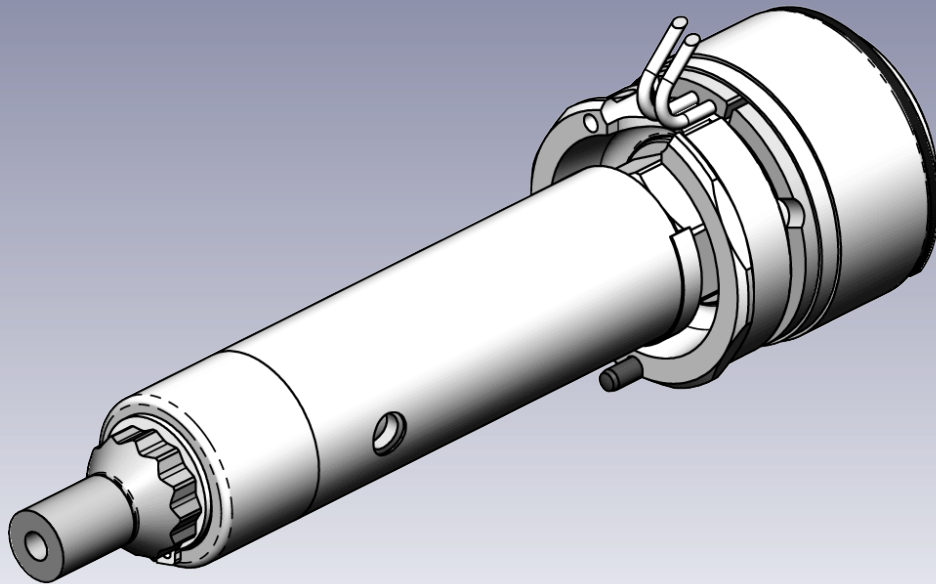


09S-03 Product Catalog

S p r u e B u s h i n g s



Doc009130_RIS.png

Stabilize your Process _____



09S-03 Sprue Bushing, open

Product Type

Hot runner nozzles in the 09S-03 range;
 → Nozzle size 09: Flow bore - Ø 9 mm
 → Nozzle style S: Sprue bushing

Different gate options can be implemented, see table on right.

Application

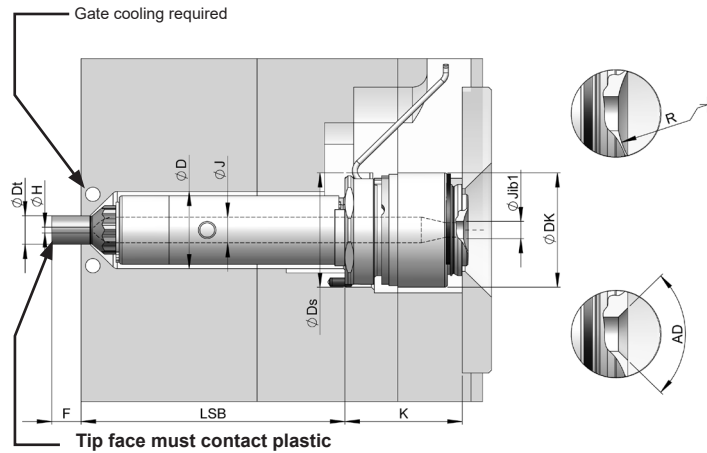
For all usual thermoplastics Max. shot weight per nozzle (g):

→ 250 (open, low viscosity)

Heating 09S-03

- externally heated, 230 V AC
- replaceable heater & thermocouple
- Nozzle heater zones, 150...510 W
- Head heater, 450 W
 Thermocouples, EN 60584
 Fe-CuNi 0 = Typ J;
 NiCr-Ni = Typ K

Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.



Major Dimensions (mm)

Doc009131_RIS.png

J	Flow bore Ø	Ø 9 ¹⁾	K	Head height	40
Jib1	Flow bore Ø inlet bushing	Ø 4,5, 6, 8	Dk	Head Ø	Ø40
LSB	Nozzle length	50...390 ²⁾	Ls	Depth of head centring	10
F	Tip Extension	see page 4	Ds	Diameter of head centering	Ø40
D	Cutout Ø	Ø27	R	Nozzle contact radius	0...40
Dt	Tip Ø	see page 4	AD	Nozzle contact angle	90°...120°
H	Gate Orifice	see page 4			

¹⁾ Standard flow bore value = Ø9

²⁾ Standard lengths shown, consult Synventive for custom lengths.

