

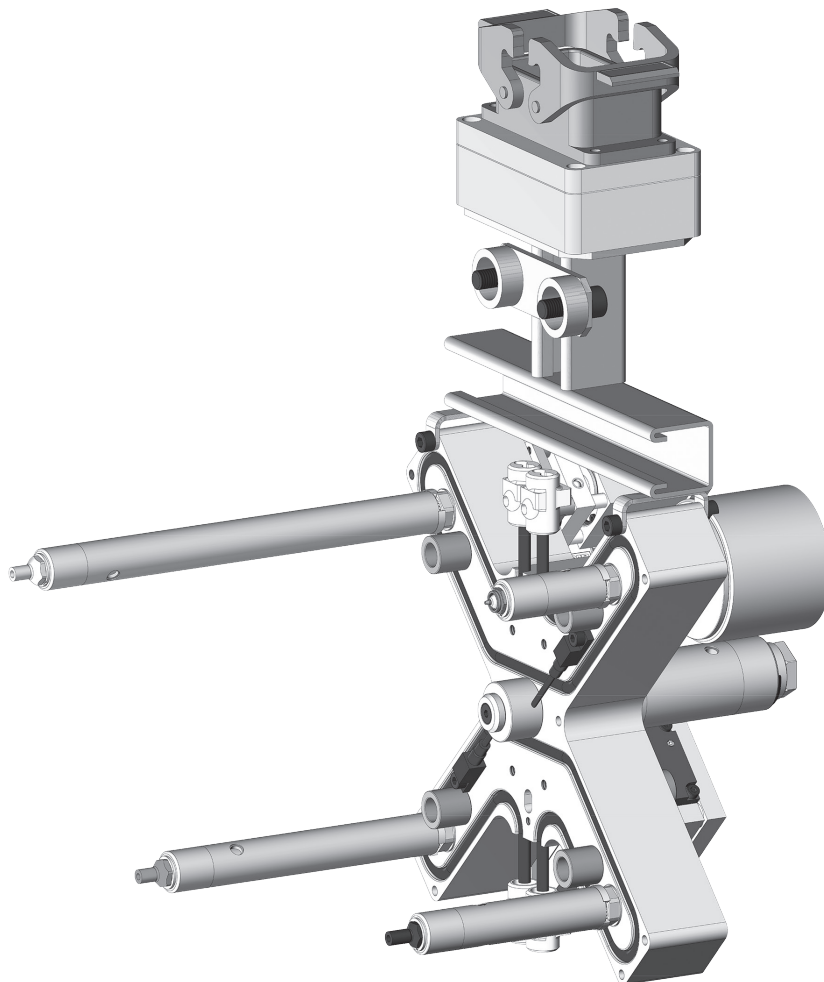


BARNES™
MOLDING SOLUTIONS

HOT RUNNER TECHNOLOGY

06E-03 Threaded Nozzles

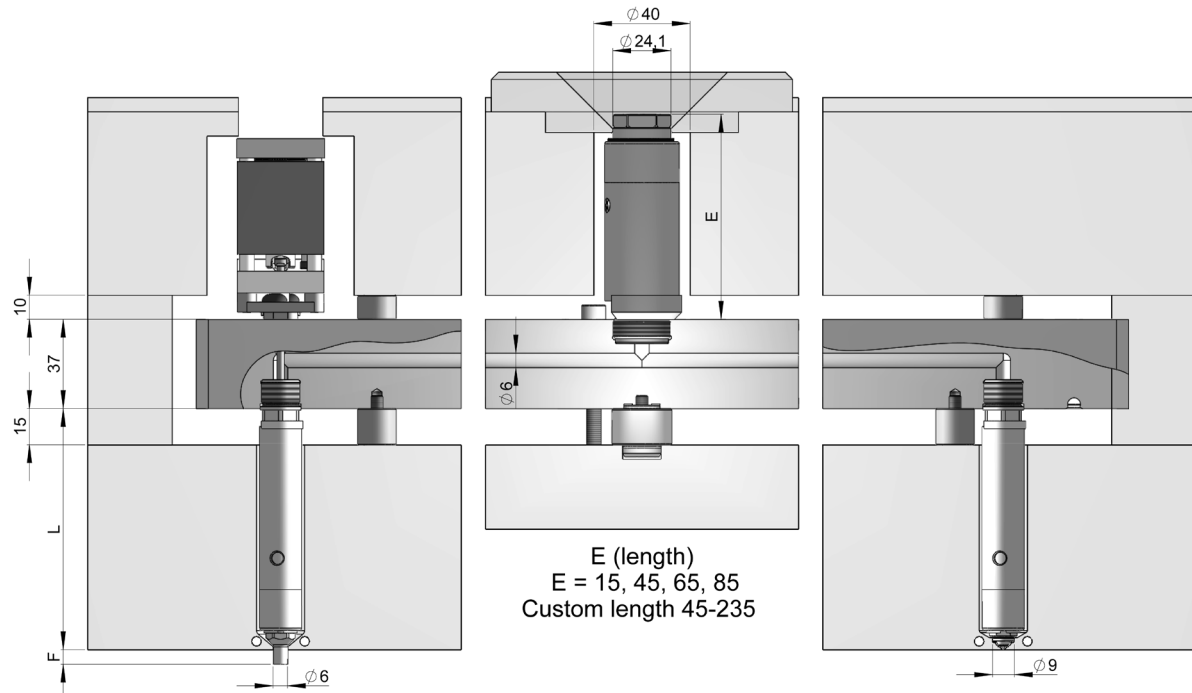
Product Catalog



Doc009162_RIS.PNG



Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

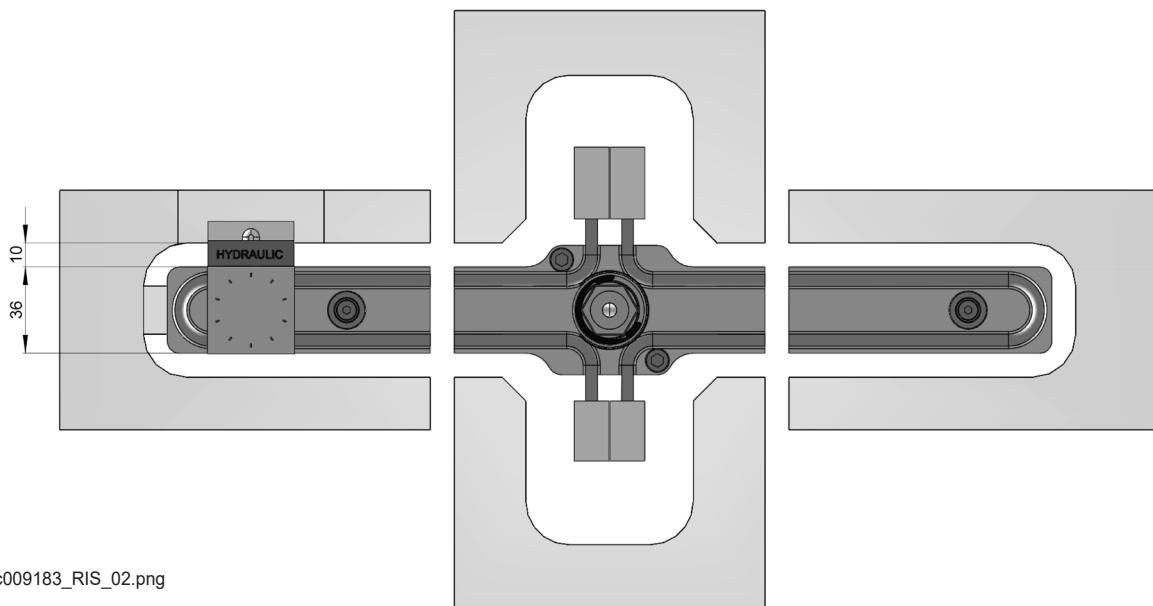


Doc009183_RIS_01.png

Thrust pad selection

Inlet bushing

Thrust pad selection

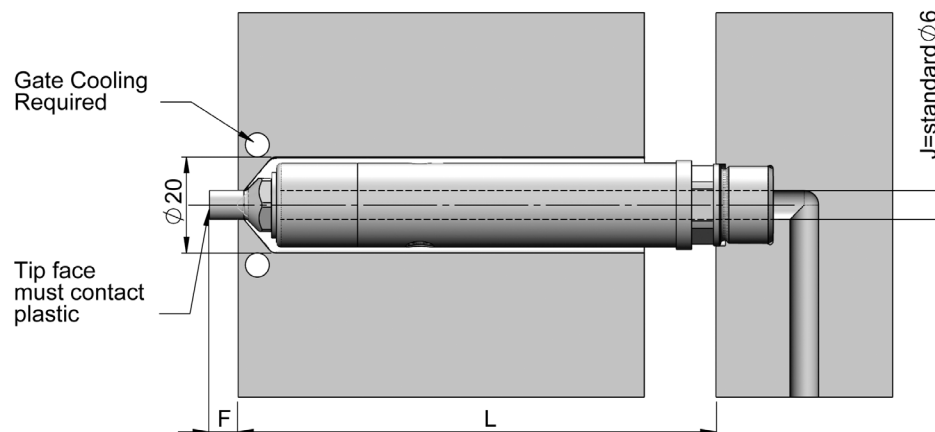


Doc009183_RIS_02.png

*min.10¹⁾ For a specific application, please consult Synventive



Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.



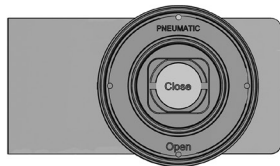
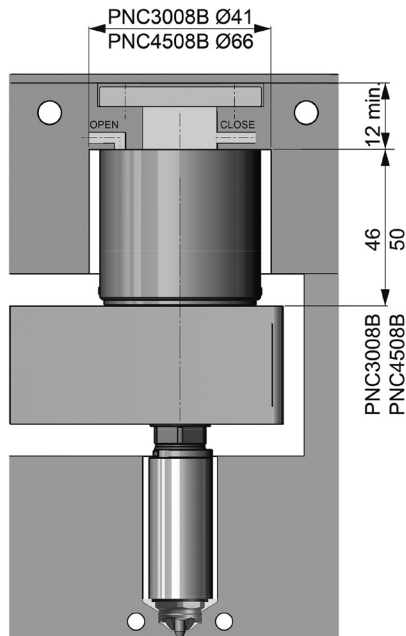
Doc009184_RIS.png

L (mm)	Heater zone power (Watt)	L (mm)	Heater zone power (Watt)
	Power1		Power 1
One control area (thermocouple) Standard lengths		One control area (thermocouple) Custom lengths	
60	125 W	>60-<80	125 W
70	125 W	>80-<100	139 W
80	139 W	>100-<120	159 W
90	139 W	>120-<140	179 W
100	159 W	>140-<180	199 W
