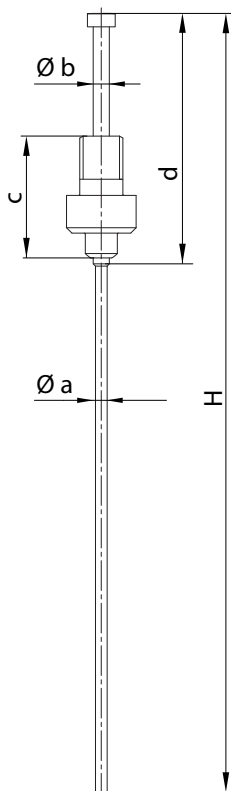




Gruppo spillo - Valve gate pin group

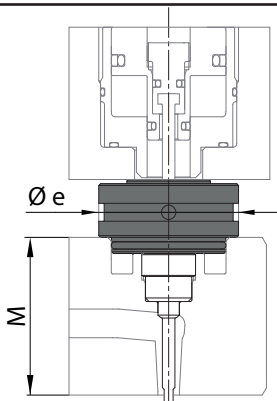


Valve Gate type / Tipo gr.ott.	S20 - S28 - S32				K32	
Nozzle type / Tipo ugello	TF12 - TF17 - TF23 - TD18 - TD22					
Pin group code / Codice gr.spillo	<b>E18330</b>	<b>E20309</b>	<b>E18331</b>	<b>E20310</b>	<b>E18332</b>	<b>E18333</b>
Ø a					Ø 2.5	
Ø b					Ø 3.5	
d	82				57	
c	22.5	37	22.5	37	22.5	
H	280		500		280	500

Valve Gate type / Tipo gr.ott.	S28 - S32				K32	
Nozzle type / Tipo ugello	FN32 - TD30					
Pin group code / Codice gr.spillo	<b>E18334</b>	<b>E20313</b>	<b>E18335</b>	<b>E20314</b>	<b>E18334</b>	<b>E20313</b>
Ø a					Ø 3.3	
Ø b					Ø 3.5	
d					98	
c	22.5	37			22.5	
H	280	500	280	500		

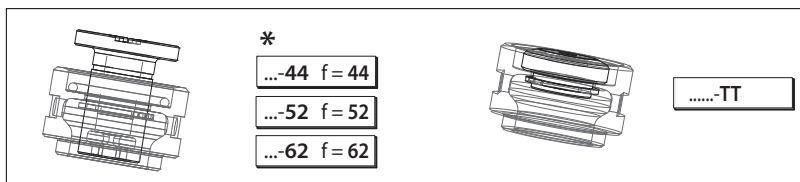
Valve Gate type / Tipo gr.ott.	S60 - K40					
Nozzle type / Tipo ugello	FN46 - DN44					
Pin group code / Codice gr.spillo	<b>E18336</b>			<b>E18337</b>		
Ø a					Ø 5.8	
Ø b					Ø 6	
d					120	
c					30.5	
H	400			600		

Gruppo contrasto - Pressure group

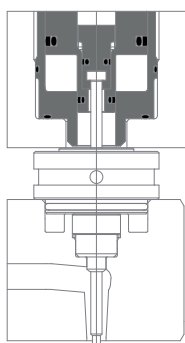


Manifold type / Tipo piastra	C - Conventional / Tradizionale					
Valve gate type / Tipo gr.otturatore	S20		S28 - S32		S60	
Pressure gr. code / Codice gr.contrasto	<b>E20327 - *</b>		<b>E20328 - *</b>		<b>E21474</b>	
Nozzle type / Tipo ugello	TFØ12/17/23 - TDØ18/22		TFØ12/17/23/32 - TDØ18/22/30		FNØ46 - DN44	
Ø e	Ø 31		Ø 39		Ø 54	
*M	44 - 52 - 62 - TT					

Manifold type / Tipo piastra	B - bolted down					
M	44		52		62	
Ø e	Ø 28	Ø 36	Ø 28	Ø 36	Ø 28	Ø 36
Pressure gr. code / Codice gr.contrasto	<b>E21375</b>	<b>E21466</b>	<b>E21383</b>	<b>E21467</b>	<b>E21384</b>	<b>E21468</b>
Valve gate type / Tipo gr.otturatore	S20 - S28 - S32					
Nozzle type / Tipo ugello	TFØ12/17/23/32 - TDØ18/22/30					