09S-03 Nozzle Lengths

One control area (thermocouple)			Two control areas (thermocouple)				Head Power
LSB (mm)		Heater zone power (Watt)	LSB (mm)		Heater zone power ¹⁾ (Watt)		
Standard lengths	Custom lengths		Standard lengths	Custom lengths	Power 1	Power 2	
50	>50-<60	150 W	-	=>160-<170	150 W	130 W	450 W
60	>60-<70	180 W	170	>170-<180	150 W	140 W	450 W
70	>70-<80	210 W	-	=>180-<190	150 W	150 W	450 W
80	>80-<90	215 W	190	>190-<200	150 W	160 W	450 W
90	>90-<100	220 W	-	=>200-<210	150 W	170 W	450 W
100	>100-<110	225 W	210	>210-<220	150 W	180 W	450 W
110	>110-<120	230 W	-	=>220-<230	150 W	190 W	450 W
120	>120-<130	235 W	230	>230-<240	150 W	200 W	450 W
130	>130-<140	250 W	-	=>240-<250	150 W	210 W	450 W
-	=>140-<150	255 W	250	>250 -<260	150 W	220 W	450 W
150	>150-<160	260 W	-	=>260 -<270	150 W	230 W	450 W
			270	>270-<280	150 W	240 W	450 W
			-	=>280-<290	150 W	250 W	450 W
			290	>290-<300	150 W	260 W	450 W
			-	=>300-<310	150 W	270 W	450 W
			310	>310-<320	150 W	280 W	450 W
			-	=>320-<330	150 W	290 W	450 W
			330	>330-<340	150 W	300 W	450 W
			-	=>340-<350	150 W	310 W	450 W
			350	>350-<360	150 W	320 W	450 W
			-	=>360-<370	150 W	330 W	450 W
			370	>370-<380	150 W	340 W	450 W
			-	=>380-<390	150 W	350 W	450 W
			390	-	150 W	360 W	450 W

³⁾ The numbering of the heating zones starts at the nozzle tip and ends at the nozzle head



Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

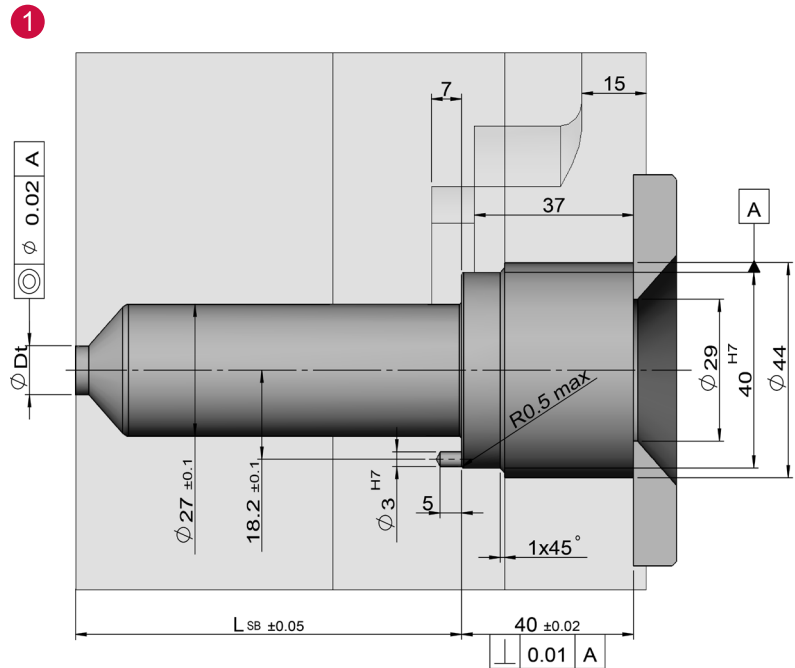
1. Cutout for the nozzle

LSB Nozzle length

General tolerances: DIN ISO 2768-mK

Surfaces: $\sqrt{Ra\ 3.2}$ ($\sqrt{Ra\ 1.6}$ $\sqrt{Ra\ 0.8}$)

