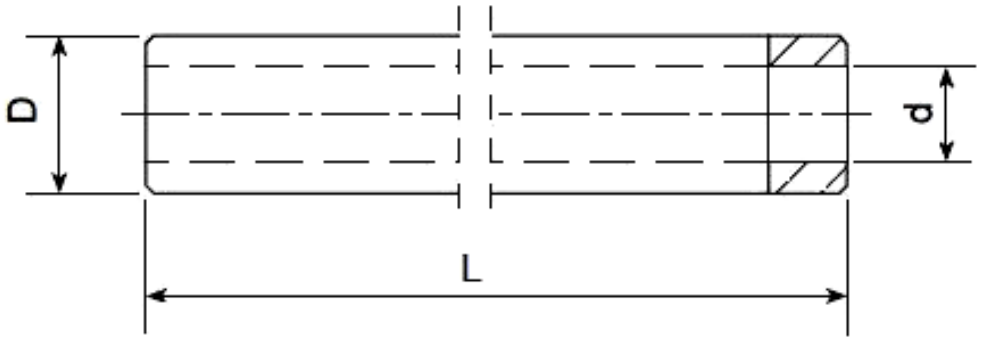
C

Alimentazione 230v.
Lunghezza cavi 850mm
Termocoppia tipo J filo bianco (+) filo rosso (-)

Power supply 230v.
Cable length 850mm
Thermocouple type J white wire (+) red wire(-)

P.3/22/23

HT



Cod/Ref	Serie	ØD	Ød	L
HT-03-40N	03	16	9,52	400
HT-03-50N	03	16	9,52	500
HT-03-60N	03	16	9,52	600
HT-04-40N	04	22,22	12,70	400
HT-04-60N	04	22,22	12,7	600
HT-04-90N	04	22,22	12,70	900
HT-05-30N	05	41,27	15,87	300
HT-05-40N	05	41,27	15,87	400
HT-05-50N	05	41,27	15,87	500
HT-05-60N	05	41,27	15,87	600
HT-05-80N	05	41,27	15,87	800
HT-05-120N	05	41,27	15,87	1200

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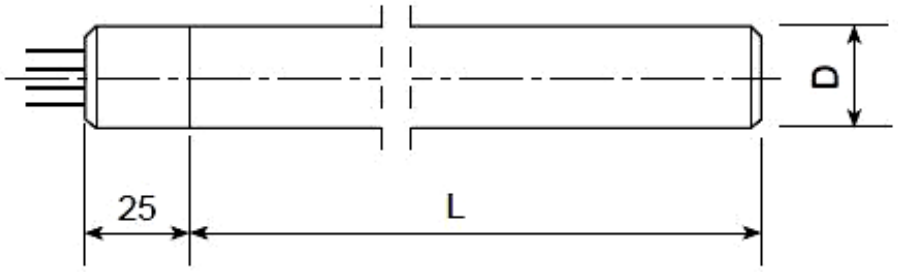
HCTC



Cod/Ref	Serie	ØD	L
HCTC-03-4E	03	9,52	102
HCTC-03-45E	03	9,52	115
HCTC-03-5E	03	9,52	127
HCTC-03-55E	03	9,52	140
HCTC-03-6E	03	9,52	152
HCTC-03-65E	03	9,52	166
HCTC-03-7E	03	9,52	178
HCTC-03-8E	03	9,52	203
HCTC-03-9E	03	9,52	229
HCTC-03-10E	03	9,52	254
HCTC-03-11E	03	9,52	279
HCTC-03-12E	03	9,52	305
HCTC-03-13E	03	9,52	330
HCTC-03-14E	03	9,52	356
HCTC-03-15E	03	9,52	381
HCTC-03-16E	03	9,52	406
HCTC-03-17E	03	9,52	432
HCTC-03-18E	03	9,52	457

Cod/Ref	Serie	ØD	L
HCTC-04-5E	04	12,70	127
HCTC-04-6E	04	12,70	152
HCTC-04-7E	04	12,70	178
HCTC-04-8E	04	12,70	203
HCTC-04-9E	04	12,70	229
HCTC-04-10E	04	12,70	254
HCTC-04-11E	04	12,70	279
HCTC-04-12E	04	12,70	305
HCTC-04-13E	04	12,70	330
HCTC-04-14E	04	12,70	356
HCTC-04-15E	04	12,70	381
HCTC-04-16E	04	12,70	406
HCTC-04-17E	04	12,70	432
HCTC-04-18E	04	12,70	457
HCTC-04-19E	04	12,70	483
HCTC-04-20E	04	12,70	508
HCTC-04-21E	04	12,70	533
HCTC-04-22E	04	12,70	559
HCTC-04-23E	04	12,70	584
HCTC-04-24E	04	12,70	610
HCTC-04-25E	04	12,70	635
HCTC-04-26E	04	12,70	660
HCTC-04-27E	04	12,70	686
HCTC-04-28E	04	12,70	711
HCTC-04-29E	04	12,70	737
HCTC-04-30E	04	12,70	762
HCTC-04-31E	04	12,70	787
HCTC-04-32E	04	12,70	839

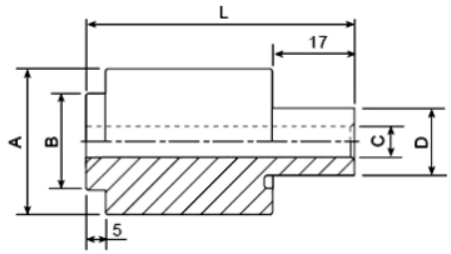
Cod/Ref	Serie	ØD	L
HCTC-05-6E	05	15,87	152
HCTC-05-7E	05	15,87	178
HCTC-05-8E	05	15,87	203
HCTC-05-9E	05	15,87	229
HCTC-05-10E	05	15,87	254
HCTC-05-11E	05	15,87	279
HCTC-05-12E	05	15,87	305
HCTC-05-13E	05	15,87	330
HCTC-05-14E	05	15,87	356
HCTC-05-15E	05	15,87	381
HCTC-05-16E	05	15,87	406
HCTC-05-17E	05	15,87	432
HCTC-05-18E	05	15,87	457
HCTC-05-19E	05	15,87	483
HCTC-05-20E	05	15,87	508
HCTC-05-21E	05	15,87	533
HCTC-05-22E	05	15,87	559
HCTC-05-23E	05	15,87	584
HCTC-05-24E	05	15,87	610
HCTC-05-25E	05	15,87	635
HCTC-05-26E	05	15,87	660
HCTC-05-27E	05	15,87	686
HCTC-05-28E	05	15,87	711
HCTC-05-29E	05	15,87	737
HCTC-05-30E	05	15,87	762
HCTC-05-31E	05	15,87	787
HCTC-05-32E	05	15,87	813
HCTC-05-33E	05	15,87	838
HCTC-05-34E	05	15,87	864
HCTC-05-35E	05	15,87	889
HCTC-05-36E	05	15,87	914
HCTC-05-37E	05	15,87	940
HCTC-05-38E	05	15,87	965
HCTC-05-39E	05	15,87	991
HCTC-05-40E	05	15,87	1016
HCTC-05-41E	05	15,87	1041
HCTC-05-42E	05	15,87	1067
HCTC-05-43E	05	15,87	1092
HCTC-05-44E	05	15,87	1118
HCTC-05-45E	05	15,87	1143

Alimentazione 230v.
Lunghezza cavi 850mm
Termocoppia tipo J filo bianco (+) filo rosso (-)

Power supply 230v.
Cable length 850mm
Thermocouple type J white wire (+) red wire(-)

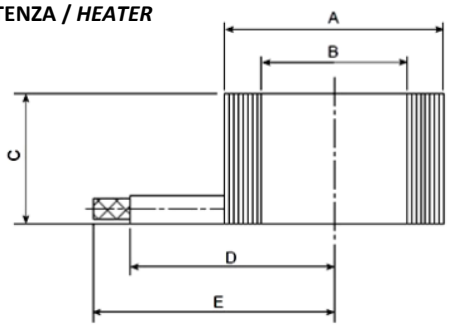
BHA-DI-WTO-WTU-DR-HR

BHA BUSSOLA / *EXT. NOZZLE*



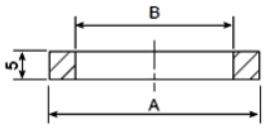
Cod/Ref	ØA	ØB	ØC	ØD	L
BHA3030N	30	20	6	14	55
BHA4030N	40	30	8	16	55
BHA4040N	40	30	8	16	65

