









**Multi-drop
hot runner nozzles**



4.2 Multi-drop hot runner nozzles as system nozzles

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OktaFlow[®] linear

Multi-drop hot runner nozzle
linear version for side gating

TECHNICAL DATA

80HT

Melt channel Ød 7.5 mm

Operating voltage 230 V_{AC} *

Nominal length of the nozzle (L) in mm

50	80	120
■	■	■

OLT45

Quantity of tips 4 or 8

Operating voltage 230 V_{AC} *

Contact us for other nozzle lengths!

*Volts alternating current

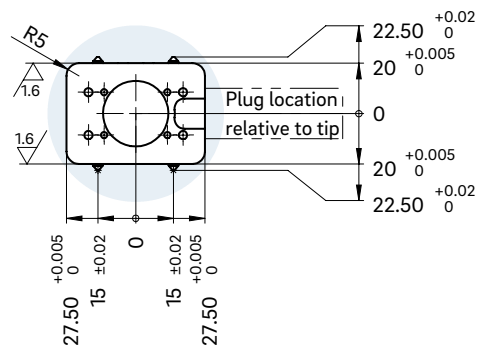
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NOTE

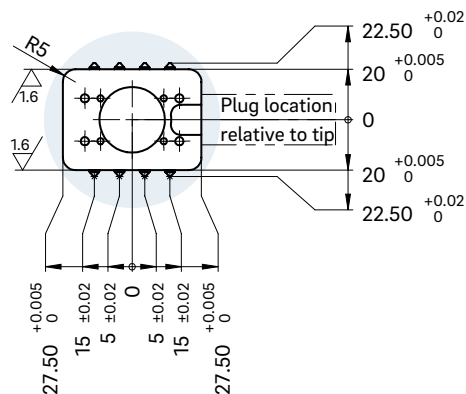
Power connector CMT and thermocouple connector CMLK are to be ordered separately.

