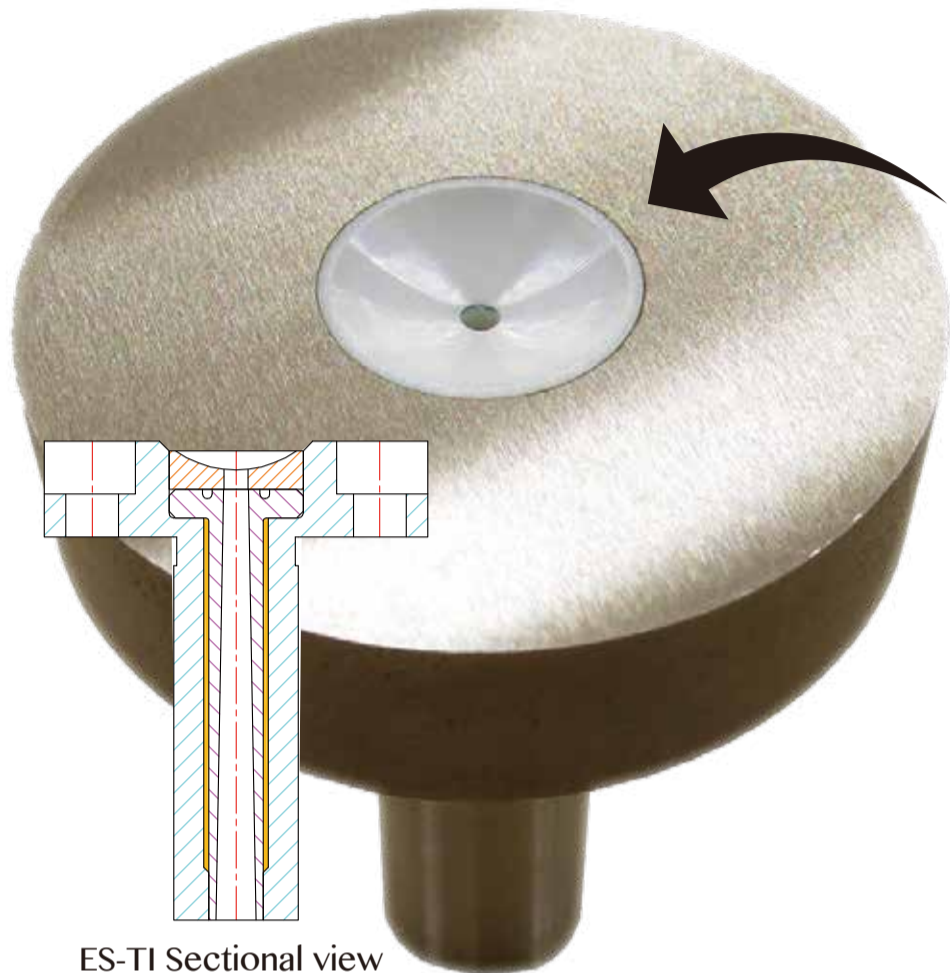


This is ZIRCONIA, but hard to crack!



Combine
a **ZIRCONIA**^{※1} or
TITANIUM
to Bush.

By combining these,
to prevent the generation of a stringing phenomenon
and a nozzle clogging. So, the choice of molding
conditions will spread significantly.

This sprue bush is effective in not only PA but also
other materials. Please feel free to contact us for
further details!

【Nozzle clogging/stringing temperature】

Molding machine	30t	Resin	PA66 Nylon	Cooling time	15sec
Mold temperature	80°C	Resin temperature	285°C		

Nozzle set temperature(°C)	Nozzle insulation			Maintenance of liquidity	Nozzle insulation & Maintenance of liquidity	
	Normal(φ2)	N-TI(φ2)	N-ZI(φ2)	E.S.(φ2)	ES-TI(φ2)	ES-ZI(φ2)
245						
250						
255			Nozzle clogging			Nozzle clogging
260			Molding OK			Molding OK
265		Nozzle clogging	Molding OK		Nozzle clogging	Molding OK
270		Molding OK	Molding OK	Nozzle clogging	Molding OK	Molding OK
275		Molding OK	Molding OK	Molding OK	Molding OK	Molding OK
280		Molding OK	Molding OK	Molding OK	Molding OK	Molding OK
285	Nozzle clogging	Molding OK	Stringing	Molding OK	Molding OK	Stringing
290	Molding OK	Molding OK		Molding OK	Molding OK	
295	Molding OK	Stringing		Stringing	Stringing	
300	Stringing					
305						

± 0 °C 20°C insulation 30°C insulation 15°C insulation 20°C insulation 30°C insulation

Compared to the normal sprue, it can be molded
20-35°C lower temperature at the nozzle.
Since the choice of molding conditions spreads, it enables the stability of molding.

※1: Zirconia ceramics has excellent strength as compared with conventional products.
However, please note that there is a possibility that crack by use.