110	159 W	>180-<200	239 W
120	179 W	>200-220	259 W
130	179 W		
140	199 W		
160	199 W		
180	219 W		
200	239 W		



Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

**PNC3008B
PNC4508B
(pneumatic)**

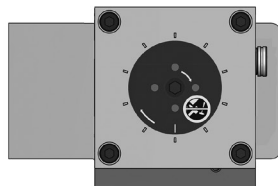
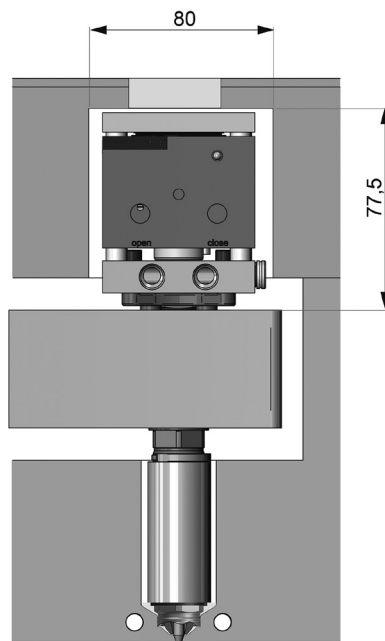


Doc009185_RIS.png

PNC3008B
Pressure range:
6 - 12 bar (87 - 174 psi)
Min/Max Close Forces:
424 N / 848 N

PNC4508B
Pressure range:
6 - 12 bar (87 - 174 psi)
Min/Max Close Forces:
954 N / 1908 N

