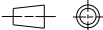


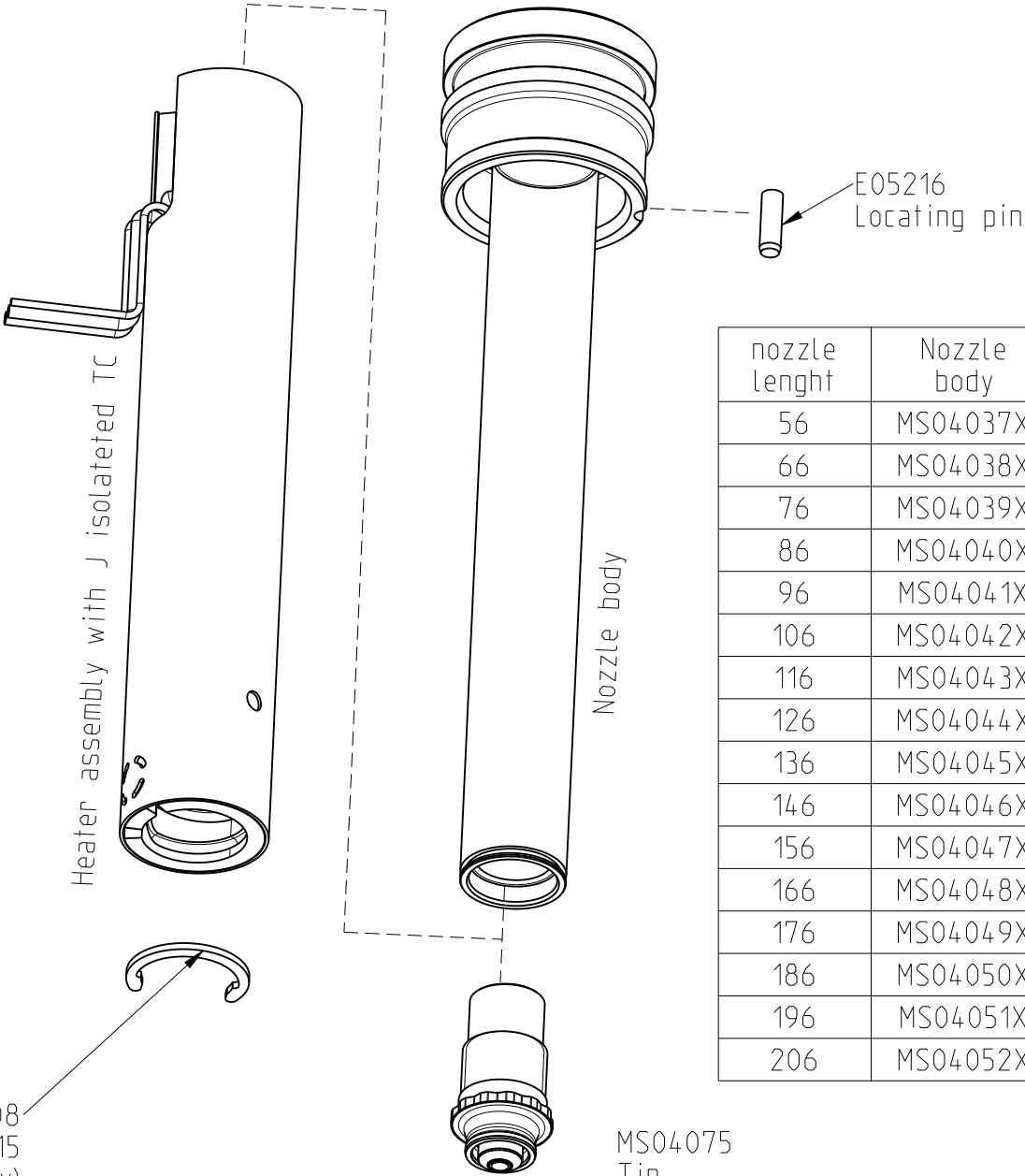
- At the area of the nozzle gate, hardened steel (52+2/-1) is recommended by Männer.
- Männer recommend that the sealing surface Ø10 and gate area are manufactured by grinding and not EDM with a surface quality of Rz 1.
- Machine the gate hole after the hardening to avoid excessive quench in the thin 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.	identification number:		rev :	
<div>männer</div> <div>Otto Männer GmbH Unter Gereuth 9-11 D-79353 Bahlingen a.K. www.maenner-group.com</div>			MPN-10-29-VSA10-M		00		
			part number:				
hardened HRC: --		tool type:	object:			CREO	
nicotrated	high tempered						
all edges on partingline are sharp			Nozzle MPN-10-29-VSA10-xxx-A			A3	
exact tuned with molded part							
X	dimensions without tolerance details under DIN ISO 2768-fH		part name:	scale:	sheet	1	
	polished	highly polished			1/1	of	3
structured							