DI RESISTENZA / *HEATER*



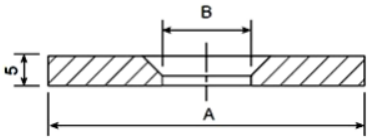
Cod/Ref	ØA	ØB	C	D	E
DI30x30	45	30	30	35	50
DI40x30	55	40	30	40	55
DI40x40	55	40	40	40	5

WTO ANELLO ISOLANTE / *INSULATED RING*



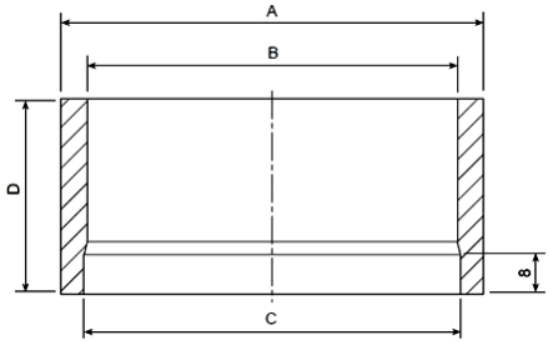
Cod/Ref	ØA	ØB
WTO30	30	20
WTO40	40	30

WTU ANELLO ISOLANTE / *INSULATED RING*



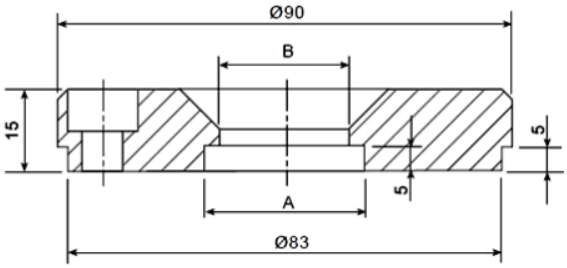
Cod/Ref	ØA	ØB
WTU50	50	14
WTU60	60	16

DR DISTANZIALE / *SUPPORT*



Cod/Ref	ØA	ØB	ØC	D
DR40	90	81	83	30
DR90	90	81	83	60

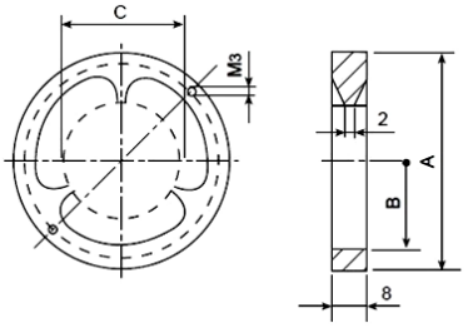
HR ANELLO DI CENTRAGGIO / *CENTER RING*



Cod/Ref	ØA	ØB
HR30	30	20
HR40	40	30

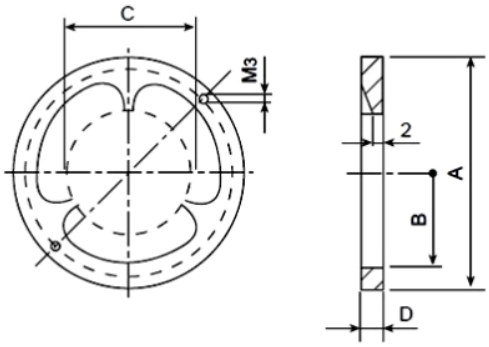
ASR-AFR

ASR GHIERE DI CENTRAGGIO / *CENTERING RING*



Cod/Ref	Serie	ØA	ØB	ØC
ASR14	03	31	23	13,5
ASR16	04	34	26	15,5
ASR22	05	40	32	21,5

AFR GHIERE DI CENTRAGGIO / *CENTERING RING*



Cod/Ref	Serie	ØA	ØB	ØC	D
AFR3114	03	31	23	13,5	3
AFR3414	04	34	26	13,5	3
AFR3416	04	34	26	15,5	3
AFR4016	05	40	32	15,5	3
AFR4022	05	40	32	21,5	3
AFR394	394	31	22	10,0	4
AFR500	500	32	24	12,7	4
AFR625	625	36	28	15,9	4
AFR750	750	40	32	19,0	4

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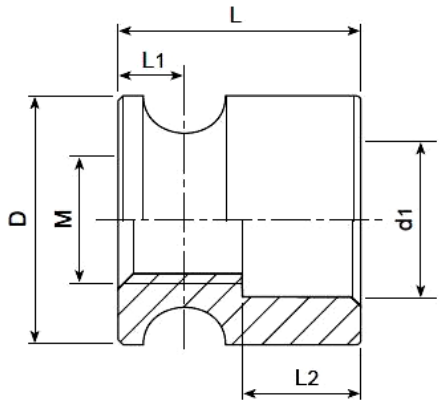
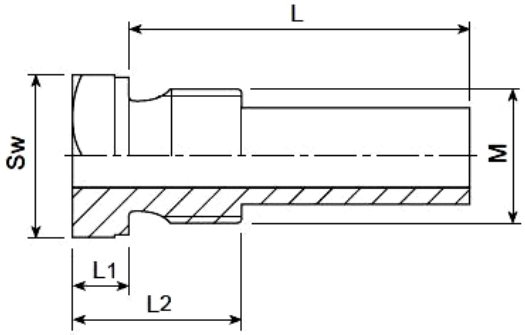
EC-AS-FHS-DF

EC TAPPO / *PLUG*



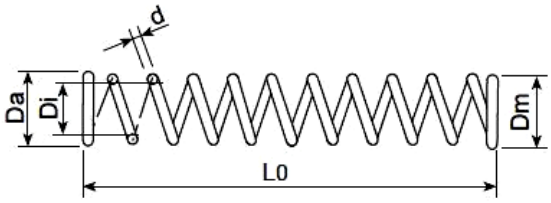
Cod/Ref	Serie	ØD	Ød1	L	L1	L2	M
EC03N	03	26	16,00	25	7	12	12
EC04N	04	32	22,22	38	10	18	16
EC06N	04	38	22,22	38	10	18	16
EC05N	05	50	41,27	38	10	18	20
EC07N	05	56	41,27	38	10	18	20

AS VITE DISTANZIATRICE / *SPACER SCREW*



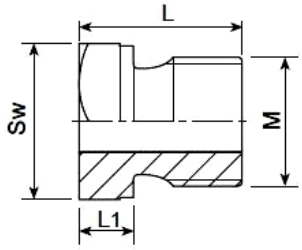
Cod/Ref	Serie	L	L1	L2	M	Sw
AS12N	03	35	7,5	17	12	17
AS16N	04	50	7,5	20	16	19
AS20N	05	50	8	23	20	24

DF MOLLA / *SPRING*



Cod/Ref	Serie	ØDa	L0	ØDi	ØDm	Ød
DF09x30	03	9	30	7,4	8,2	0,8
DF12x55	04	12	55	9	10,5	1,5
DF15x55	05	15	55	12	13,5	1,5

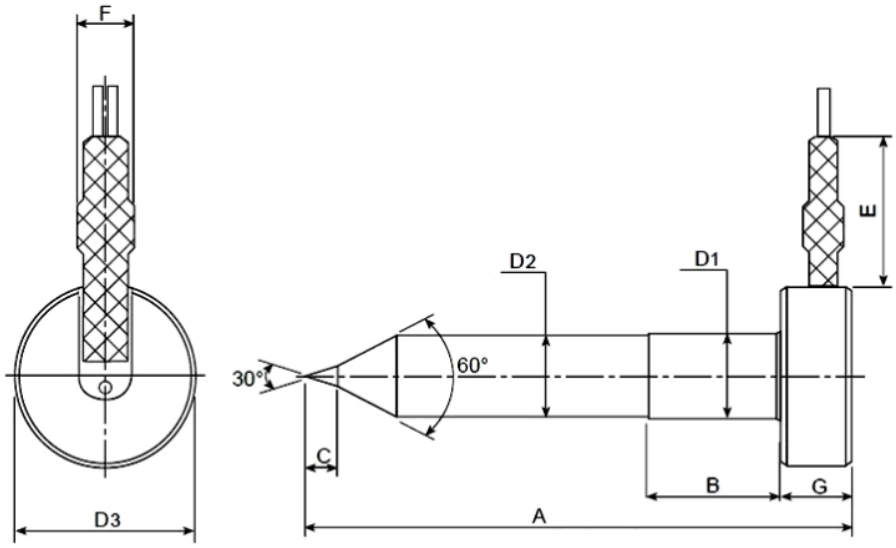
FHS GHIERA / *RING*

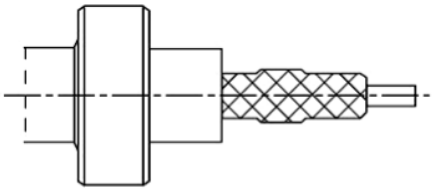


Cod/Ref	Serie	L	L1	M	Sw
FHS12	03	17	7,5	12	17
FHS16	04	20	7,5	16	19
FHS20	05	23	8	20	24