Gruppo otturatore - Valve gate group

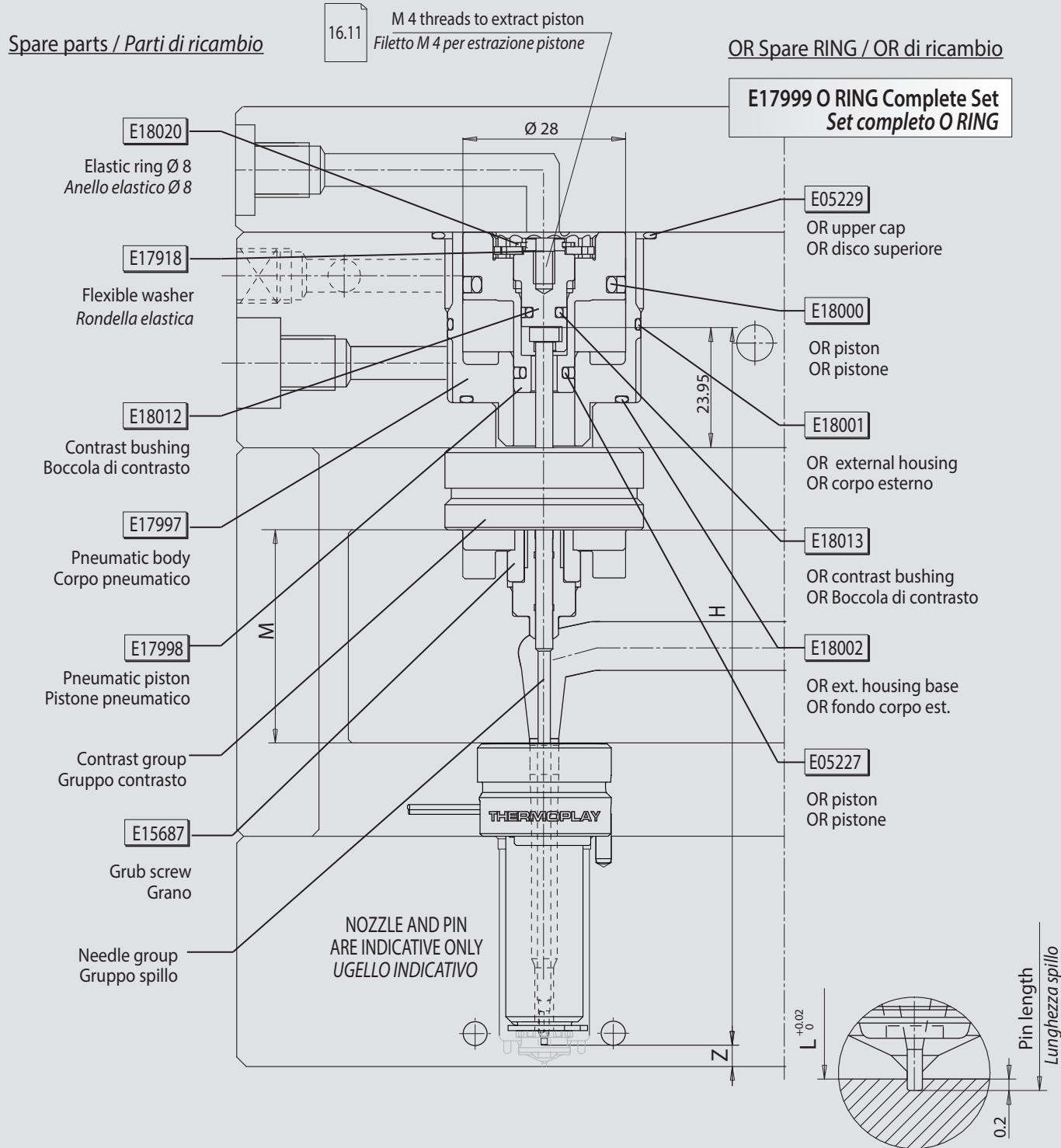


Manifold type / Tipo piastra	C - Conventional / Tradizionale					
Valve gate type / Tipo gr.otturatore	S				K	
Valve gate type / Tipo gr.otturatore	S20 - HY	S28 - PN	S32 - PN	S32 - HY	S60 - PN	K32 - PN / K40 - PN
Valve gate gr.code / Codice gr.otturatore	E21105 - *	E21474 - *	E19399 - *	E21487 - *	E18327	E18326 / E18329
Nozzle type / Tipo ugello	TFØ12/17/23 - TDØ18/22	TFØ12/17/23/32 - TDØ18/22/30		FNØ46 - DNØ44	TFØ12/17/23/32 - TDØ18/22/30	FNØ46 - DNØ44
Manifold type / Tipo piastra	B - bolted down					
Valve gate type / Tipo gr.otturatore	S					
Valve gate type / Tipo gr.otturatore	S20 - HY	S28 - PN	S32 - PN	S32 - HY		
Valve gate gr.code / Codice gr.otturatore	E21360	E21492	E21361	E21362		
Nozzle type / Tipo ugello	TFØ12/17/23 - TDØ18/22	TFØ12/17/23/32 - TDØ18/22/30		TFØ12/17/23/32 - TDØ18/22/30		



**S28-PN**

"S" TYPE VALVE GATE GROUP - BORE PISTON 28 - PNEUMATIC  
GRUPPO OTTURATORE TIPO "S" - ALESAGGIO PISTONE 28 - PNEUMATICO



Z = Pin stroke 10 mm (for TF3Ø 12 stroke 7 mm) / Corsa spillo 10 mm (per TF3Ø 12 corsa 7 mm)

M = Manifold height / Altezza distributore

H = Pin length / Lunghezza spillo

Not suggested for filled resins and technical polymers. All applications subjected to Thermoplay A.E. review  
Non indicato per materiali caricati e polimeri tecnici. Tutte le applicazioni sono sono soggette a verifica in fase di offerta

