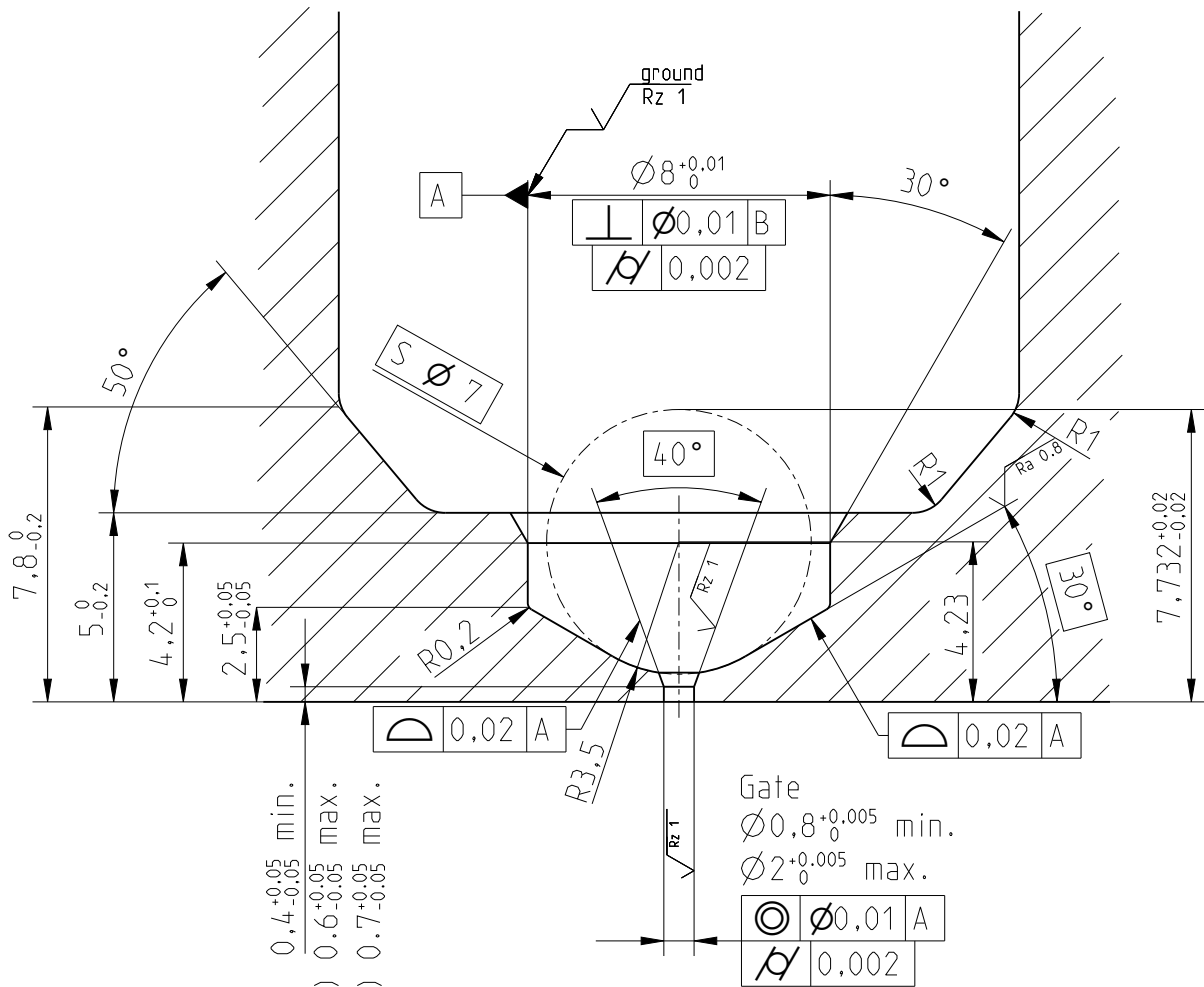


- At the area of the nozzle gate, hardened steel (52+2/-1) is recommended by Männer.
- Männer recommend that the sealing surface Ø8 and gate area are manufactured by grinding and not EDM with a surface quality of Rz 1.
- Machine the gate hole after the hardening to avoid excessive quench in the thin section during heat treat & resulting overhardening in the gate.