GDI / GDH

Materiale / *Material* **H13**
Durezza / *Hardened* **HRC 52-56**





Uscita fili a 0° su richiesta /
Exit wires to 0° on request

Cod/Ref	B	C	ØD1	ØD2	ØD3	E	F	G	A disponibili / *available*
GDI/GDH - 394	15,9	4,7	10,02	9,75	18,8	25,0	10	12,7	from 3.22 to 8.72
GDI/GDH - 500	15,9	4,7	12,70	12,45	22,0	25,0	10	12,7	from 3.22 to 10.72
GDI/GDH - 625	22,2	4,7	15,87	15,62	31,5	25,0	10	12,7	from 3.22 to 13.22
GDI/GDH - 750	22,2	4,7	19,05	18,80	31,5	25,0	10	12,7	from 3.22 to 13.72

Lunghezza **"A"** in pollici
***"A"** lenght in inc*

	3.22	3.72	4.22	4.72	5.22	5.72
6.22	6.72	7.22	7.72	8.22	8.72	9.22
9.72	10.22	10.72	11.22	11.72	12.22	12.72
13.22	13.72					

Alimentazione 240v.
Lunghezza cavi 2000mm
Torpedo fornito senza termocoppia
Per applicazioni su camere calde usare la sigla GDH

Esempio ordine : **GDI039400322**
GDH039400322

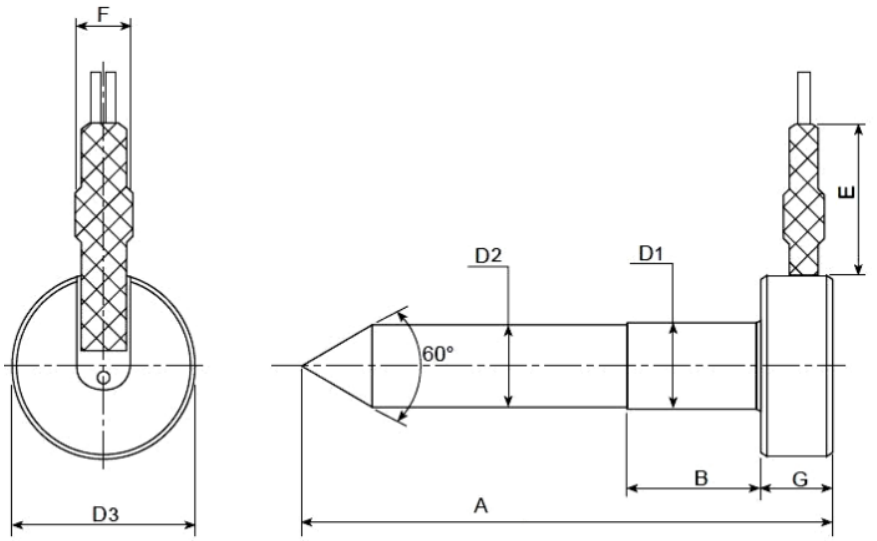
Power supply 240v.
Cable length 2000mm
Probe supplied without thermocouple
For applications on hot channel use the abbreviation GDH

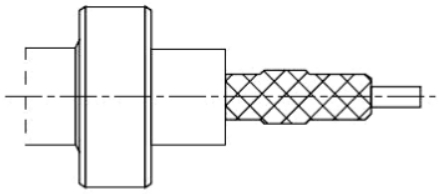
Order example : ***GDI039400322***
GDH039400322

P.4/22/23

GSI / GSH

Materiale / *Material* **H13**
Durezza / *Hardened* **HRC 52-56**





Uscita fili a 0° su richiesta /
Exit wires to 0° on request

Cod/Ref	B	ØD1	ØD2	ØD3	E	F	G	A disponibili / *available*
GSI/GSH - 394	15,9	10,02	9,75	18,8	25,0	10	12,7	from 3.22 to 10.72
GSI/GSH - 500	15,9	12,70	12,45	22,0	25,0	10	12,7	from 3.22 to 12.22
GSI/GSH - 625	22,2	15,87	15,62	31,5	25,0	10	12,7	from 3.22 to 14.22
GSI/GSH - 750	22,2	19,05	18,80	31,5	25,0	10	12,7	from 3.22 to 24.72

Lunghezza **"A"** in pollici
***"A"** lenght in inc*

	3.22	3.72	4.22	4.72	5.22	5.72
6.22	6.72	7.22	7.72	8.22	8.72	9.22
9.72	10.22	10.72	11.22	11.72	12.22	12.72
13.22	13.72	14.22	14.72	15.22	15.72	16.22
16.72	17.22	17.72	18.22	18.72	19.22	19.72
20.22	20.72	21.22	21.72	22.22	22.72	23.22
23.72	24.22	24.72				

Alimentazione 240v.
Lunghezza cavi 2000mm
Torpedo fornito senza termocoppia
Per applicazioni su camere calde usare la sigla GSH

Power supply 240v.
Cable length 2000mm
Probe supplied without thermocouple
For applications on hot channel use the abbreviation GSH

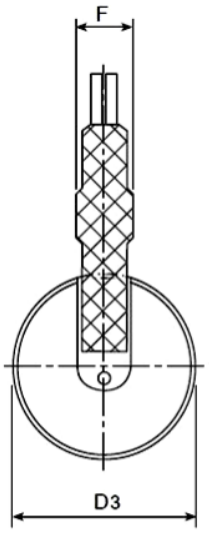
Esempio ordine : **GSI039400322**
GSH039400322

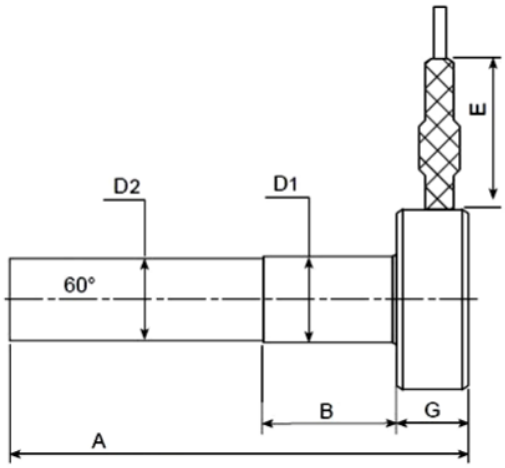
Order example : ***GSI039400322***
GSH039400322

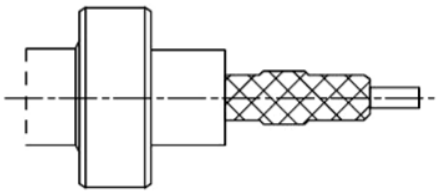
P.4/22/23

GTI / GTH

Materiale / *Material* **H13**
Durezza / *Hardened* **HRC 52-56**







Uscita fili a 0° su richiesta /
Exit wires to 0° on request

Cod/Ref	B	ØD1	ØD2	ØD3	E	F	G	A disponibili / *available*
GTI/GTH - 500	15,9	12,70	12,45	22,0	25,0	10	12,7	from 3.22 to 10.72
GTI/GTH - 625	22,2	15,87	15,62	31,5	25,0	10	12,7	from 3.22 to 13.22
GTI/GTH - 750	22,2	19,05	18,80	31,5	25,0	10	12,7	from 3.22 to 13.22
GTI/GTH - 1000	25,4	25,40	25,15	37,8	25,0	10	12,7	from 3.22 to 13.22

Lunghezza **"A"** in pollici
"A" *lenght in inc*

3.22	3.72	4.22	4.72	5.22	5.72	6.22
6.72	7.22	7.72	8.22	8.72	9.22	9.72
10.22	10.72	11.22	11.72	12.22	12.72	13.22

Alimentazione 240v.
Lunghezza cavi 2000mm
Torpedo fornito senza termocoppia
Per applicazioni su camere calde usare la sigla GTH

Esempio ordine : **GTI039400322**
GTH039400322

Power supply 240v.
Cable length 2000mm
Probe supplied without thermocouple
For applications on hot channel use the abbreviation GTH

