



BARNES™
MOLDING SOLUTIONS

HOT RUNNER TECHNOLOGY

M10

Performance Line

Product Catalog

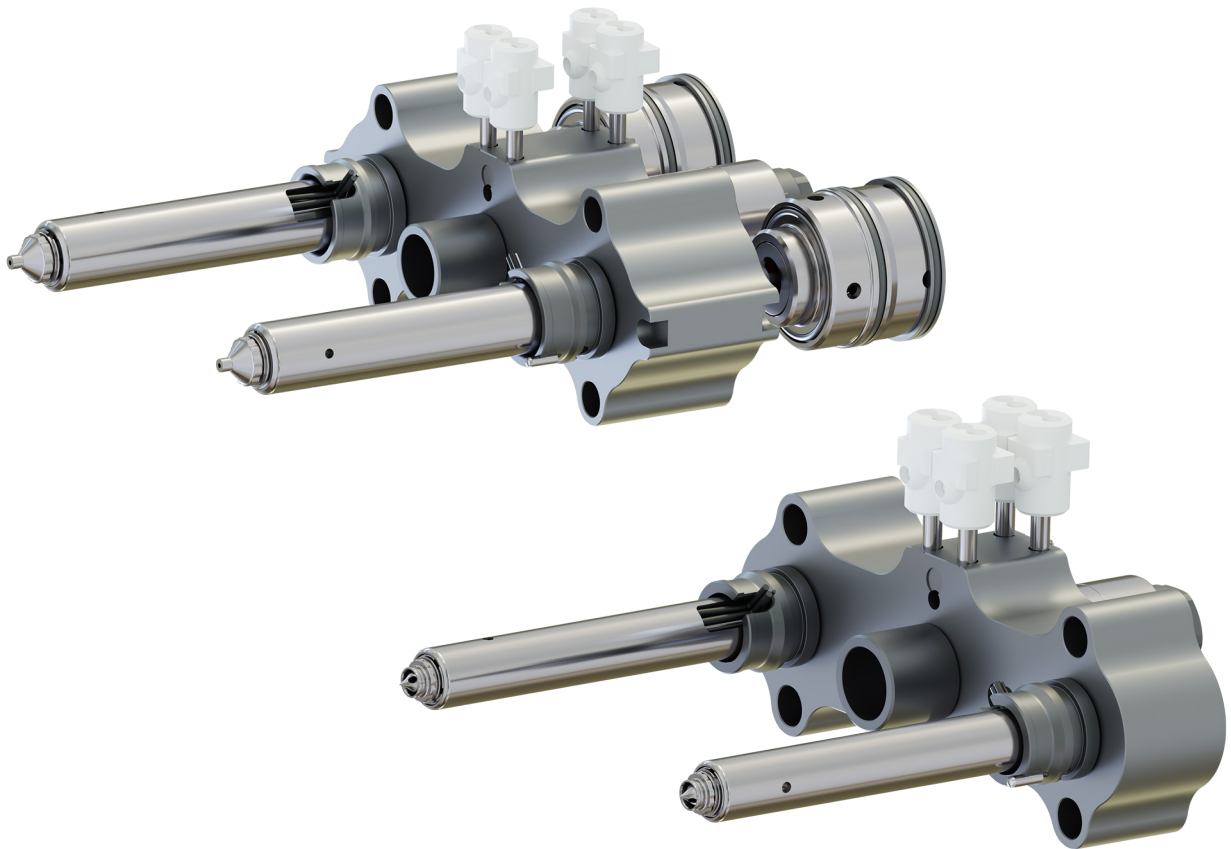




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Hot Runner Technology

This catalog gives an overview of the latest product, including descriptions, dimensions and technical data. The text next to the graphics gives additional instructions on the use of the product. If available, options are explained with pictures and text. All available accessories for this product are specified. Where necessary, a separate chapter gives the information and important technical data.

General Description of the Nozzle

Hot runner nozzles are the connection to the cavity. They either gate directly into the part or into a sub runner which will feed into the cavity.

General Description of MPN-10

MPN-10 series nozzles have an enlarged flow bore to optimize injection and reduce pressure loss. The nozzles have a patented heating system and are made of special steel. Different lengths are available. The nozzles are suitable for the most commonly used polymers. MPN-10 nozzles series are the ideal combination with Bolt Down Manifolds.

Target Group

The target groups of this product catalog are mold designers, toolmakers, molders and service technicians. They will find the needed information in the relevant chapters.

Applied Standards and Norms

- DIN EN IEC/IEEE 82079-1 Edition 2 Creation of usage information for products
- Standard and norms for Technical drawings

Tolerances and Customer Graphics

The product catalog gives a general information about the product. For tolerances and other details, use the customer drawings. There you find the detailed information.

