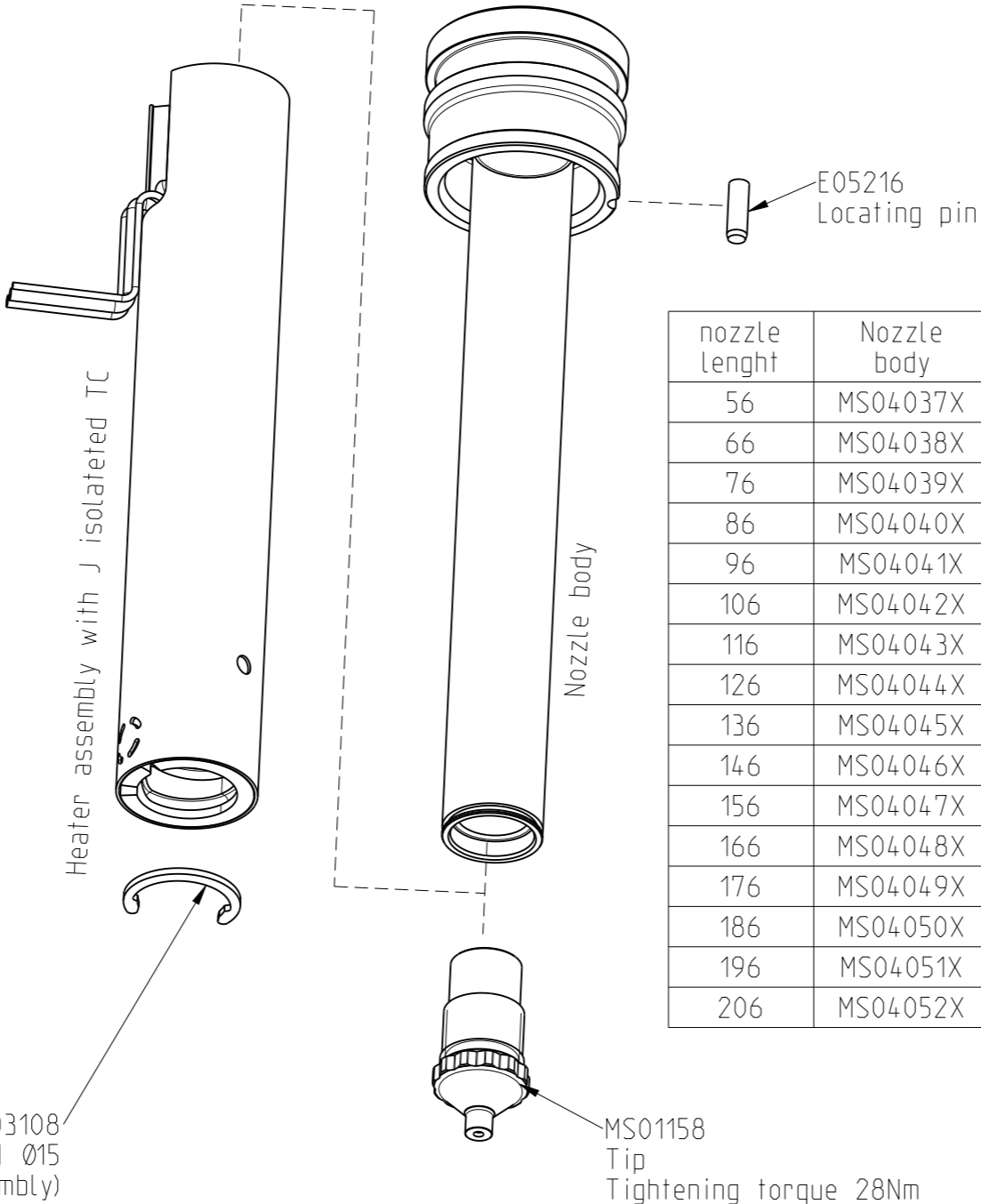


- At the area of the nozzle gate, hardened steel (52+2/-1) is recommended by Männer.
- Männer recommend that the sealing surface Ø4 is manufactured by grinding and not EDM with a surface quality of Rz 1.
- Machine the gate hole after the hardening to avoid excessive quench in the thin section during heat treat & resulting overhardening in the gate.