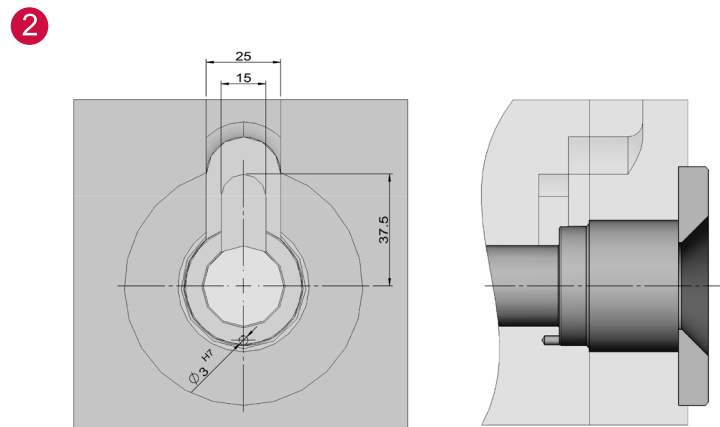
Values of the dimension LSB can be found in the data sheet on page 2.



Doc008696_RIS.png

2. Cutout for connections

- Electrical power
- Thermocouple



Doc008697_RIS.png



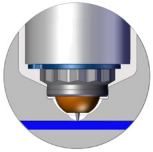
Nozzle Tip Styles

Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.
H = Gate orifice diameter, F = Tip extension, Dt = Tip Diameter, Mod = Modifiable

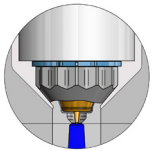
TTW Thermal Gate – Torpedo - Blind

Tip Style		Description	Dt = Ø14			
			H=1.2	H=1.6	H=2.0	H=2.5
	TTW Doc009086_RIS.png	Standard	✓	✓	✓	✓

TTW-C Thermal Gate – Torpedo - Blind

Tip Style		Description	Dt = Ø14			
			H=1.2	H=1.6	H=2.0	H=2.5
	TTW-C Doc009087_RIS.png	Standard	✓	✓	✓	✓

TTP Thermal Gate – Torpedo - Plunged Through

Tip Style		Description	Dt = Ø10 F = 10		
			H=1.5	H=2.0	H=2.5
	TTP Doc009088_RIS.png	Standard	✓	✓	✓

✓ Preferred

(✓) Available

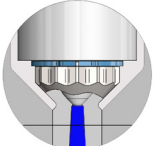
✗ Not Available



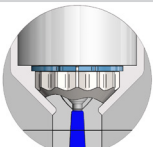
Nozzle Tip Styles

Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.
H = Gate orifice diameter, F = Tip extension, Dt = Tip Diameter, Mod = Modifiable

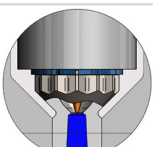
TPK Thermal Gate – Full Flow - Plunged Through

Tip Style		Description	Dt = Ø10 F = 10	
			H=2.0	H=2.5
	TPK Doc009089_RIS.png	Standard	✓	✓

TNK Thermal Gate – Full Flow - Plunged Through

Tip Style		Description	Dt = Ø10 F = 10	
			H=2.0	H=2.5
	TNK Doc009090_RIS.png	Standard Cold Runner	✓	✓

TTK Thermal Gate – Torpedo - Plunged Through

Tip Style		Description	Dt = Ø10 F = 10	
			H=2.0	H=2.5
	TTK Doc009091_RIS.png	Standard Cold Runner	✓	✓

✓ Preferred

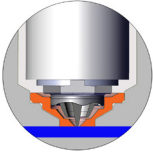
(✓) Available

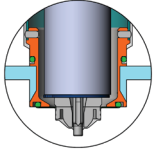
✗ Not Available



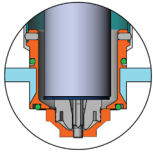
Wear Insert / Cooling Bushing

Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.
 H = Gate orifice diameter, F = Tip extension, Dt = Tip Diameter, Mod = Modifiable

Wear Insert		F = 0, 10, Mod			
Part	Description	H=1.2	H=1.6	H=2.0	H=2.5
 <p>WI-TTW Doc009092_RIS.png</p>	Wear Insert for TTW Nozzle tips	✓	✓	✓	✓

Cooling Bushing		TTW	TTP	TPK	TNK	TTK
 <p>Doc009093_RIS.png</p>	<p>NC Nozzle Cooling Bushing for Nozzle Tips, Blind and Plunged Through</p> <p>Doc009094_RIS.png</p>	✓	✓	✓	✓	✓