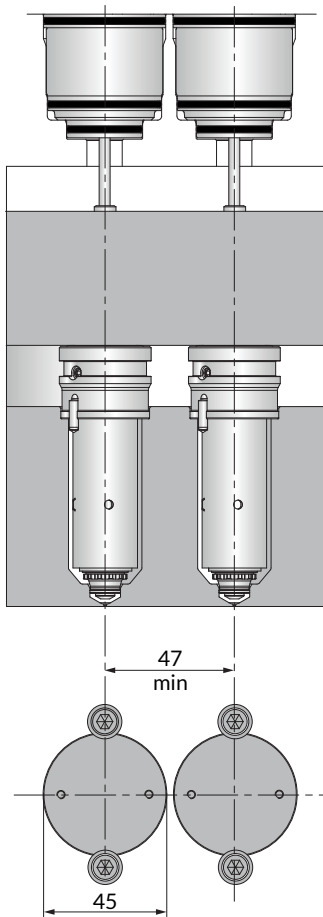


Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

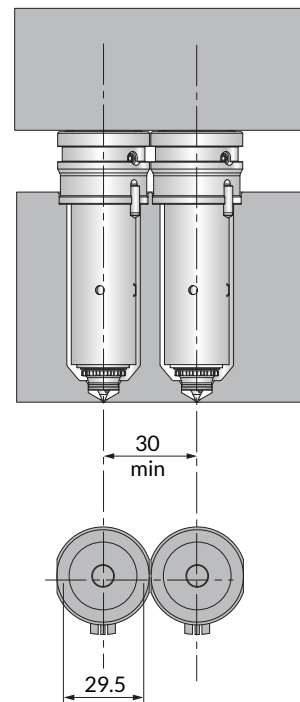
Minimum Distance between Nozzle Centers

In this graphic the minimum distance between the nozzle centers is drawn, as example. Other minimum distance between nozzles centers are available on request.

Valve Gate



OpenGate

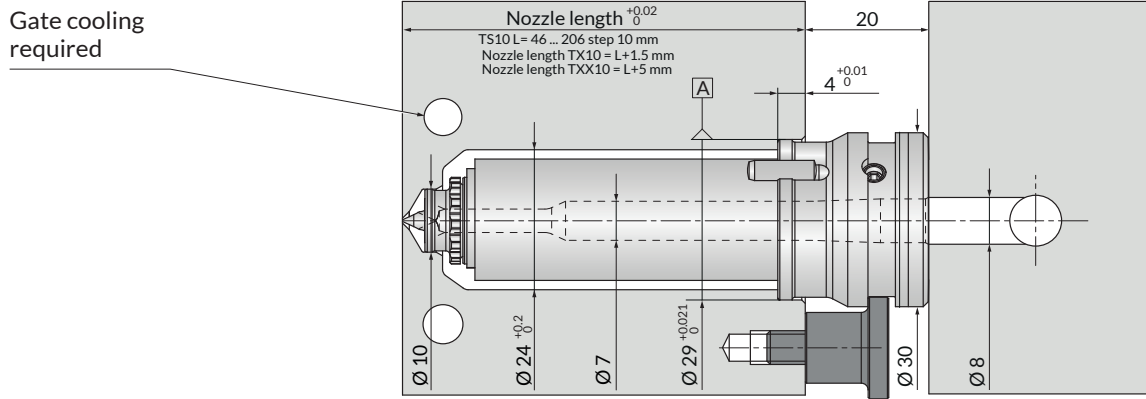




Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

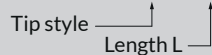
Technical Data TS10, TX10 and TXX10

There are slight differences in the length range of different tip types.
E18763 Bi-hex Ø 13 Tightening torque 28 Nm.



TS10 Nozzle length [mm] (L)	TX10 Nozzle length [mm] (L+1.5)	TXX10 Nozzle length [mm] (L+5)	Nozzle Code	Watt [W]
46	47.5	51	MPN-10-29-...-046	220
56	57.5	61	MPN-10-29-...-056	220
66	67.5	71	MPN-10-29-...-066	220
76	77.5	81	MPN-10-29-...-076	220
86	87.5	91	MPN-10-29-...-086	220
96	97.5	101	MPN-10-29-...-096	260
106	107.5	111	MPN-10-29-...-106	260
116	117.5	121	MPN-10-29-...-116	260
126	127.5	131	MPN-10-29-...-126	260
136	137.5	141	MPN-10-29-...-136	300
146	147.5	151	MPN-10-29-...-146	300
156	157.5	161	MPN-10-29-...-156	300
166	167.5	171	MPN-10-29-...-166	300
176	177.5	181	MPN-10-29-...-176	350
186	187.5	191	MPN-10-29-...-186	350
196	197.5	201	MPN-10-29-...-196	350
206	207.5	211	MPN-10-29-...-206	350

Example nozzle code: MPN-10-29 - TX10 - 206



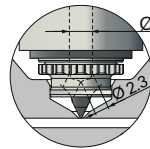


Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

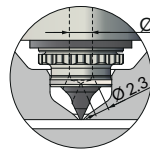
Nozzle Tip Styles TS10, TX10 and TXX10

The following nozzle tip styles are available.

