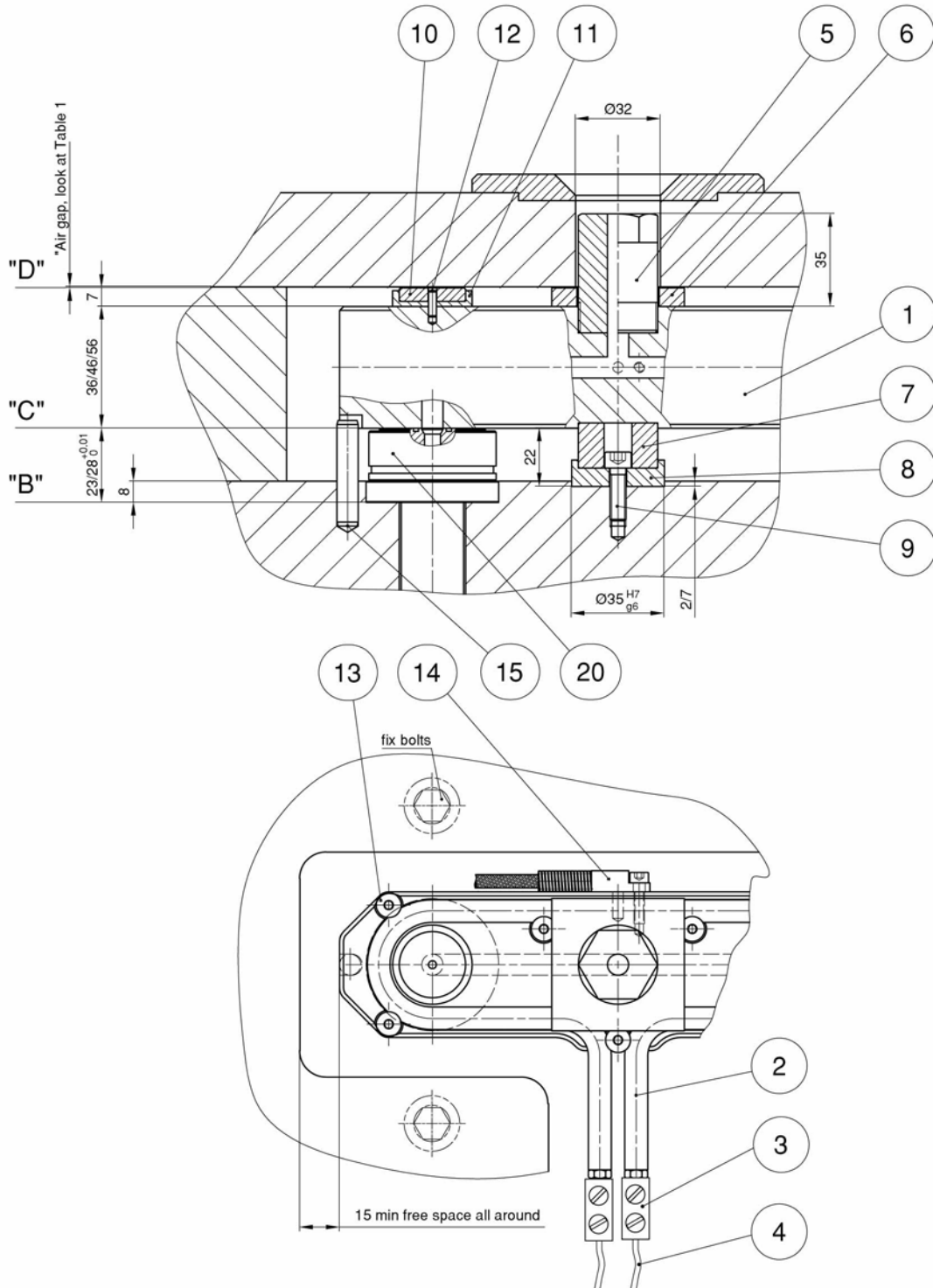


MANIFOLD

HEATLOCK®



Assembly Instruction

Check the following before the manifold is finally assembled (see overview on the left side):