FOR NOZZLES / PER UGELLI

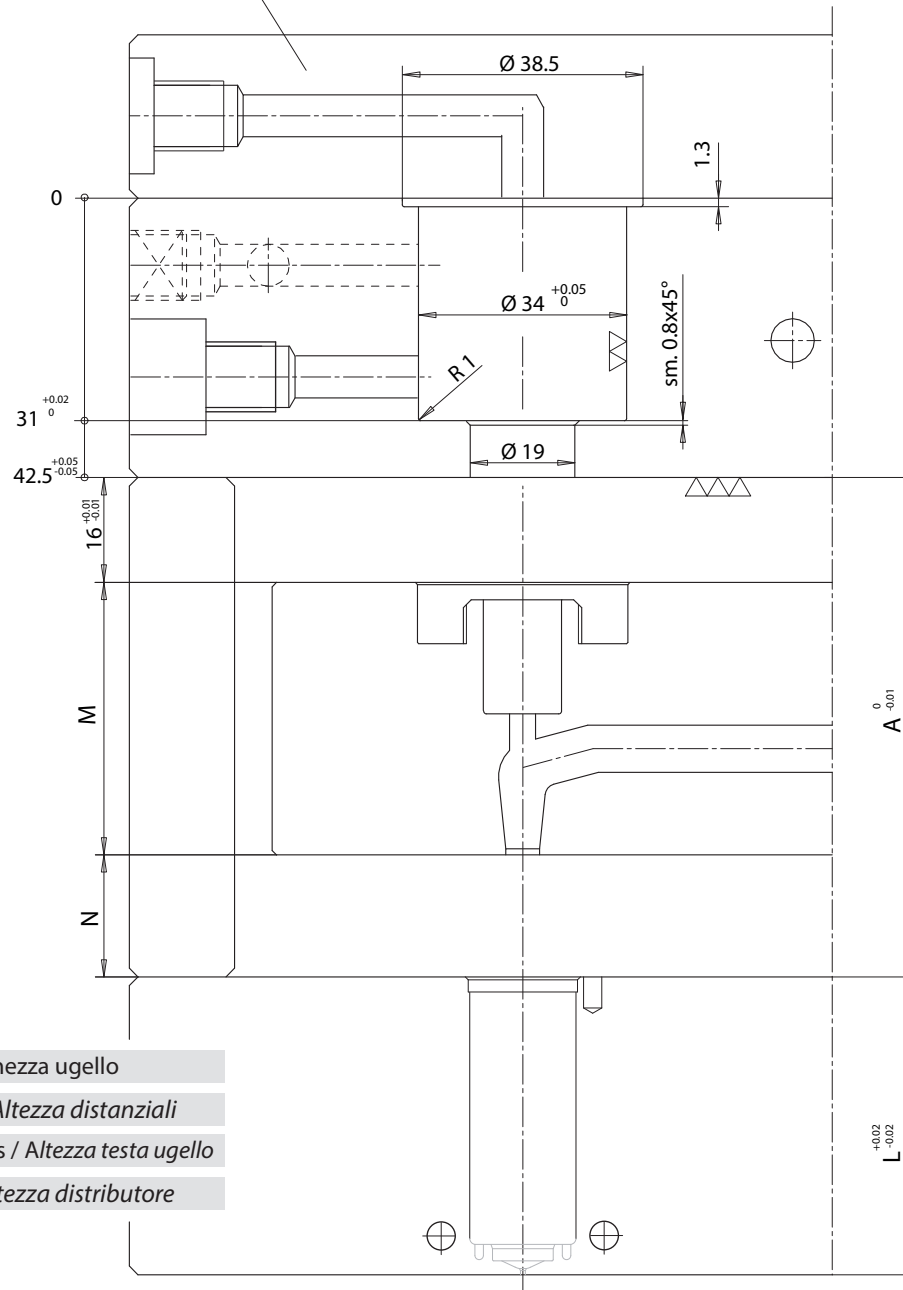
**TF3 Ø12 - TF3-TF3B-TF3DSL A-TF3DSL U Ø17-23 - TD3 Ø18-22**



"S" TYPE VALVE GATE GROUP CUT OUT - BORE PISTON 28 - PNEUMATIC  
SEDE GRUPPO OTTURATORE TIPO "S" - ALESAGGIO PISTONE 28 - PNEUMATICO

**S28-PN**

Piastra in acciaio bonificato 110 Kg/mm<sup>2</sup>  
in alternativa acciaio temprato HRc 42-46  
Plaque en acier trempé et revenu 110 Kg/mm<sup>2</sup>  
en alternative acier trempé HRc 42-46



**L** = Nozzle length / Lunghezza ugello

**A** = Spacers thickness / Altezza distanziali

**N** = Nozzle head thickness / Altezza testa ugello

**M** = Manifold height / Altezza distributore

**ATTENZIONE!**

Si consiglia di non azionare il gruppo otturazione a sistema d'iniezione freddo.

**FUNZIONAMENTO PNEUMATICO consigliati 10 bar.**

Nelle prove eseguite con stampo non fissato sulla pressa **NON** utilizzare pressioni oltre i 5 bar.

