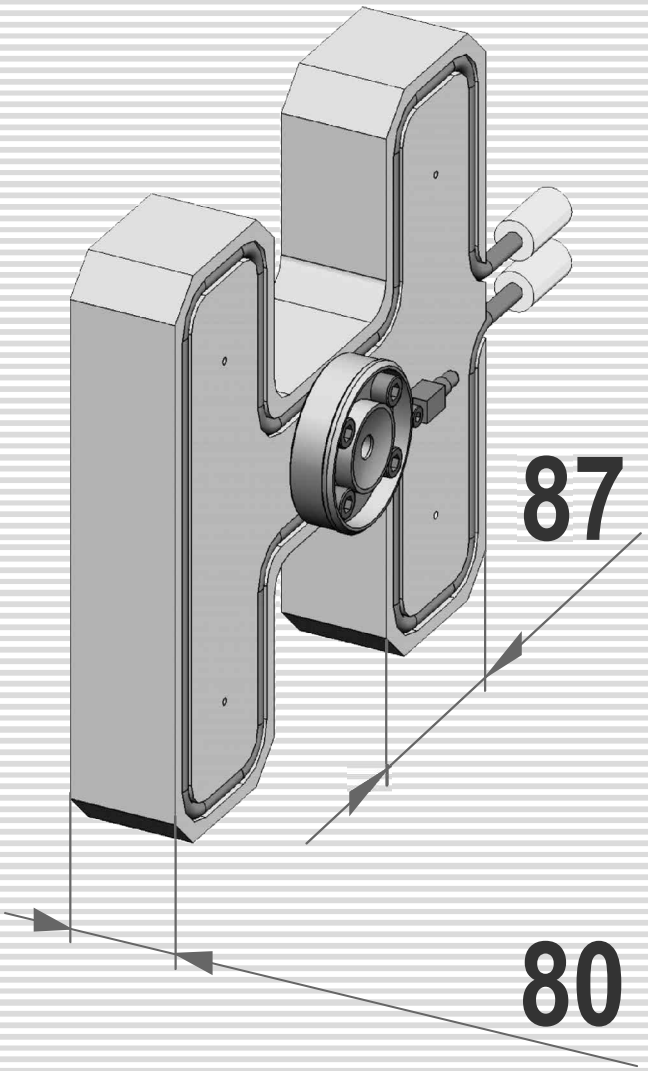
Series VH

Hot Runner Manifolds



C Company
P Products
T Technology
A Application

Synventive
molding solutions

Product type

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

M	Thickness	80 mm
M1	Width	87 mm
J2	Flow bore Ø	max. Ø20 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)