Wear Insert and Cooling Bushing

Part	TTW
 <p>Doc009095_RIS.png</p>	✓

✓ Preferred

(✓) Available

✗ Not Available

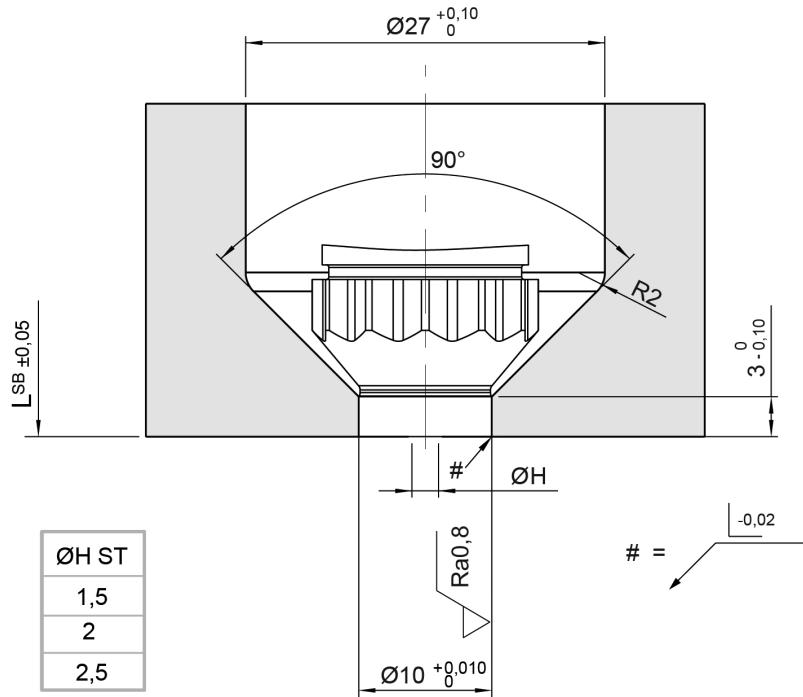


Nozzle Tip Cutout Dimensions

Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

Dimensions for reference only. Reference system drawing for complete dimensions prior to machining gate detail in mold.

TTP Nozzle tip cutout dimensions



Doc007729.png

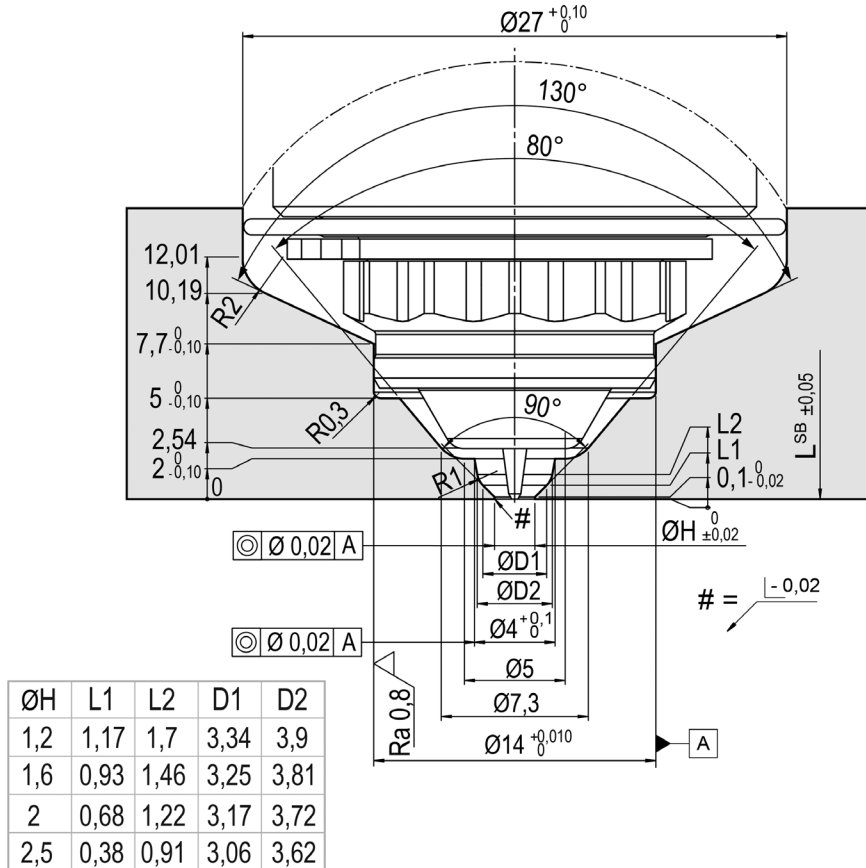


Nozzle Tip Cutout Dimensions

Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

Dimensions for reference only. Reference system drawing for complete dimensions prior to machining gate detail in mold.