Order example : ***GTI039400322***
GTH039400322

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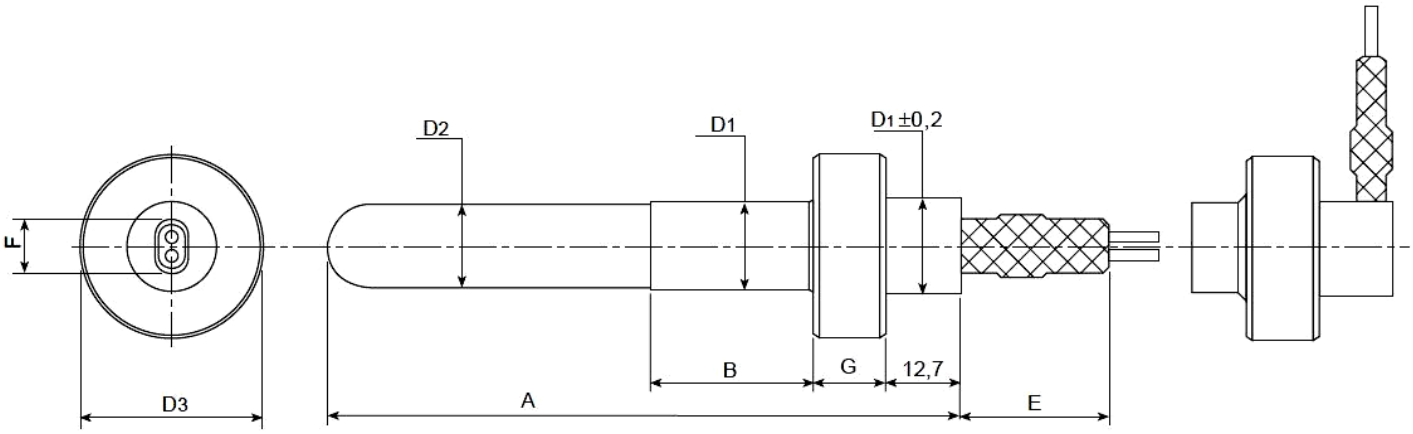
RR

Materiale / *Material* **H13**
Durezza / *Hardened* **HRC 52-56**



Uscita fili a 90° su richiesta /
Exit wires to 90° on request

Cod/Ref	B	ØD1	ØD2	ØD3	E	F	G	A disponibili / *available*
RR-394	19	10,02	9,75	18,8	25	10	12,7	from 4.00 to 17.50
RR-500	25,4	12,70	12,45	22,0	25	10	12,7	from 5.00 to 18.50
RR-625	28,6	15,87	15,62	31,5	25	10	12,7	from 5.00 to 28.00
RR-750	31,8	19,05	18,80	31,5	25	10	12,7	from 5.00 to 28.00
RR-1000	31,8	25,40	25,15	37,9	25	10	12,7	from 6.00 to 30.00

Lunghezza **"A"** in pollici
***"A"** length in inc*

4.00	4.50	5.00	5.50	6.00	6.50	7.00
7.50	8.00	8.50	9.00	9.50	10.00	10.50
11.00	11.50	12.00	12.50	13.00	13.50	14.00
14.50	15.00	15.50	16.00	16.50	17.00	17.50
18.00	18,50	19.00	19.50.	20.00	20.50	21.00
21.50	22.00	22.50	23.00	23.50	24.00	24.50
25.00	25.50	26.00	26.50	27.00	27.50	28.00
28.50	29.00	29.50	30.00			

Alimentazione 240v.
Lunghezza cavi 2000mm
Torpedo fornito senza termocoppia

Esempio ordine : **RR03940400**

Power supply 240v.
Cable length 2000mm
Probe supplied without thermocouple

Order example : ***RR03940400***

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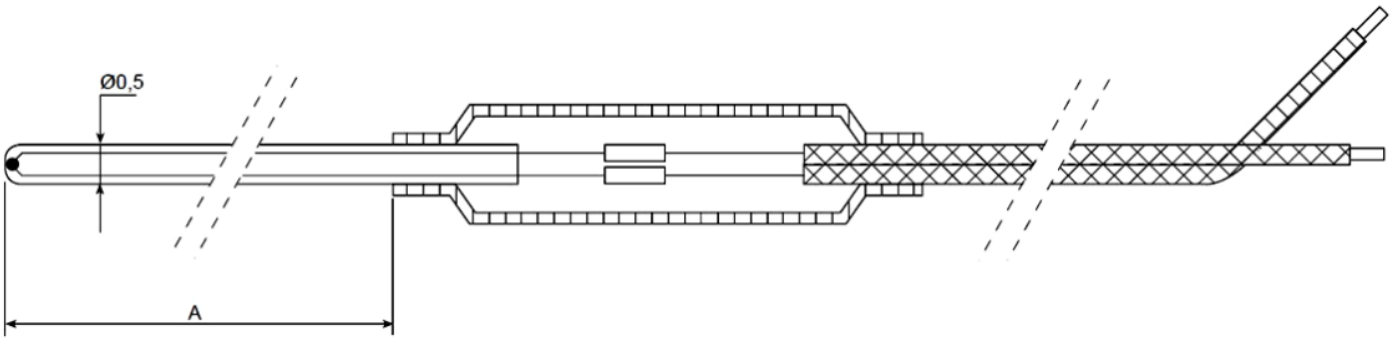
TC



Cod/Ref	A	Utilizzo / *Utilization*
WCTC	6''	Adatta per torpedo (GDI-GSI-GTI) con A≤ 5.22 e torpedo RR con A ≤ 5.00 *Suitable for probe (GDI-GSI-GTI) with A≤ 5.22 and probe RR con A ≤ 5.00*
THTC	12''	Adatta per torpedo (GDI-GSI-GTI) con A≤ 11.22 e torpedo RR con A ≤ 11.00 *Suitable for probe (GDI-GSI-GTI) with A≤ 11.22 and probe RR with A ≤ 11.00*
XLTC	24''	Adatta per torpedo (GDI-GSI-GTI) con A≤ 23.22 e torpedo RR con A ≤ 23.00 *Suitable for probe (GDI-GSI-GTI) with A≤ 23.22 and probe RR with A ≤ 23.00*
XXLTC	42''	Adatta per torpedo (GDI-GSI-GTI) con A≤ 41.22 e torpedo RR con A ≤ 41.00 *Suitable for probe (GDI-GSI-GTI) with A≤ 41.22 and probe RR con A ≤ 41.00*

Queste termocoppie sono progettate per essere utilizzate nei torpedi integrali.
Il giunto di transizione sopporta temperature sino a 250°c.
Termocoppia tipo J a massa.
Lunghezza cavi 2000mm con doppio isolamento in Teflon
Filo bianco (+)
Filo rosso (-)

These thermocouples are designed for use in the integral torpedoes.
The transition joint supports temperatures up to 250 ° c.
Type J thermocouple to ground.
Cable length= 2000mm with double Teflon insulation
White wire (+)
Red wire (-)

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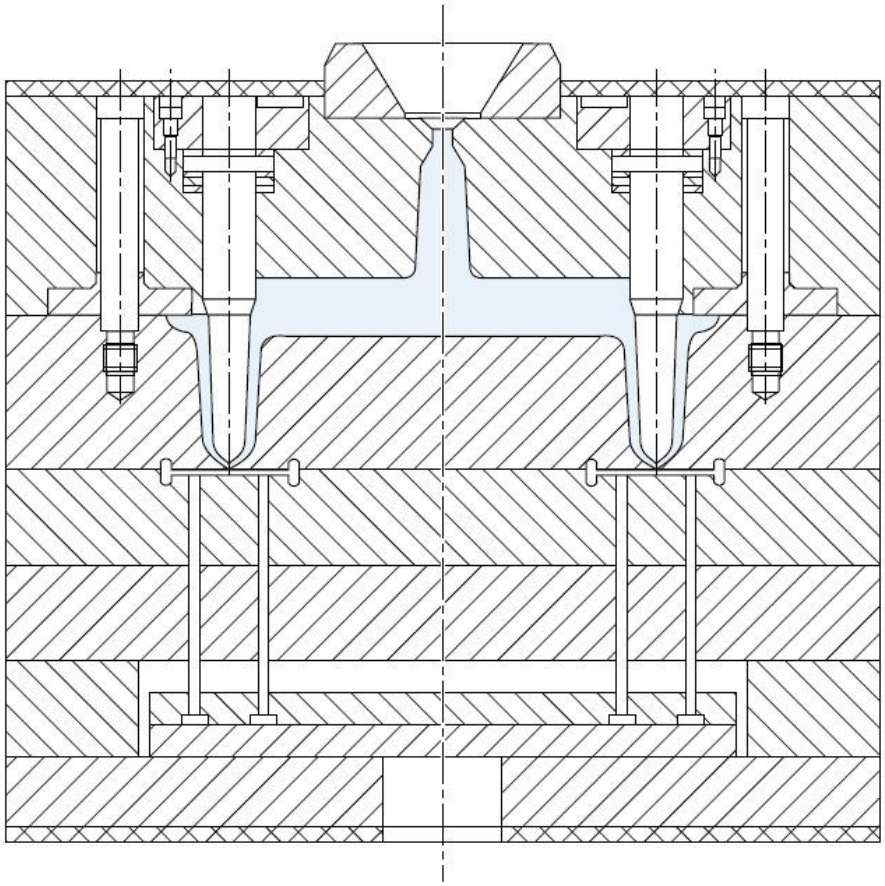