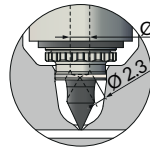
Thermal gate - Torpedo - Blind

Tip Style with Description	Tip Group Code	Picture	Gate diameter
TS10 Standard	MS01146		Ø 0.6 min - Ø 1.2 max

Thermal gate - Torpedo - Blind - Extended tip

Tip Style with Description	Tip Group Code	Picture	Gate diameter
TX10 Extended 1.5 mm	MS01160		Ø 0.6 min - Ø 1.2 max

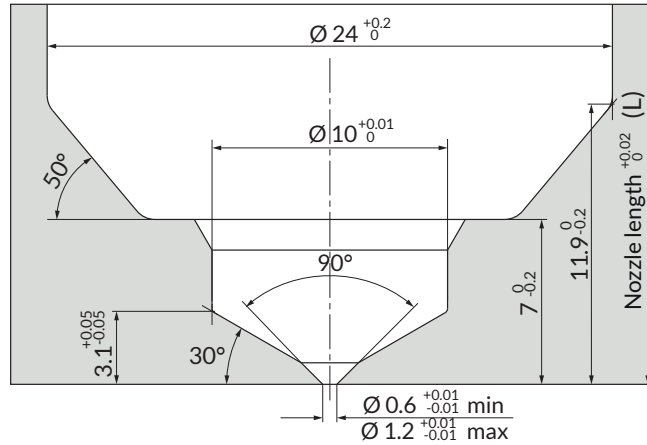
Thermal gate - Torpedo - Blind - Extended tip

Tip Style with Description	Tip Group Code	Picture	Gate diameter
TXX10 Extended 5 mm	MS01148		Ø 0.6 min - Ø 1.2 max



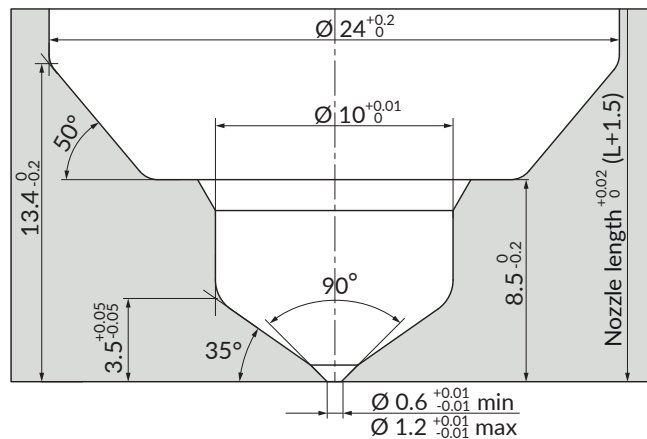
Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.
Dimensions for reference only. Reference system drawing for complete dimensions prior to machining gate detail in mold.
The following pictures shows the nozzle tip cutout dimensions for this nozzle.