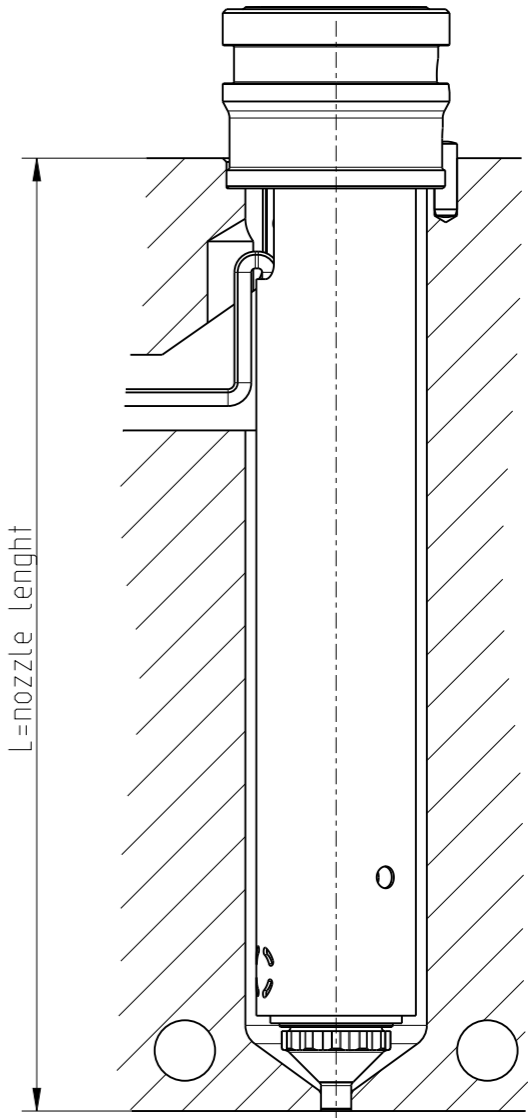
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date	name	modification				
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			-- old id.no:			
pos.	piece	all dimensions in mm	material no.			
<div>männer</div> <div>Otto Männer GmbH Unter Gereuth 9-11 D-79353 Bahlingen a.K. www.maenner-group.com</div>			identification number: <div>MPN-10-29-VP4-M</div>	rev : <div>00</div>		
			part number:			
hardened HRC: --		tool type:	object: <div>Nozzle MPN-10-29-VP4-xxx-A</div>		CREO	
nicotrated	high tempered				A3	
all edges on partingline are sharp			part name: <div>--</div>	scale: <div>1/1</div>	sheet of	1 3
exact tuned with molded part						
X dimensions without tolerance details under DIN ISO 2768-fH						
polished			engineered	18/12/25	Massara	
highly polished			drawn	18/12/25	Massara	
structured			checked			

nozzle length	Heater assembly with J isolated TC	Power Watt
56	MPH10056-M	220
66	MPH10066-M	220
76	MPH10076-M	220
86	MPH10086-M	220
96	MPH10096-M	260
106	MPH10106-M	260
116	MPH10116-M	260
126	MPH10126-M	260
136	MPH10136-M	300
146	MPH10146-M	300
156	MPH10156-M	300
166	MPH10166-M	300
176	MPH10176-M	350
186	MPH10186-M	350
196	MPH10196-M	350
206	MPH10206-M	350

B03108
Ring type H Ø15
(Included in heater assembly)