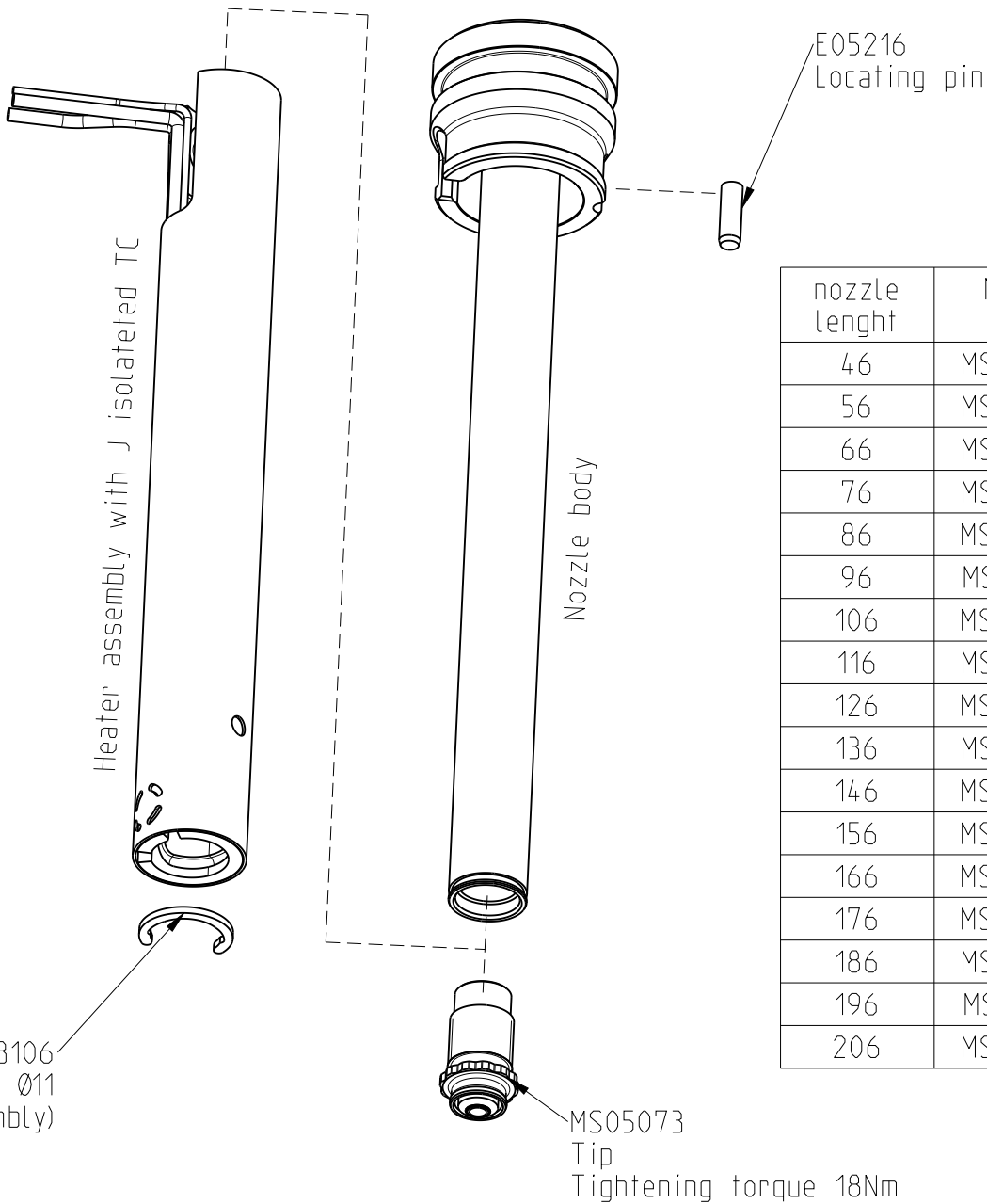


-Gate diameter is approximate and could vary depending on injected volume and part wall thickness.  
-Use all geometric information for gate diameter and cylindrical gate height from the associated general assembling drawing.