Nozzle Tip Cutout Dimensions TS10

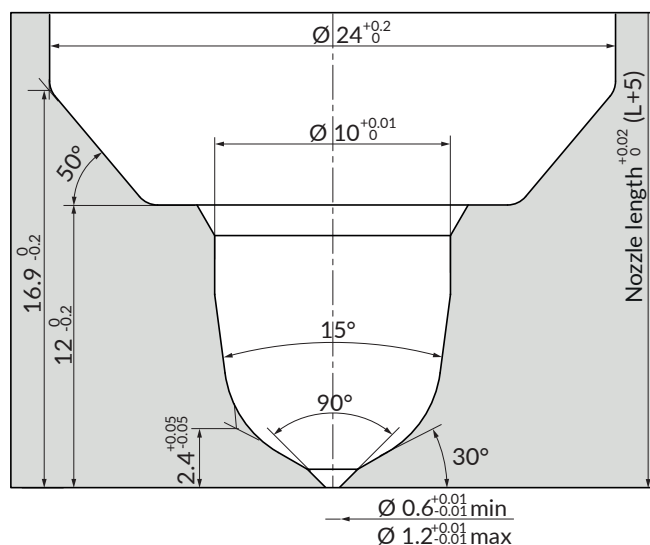


L = 46 ... 206 step 10 mm

Nozzle Tip Cutout Dimensions TX10



Nozzle Tip Cutout Dimensions TXX10

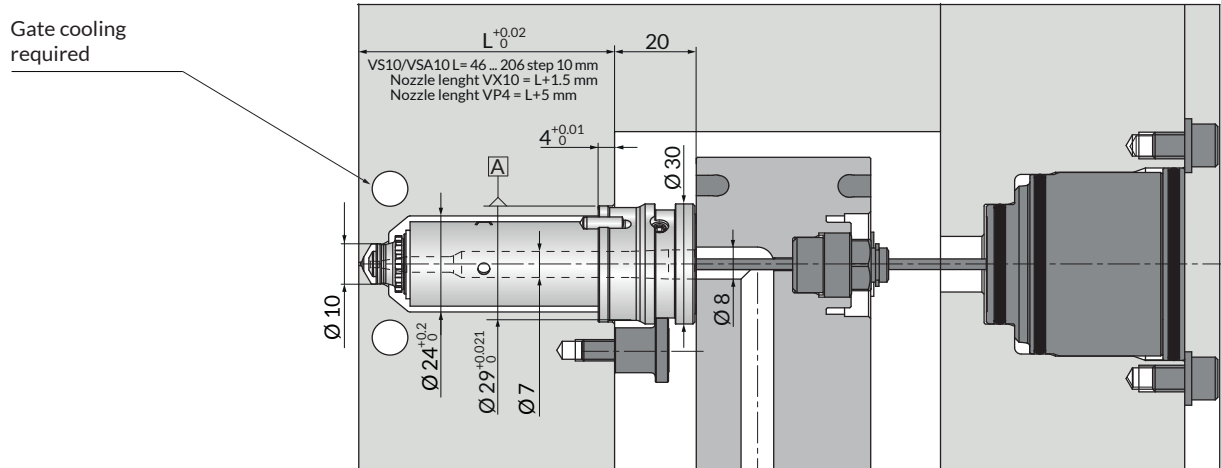




Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

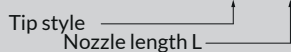
Technical Data VS10, VSA10, VX10 and VP4

There are slight differences in the length range of different tip types.
E18763 Bi-hex Ø 13 Tightening torque 28 Nm.



VS10-VSA10-VP4 Nozzle length [mm] (L)	VX10 Nozzle length [mm] (L+1.5)	Nozzle code	Watt [W]
46	47.5	MPN-10-29-...-046	220
56	57.5	MPN-10-29-...-056	220
66	67.5	MPN-10-29-...-066	220
76	77.5	MPN-10-29-...-076	220
86	87.5	MPN-10-29-...-086	220
96	97.5	MPN-10-29-...-096	260
106	107.5	MPN-10-29-...-106	260
116	117.5	MPN-10-29-...-116	260
126	127.5	MPN-10-29-...-126	260
136	137.5	MPN-10-29-...-136	300
146	147.5	MPN-10-29-...-146	300
156	157.5	MPN-10-29-...-156	300
166	167.5	MPN-10-29-...-166	300
176	177.5	MPN-10-29-...-176	350
186	187.5	MPN-10-29-...-186	350
196	197.5	MPN-10-29-...-196	350
206	207.5	MPN-10-29-...-206	350

Example nozzle code: MPN-10-29 - VS10 - 206



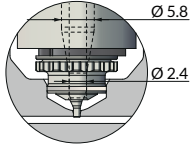


Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

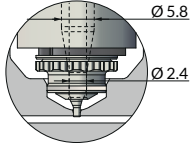
Nozzle Tip Styles VS10, VSA10, VX10 and VP4

The following nozzle tip styles are available.

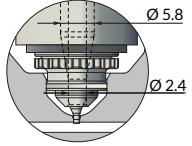
Valve gate - Straight pin - Blind

Tip Style with Description	Tip Group Code	Picture	Gate diameter
VS10 Standard	MS01154		Ø 0.8 min - Ø 2 max

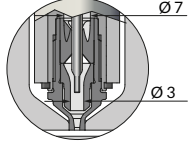
Valve gate - Straight pin - Blind

Tip Style with Description	Tip Group Code	Picture	Gate diameter
VSA10 Standard - Advanced	MS01154		Ø 0.8 min - Ø 2 max

Valve gate - Straight pin - Blind - Extended tip

Tip Style with Description	Tip Group Code	Picture	Gate diameter
VX10 Standard - Extended 1.5 mm	MS01162		Ø 0.8 min - Ø 2 max

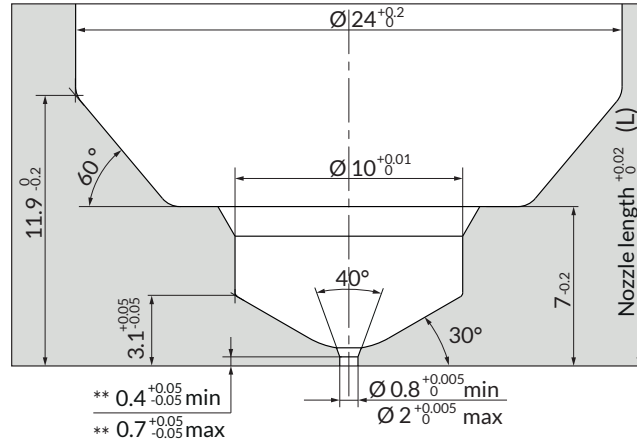
Valve gate - Straight pin - Plunged Through

Tip Style with Description	Tip Group Code	Picture	Gate diameter
VP4 Plunged Through	MS01158		Ø 1.5