M.I.R. (Modified Insulated Runnerless)

Conosciuto anche con il none di “CANALE CANADESE”
Con l’utilizzo di plastiche termosensibili nella loro fase di trasformazione è stato necessario apportare sostanziali modifiche alla tecnologia di base del sistema canadese.
Il sistema MIR ha permesso di poter trasformare quelle resine termosensibili che con i piu familiari “canali caldi” creano difficoltà e/o ne diminuiscono le loro caratteristiche basilari.

VANTAGGI

- SEMPLICITA’ DI ESECUZIONE
- ASSENZA DI PUNTI DI RISTAGNO
- IL POLIMERO FUSO NON VIENE MAI IN CONTATTO CON L’ACCIAIO
- POSSIBILITA’ DI TRASFORMARE ANCHE IL PVC
- CAMBIO COLORE AL 100% IN POCHI MINUTI
- ESTRAZIONE AUTOMATICA DEL CANALE ISOLATO
- MASSIMA SICUREZZA IN CASO DI FERMATE IMPROVVISE
- PUO’ LAVORARE ANCHE CON IMPRONTE BLOCCATE
- GRAMMATURE PREVISTE DA 0.2GR A 1000GR
- USURA RIDOTTA
- CONSUMI ENERGETICI RIDOTTI
- FACILE ACCESSIBILITA’ AI COMPONENTI PER LA MANUTENZIONE ANCHE A STAMPO IN PRESSA
- BASSI COSTI DI MANUTENZIONE
- COSTI GENERALI BASSI

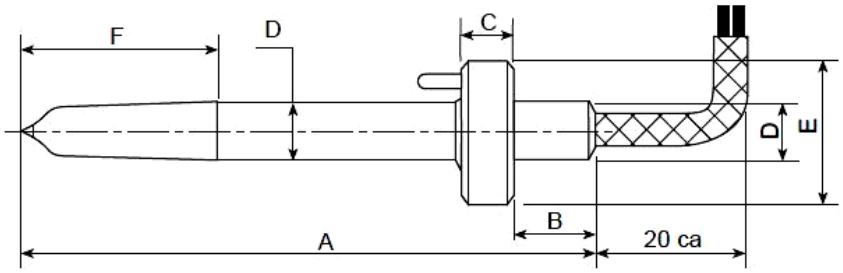
Known also as "CANADIAN CHANNEL"
With the use of thermosensitive plastics in their transformation phase it was necessary to make substantial changes to the basic technology of the Canadian system.
The MIR system has made it possible to transform those thermosensitive resins that with the more familiar "hot channels" create difficulties and / or decrease their basic characteristics.

ADVANTAGES

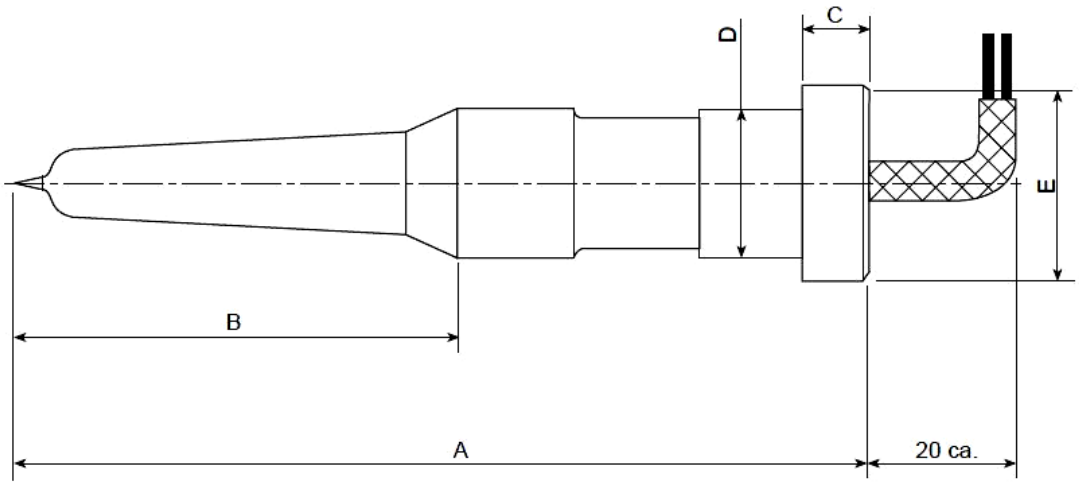
- *SIMPLICITY OF EXECUTION*
- *ABSENCE OF STAGNATION POINTS*
- *THE MELTED POLYMER NEVER COMES INTO CONTACT WITH STEEL*
- *POSSIBILITY TO TRANSFORM PVC*
- *100% COLOR CHANGE IN A FEW MINUTES*
- *AUTOMATIC EXTRATION OF THE INSULATED CHANNEL*
- *MAXIMUM SAFETY IN CASE OF IMPROVVISE STOPS*
- *CAN ALSO WORK WITH BLOCKED CAVITY*
- *EXPECTED WEIGHTS FROM 0.2GR TO 1000GR*
- *REDUCED WEAR*
- *REDUCED ENERGY CONSUMPTIONS*
- *EASY ACCESSIBILITY TO MAINTENANCE COMPONENTS ALSO WITH MOULD IN INJECTION MACHINE.*
- *LOW MAINTENANCE COSTS*
- *LOW GENERAL COSTS*

DU

Materiale acciaio D-2 titaniato
Material D-2 steel titanate.
Durezza / *Hardened* **HRC 55-58**



Cod/Ref	A	B	C	ØD^{g6}	ØE	F
DU200N	72,5	10,5	6	8	16	25
DU250N	87,5	10,5	6	8	16	40



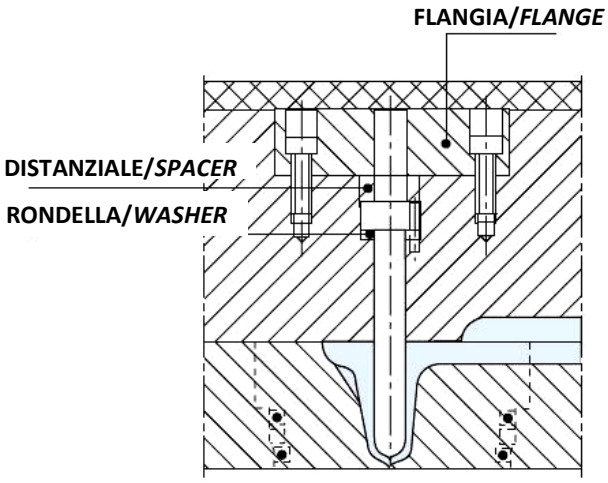
Cod/Ref	A	B	C	ØD^{g6}	ØE
DU085SN	114,5	60	9	20	35
DU100SN	144,5	90,0	9	20	35

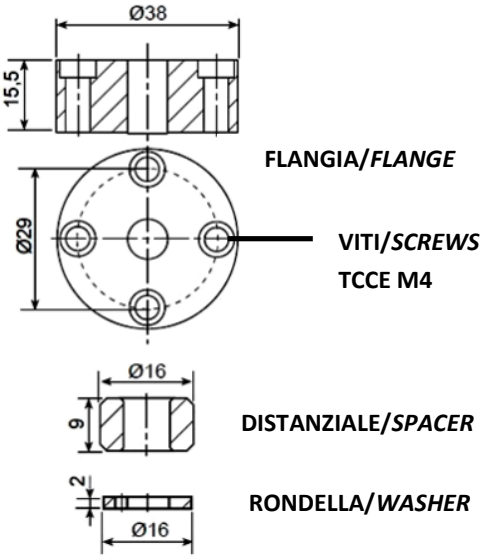
Alimentazione 220v.
Lunghezza cavi 2000mm
Torpedo fornito con termocoppia
TORPEDO DU 200/250 fornito con Diodo