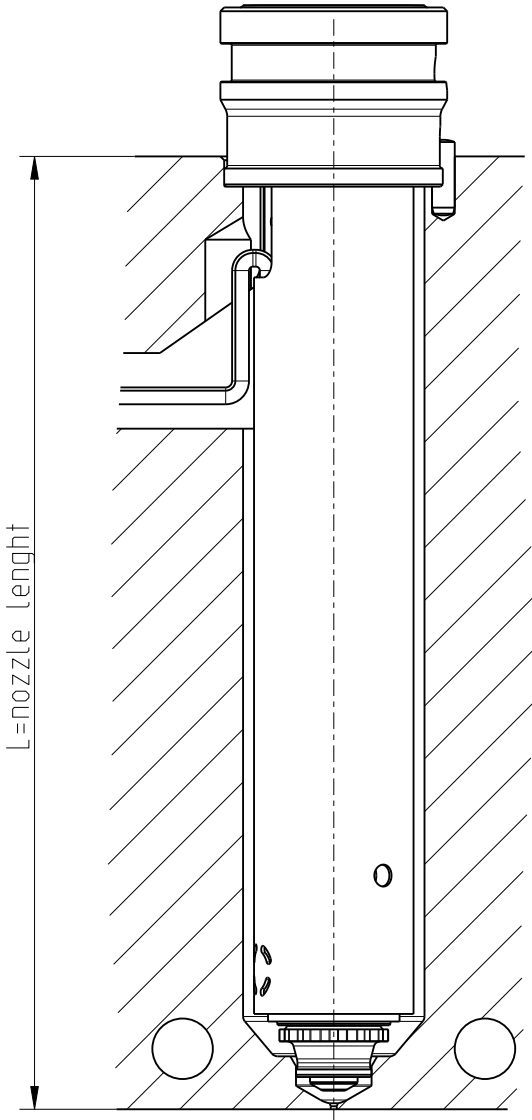
nozzle length	Heater assembly with J isolated TC	Power Watt
56	MPH10056-M	220
66	MPH10066-M	220
76	MPH10076-M	220
86	MPH10086-M	220
96	MPH10096-M	260
106	MPH10106-M	260
116	MPH10116-M	260
126	MPH10126-M	260
136	MPH10136-M	300
146	MPH10146-M	300
156	MPH10156-M	300
166	MPH10166-M	300
176	MPH10176-M	350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

B03108  
Ring type H Ø15  
(Included in heater assembly)