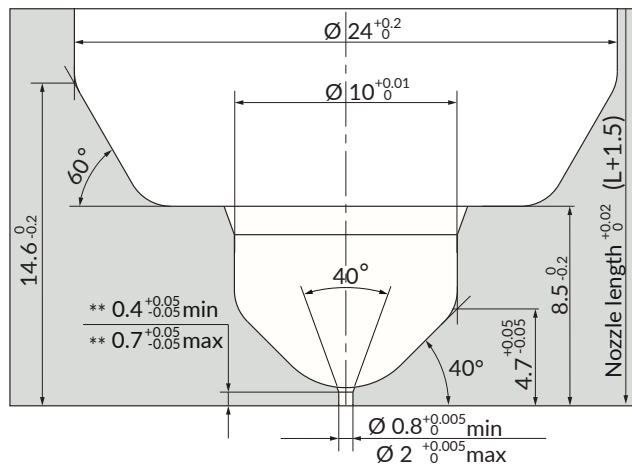


Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.
Dimensions for reference only. Reference system drawing for complete dimensions prior to machining gate detail in mold.
The following pictures shows the nozzle tip cutout dimensions for this nozzle.

Nozzle Tip Cutout Dimensions VS10 and VSA10

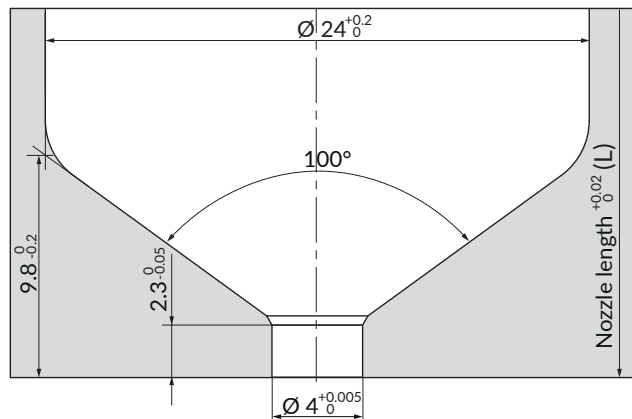


Nozzle Tip Cutout Dimensions VX10



** To be defined according to polymers characteristics, injection cycle and cooling cycles.

Nozzle Tip Cutout Dimensions VP4



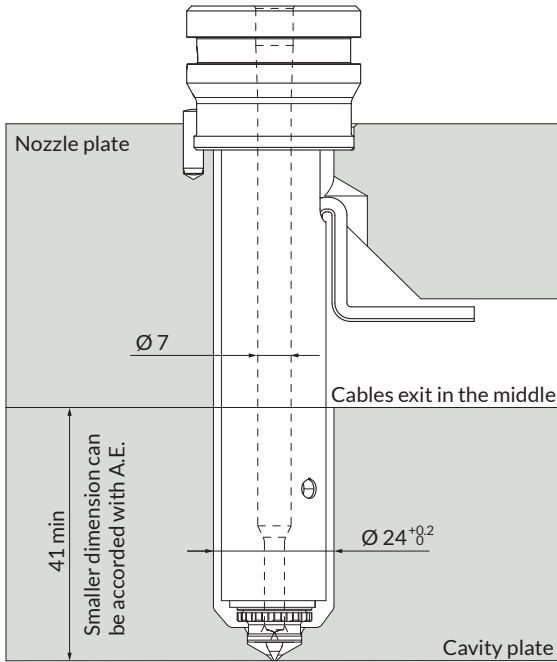


Illustrations simplified, schematically drawn and not to scale. All dimensions in mm.

Options

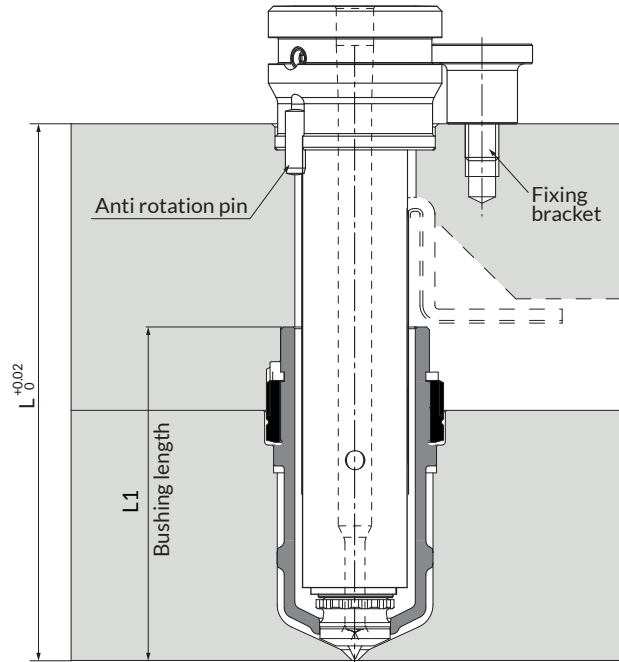
This following options are available for this product.