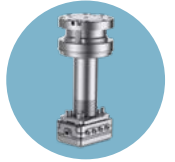


Tip distance for four tips

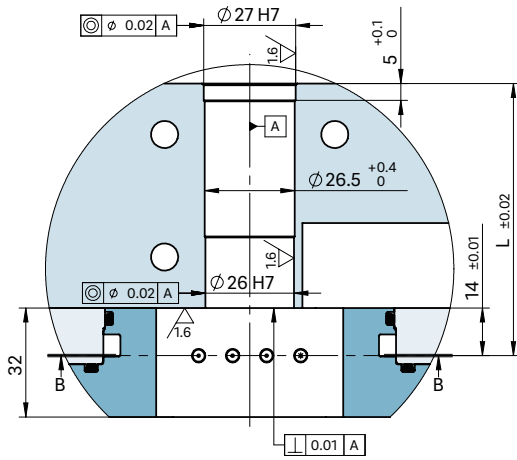


Tip distance for eight tips

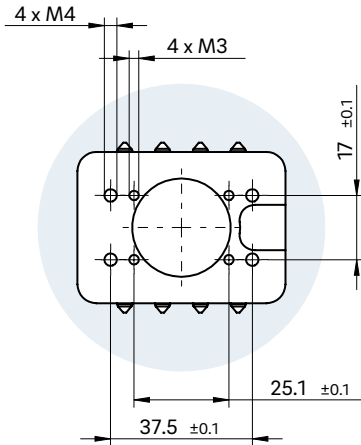




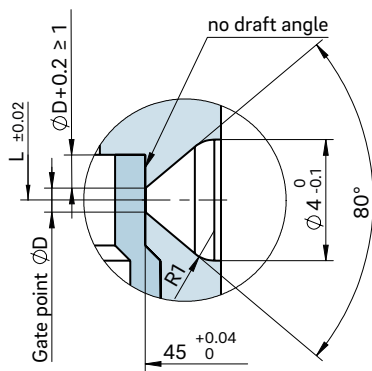
INSTALLATION



View B-B for fastening screw thread

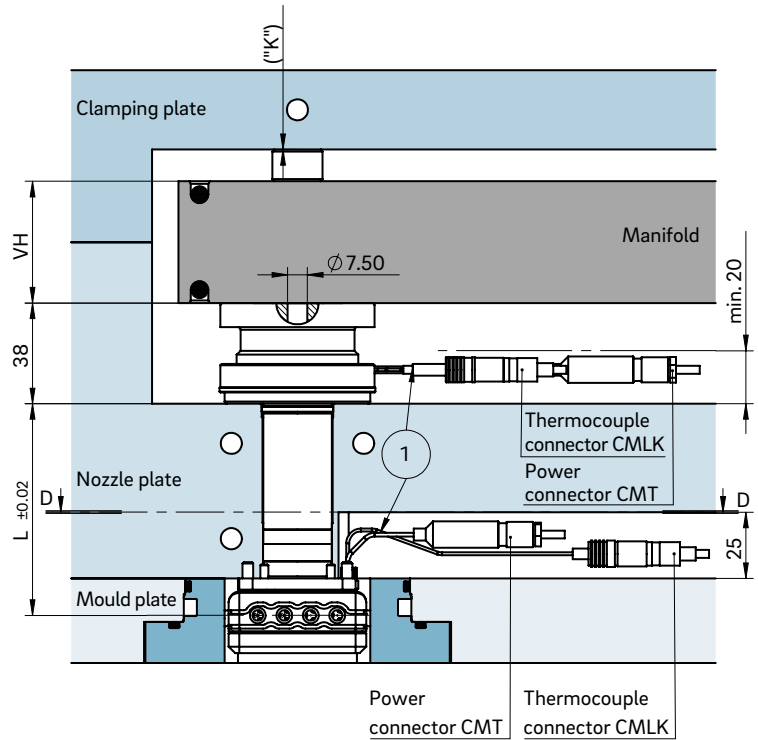


Gate point geometry

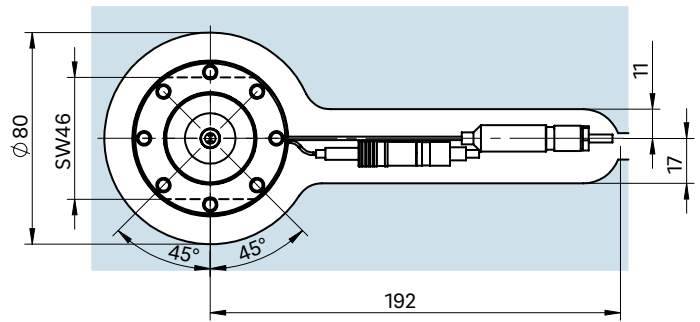


The size "K" required for heat expansion is to be ensured by grinding the pressure pads (12 + 0.1 mm)! Determine the difference between the height of the manifold system and the height of the frame plate when installed! ΔT specifies the temperature differential between the processing temperature and the mould temperature!

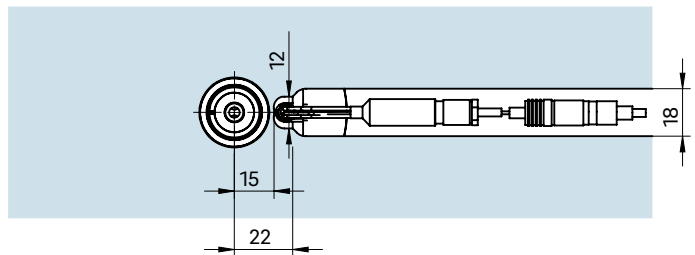
VH	ΔT (°C)	100	150	200	250	300	350
36 mm	K (mm)	0.021	0.059	0.098	0.137	0.177	0.217
46 mm	K (mm)	0.033	0.078	0.124	0.170	0.218	0.264
56 mm	K (mm)	0.046	0.097	0.150	0.203	0.258	0.311



Example Cutout for nozzle head, power and thermocouple plug connections



View D-D cutout for power and thermocouple plug connections of the sub-manifold



① Power and thermocouple plug connections in this area can only be bent once; minimum radius: R8

SW = flat area on nozzle head



OktaFlow[®] radial TK45

Multi-drop hot runner nozzle
radial version for side gating

TECHNICAL DATA

80HT

Melt channel Ød 7.5 mm

Operating voltage 230 V_{AC} *

Nominal length of the nozzle (L) in mm

60	90	130
■	■	■

ORT45

Quantity of tips 1, 2, 4 or 8

Operating voltage 230 V_{AC} *

Contact us for other nozzle lengths!