**ATTENTION!**

Do not activate the shut off group when the injection system is cold

**PNEUMATIC OPERATION: 10 bar ADVISED**

When testing the injection system on the bench, use 5 bar maximum pressure.

Not suggested for filled resins and technical polymers. All applications subjected to Thermoplay A.E. review  
Non indicato per materiali caricati e polimeri tecnici. Tutte le applicazioni sono sono soggette a verifica in fase di offerta

FOR NOZZLES / PER UGELLI

**TF3 Ø12 - TF3-TF3B-TF3DSL A-TF3DSL U Ø17-23- TD3 Ø18-22**



S20-HY

S28-PN

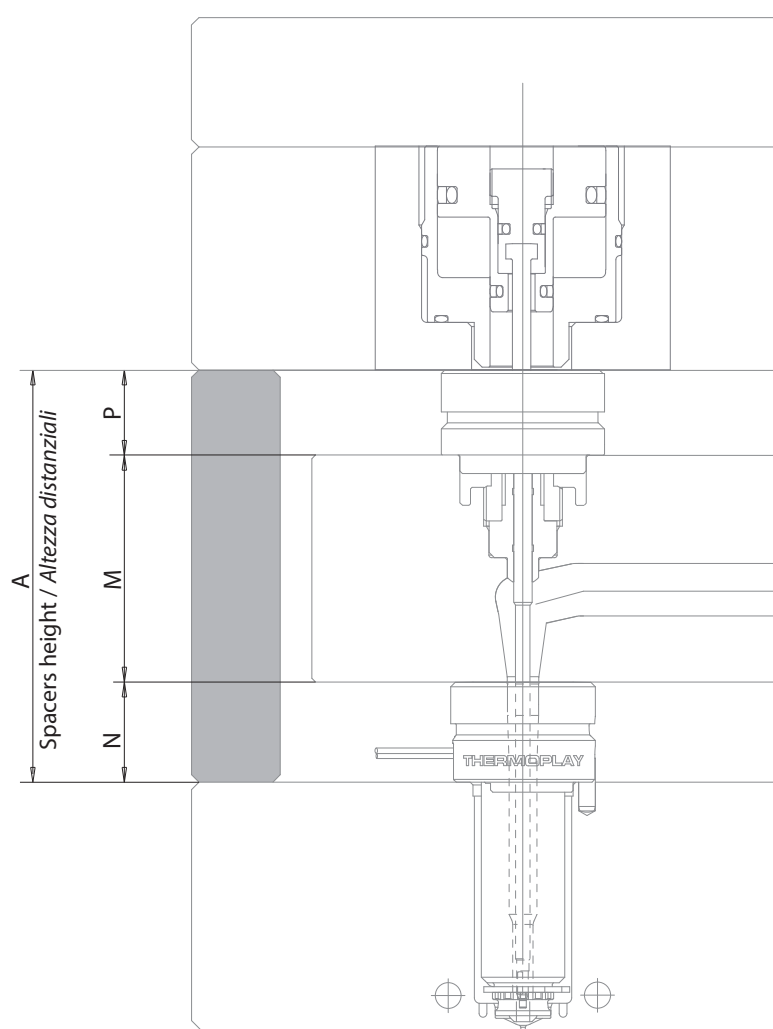
S32-PN

S32-HY

S60-PN

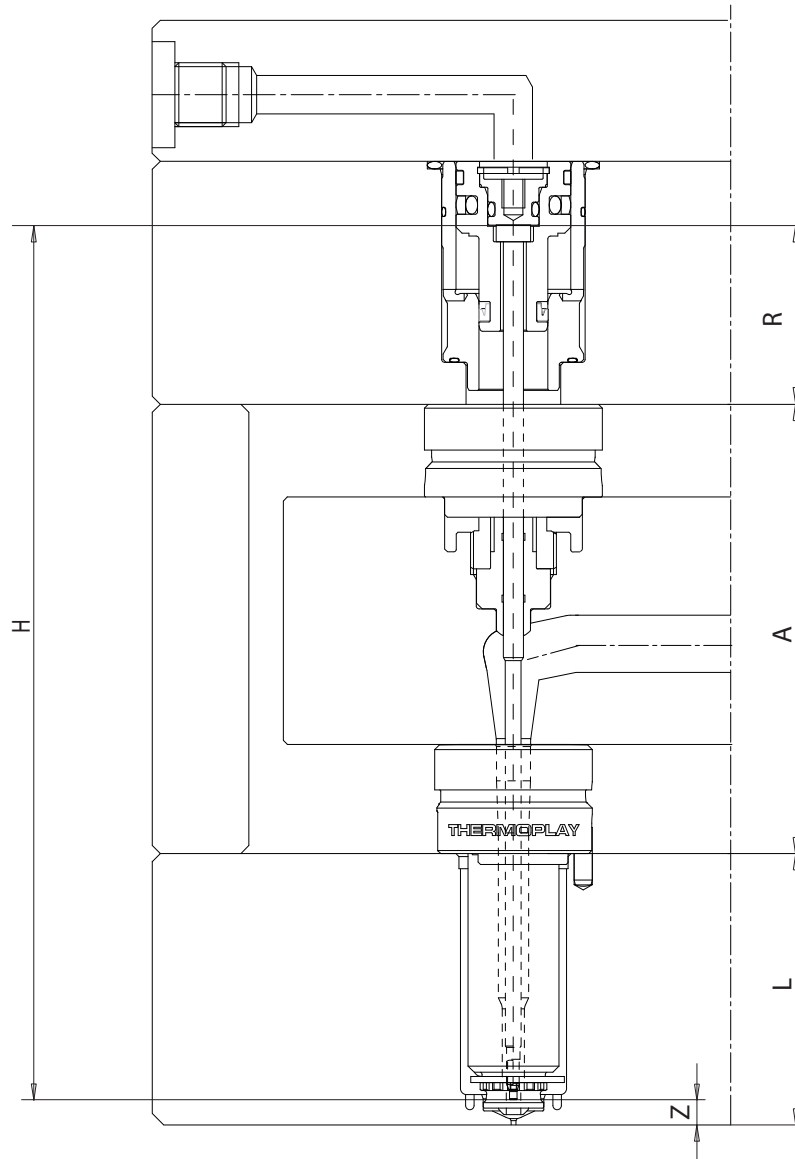
K32-PN

K40-PN



$$A = (N+M+P)+[(N+M+6) \times \Delta t \times K]-0.05 = \text{mm}$$

<b>A</b>	Spacer height / Altezza distanziali								
	<b>Nozzle type / Tipo ugelli</b>								
	TF12	TF17	TF23	TF32	TF46	TD18	TD22	TD30	TD44
<b>N</b>	13	18	20	20	25	18	20	20	25
<b>M</b>	Manifold height / Altezza distributore								
	<b>Actuator group / Gruppo otturatore</b>								
	S20HY	S28PN	S32HY	S32PN	S60PN	K32PN	K40PN		
<b>P</b>	16				20		21.5	30.5	
<b>ΔT</b>	Temperature difference between manifold and mold / Differenza di temperatura tra canale caldo e stampo								