Power supply 220v.
Cable length 2000mm
Probe supplied with thermocouple
TORPEDO DU 200/250 supplied with Diode

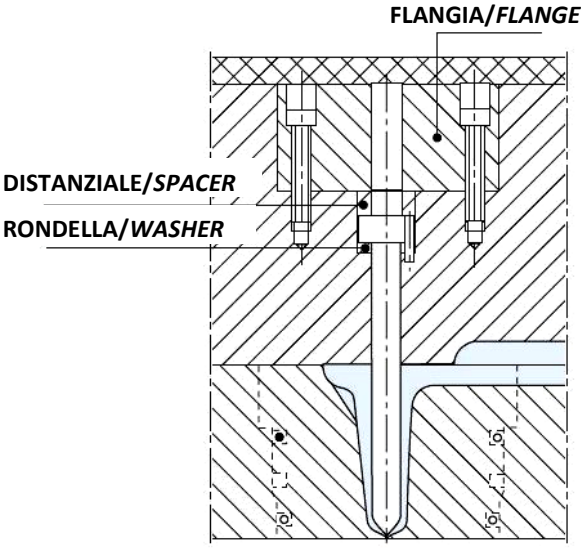
DU200-DU250

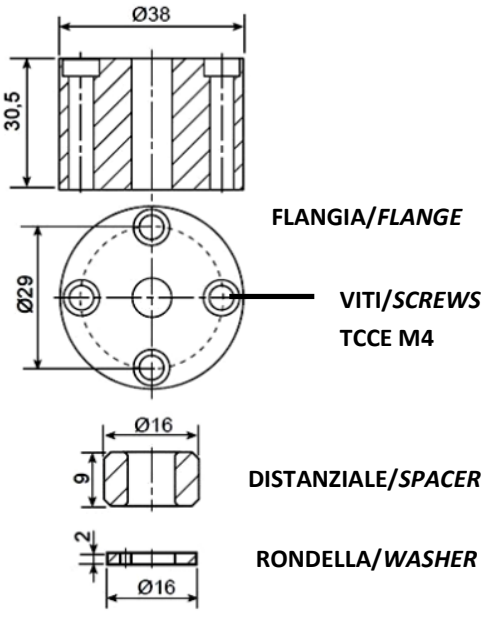
Installazione / *Installation* **DU200**





Installazione / *Installation* **DU250**





Il KIT di montaggio è fornito su richiesta, comprende:
n°1 Rondella
n°1 Distanziale
n°1 Flangia

Cod KIT DU200 DU200006
Cod KIT DU250 DU250008

The assembly KIT is supplied upon request, including:
n ° 1 Washer
n ° 1 Spacer
n ° 1 Flange

Ref KIT DU200 DU200006
Ref KIT DU250 DU250008

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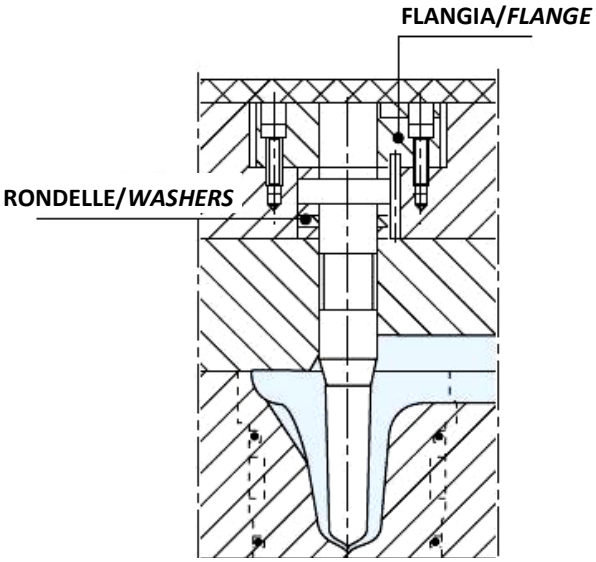
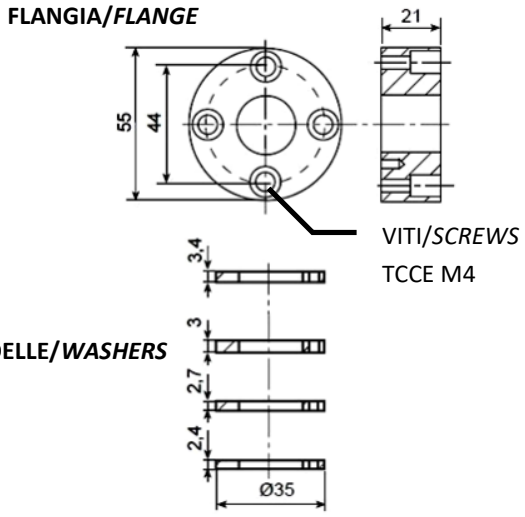
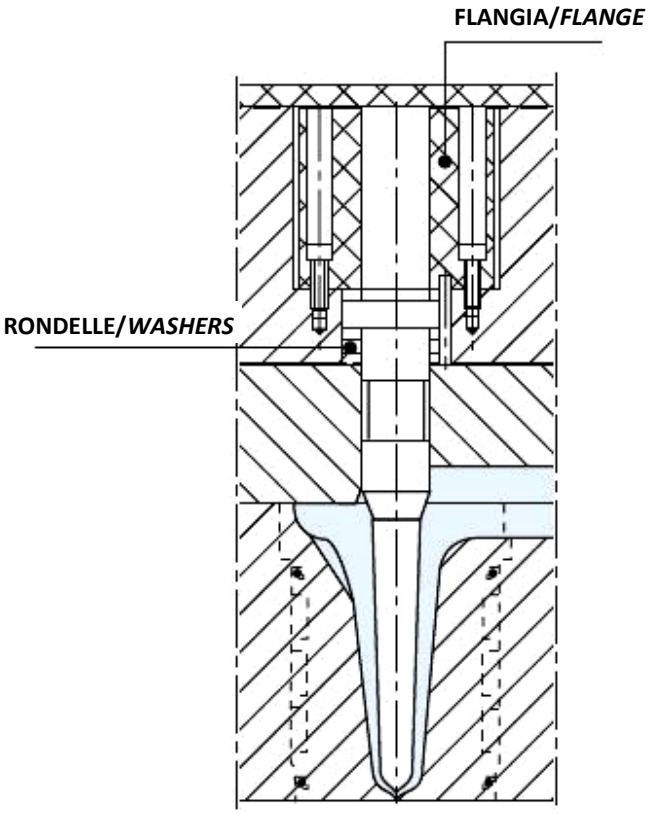
DU085-DU100

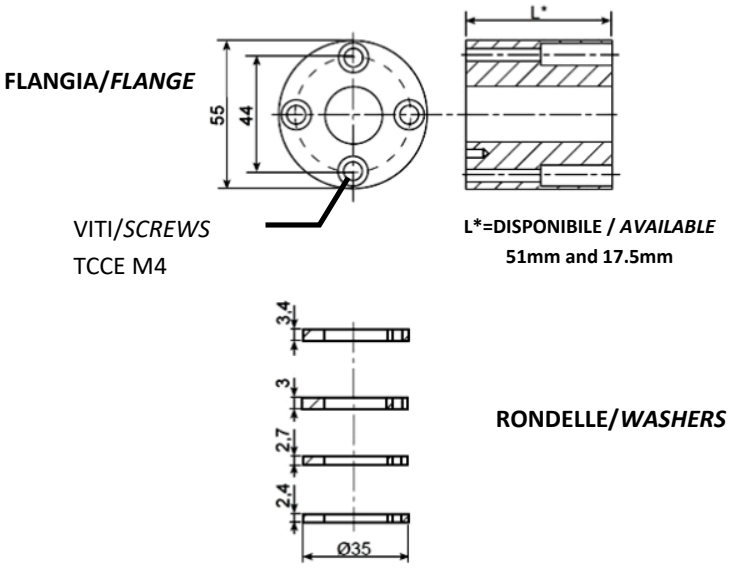
Installazione / *Installation* **DU085**





Installazione / *Installation* **DU100**





Su richiesta possono essere forniti i seguenti articoli:
Set n°4 Rondelle per DU085 e DU100 **cod.DU085002**
n°1 Flangia sp=21 per DU085 **cod.DU085001**
n°1 Flangia sp=51 per DU100 **cod.DU100003**
n°1 Flangia sp=17.5 per DU100 **cod.DU100004**