*Volts alternating current

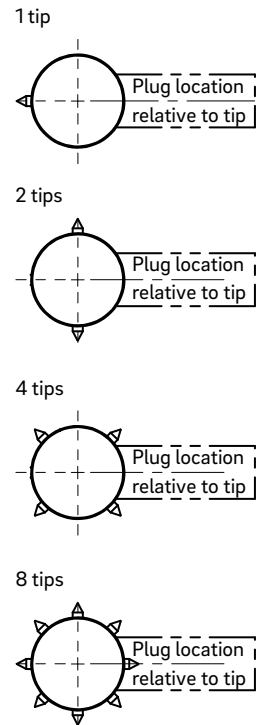
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NOTE

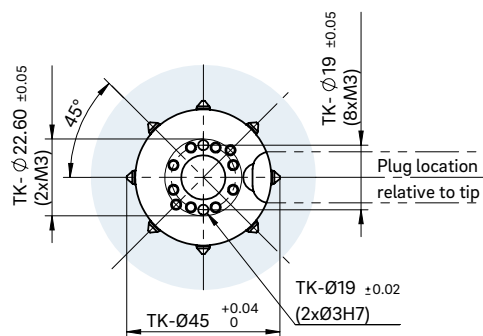
Power connector CMT and thermocouple connector CMLK are to be ordered separately.



PLUG LOCATION RELATIVE TO TIP



View B-B
Fastening screw thread and tip distance





OktaFlow[®] radial TK65

Multi-drop hot runner nozzle
radial version for side gating

TECHNICAL DATA

80HT

Melt channel Ød	7.5 mm	
Operating voltage	230 V _{AC} *	
Nominal length of the nozzle (L) in mm	65	95
	■	■

ORT65

Quantity of tips	1, 2, 4 or 8
Operating voltage	230 V _{AC} *

Contact us for other nozzle lengths!

*Volts alternating current

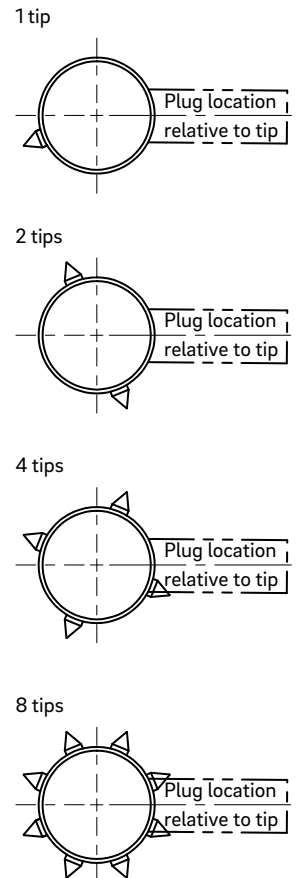
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NOTE

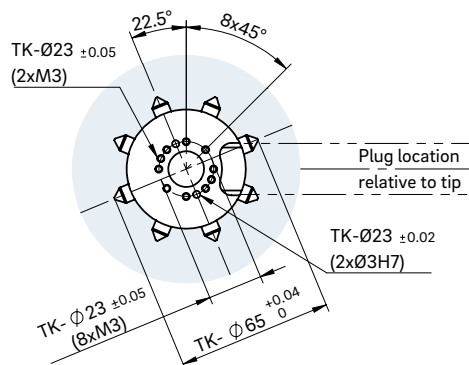
Power connector CMT and thermocouple connector CMLK are to be ordered separately.