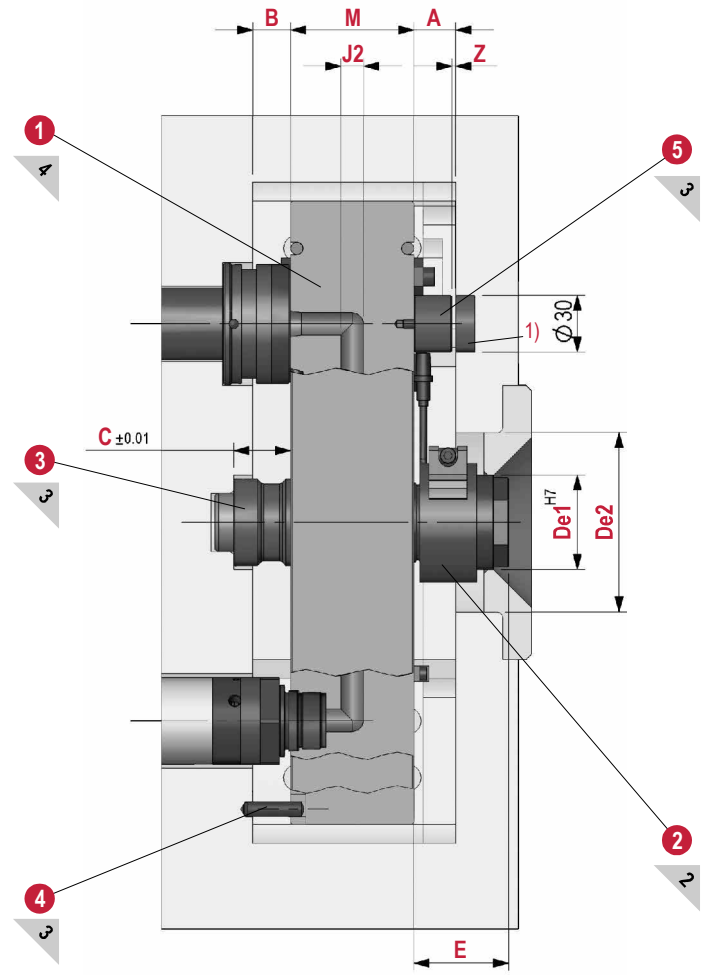
Attached parts and accessories

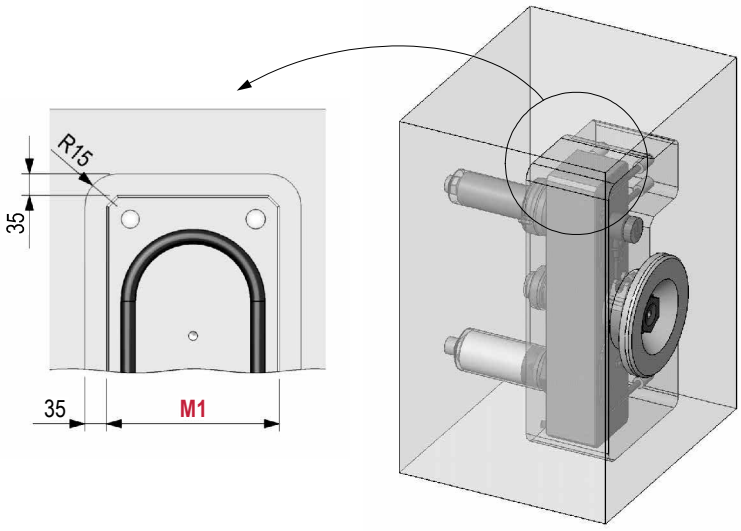
3. Centre support
4. Dowel
5. Support pad

Major dimensions (mm)

A	Manifold cut out, right (above)	22 2)
B	Manifold cut out, left (below)	18 2)
Z	Expansion gap	0...0.17 2)
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

Illustrations simplified, schematically drawn and not to scale.





8 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.

For design and application information, see the Synventive Hot Runner Guide.

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

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=↑

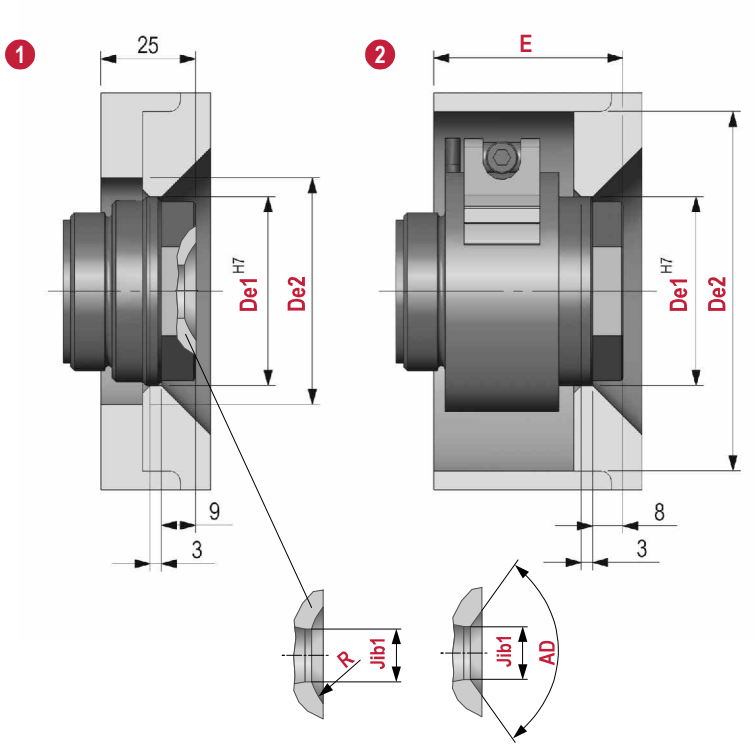
Example and explanations

Inlet bushing → BC (Part code ↑)
Position in length chart → 100 (Length code ↑)
50 (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