The following items can be supplied on request:
Set n°4 washers for DU085 e DU100 ***ref.DU085002***
n°1 Flange th=21 for DU085 ***ref.DU085001***
n°1 Flange th=51 for DU100 ***ref.DU100003***
n°1 Flange th=17.5 for DU100 ***ref.DU100004***

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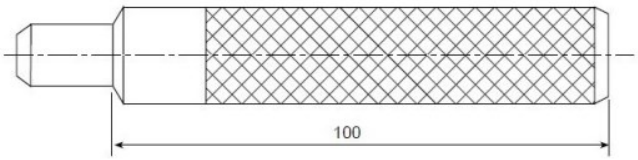
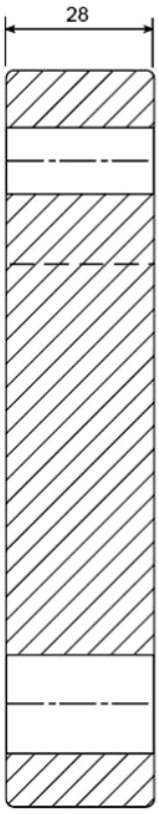
ANC

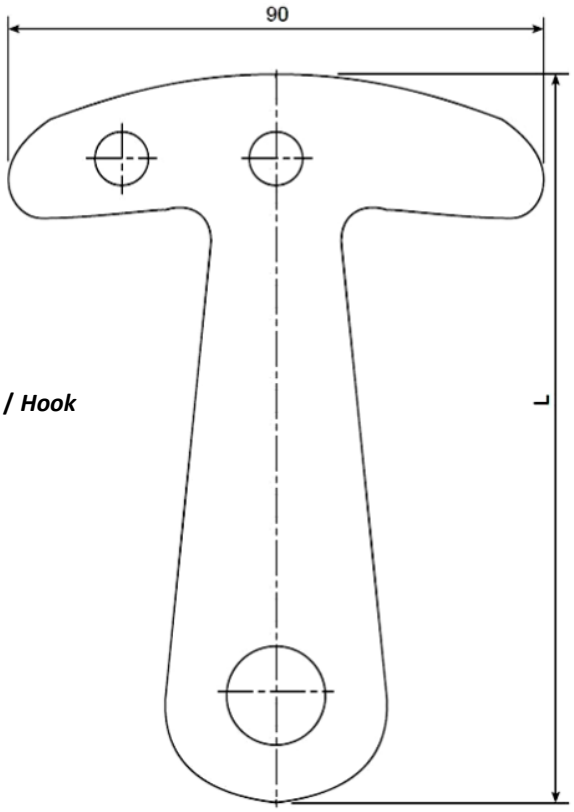
Perno di azionamento/ *Pin drive*



Cod/Ref	L
ANC1	100
ANC2	125



Aggancio / *Hook*



Ogni kit è composto da:
n°2 Agganci
n°1 Perno
n°6 viti di arresto HE M12x40
n°2 Grani di fermo FD M10x19

Each kit consists of:
n°2 Hooks
n°1 Pin
n°6 screw HE M12x40
n°2 retaining grains FD M10x19

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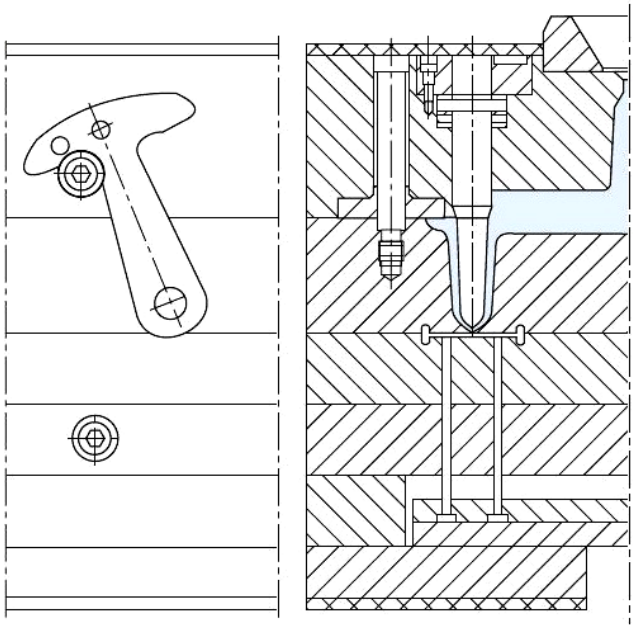
ANC

SEQUENZA OPERATIVA
OPERATIONAL SEQUENCE

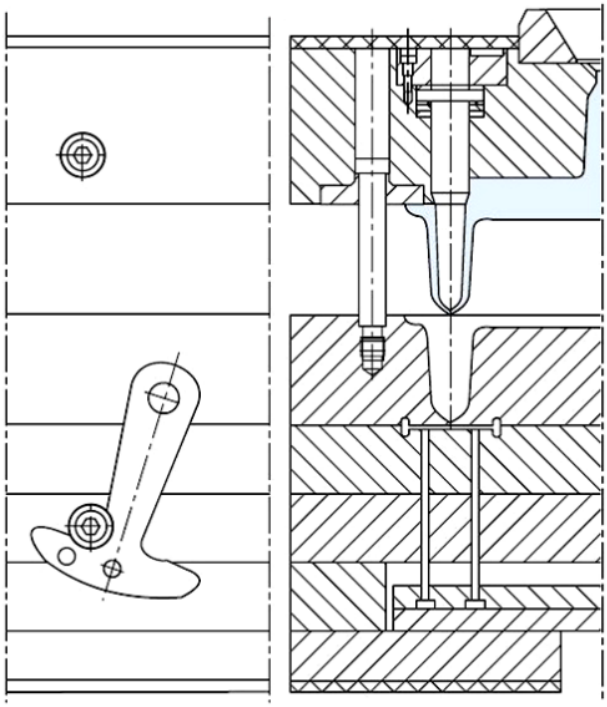
FASE / *PHASE 1*

Posizione di lavoro / *Working position*



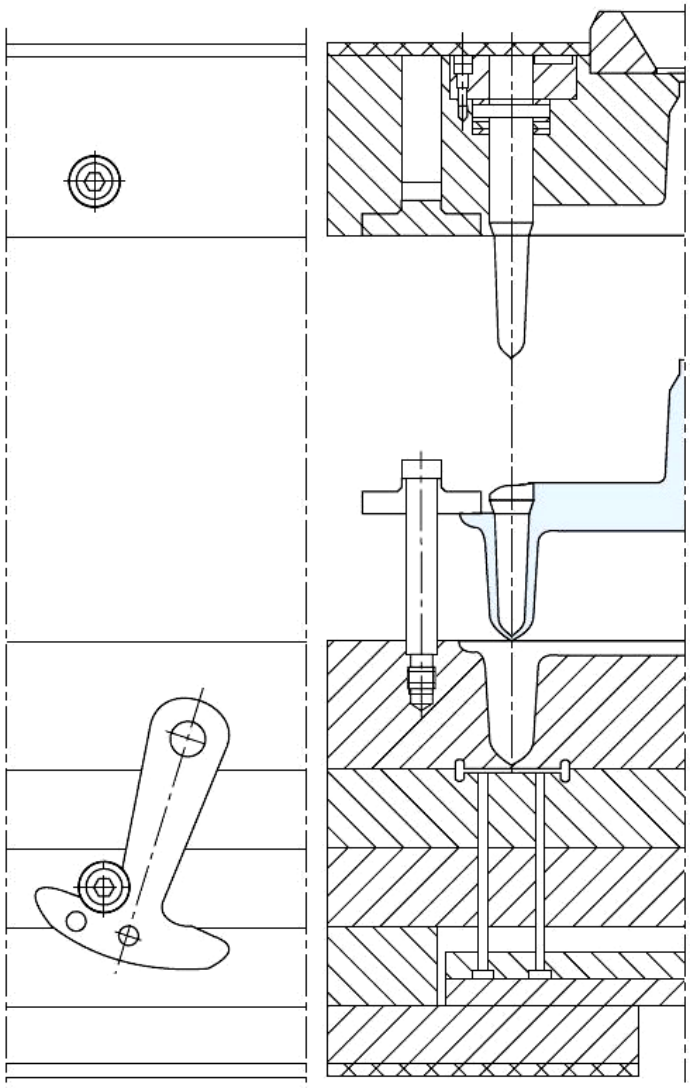
FASE / *PHASE 2*

Posizione per estrazione materozza /
Position for take out cold runners



FASE / *PHASE 3*

estrazione materozza / *sprue take out cold runners*



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INFORMAZIONI TECNICHE / *TECHNICAL INFORMATION*

L'impiego ottimale dei sistemi a "canali isolati" si ottiene mediante una corretta osservanza di alcune semplici regole:

PROVA AL BANCO

Eseguire un preliminare collaudo elettrico al banco e procedere con un preriscaldo di tutte le resistenze a circa 120°c per almeno 15min. Erogare durante questo periodo una potenza massima non superiore a 10% /15%.