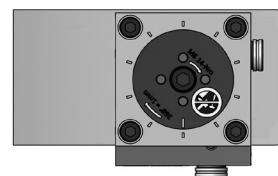
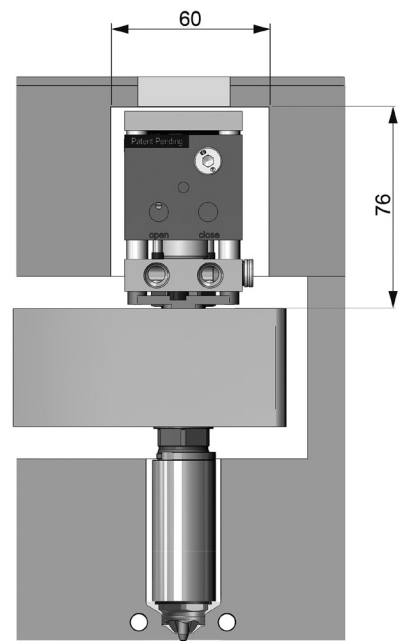
**PB4008
(pneumatic)**



PB4008
Pressure range:
6 - 12 bar (87 - 174 psi)
Min/Max Close Forces:
754 N / 1508 N

Available features:
♦ Position Sensor
♦ SynCool®

**HB2508
(hydraulic)**



HB2508
Pressure range:
40 - 60 bar (600 - 870 psi)
Min/Max Close Forces:
1963 N / 2945 N

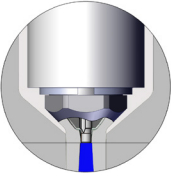
Available features:
♦ Position Sensor
♦ SynCool®

Electric actuators are also available for the 06E nozzle.
See the actuator catalog CAT-03-0001_EN-REV##

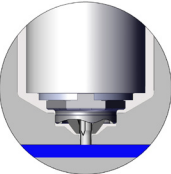


Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.
H = Gate orifice diameter, F = Tip extension, Dt = Tip Diameter, Mod = Modifiable

VSP Valve Gate - Straight Pin - Plunged Through

Tip Style	Description	Dt = Ø6 F = 0, 6, Mod H = 1.6		
	Standard Doc009099_RIS.png		✓	

VSW Valve Gate - Straight Pin - Blind

Tip Style	Description	Dt = Ø9		
		H = 0.8	H = 1.2	H = 1.6
	Standard Doc009100_RIS.png	✓	✓	✓



Preferred



(✓) Available

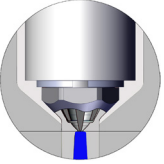


✗ Not Available

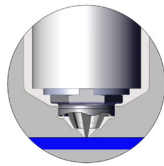


Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.
H = Gate orifice diameter, F = Tip extension, Dt = Tip Diameter, Mod = Modifiable

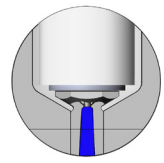
TTP Thermal Gate – Torpedo - Plunged Through

Tip Style	Description	Dt = Ø6 F = 0, 6, Mod		
		H = 0.8	H = 1.2	H = 1.6
	Standard Doc009101_RIS.png	✓	✓	✓

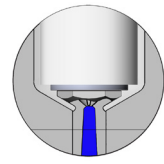
TTW Thermal Gate – Torpedo - Blind

Tip Style	Description	Dt = Ø9		
		H = 0.8	H = 1.2	H = 1.6
	Standard Doc009102_RIS.png	✓	✓	✓

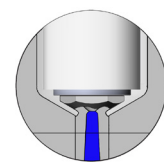
TNK Thermal Gate – Full Flow - Plunged Through

Tip Style	Description	Dt = Ø6 / Mod Dt = 5-6 F = 6, Mod F = 0-6		
		H = 1.2 Mod 1,4	H = 1.6 Mod 1,8	H = 2.0
	Standard (cold runner applications) Doc009103_RIS.png	✓	✓	✓

TTK Thermal Gate – Torpedo - K

Tip Style	Description	Dt = Ø6 / Mod Dt = 5-6 F = 6, Mod F = 0-6		
		H = 1.2 Mod 1,4	H = 1.6 Mod 1,8	H = 2.0
	Standard (cold runner applications, semi crystalline materials) Doc009104_RIS.png	✓	✓	✓