Optional cables exit in the middle



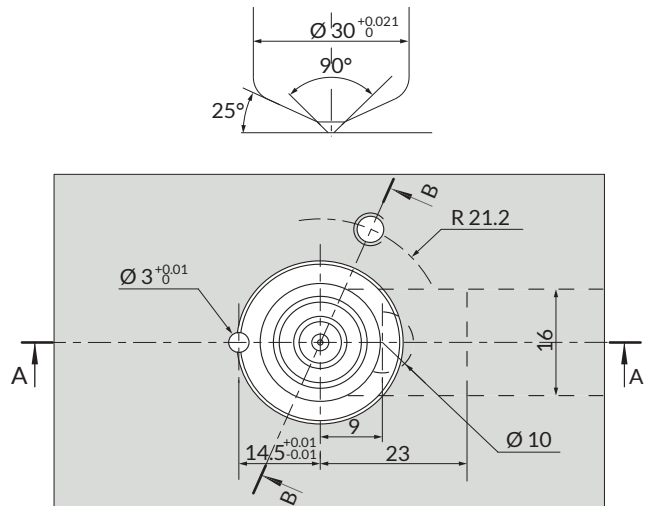
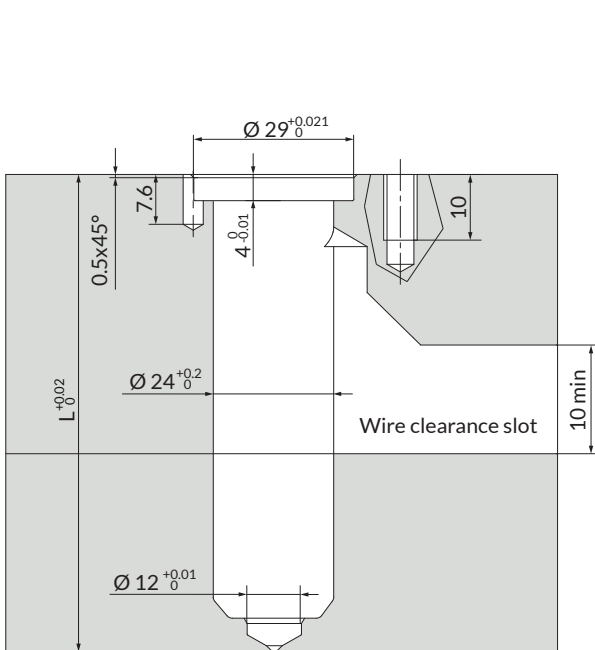
sez A-A

Optional D Bushing



sez B-B

Alternative cutout with D bushing

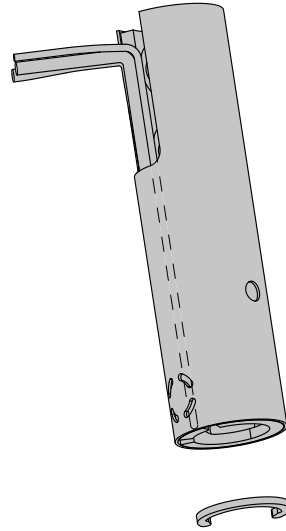




Illustrations simplified, schematically drawn and not to scale.

Heater with integrated Thermocouple

This chapter gives a schematic overview of the Heater including Technical Data.



Example heater code: MPH10 - 206

Nozzle diameter

Length L

Description	Code
Heater fixing ring	B02905

Heater group cables		
Heater	Orange / Grey	230 V
Thermocouple	Black	TC+
	White	TC-



Nozzle length [mm]			Heater group code	Watt [W]
TS10, VS10, VSA10, VP4	TX10, VX10	TXX10		
46	47.5	51	MPH10-046...	220
56	57.5	61	MPH10-056...	220
66	67.5	71	MPH10-066...	220
76	77.5	81	MPH10-076...	220
86	87.5	91	MPH10-086...	220
96	97.5	101	MPH10-096...	260
106	107.5	111	MPH10-106...	260
116	117.5	121	MPH10-116...	260
126	127.5	131	MPH10-126...	260
136	137.5	141	MPH10-136...	300
146	147.5	151	MPH10-146...	300
156	157.5	161	MPH10-156...	300
166	167.5	171	MPH10-166...	300
176	177.5	181	MPH10-176...	350
186	187.5	191	MPH10-186...	350
196	197.5	201	MPH10-196...	350
206	207.5	211	MPH10-206...	350

Maintenance Kit

Code	Description
E22391	Maintenance kit for MPN-10 nozzles

Composed by:

1. Bi-hexagon socket
2. Heater extractor
3. Insertion tool for heater



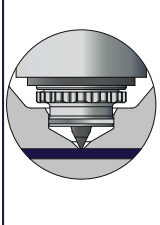
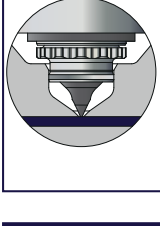
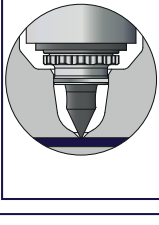
Resin - Tip suitability