<b>k</b>	Coefficient of thermal expansion for steel / Coeficente di dilatazione termica dell'acciaio 0.0000125								
<b>0.05</b>	Theoretical compression value / Valore teorico di chiusura								



S20-HY

S28-PN

S32-PN

S32-HY

S60-PN

$$H = (L+A+R-Z) - [(L+A+R-Z) \times \Delta t \times k] + n = \text{mm}$$

H	Pin length (cold) / Lunghezza spillo a freddo
---	---

L	Nozzle length / Lunghezza ugello
---	----------------------------------

A	Spacer height (including expansion) / Misura dei distanziali comprensiva della dilatazione per il serraggio
---	---

Valve gate group type / Tipo gruppo otturatore

	S20HY	S28PN	S32HY	S32PN	S60PN
R	31.4	23.95		35.45	
Z	10		16		

Nozzle TIP type / Tipo puntale ugello

	TF3/3B-TF3D/3DSL A all diameters	TD18/22/30/44-3	TF17/23-TF32 - 3DSL U	TF46-3DSL U
n	0.2		0.64	1.76

k	Coefficient of thermal expansion for steel / Coeficiente di dilatazione termica dell'acciaio 0.0000125
---	--

ΔT	Temperature difference between manifold and mold / Differenza di temperatura tra canale caldo e stampo
----	--

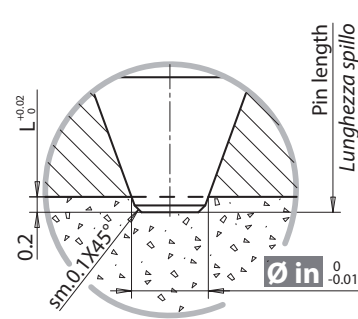
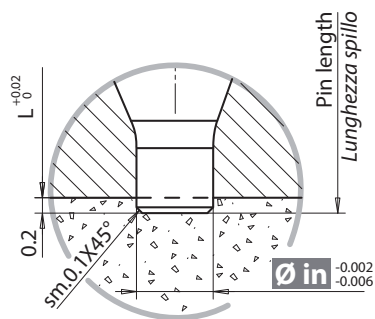
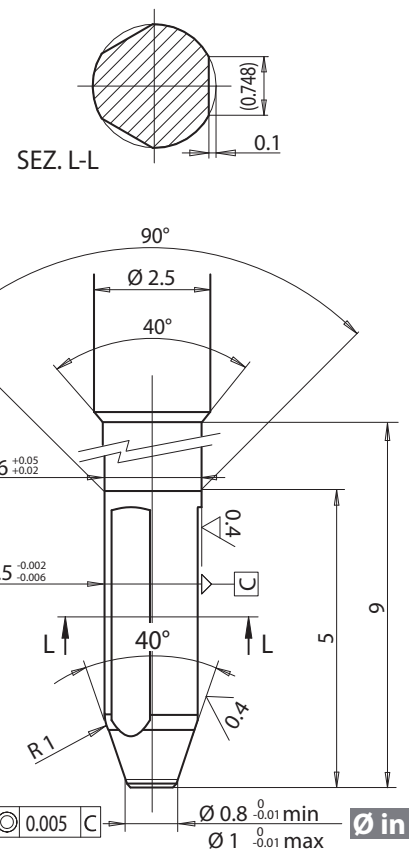
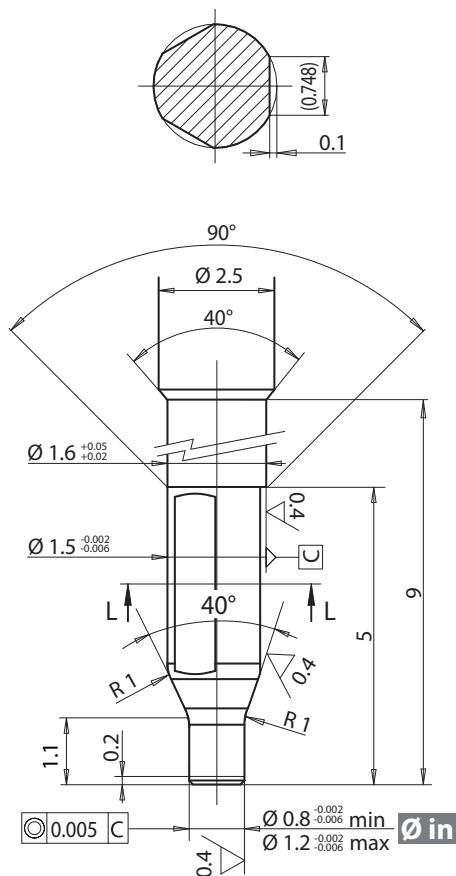