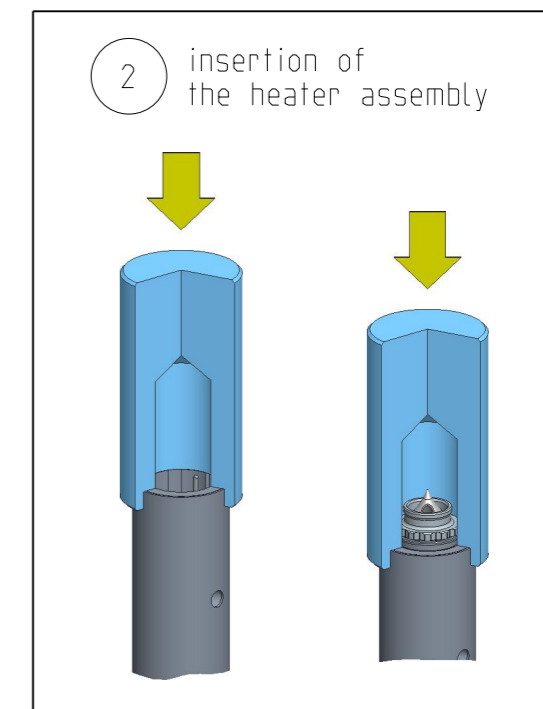
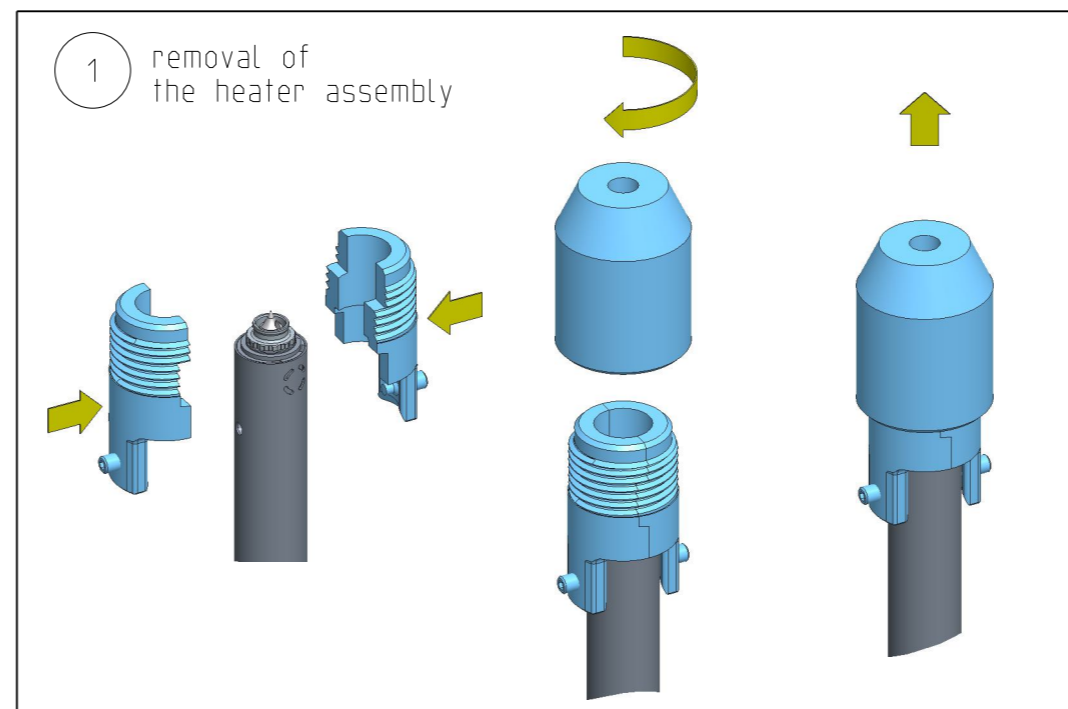
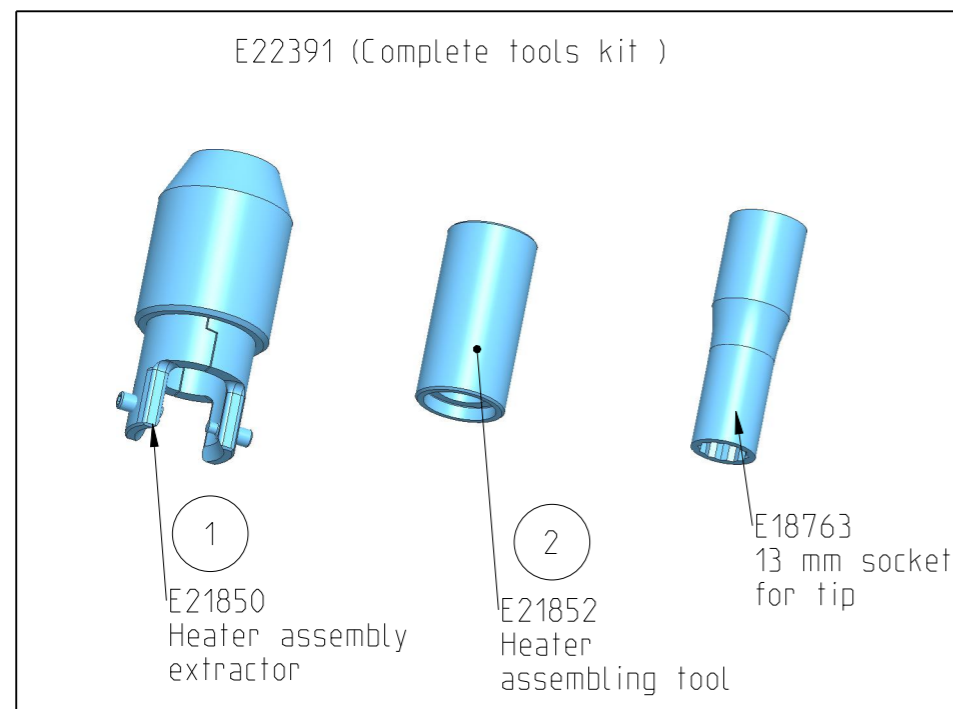


nozzle length	Nozzle body
56	MS04037X
66	MS04038X
76	MS04039X
86	MS04040X
96	MS04041X
106	MS04042X
116	MS04043X
126	MS04044X
136	MS04045X
146	MS04046X
156	MS04047X
166	MS04048X
176	MS04049X
186	MS04050X
196	MS04051X
206	MS04052X



hotrunner assembly				Nozzle MPN-10-29-VP4-xxx-A
männer		18/12/25	Massara	--
	MPN-10-29-VP4-M.00			Männer Performance Line
				--

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



hotrunner assembly				Nozzle MPN-10-29-VP4-xxx-A
männer		18/12/25	Massara	--
	MPN-10-29-VP4-M.00			Männer Performance Line
				--