1. Adjust all the ceramics, insulation for each bushing so that they are all at the same level as Plan "B".
2. Put in the bushings and check that the bushings / torpedoes rear plane is at the same height, 0,01 mm, according to the measurement level "C". Use three measuring points in each bushing.
3. Assemble the ceramic KEM03001017 with the support DSP0353010, measure the total height (approx. 24mm). Measure and reduce this height by the pre-bored depth of the ceramic in the manifold, (approx. 2 mm) and the measured distance between plane "C" and plane "B" (approx. 23 or 28 mm depending on the bushing), the remaining 7 or 2 mm is countersunk in the form plate. It is important that the manifold is at the same level as the bushings and don't have too much play or "roll" under the central support.
4. If the manifold is to be bolted check that the shape of the hole in the manifold matches the hole shape in the cavity plate.
5. Assemble the back support KE02500305 with the support DSP0300306 / DSP0300312, make sure that the ceramic reaches the bottom of the support. Measure and check the height of all the units. If there are any discrepancies, adjust all to the same height within 0.005 mm, work with the underside of the support. Fix this with dowel DW03X12 in the pre-bored holes in the manifold. Correct here for the air gap which there shall be in cold condition to allow for heat expansion according to table 1. plane "D".
6. Put the manifold on the bushings, which is centred using the ceramic center support KEM03001017. Torsion fixing is done with the help of dowels which are placed in the pre-milled slot in the manifold. This is done without the O-rings mounted.
7. Tighten the manifold with the screws provided if the manifold is to be bolted, check that all the cables are free.
8. Check the level of the upper part of the rear support plane "D", they shall all be within 0.005 mm.
9. Take off the manifold, assemble all the O-rings, re-assemble and check that there are no trapped cables or cables laying against the manifold.
10. Check that the manifold is back at the right level/height from the measurement level "D". If the manifold isn't fixed the fixing plate is mounted and tightened so that the O-rings are pressed together before the control is carried out. Heat up to running temperature before the clamp plate is removed for the final check.

安裝指引

在裝配流道板之前請核對以下：

1. 調整所有要裝置陶瓷圈的位置(B)深度一致。
2. 放入射咀,檢查所有射咀頂部高度是否一致,並保持與C平面的最大間隙不超過0.01mm的範圍。利用射咀頂部取3點平衡值作為高度平面資料。
3. 將陶瓷中央定位圈KEM03001017和中央定位鋼墊DSP0353010組裝在一起,測量其總高度(約24mm)。再測量陶瓷圈嵌入熱流道板的深度(約2mm),剩下高度為約22mm。然後,測量C和B之間的距離(大約23或28mm,由射咀的大小決定)。所以鋼墊嵌入CAVITY板內的深度約為7或2mm。流道板與射咀是否在同一水平面上及保持其在中央定位墊片控制下不會有太多的轉動是很重要的。
4. 檢查流道板上的孔與型腔板孔是否配合,以便確定流道板是否被固定好。
5. 將背托陶瓷墊片KE02500305裝配到鋼墊片DSP0300306/DSP0300312內,確保陶瓷墊片裝到鋼墊片底部。檢測所有元件的高度。調整所有元件到同一高度,允許偏差在0.005mm以內。再用管釘DW03x12將陶瓷墊片固定到流道板上。查詢Table1中熱膨脹尺寸,調整D處的氣縫寬度。
6. 將流道板放在射咀上,用陶瓷中央定位圈KEM03001017定位。然後用管釘固定在流道板上已加工的槽內。這一步不需要O-RING密封圈。
7. 用螺釘鎖緊流道板,檢查電線是否有受損。
8. 檢查後部墊片在D平面上,應該在0.005mm以內。
9. 取下流道板,安裝上所有的O-RING密封圈,再重裝流道板,確保電線沒有被卡住或放在流道板上。
10. 檢查流道板距離D測量面的準確高度。如果流道板不固定,便安裝並鎖緊固定板,確保O-RING密封圈壓緊在一起。加熱到原料流動時的溫度再去掉夾板作最後檢查。