TTW - Nozzle tip cutout dimensions



Notes:

- Cooling required around the nozzle tip, opposite to the nozzle tip
- The front of the nozzle tip must always be against plastic.

Doc007728.png

General tolerances according to DIN ISO 2768-mK

At the area of the nozzle gate replaceable, hardened (52 +2/-1 HRC) inserts are recommended by Synventive.

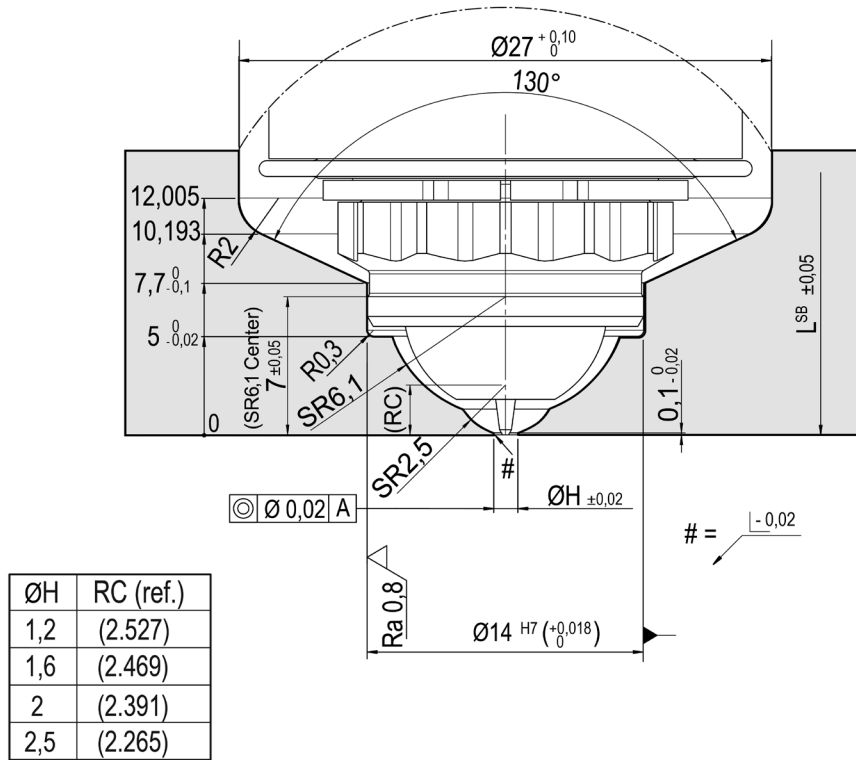
Synventive recommends that the gate area geometry is manufactured by grinding and not EDM with a surface quality of $\sqrt{Ra 0,8}$.



Nozzle Tip Cutout Dimensions

Dimensions for reference only. Reference system drawing for complete dimensions prior to machining gate detail in mold.

TTW-C - Nozzle tip cutout dimensions



Notes:

- Cooling required around the nozzle tip, opposite to the nozzle tip
- The front of the nozzle tip must always be against plastic.

Doc007746.png

General tolerances according to DIN ISO 2768-mK

At the area of the nozzle gate replaceable, hardened (52 +2/-1 HRC) inserts are recommended by Synventive.

Synventive recommends that the gate area geometry is manufactured by grinding and not EDM with a surface quality of $\sqrt{\text{Ra}0,8}$.

The Americas

Synventive Molding Solutions Inc.
10 Centennial Drive
Peabody, MA 01960
Tel.: +1 978 750 8065
Fax: +1 978 646 3600
Email: info@synventive.com

Europe

Synventive Molding Solutions GmbH
Heimrodstraße 10
P. O. Box 3123
64625 Bensheim
Tel. :+49 (0)6251 9332-0
Fax :+49 (0)6251 9332-90
Email: infohrde@synventive.com

Asia

Synventive Molding Solutions (Suzhou) Co. Ltd.
12B Gang Tian Industrial Square
Suzhou Industrial Park, China 215021
Tel.: +86 512 6283 8870
Fax: +86 512 6283 8890
Email: infohrcn@synventive.com