



18LHF

Multi-drop hot runner nozzle for side gating under 90°, without cold slugs, with thick-film heating element (BlueFlow®)

TECHNICAL DATA

18LHF

Melt channel Ød 3.8 mm

Operating voltage 230 V_{AC} *

Quantity of tips 1, 2 or 4

Nominal length of the nozzle (L) in mm

60	80	100
■	■	■

*Volts alternating current

■ available

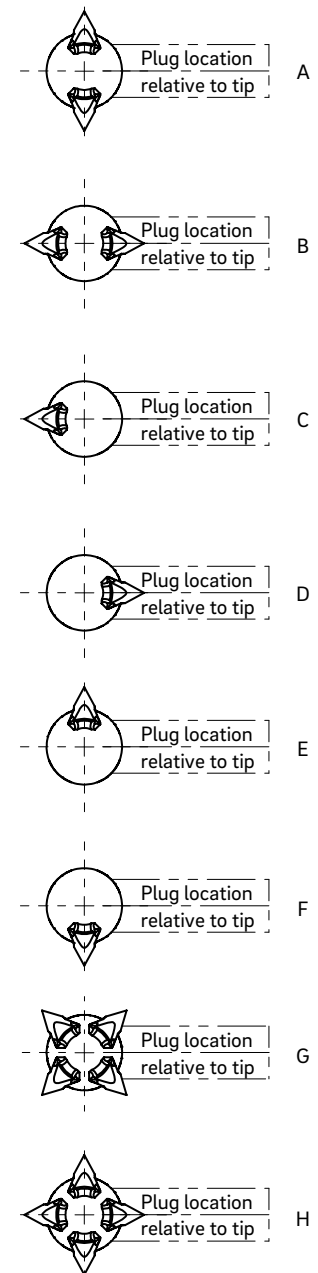
NOTE

Power connector CHF and thermocouple connector CMLK are to be ordered separately.

BlueFlow® hot runner nozzle type 18LHF is not intended for sale or use in the USA or Canada!



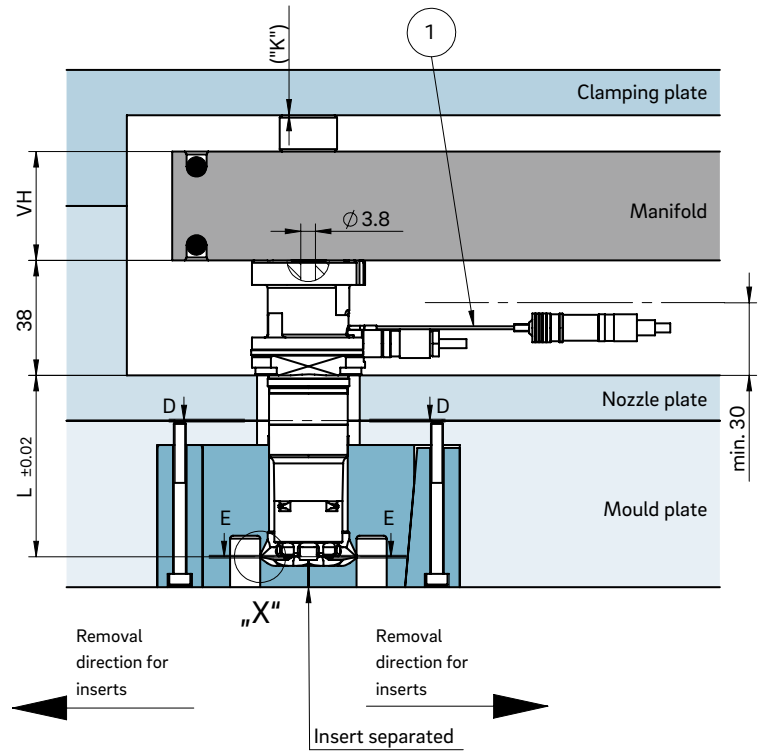
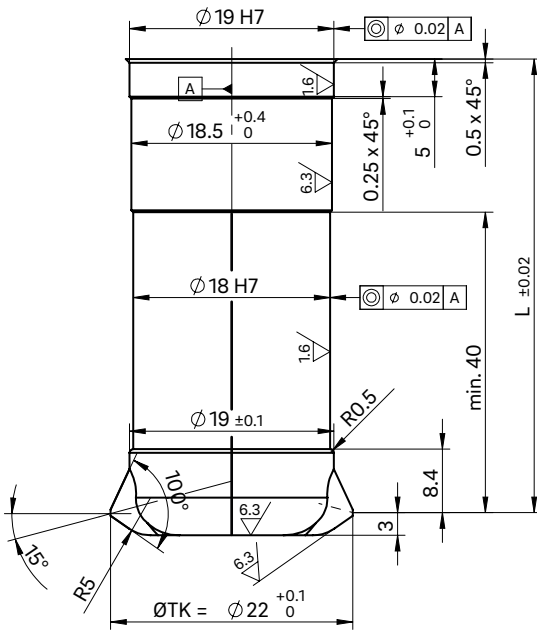
PLUG LOCATION RELATIVE TO TIP