PLUG LOCATION RELATIVE TO TIP



View B-B
Fastening screw thread and tip distance





18LHF

Multi-drop hot runner nozzle for side gating under 90°, without cold slugs, with thick-film heating element (BlueFlow®)

TECHNICAL DATA

18LHF

Melt channel Ød 3.8 mm

Operating voltage 230 V_{AC} *

Quantity of tips 1, 2 or 4

Nominal length of the nozzle (L) in mm

60	80	100
■	■	■

*Volts alternating current

■ available

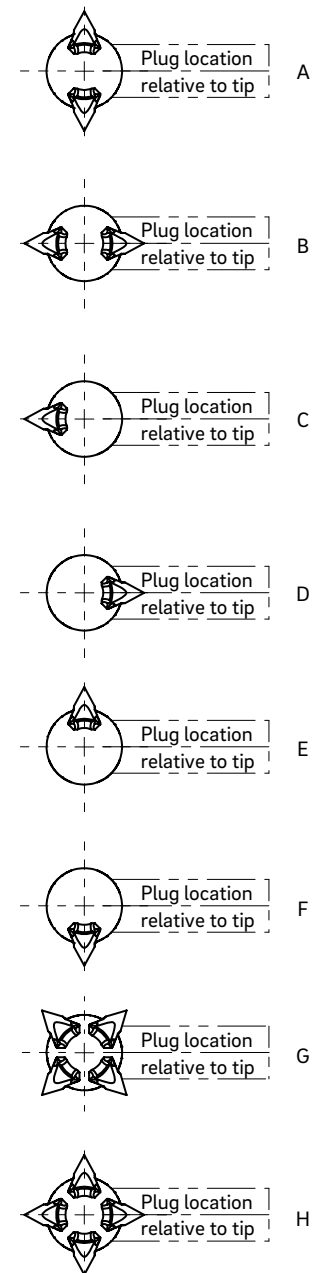
NOTE

Power connector CHF and thermocouple connector CMLK are to be ordered separately.

BlueFlow® hot runner nozzle type 18LHF is not intended for sale or use in the USA or Canada!



PLUG LOCATION RELATIVE TO TIP





22LHT

Multi-drop hot runner nozzle for side gating under 90°, without cold slugs, with conventional heating element

TECHNICAL DATA

22LHT

Melt channel Ød 4.8 mm

Quantity of tips 1, 2 or 4

Operating voltage 230 V_{AC}*

Nominal length of the nozzle (L) in mm

60	80	100
■	■	■

*Volts alternating current

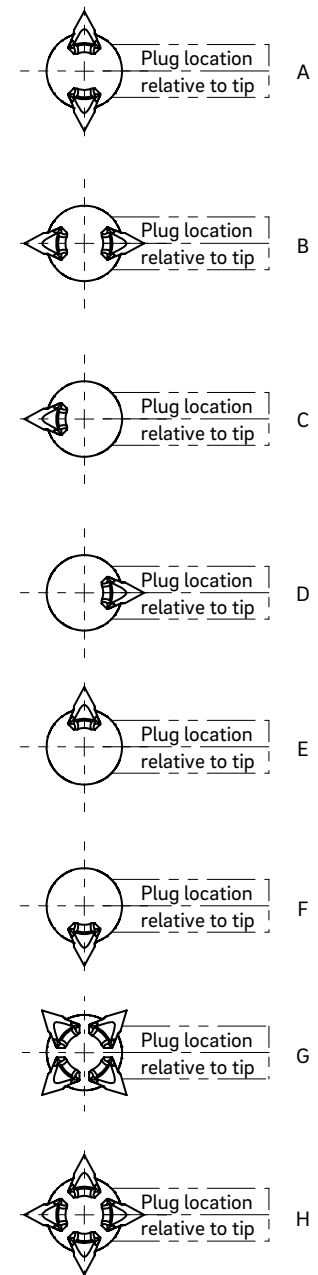
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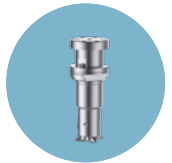
NOTE

Power connector CMT and thermocouple connector CMLK are to be ordered separately.