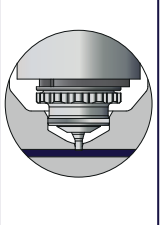
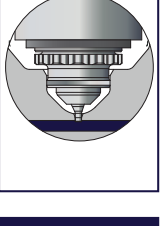
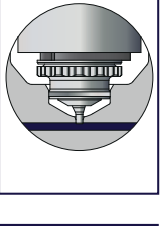
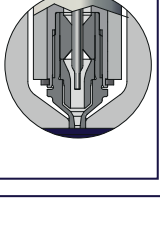
Nozzle Series	Thermal Gate			Valve Gate			
	TS	TX	TXX	VS	VX	VSA	VP
MPN-08 / MPN-10 Sliding							
Polyolefine							
PE, HDPE, LDPE, LLDPE	✓	✓	✓	✓	✓	✓	✓
PP, PP/PE, PP+Talc	✓	✓	✓	✓	✓	✓	✓
Polyolefin ≤GF35	✓	✓		✗	✗		
TPE							
TPE-O/S/V, PP/EPDM	✗	✗		✓	✓	✓	✓
TPE-U	✗			✓	✓	✓	✓
Semi-Crystalline							
PBT	✓	✓		✓	✓	✓	✓
PBT≤35GF	✓	✓		✗	✗	✓	✓
PA6	✓	✓	✗	✓	✓	✓	✓
PA6 ≤35GF	✓	✓	✗	✗	✗	✓	✓
PA6.6	✓	✓		✓	✓	✓	✓
PA6.6≤35GF	✓	✓		✗	✗	✓	✓
PA4.6	✗	✗				✗	✗
PPA	✓	✓		✓	✓	✓	✓
PPA≤35GF	✓	✓		✗	✗	✓	✓
POM	✓	✓		✓	✓	✓	✓
PET		✓		✓	✓	✓	✓
PET≤35GF	✓	✓		✗	✗	✓	✓
Amorphous							
PMMA	✓	✓		✓	✓	✓	✓
ABS	✓	✓	✓	✓	✓	✓	✓
ASA	✓	✓	✓	✓	✓	✓	✓
SAN	✓	✓	✗	✓	✓	✓	✓
SMA	✓	✓		✓	✓	✓	✓
PS (HIPS, PS clear)	✓	✓	✓	✓	✓	✓	✓
PC	✓	✓		✓	✓	✓	✓
PC ≤35GF	✓	✓		✓	✓	✓	✓
PPE/PS	✓	✓		✓	✓	✓	✓
PPE/PA (Noryl GTX)	✓	✓		✓	✓	✓	✓
Blends							
PC/ABS	✓	✓	✗	✓	✓	✓	✓
PC/ABS ≤GF35	✓	✓		✓	✓	✓	✓
PC/ASA	✓	✓	✗	✓	✓	✓	✓
PC/ASA ≤GF35	✓	✓		✓	✓	✓	✓
PC/PBT	✓	✓	✗	✓	✓	✓	✓
PC/PBT ≤GF35	✓	✓		✓	✓	✓	✓
PC/PET	✓	✓		✓	✓	✓	✓
PC/PET ≤GF35	✓	✓		✓	✓	✓	✓
PA/ABS	✓	✓		✓	✓	✓	✓
PA/ABS ≤GF35	✓	✓		✓	✓	✓	✓
High Temperature							
PEEK	✗			✗	✗	✗	✗
PPS	✗			✗	✗	✗	✗
PES	✗			✗	✗	✗	✗
PSU	✗			✗	✗	✗	✗
PEI	✗			✗	✗	✗	✗
Special							
PET Clear	✗			✗	✗	✗	✗
PETG	✗			✓	✓	✓	✓
PCTG	✗			✓	✓	✓	✓
COC, COP	✗			✓	✓	✓	✓
LCP	✗			✓	✓	✓	✓
PVC soft							
PVC rigid							