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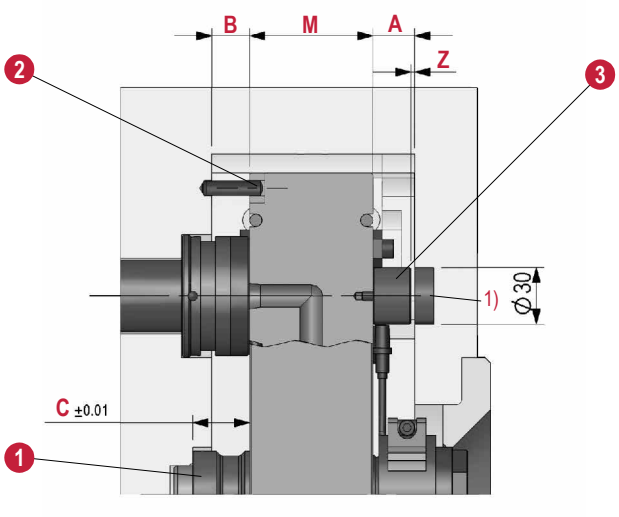
Attached parts and accessories for hot runner manifolds of series **VH**:

1. MCS 46 ...

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

C (mm) for nozzle size 16 / 20
≥B



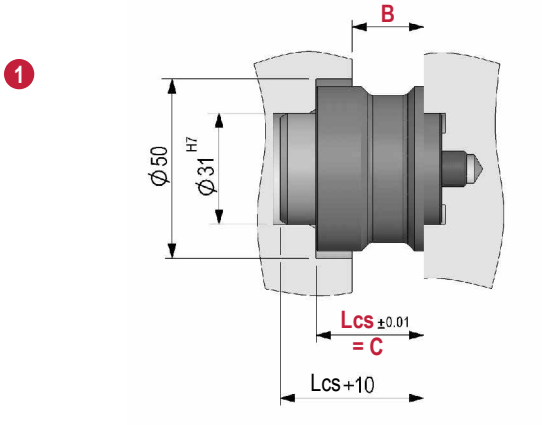
2. DIN 6325: 12 m6

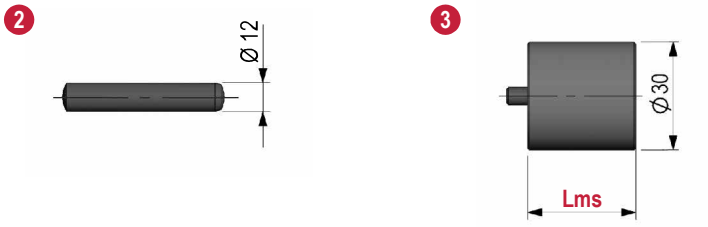
➔Dowel

3. MS 30 ...

➔Support pads

Z (mm)[2]
0 ... 0.17





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Illustrations simplified, schematically drawn and not to scale.

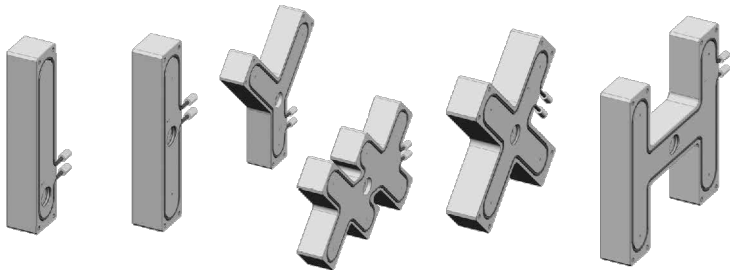
1. Manifolds in standard shape

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 **VH**. 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.

1



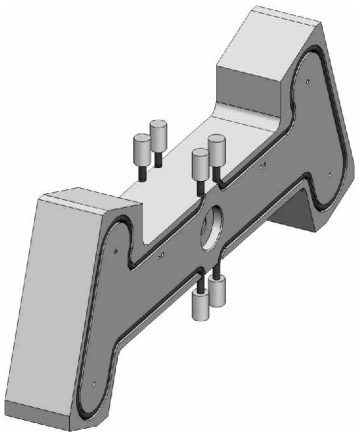
I1 | I2 , I3, I4 ... | Y3 ... Y6 ... | X4 ... | H4 ...

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 **VH**.

2

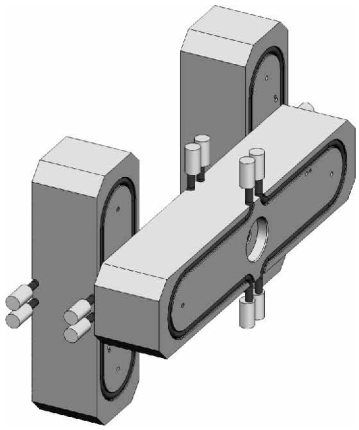


3. Bridge manifolds

Bridge manifolds make it possible to combine several manifolds to one feed system. They are 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 **VH**.

3



For design and application information, see the Synventive Hot Runner Guide.

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MK-PRM.BRM. GB .P.IVHMAN 2008-10-15

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