TPK Thermal Gate – Full Flow - K

Tip Style	Description	Dt = Ø6 / Mod Dt = 5-6 F = 6, Mod F = 0-6		
		H = 1.2 Mod 1,4	H = 1.6 Mod 1,8	H = 2.0
	Standard (cold runner applications) Doc009105_RIS.png	✓	✓	✓



Preferred



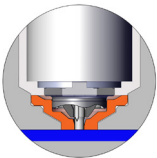
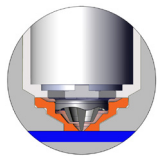
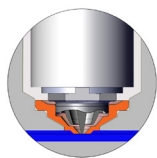
Available



Not Available



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H = Gate orifice diameter, F = Tip extension, Dt = Tip Diameter, Mod = Modifiable

Part		Description	F = 0, 6, Mod		
			H=0.8	H=1.2	H=1.6
	WI-VSW Doc009106_RIS.png	Wear Insert	✓	✓	✓
	WI-TTW Doc009108_RIS.png	Wear Insert (without Dimple)	✓	✓	✓
		Wear Insert (with Dimple)	F = 0		
			✓	✓	✓

✓ Preferred

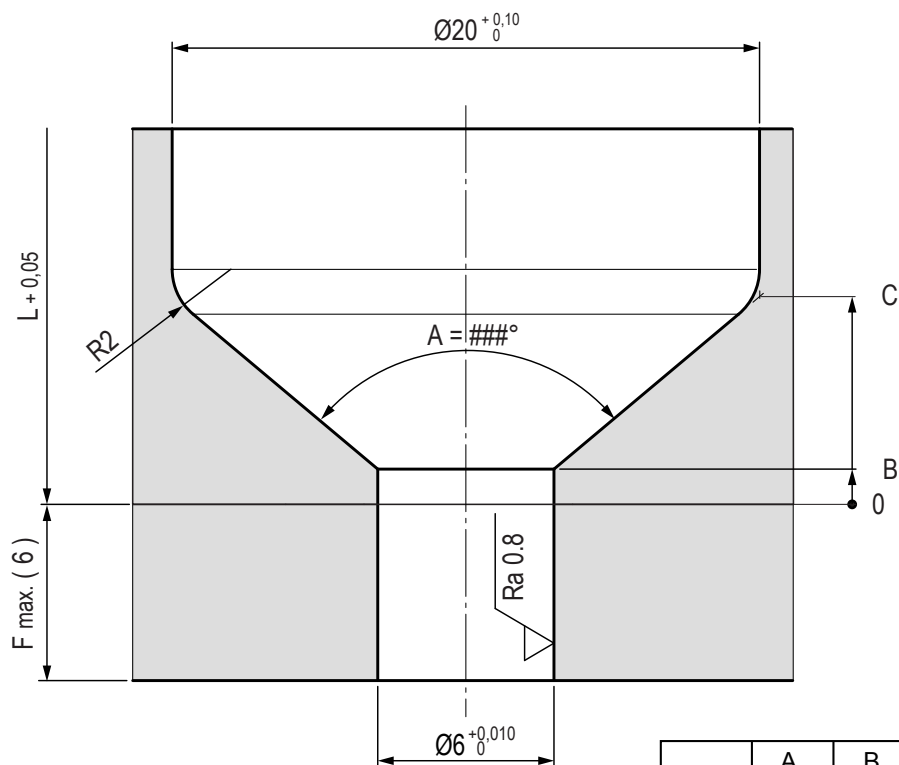
(✓) Available

✗ Not Available



Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.
Dimensions for reference only. Reference system drawing for complete dimensions prior to machining gate detail in mold.