WEBCODE
42040

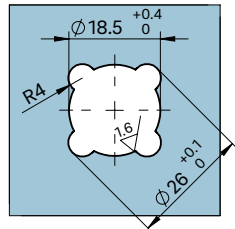
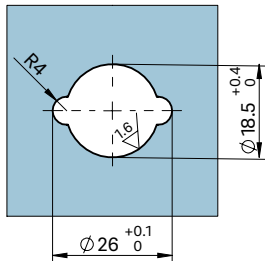


INSTALLATION



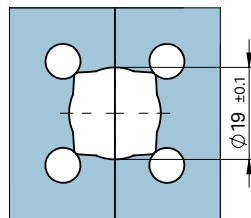
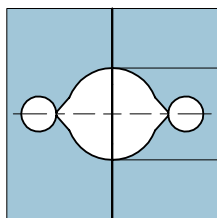
View D-D for two nozzle tips

View D-D for four nozzle tips

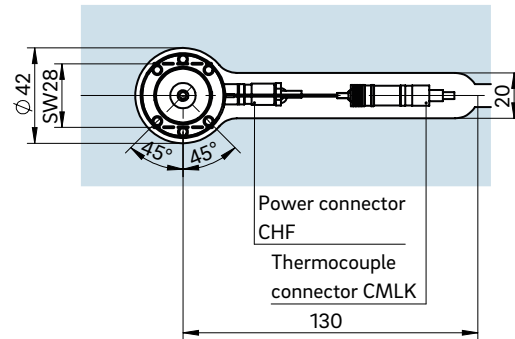


View E-E for two nozzle tips

View E-E for four nozzle tips

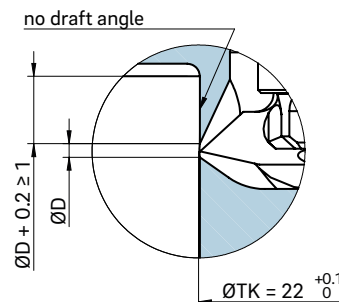


Example cutout for nozzle head, power and thermocouple plug connections

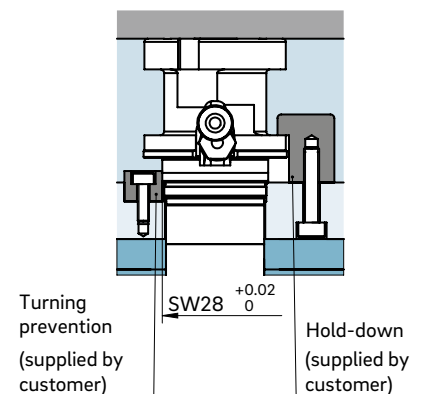


① Thermocouple plug connection in this area can only be bent once; minimum radius: R8
SW = flat area on nozzle head

Detail "X"



Turning prevention



The size "K" required for heat expansion is to be ensured by grinding the pressure pads (12 + 0.1 mm)! Determine the difference between the height of the manifold system and the height of the clamping plate when installed! ΔT specifies the temperature differential between the processing temperature and the mould temperature!

VH	ΔT (°C)	100	150	200	250	300	350
36 mm	K (mm)	0.021	0.059	0.098	0.137	0.177	0.217
46 mm	K (mm)	0.033	0.078	0.124	0.170	0.218	0.264
56 mm	K (mm)	0.046	0.097	0.150	0.203	0.258	0.311

To prevent open jet formations, injection should be carried out against a core, for example.