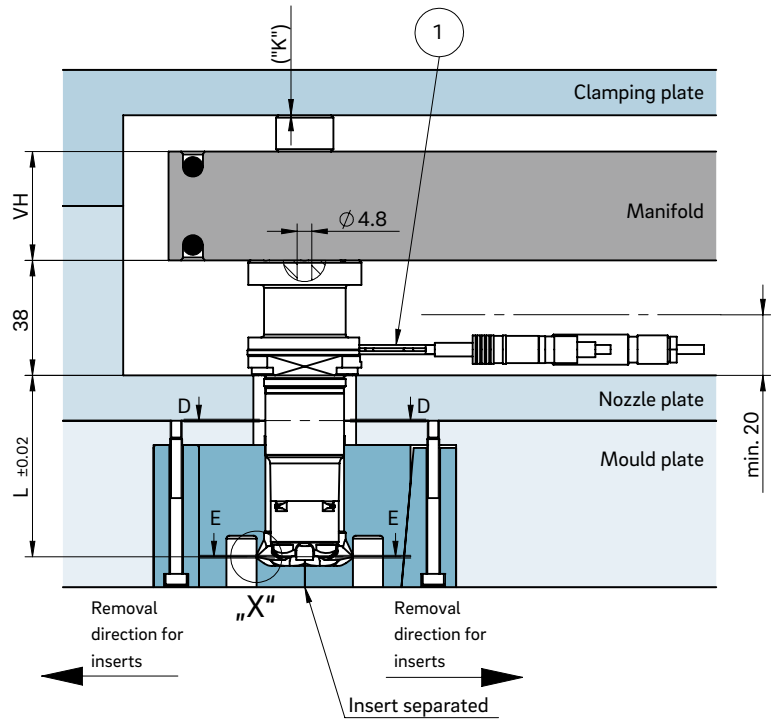
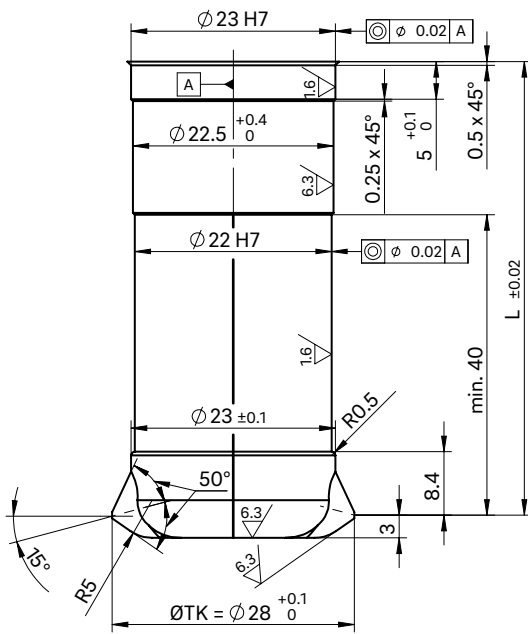


PLUG LOCATION RELATIVE TO TIP

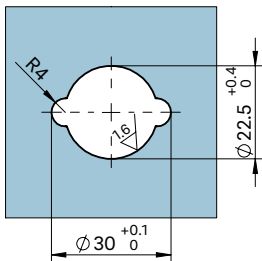




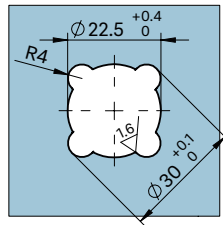
INSTALLATION



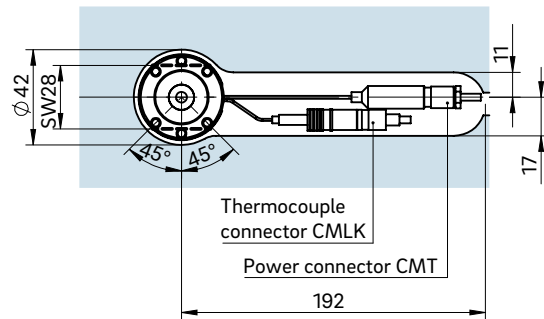
View D-D for two nozzle tips



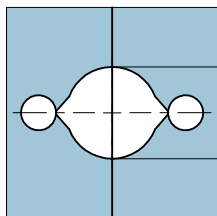
View D-D for four nozzle tips



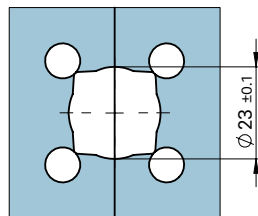
Example cutout for nozzle head, power and thermocouple plug connections