NOZZLE / UGELLO  
**TF3 Ø12**

INDICATIONS FOR EXECUTION OF PIN PROFILE / INDICAZIONI PER L'ESECUZIONE DEL PROFILO PUNTA SPILLO  
(execution customer care - a cura cliente)

## CILINDRIC / CILINDRICO

## CONICAL / CONICO



### ATTENTION - ATTENZIONE!

With conical shut off, if pin stroke adjustment or length are not correct, damage can occur to steel in the gate area.  
*Nella chiusura conica l'errata regolazione della corsa dello spillo o della sua lunghezza potrebbero causare danni alla matrice*

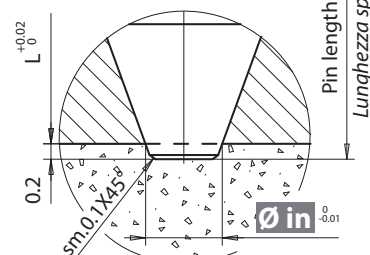
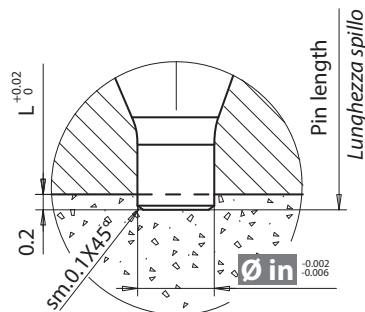
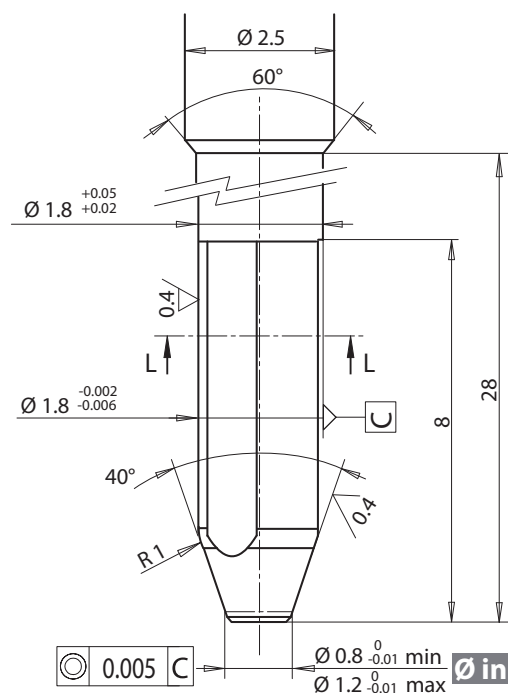
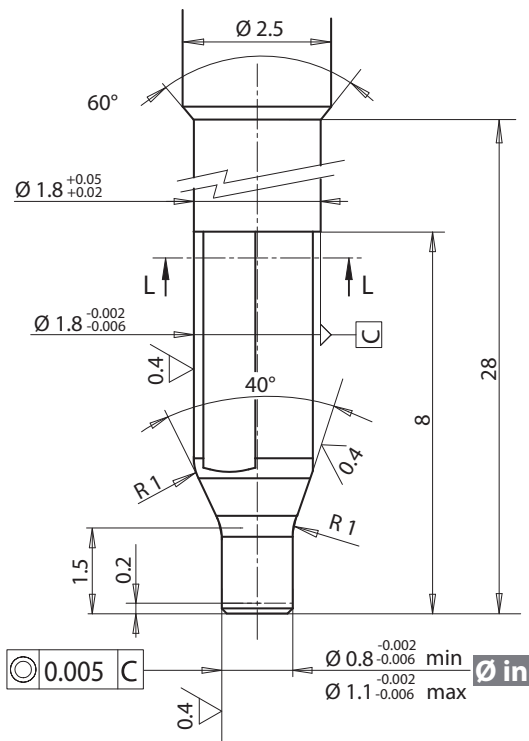
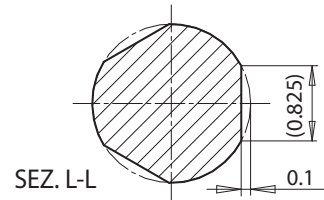
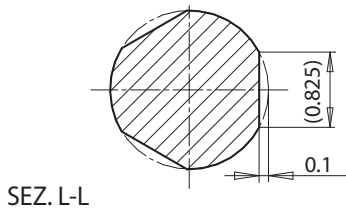