VSP, TTP, TNK, TTK, TPK- Nozzle tip cutout dimensions



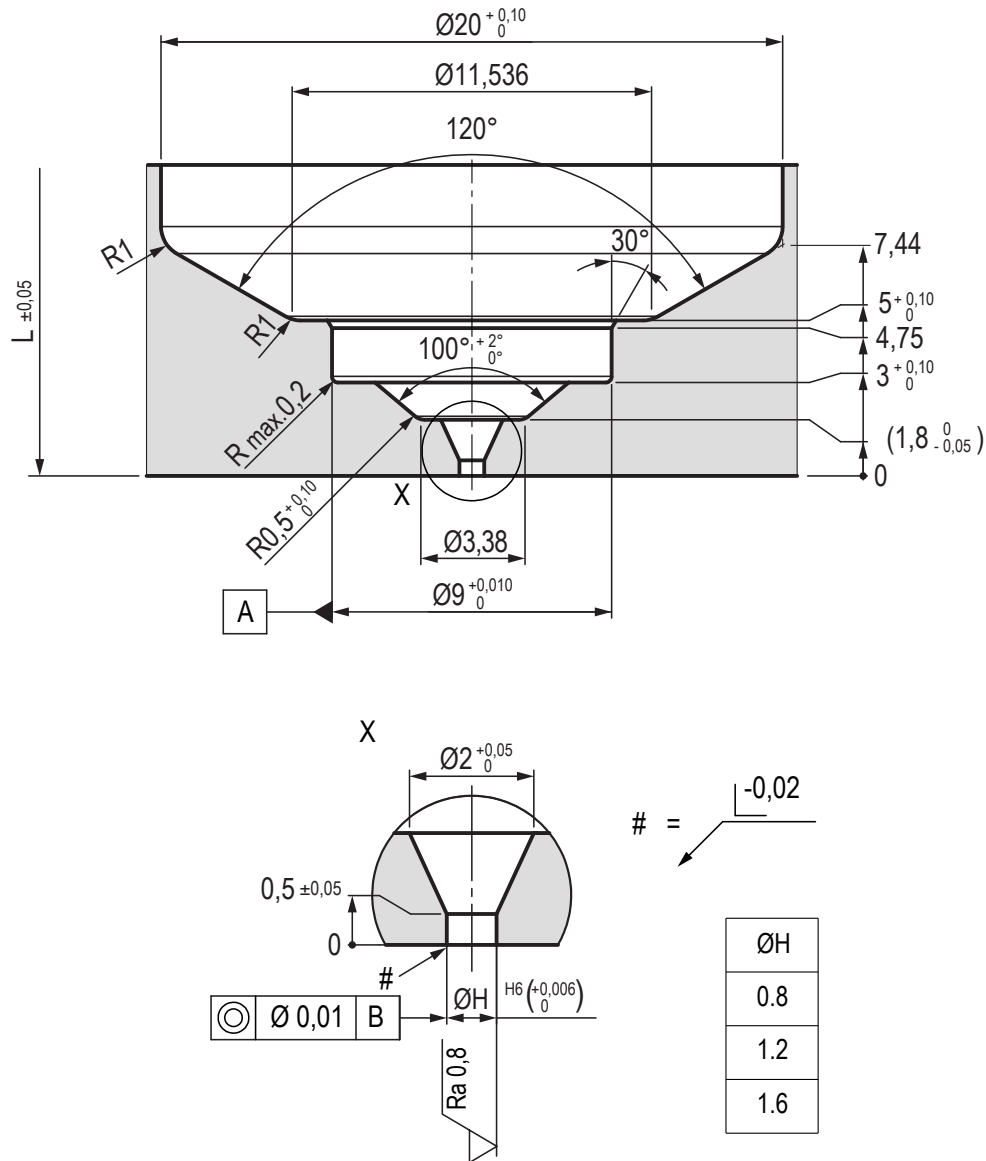
Doc006957.ai

	A	B	C
VSP			
TTP	100°	1,2	7,1
TNK			
TPK	120°	3,2	7,24
TTK			



Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.
Dimensions for reference only. Reference system drawing for complete dimensions prior to machining gate detail in mold.

VSW - Nozzle tip cutout dimensions



1. At the area of the nozzle gate replaceable, hardened ($52 \pm 2/-1$ HRC) inserts are recommended by Synventive.
2. Radius/chamfer at the front of the valve pin shall not be removed.
3. Synventive recommends that the gate area geometry is manufactured by grinding and not EDM with a surface quality of $\sqrt{Ra0,4}$
4. To avoid a deformation at the gate the space to move freely has to be checked at hot condition.

Doc006956.ai



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Barnes Molding Solutions is the expert cluster for molds, hot runners, and controls for industrial plastic injection molding. Our brands Foboha, Männer, Synventive, Thermoplay, Priamus and Gammaflux are leaders in their field. We have a comprehensive and in-depth understanding of the automotive, medical, packaging and electronics industries. We support our customers with sophisticated high-performance technologies through to customized turnkey solutions.



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