

FUCHSLOCHER SHUT-OFF NOZZLES

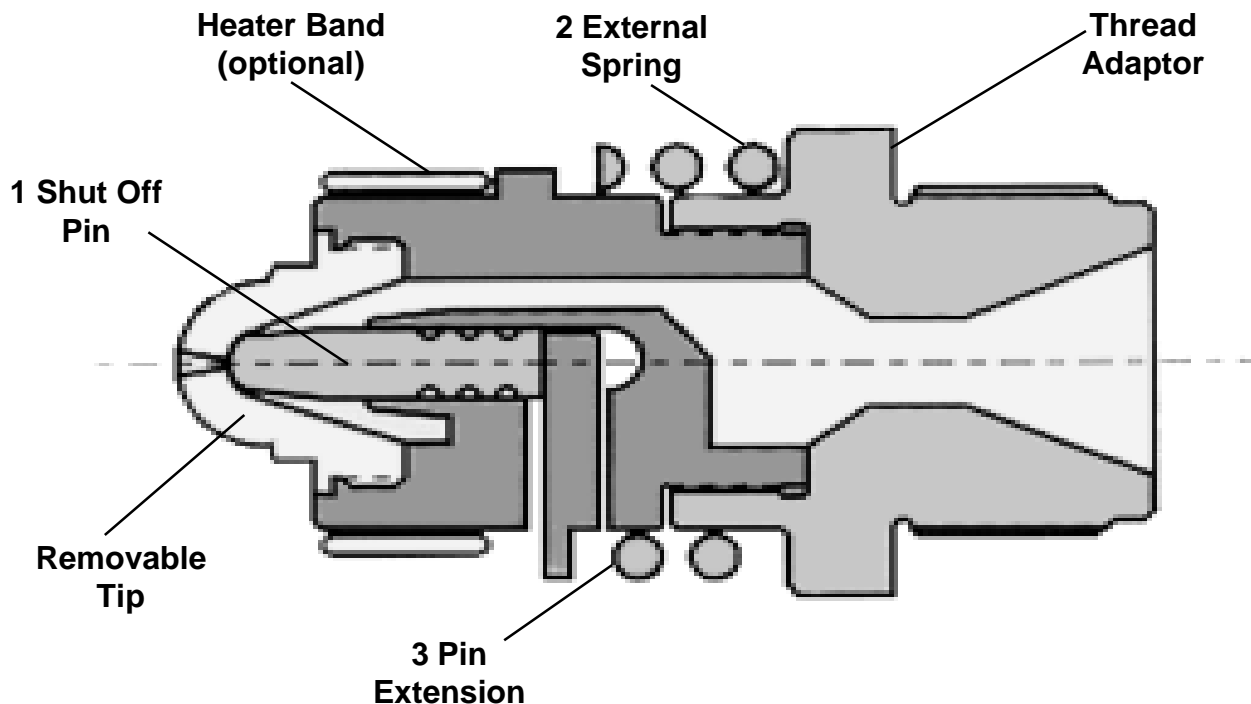
OPERATING PROCEDURES

The Fuschlocher SHUT-OFF NOZZLE is designed to be fully automatic and mechanical. Its movement is generated by the machine injection cycle.

During injection, the plastic material forces the shut-off pin (1) back against the spring tension (2) on the pin extension (3). The material then flows without restriction through the sprue bushing into the mold.

When the injection cycle is complete, no pressure is present. The spring (2) closes the shut-off pin (1) by means of the pin extension (3) against the inside nozzle orifice.

Since the nozzle tip is of a nylon, reverse taper design, cold slugs and stringing are now eliminated.



- **CRACKING PRESSURE 1800 psi**
(Max. Screw Back Pressure)

- **PRESSURE TO OPEN FULLY**

1/8" orifice 1900 psi

5/32" orifice 2000 psi

3/16" orifice 2100 psi

NOTE: Pressures are in lbs. per square inch of plastic melt. In most cases the hydraulic pressure of the machine will be one tenth of the above values. It should be noted, however, that the hydraulic oil to plastic ratio is not always one-to-ten.

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