NOZZLE / UGELLO  
**TD3 Ø18**

INDICATIONS FOR EXECUTION OF PIN PROFILE / INDICAZIONI PER L'ESECUZIONE DEL PROFILO PUNTA SPILLO  
(execution customer care - a cura cliente)

**CILINDRIC / CILINDRICO**

**CONICAL / CONICO**



**ATTENTION - ATTENZIONE!**

With conical shut off, if pin stroke adjustment or length are not correct, damage can occur to steel in the gate area.  
*Nella chiusura conica l'errata regolazione della corsa dello spillo o della sua lunghezza potrebbero causare danni alla matrice*

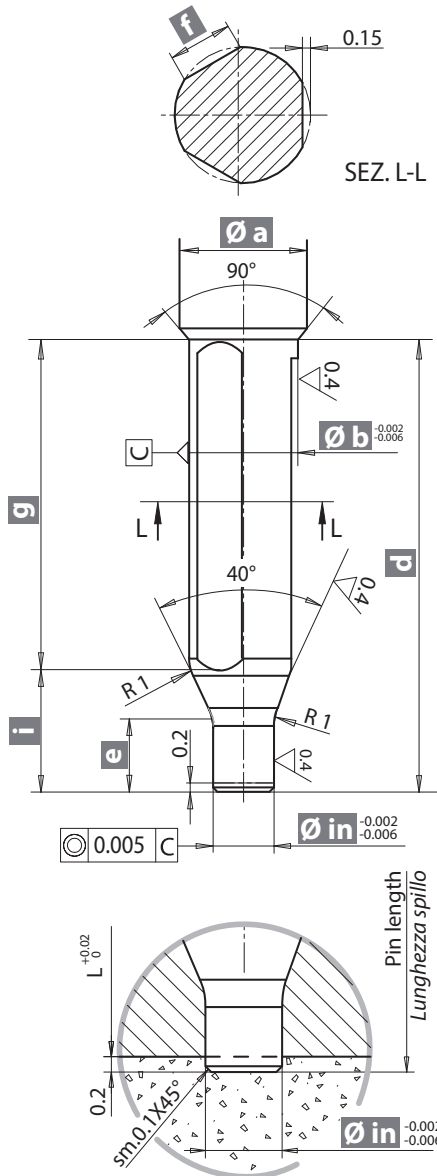




NOZZLE / UGELLO  
**TF3-TF3B-TD3**

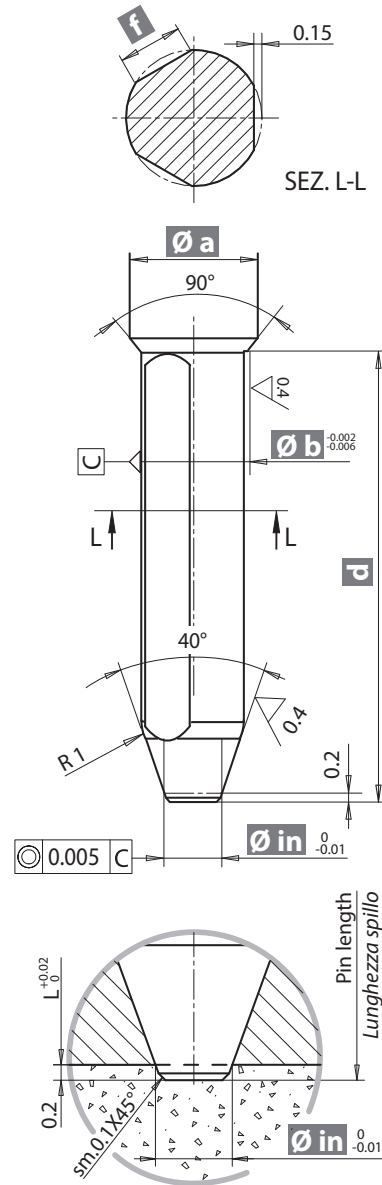
## CILINDRIC / CILINDRICO

(execution customer care - a cura cliente)



## CONICAL / CONICO

(execution customer care - a cura cliente)



### ATTENTION - ATTENZIONE!

With conical shut off, if pin stroke adjustment or length are not correct, damage can occur to the gate area.  
Nella chiusura **conica** l'errata regolazione della corsa dello spillo o della sua lunghezza potrebbero causare danni alla matrice