31	1	HEATMANPROOF	圖紙確認
30	1	HEATMANDOC	熱膠道系統文件
20	2	ESB2046102	射咀, L=46 mm
15	1	DW08 x 40	管釘 $\varnothing 8 \times 40$
14	1	TC00040180	熱電偶, L = 12 mm
13	14	MF6S05 x 008	螺絲 M5 x 8
12	2	DW03 x 12	管釘 $\varnothing 3 \times 12$
11	2	DSP0300306	背托鋼墊片
10	2	KE02500305	背托陶瓷墊片
9	1	CS06020	螺絲 M6 x 20
8	1	DSP0353010	中央定位鋼墊
7	1	KE03001017	陶瓷中央定位圈
6	1	DSPP503107	擋板
5	1	DSP4503008	進料咀
4	1	MHWIRE050	電線
3	4	MHCONN001	電線連接器
2	2	MHI02400	管式發熱線
1	1	MI2400004608	I 型標準流道板

Table 1

熱膨脹			
°C	T=36	T=46	T=46
200	0.08	0.10	0.13
250	0.10	0.13	0.16
300	0.12	0.16	0.20
350	0.14	0.18	0.23

Check List / 核對清單

在裝配流道板之前請核對以下：

- | | |
|--|--------------------------|
| 1. 調整所有要裝置陶瓷圈的位置(B)深度一致。 | <input type="checkbox"/> |
| 2. 放入射咀，檢查所有射咀頂部高度是否一致，並保持與C平面的最大間隙不超過0.01mm的範圍內。利用射咀頂部取3點平衡值作為高度平面資料。 | <input type="checkbox"/> |
| 3. 將陶瓷中央定位圈KEM03001017和中央定位鋼墊DSP0353010組裝在一起，測量其總高度(約24mm)。再測量陶瓷圈嵌入熱流道板的深度(約2mm)，剩下高度為約22mm。然後，測量C和B之間的距離(大約23或28mm，由射咀的大小決定)。所以鋼墊嵌入CAVITY板內的深度約為7或2mm。流道板與射咀是否在同一水平面上及保持其在中央定位墊片控制下不會有太多的轉動是很重要的。 | <input type="checkbox"/> |
| 4. 檢查流道板上的孔與型腔板孔是否配合，以便確定流道板是否被固定好。 | <input type="checkbox"/> |
| 5. 將背托陶瓷墊片KE02500305裝配到鋼墊片DSP0300306 / DSP0300312內，確保陶瓷墊片裝到鋼墊片底部。檢測所有元件的高度。調整所有元件到同一高度，允許偏差在0.005mm以內。再用管釘DW03x12將陶瓷墊片固定到流道板上。查詢Table1中熱膨脹尺寸，調整D處的氣縫寬度。 | <input type="checkbox"/> |
| 6. 將流道板放在射咀上，用陶瓷中央定位圈KEM03001017定位。然後用管釘固定要流道板上已加工的槽內。這一步不需要O-RING密封圈。 | <input type="checkbox"/> |
| 7. 用螺釘鎖緊流道板，檢查電線是否有受損。 | <input type="checkbox"/> |
| 8. 檢查後部墊片在D平面上，應該在0.005mm以內。 | <input type="checkbox"/> |
| 9. 取下流道板，安裝上所有的O-RING密封圈，再重裝流道板，確保電線沒有被卡住或放在流道板上。 | <input type="checkbox"/> |
| 10. 檢查流道板距離D測量面的準確高度。如果流道板不固定，便安裝並鎖緊固定板，確保O-RING密封圈壓緊在一起。加熱到原料流動時的溫度再去掉夾板作最後檢查。 | <input type="checkbox"/> |

* 安裝電路連接後，再進行控制測試，確保電源正常輸出。

按步驟5，指定氣縫寬度：_____

附注：

Company / 公司：	
Name / 名稱：	
Address / 地址：	
Date / 日期：	
Project No. / 專案代碼：	

有任何不滿，請填寫此表並簽名傳真至 (86) 769 8382 5600