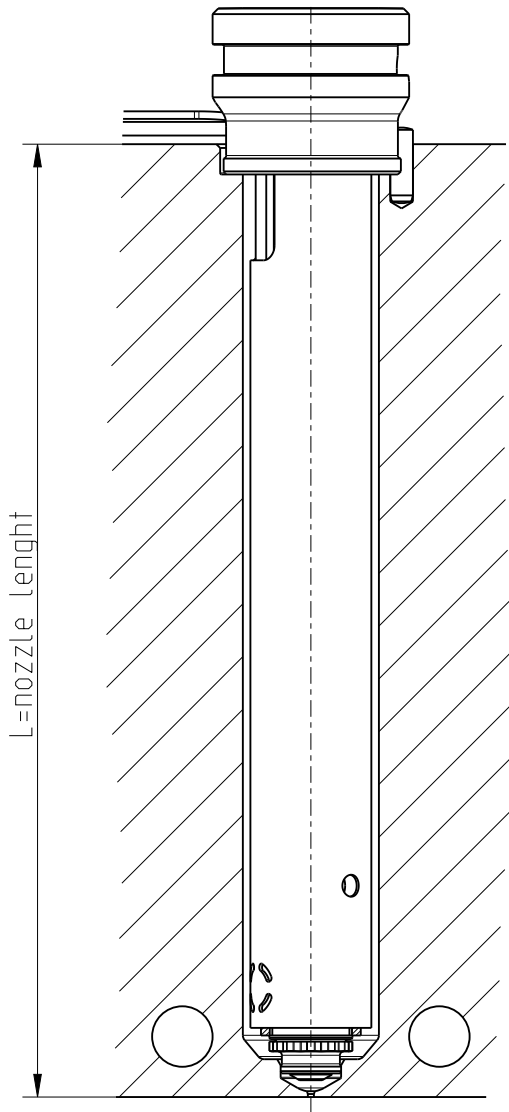
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date		name		modification	
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				old id.no:	
pos.		piece		all dimensions in mm	
				material no.	
<div>männer</div> <div>Otto Männer GmbH Unter Gereuth 9-11 D-79353 Bahlingen a.K. www.maenner-group.com</div>				identification number:	
				MPN-08-24-VSA8-A	
				rev :	
				00	
				part number:	
		hardened HRC: --		tool type:	
		nicotrated		high tempered	
		all edges on partingline are sharp		object:	
		exact tuned with molded part		Nozzle MPN-08-24-VSA8-xxx-A	
X		dimensions without tolerance details under DIN ISO 2768-fH		part name:	
		polished		--	
		structured		scale:	
				1/1	
				engineered	
				18/12/25	
				Massara	
				drawn	
				18/12/25	
				Massara	
				checked	
				sheet 1	
				of 3	

nozzle length	Heater assembly with J isolated TC	Power Watt
46	MPH08046-A	200
56	MPH08056-A	200
66	MPH08066-A	200
76	MPH08076-A	200
86	MPH08086-A	220
96	MPH08096-A	220
106	MPH08106-A	220
116	MPH08116-A	220
126	MPH08126-A	220
136	MPH08136-A	240
146	MPH08146-A	240
156	MPH08156-A	240
166	MPH08166-A	240
176	MPH08176-A	260
186	MPH08186-A	260
196	MPH08196-A	260
206	MPH08206-A	260

B03106  
Ring type H Ø11  
(Included in heater assembly)