### CILINDRIC / CILINDRICO

#### Nozzle type / Tipo ugello

TF17	TF23	TF32	TF46	TD22	TD30	TD44	
0.8	0.8	1.6	3.5	0.8	1.6	3.5	Ø in min
1.8	2	3	5.5	1.3	2	4	Ø in max
2.5	2.5	3.3	5.8	2.5	3.3	5.8	Ø a
2.4	2.4	3.2	5.7	2.4	3.2	5.7	Ø b
9	9	9	13	9	9	13	d
1.5	1.5	1.8	2.2	1.5	1.8	2.2	e
1.16	1.16	1.35	1.82	1.16	1.35	1.82	f
-	-	7.7	11.2	-	7.7	11.2	g
-	-	1.3	1.8	-	1.3	1.8	i

### CONICAL / CONICO

#### Nozzle type / Tipo ugello

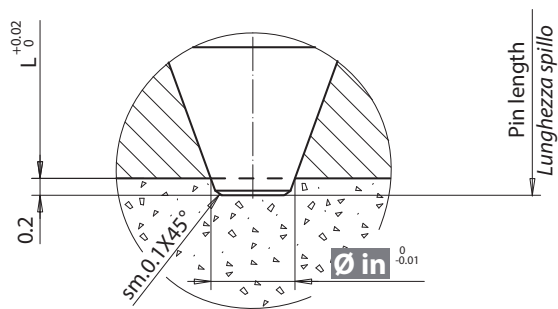
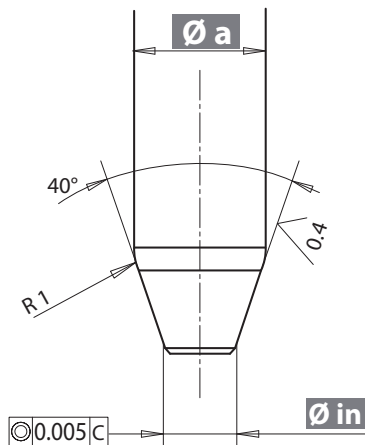
TF17	TF23	TF32	TF46	TD22	TD30	TD44	
0.8	0.8	1.6	3.5	0.8	1.6	3.5	Ø in min
1.3	1.3	2.5	4.5	1.6	2.5	4.5	Ø in max
2.5	2.5	3.3	5.8	2.5	3.3	5.8	Ø a
2.4	2.4	3.2	5.7	2.4	3.2	5.7	Ø b
9	9	9	13	9	9	13	d
-	-	-	-	-	-	-	e
1.16	1.16	1.35	1.82	1.16	1.35	1.82	f
-	-	7.7	11.2	-	7.7	11.2	g
-	-	1.3	1.8	-	1.3	1.8	i



NOZZLE / UGELLO  
**TF3D-TF3DSL A**

## CILINDRIC / CILINDRICO

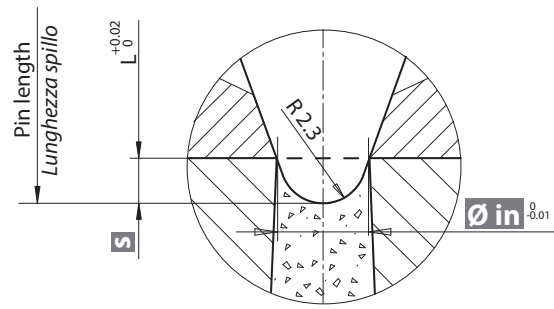
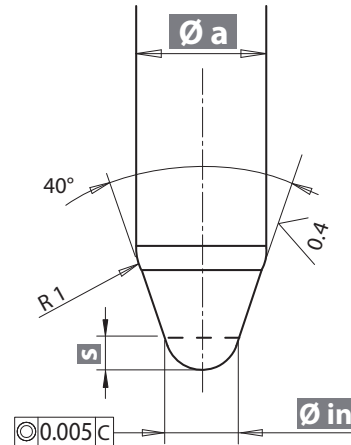
(execution customer care - *a cura cliente*)



NOZZLE / UGELLO  
**TF3DSL U**

## CONICAL / CONICO

(execution customer care - *a cura cliente*)



### ATTENTION - ATTENZIONE!

With conical shut off, if pin stroke adjustment or length are not correct, damage can occur to steel in the gate area.  
Nella chiusura **conica** l'errata regolazione della corsa dello spillo o della sua lunghezza potrebbero causare danni alla matrice

Nozzle type / Tipo ugello								Nozzle type / Tipo ugello						
3D				3DSL A				3DSL U						
TF17	TF23	TF32	TF46	TF17	TF23	TF32	TF46	TF17	TF23	TF32	TF46			
0.8	1.6	3.5		0.9		1.7	3.5	$\varnothing in$	1.3	2.5	4.5			
	1.7	3.6				1.9	3.7							
0.9	1.8	3.7		1.1		2.1	4.1							
	1.9	3.8				2.3	4.3							
1.0	2.0	3.9				2.5	4.5							
1.1	2.1	4.1		1.3										
	2.2	4.2												
1.2	2.3	4.3												
1.3	2.4	4.4												
	2.5	4.5												
2.5	3.3	5.8		2.5	3.3	5.8	$\varnothing a$					2.5	3.3	5.8
--	--	--		--	--	--	$s$					0.63	1.02	1.76