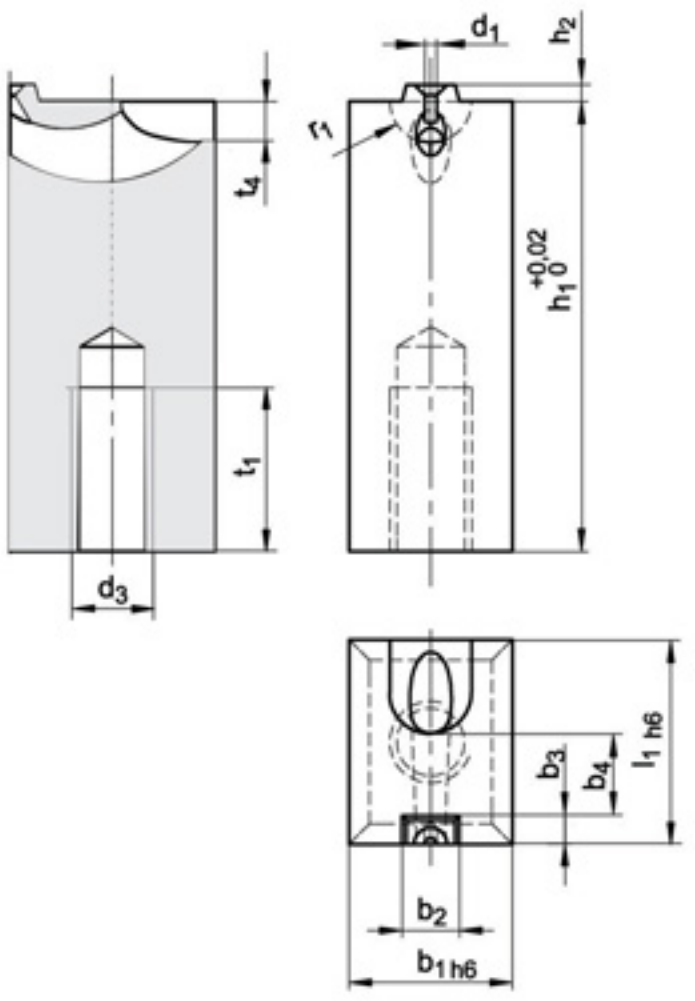
Tunnel gate

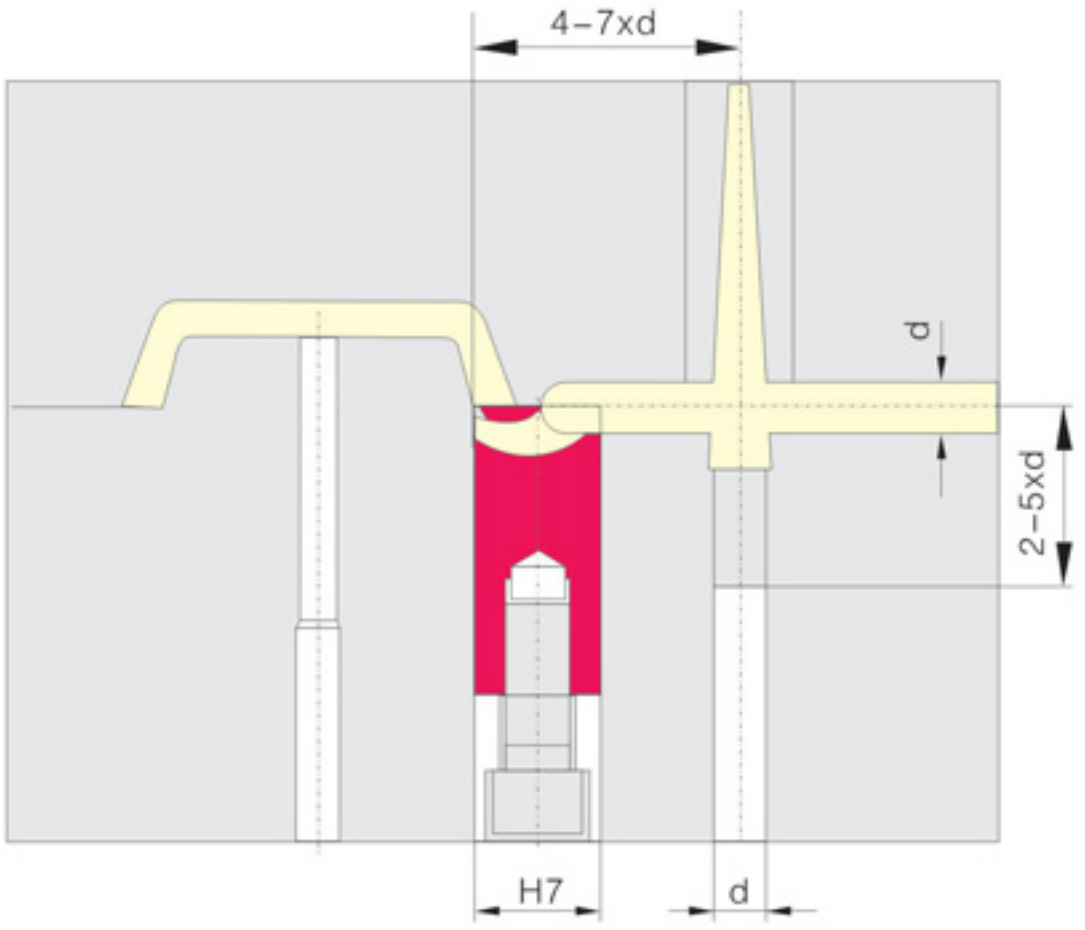
material: 718

r_1	t_1	t_4	b_2	b_3	b_4	d_3	h_2	l_1	b_1	h_1	d_1
1,5	8	2	2,6	1,3	3,7	M4	0,8	8	6	17	0,4 0,6 0,8
2		2	2,6	1,3	3,7			10	8	22	0,6 0,8 1
2,25	10	2,25	3,0	1,5	4,5	M5		12	10	27	0,6 0,8 1
2,5		2,5	3,5	1,75	5	M6		15	12		0,8 1 1,2



Assembly & design

1. According to hardness of plastics, distance of 4 to 7 runner diameters should be kept between burner of pouring head & ejecting point of mandrl in order for pouring head to promise leaving enough demolding space because of adhesion from itself (about 2 to 5 runner diameters)
2. Choose pouring head standard cushion block:L=15,25,35 & 45 mm, adjust cushion block according to height of template.



Tunnel gate is a hiding pouring head model to replace push-cut, pull-cut & second-runner. White halo will be produced on the surface of plastics because of high pressure in push-cut pouring head. Besides, the pouring head still needs manual cutting. Pull-cut will leave pouring head trace on the surface of plastic products. Second-runner & push-cut have the same problem. Tunnel gate simplifies mold pouring head structure. It uses tunnel to pour-in on the thick wall head face of products. This cutting runner structure guarantees smooth separation with plastic products. No obvious trace on the top of pouring head. As compared to other hiding models, resistance of plastics pour-in lowered a lot, makes quality of plastics reaches higher level.

Characteristics:

1. Pouring head & the mold will separate automatically when demolding.

2. The part of puring head becomes a standard part, easy to replace.

3. Appropriate for flat or thin-wall plastic parts.

4. There are 4 specs if divided by pouring head diameter:1.5, 2, 2.25 & 2.5 mm.

5. Use standard pouring head cushion block to adjust assembling height.