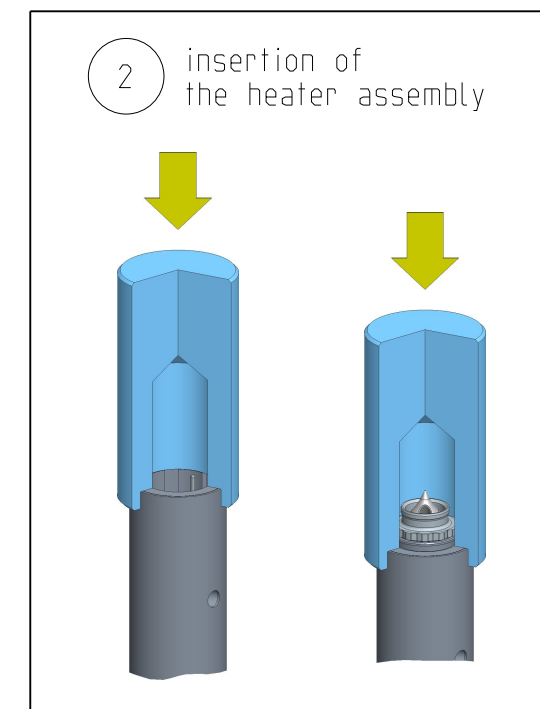
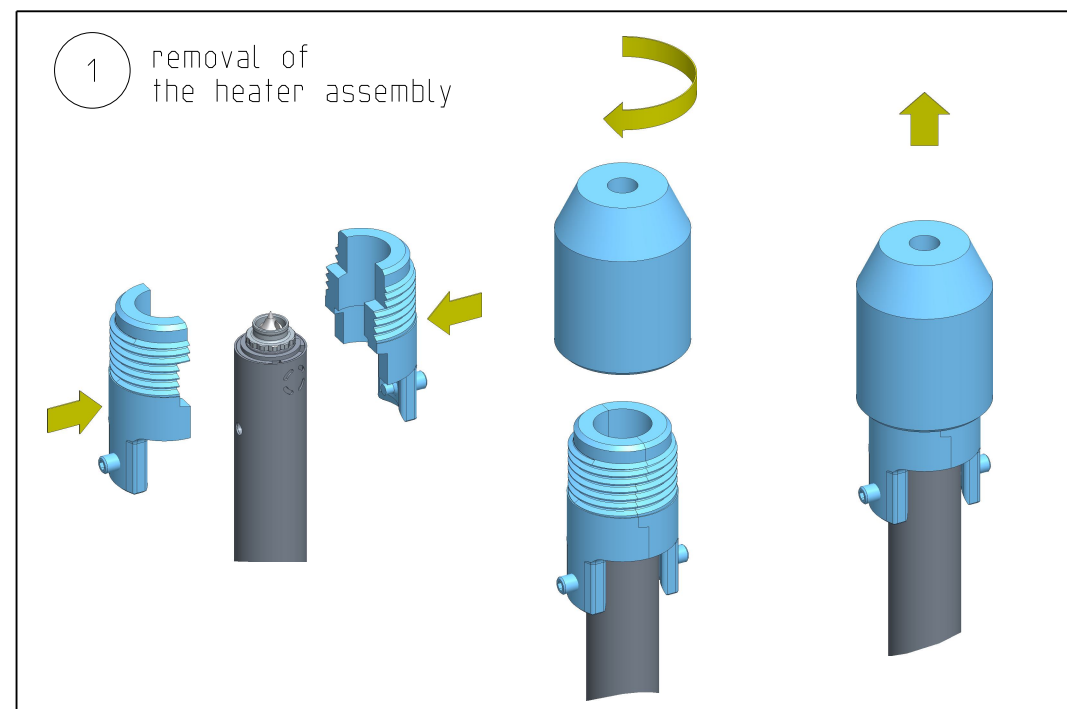
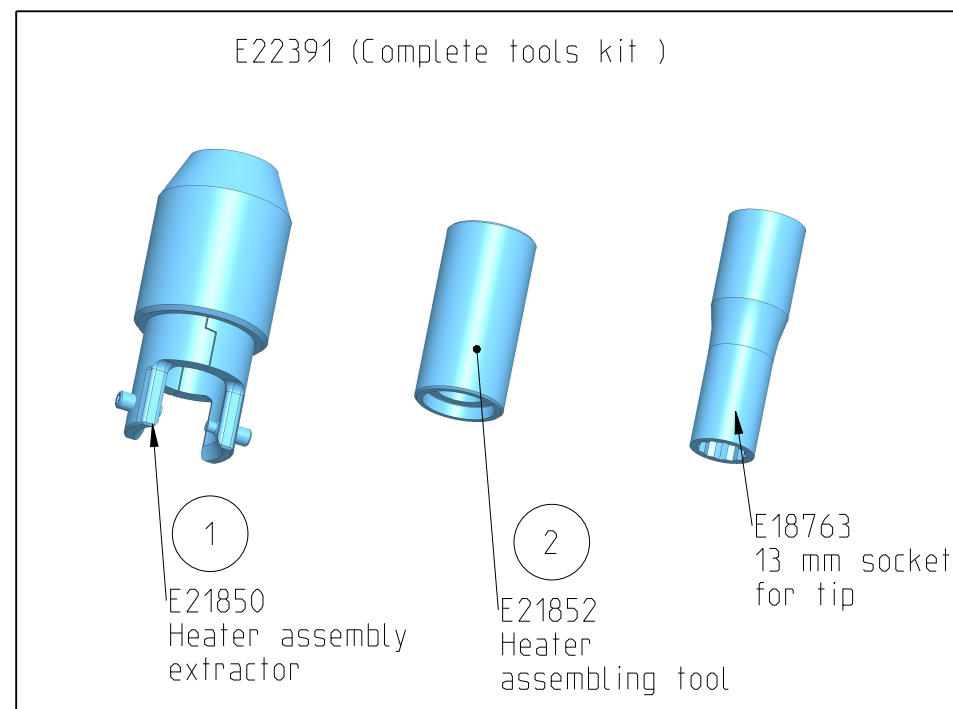
nozzle length	Nozzle body
56	MS04037X
66	MS04038X
76	MS04039X
86	MS04040X
96	MS04041X
106	MS04042X
116	MS04043X
126	MS04044X
136	MS04045X
146	MS04046X
156	MS04047X
166	MS04048X
176	MS04049X
186	MS04050X
196	MS04051X
206	MS04052X

- Hot Tightening torque 25Nm
1. Manually screw the tip in the core until is not in complete contact
  2. Heat the nozzle at the temperature T set point =230°C
  3. Wait the time necessary to reach the temperature T set point in the tip (3 min)
  4. Tighten the tip group at the torque defined table here above



hotrunner assembly				Nozzle MPN-10-29-VSA10-xxx-A	
<b>männer</b>				--	Männer Performance Line
				18/12/25	
MPN-10-29-VSA10-M.00				Massara	--

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



hotrunner assembly				Nozzle MPN-10-29-VSA10-xxx-A	
männer		18/12/25	Massara	--	
	MPN-10-29-VSA10-M.00			Männer Performance Line	--