PROVA SULLA PRESSA

Alcuni accorgimenti soprattutto per il primo avvio:

- Circuito di condizionamento stampo chiuso
- Impostare le temperature del sistema come la temperature della parte anteriore della vite
- Al raggiungimento riempire il sistema con basse velocità di iniezione sino a vedere la fuoriuscita del materiale plastico da tutti i torpedi.
- Attendere 5/10minuti per permettere la formazione di una guaina isolante sulle pareti più esterne del sistema
- Aprire il circuito di condizionamento
- Innalzare le temperature del sistema (tubi e torpedi) oltre la temperatura della vite della pressa.
- Al raggiungimento attendere 5minuti prima di procedere allo stampaggio
- Effettuare gradatamente tutte le regolazioni necessarie per ottenere il ciclo di stampaggio necessario.
- Registrare tutti i parametri

FINE STAMPAGGIO

Chiudere il circuito di condizionamento e spegnere la centralina di termoregolazione del sistema.

CAMBIO COLORE

Pulire accuratamente la vite della pressa ed introdurre ed ottenere il nuovo colore.

- Aumentare la temperatura del sistema in funzione delle caratteristiche del materiale plastico.
- Al raggiungimento attendere 5 minuti
- Iniettare nel sistema il nuovo colore con velocità di iniezione molto bassa.
- Ripetere l'operazione di iniezione più volte facendo delle pause di qualche minuto fra una e l'altra sino alla pulizia completa del sistema
- Abbassare gradualmente le temperature sino ai valori iniziali.
- Ritornare alle condizioni di lavoro normale.

The optimal use of systems with "isolated channels" is obtained through correct observance of some simple rules:

TEST AT THE BANK

Perform a preliminary electrical test on the bench and proceed with a preheating of all the heaters at about 120 ° c for at least 15min. Deliver a maximum power not exceeding 10% / 15% during this period.

TEST ON THE PRESS

Some tricks especially for the first start:

- *Closed mold conditioning circuit*
- *Set the system temperatures such as the temperature at the front of the screw*
- *When it is reached, fill the system with low injection speeds until the plastic material comes out of all the probes*
- *Wait 5 / 10minutes to allow the formation of an insulating sheath on the outer walls of the system*
- *Open the conditioning circuit*
- *Raise system temperatures (pipes and probes) beyond the press screw temperature.*
- *When it is reached wait 5 minutes before proceeding with the molding*
- *Gradually perform all the adjustments necessary to obtain the necessary molding cycle.*
- *Record all parameters*

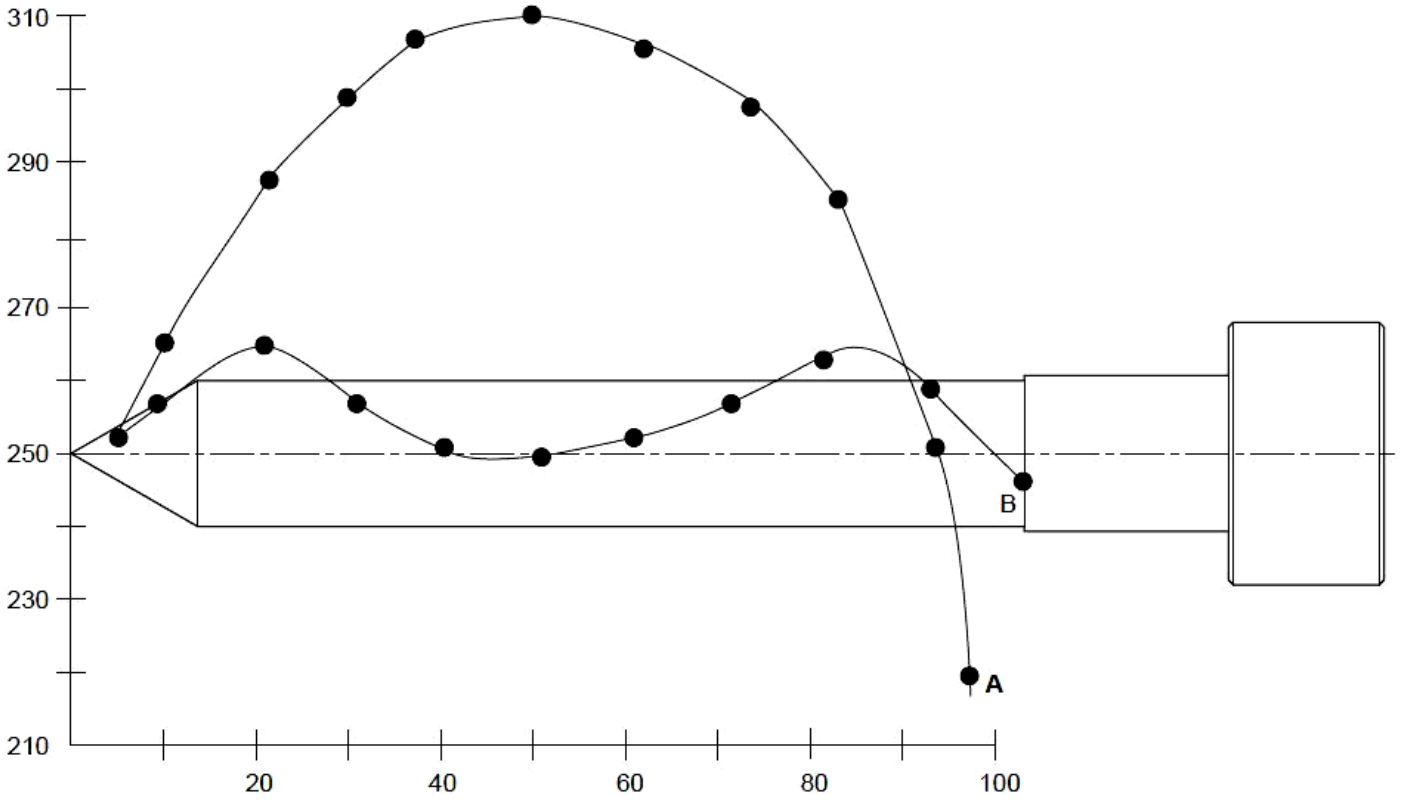
END OF MOLDING

Close the air conditioning circuit and switch off the system temperature control unit.

CHANGE COLOR

Thoroughly clean the press screw and introduce and obtain the new color.

- *Increase the system temperature according to the characteristics of the plastic material.*
- *At the end wait 5 minutes*
- *Inject the new color into the system with very low injection speed.*
- *Repeat the injection operation several times by pausing for a few minutes between each other until the system is completely cleaned*
- *Gradually lower the temperatures to the initial values.*
- *Return to normal working conditions.*



Per ottenere dei buoni risultati è necessario ricordare che le funzioni di riscaldamento e raffreddamento e controllo debbono essere ben coordinate, ricordando che ciascuna di esse influenza in modo diretto le altre, con modalità diverse in funzione delle condizioni di stampaggio.
Nel grafico riportato è significativa la curva “A” (come esempio) di un componente “non coordinato” reagisca durante il processo di stampaggio.
La curva “B” mostra il profilo di un componente progettato correttamente.
I nostri torpedi sono progettati seguendo queste regole verificate sperimentalmente sul campo.
Ognuno di essi in funzione del diametro e della sua lunghezza ha una resistenza con uno specifico avvolgimento.
In funzione se il torpedo è installato in un canale isolato o in una piastra calda avrà una resistenza con avvolgimento differente.

To obtain good results it is necessary to remember that the heating and cooling and control functions must be well coordinated, remembering that each of them directly affects the others, with different modes depending on the molding conditions.
In the graph shown, the "A" curve (an example) of an "uncoordinated" component reacts during the molding process.
The "B" curve shows the profile of a properly designed component.
Our probes are designed according to these rules tested experimentally in the field.
Each one of them, depending on the diameter and its length, has a resistance with a specific winding.
In function if the probes is installed in an isolated channel or in a manifold it will have a resistance with different windings.

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