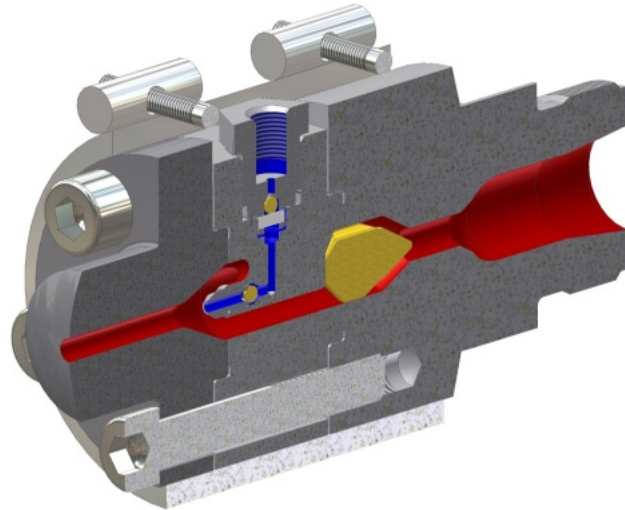


Machine nozzle for GIT Type GM (GasInjectionTechnology)



Applications:
thermoplastics
(not suitable for PVC)

Gas module:
without return gassing
with return gassing (on request)

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Technical description

Under **GasInjectionTechnology GIT** one understands gas delivery in the mass core of the injected part. Principally one differentiates between two different types of injection process:

- Injection in the mold (See mold injectors)
- Gas delivery via the machine nozzle (Theme of this documentation)

How does it work?

The gas searches the easiest way through the soft core of the injected part and displaces the mass until the cavity is filled out.

Since the initial attempts with Gas / Water injection technology, the company Herzog AG has successfully set itself apart with gas introduction components (injectors and machine nozzles).

The machine nozzle is used here, where the gas introduction is to be made by the sprue bushing. This has the advantage that no adjustments must be made at the mold. The resulting opening at the injected part from the gas introduction, can be closed by post-injection.

Note:

Values and dimensions in this documentation refer to standard applications.

Arguments for the machine nozzle Type GM

- Assured gassing via the machine nozzle by the core of the bushing
- Shorter cycle times - increased productivity
- Process reliability and repeatability
- Problem-free installation in a short time
- Usability with increased back pressure - improved homogenization
- Good self-cleaning effect
- Compact design
- Interchange ability of all parts
- Easy to dismantle
- Variably applicable as shut-off nozzle option

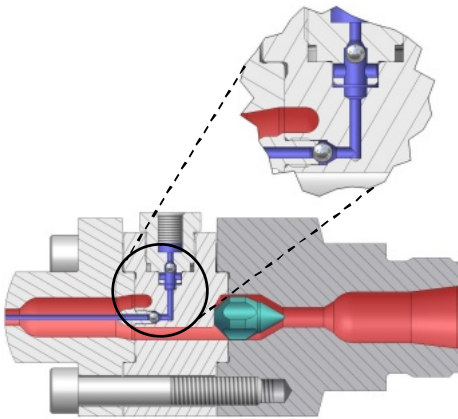
What speaks for Herzog

- Nozzle activity as core business
- Long standing market presence
- Product development and interpretation of today's requirement profiles
- Development of special applications
- Short reaction time (supplies from stock)
- Service

GIT replacement tip for machine shut-off nozzles

In order to be able to use the Herzog® machine shut-off nozzle for the GIT procedure, the needle and Tipp must be replaced. The actual gas injector sits in the Tipp extension of the machine nozzle. The gas inlet range is completely plastic-sealed by a specific valve.

The machine nozzle with shut-off system is additionally used for its actual task and so contributes considerably to a stable and secure process.



For & against

For:

Cost reduction

- Shorter cycle times
- Material saving (~ 30 - 40%)
- Closing force reduction

Quality improvements

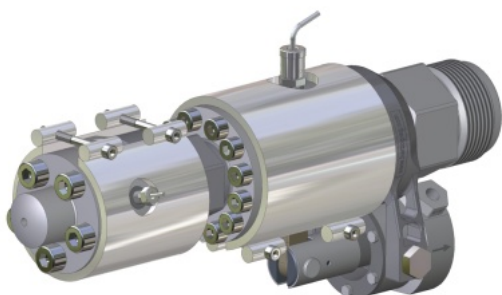
- Even shrinking
- Reduced internal stresses
- Substantially less delay
- Injected parts without sunken areas

Construction

- Increased configuration possibilities

Against:

- Installation must be performed according to instructions



Dimension sheet for Enquiry		or order	Machine nozzle Type GM
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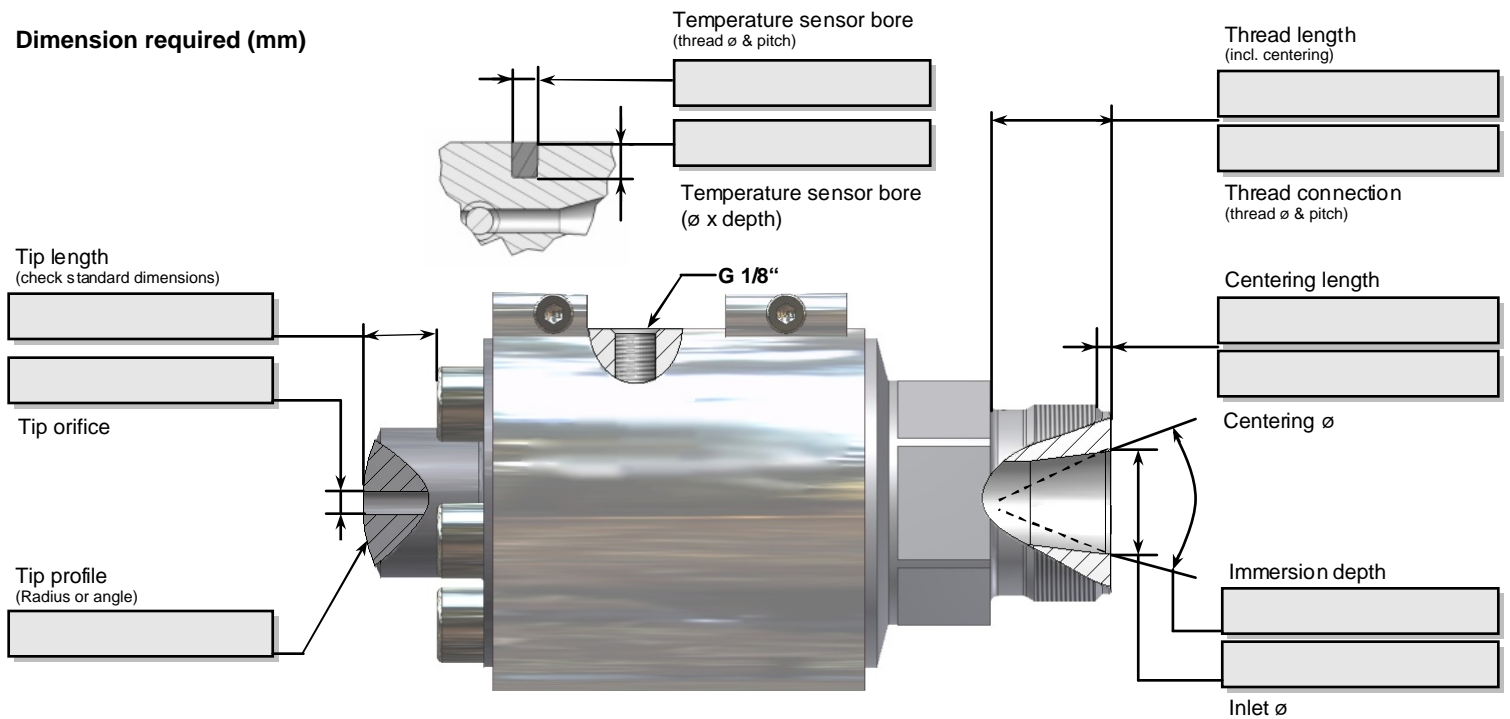
Company:
Street:
City / Zip:
Country:

Contact person:
Tel.:
Fax:
E-Mail:

Operating data and standard dimensions

Max. injection rate cm ³ /s based on Polystyrol (PS)	3500
Approx. screw diameter in mm	up to approx. 120
Closing force in kN	180
Max. injection pressure / temperature	3000 bar / 400°C
Body length; without thread and tip length	97 mm
Heater band dimensions (inside ø * max. length) cable 3m	ø70 x 80 / 700 Watt (230 V)
Tip length (Other dimensions on request)	16 / 26 mm
Optional Variant without tip - Customer specific tip dimensions	
a max. thread ø	30
b max. thread length incl. centering	25

Dimension required (mm)



Machine type (when known):

Option

Temperature sensor - Type J (FeCuNi) **yes**

Note:

- Technical modifications reserved.
- We need additional information for requirements, which vary from our standard range e.g. drawing sample. Our customer services will be pleased to help you.