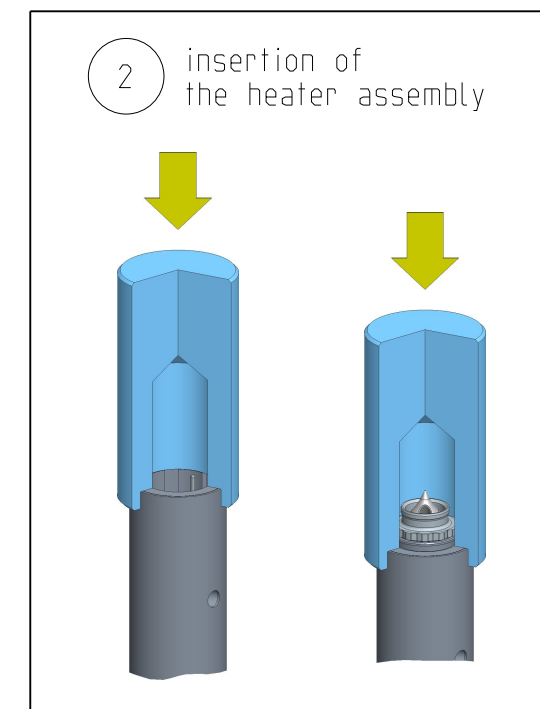
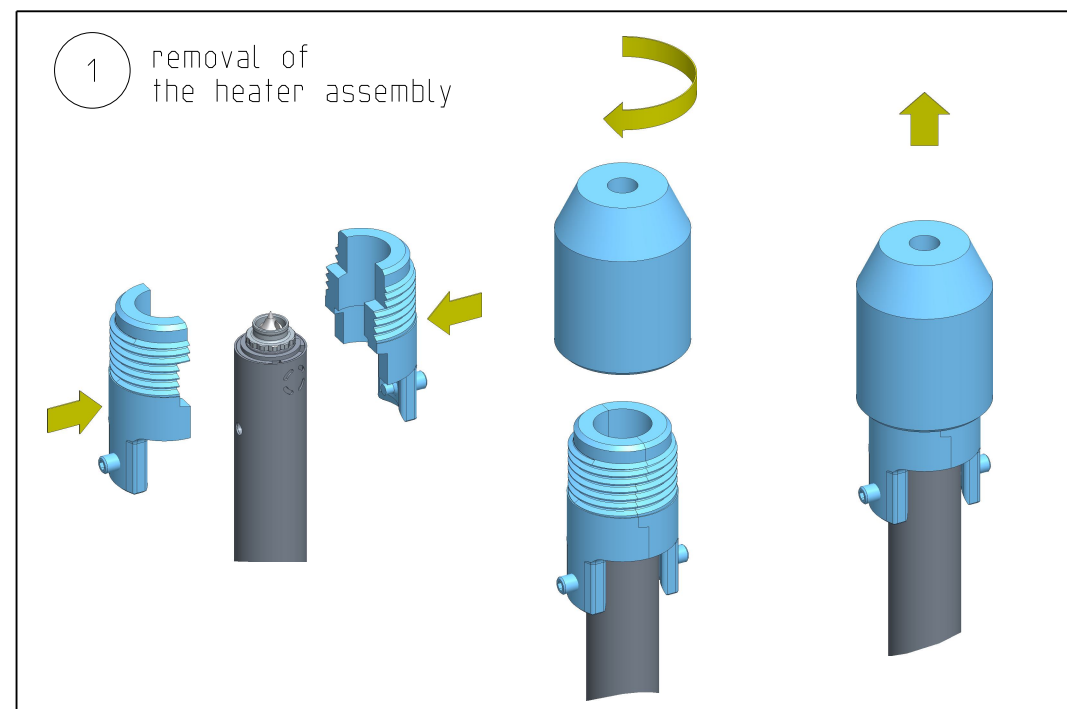
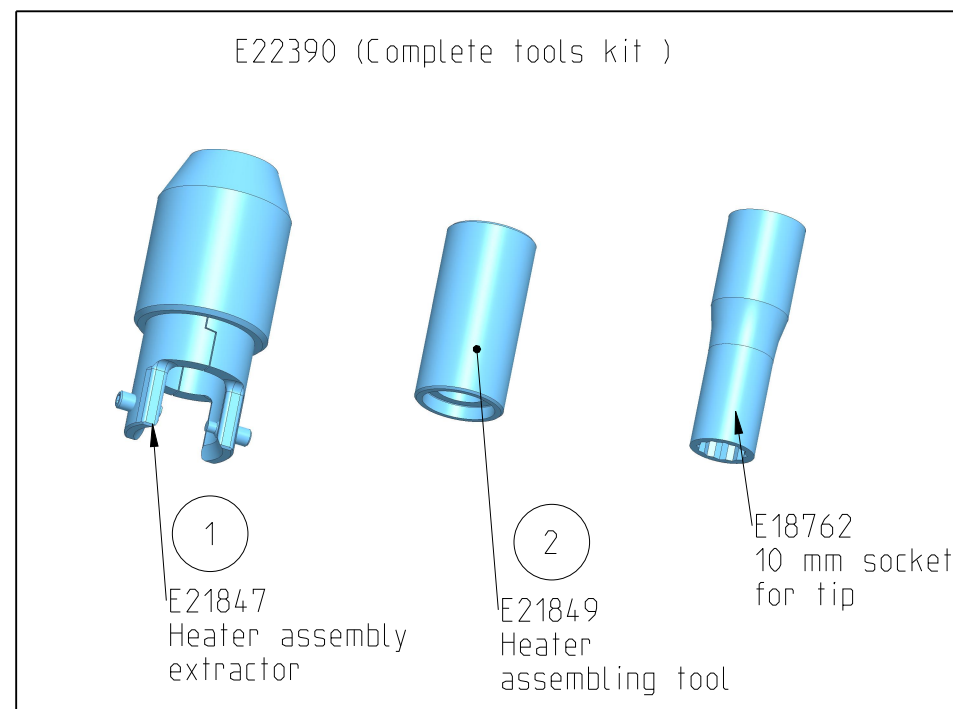


nozzle length	Nozzle body
46	MS05036X
56	MS05037X
66	MS05038X
76	MS05039X
86	MS05040X
96	MS05041X
106	MS05042X
116	MS05043X
126	MS05044X
136	MS05045X
146	MS05046X
156	MS05047X
166	MS05048X
176	MS05049X
186	MS05050X
196	MS05051X
206	MS05052X



hotrunner assembly				Nozzle MPN-08-24-VSA8-xxx-A	
<b>männer</b>				--	--
				Männer Performance Line	
MPN-08-24-VSA8-A.00				--	--

Attention: tools not included in the standard supply.  
Must be ordered separately.



hotrunner assembly				Nozzle MPN-08-24-VSA8-xxx-A
männer		18/12/25	Massara	--
	MPN-08-24-VSA8-A.00			Männer Performance Line
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