✗ Requires review



Tip performance & Suitability overview

THERMAL GATE																							
 <p>TS</p>	<table border="1"> <thead> <tr> <th>Resin group</th> <th>Suitability</th> </tr> </thead> <tbody> <tr><td>Polyolefine</td><td>██████████</td></tr> <tr><td>Amorphous</td><td>██████████</td></tr> <tr><td>Semi-Crystalline</td><td>██████████</td></tr> <tr><td>Blends</td><td>██████████</td></tr> <tr><td>Specials</td><td>██████████</td></tr> </tbody> </table> <table border="1"> <thead> <tr> <th>Feature</th> <th>Performance</th> </tr> </thead> <tbody> <tr><td>Processing window</td><td>██████████</td></tr> <tr><td>Wear resistance</td><td>██████████</td></tr> <tr><td>Color change</td><td>██████████</td></tr> <tr><td>Cosmetic gating</td><td>██████████</td></tr> </tbody> </table>	Resin group	Suitability	Polyolefine	██████████	Amorphous	██████████	Semi-Crystalline	██████████	Blends	██████████	Specials	██████████	Feature	Performance	Processing window	██████████	Wear resistance	██████████	Color change	██████████	Cosmetic gating	██████████
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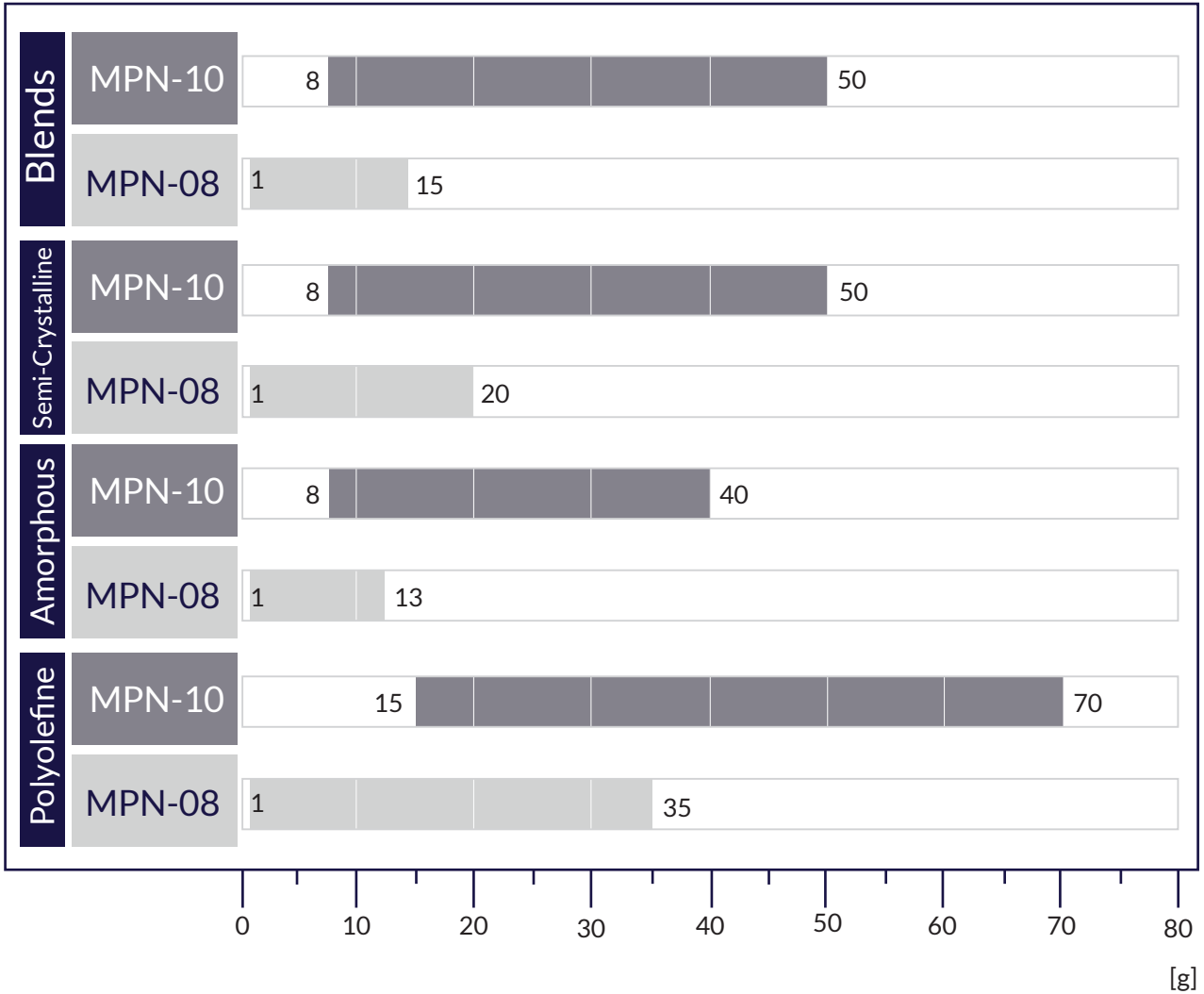
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Typical resins	Polyolefine	PE, HDPE, LDPE, LLDPE, PP/EPDM, (TPE *)
	Amorphous	PMMA, ABS, SAN, SMA, PS, PC, PPE, PPE/PA
	Semi-Crystalline	PBT, PA&, PA6.6, PA4.6, PPA, POM, (TPU *)
	Blends	PC/ABS, PC/ASA, PC/PBT, PA/ABS
	Specials	PEEK, PPS, PES, PSU, PEI, PET, PETG, PCTG, COC, COP, LCP

* Check for application



Maximum shot weight



The chart shows indicative values of the max shot weight by nozzle series.
For more accurate shot weights, the exact material grade and a complete application data set are needed.

Typical resins	Polyolefine	PE, HDPE, LDPE, LLDPE
	Amorphous	PMMA, ABS, SAN, SMA, PS, OC, PPE, PPE/PA
	Semi-Crystalline	PBT, PA&, PA6.6, PA4.6, PPA, POM, PET
	Blends	PC/ABS, PC/ASA, PC/PBT, PA/ABS



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