View E-E for two nozzle tips

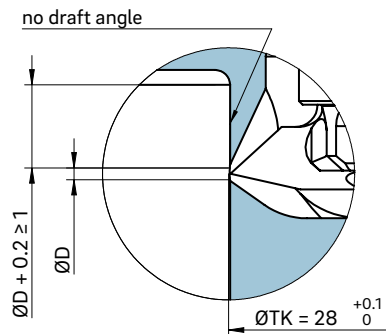


View E-E for four nozzle tips

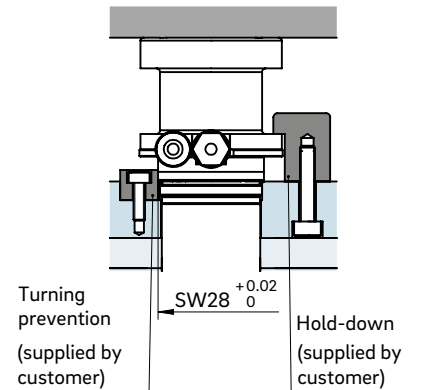


① Thermocouple plug connection in this area can only be bent once; minimum radius: R8
SW = flat area on nozzle head

Detail "X"



Turning prevention



The size "K" required for heat expansion is to be ensured by grinding the pressure pads (12 + 0.1 mm)! Determine the difference between the height of the manifold system and the height of the clamping plate when installed! ΔT specifies the temperature differential between the processing temperature and the mould temperature!

VH	ΔT (°C)	100	150	200	250	300	350
36 mm	K (mm)	0.021	0.059	0.098	0.137	0.177	0.217
46 mm	K (mm)	0.033	0.078	0.124	0.170	0.218	0.264
56 mm	K (mm)	0.046	0.097	0.150	0.203	0.258	0.311

To prevent open jet formations, injection should be carried out against a core, for example.



26LHT

Multi-drop hot runner nozzle for side gating under 90°, without cold slugs, with conventional heating element

TECHNICAL DATA

26LHT

Melt channel Ød 6.0 mm

Quantity of tips 1, 2 or 4

Operating voltage 230 V_{AC}*

Nominal length of the nozzle (L) in mm

60	80	100
■	■	■

*Volts alternating current

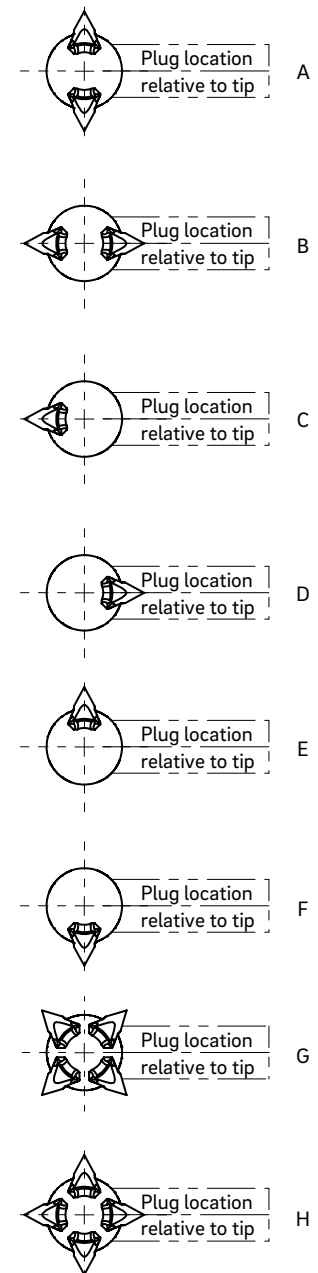
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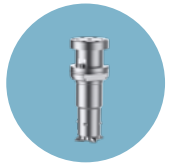
NOTE

Power connector CMT and thermocouple connector CMLK are to be ordered separately.

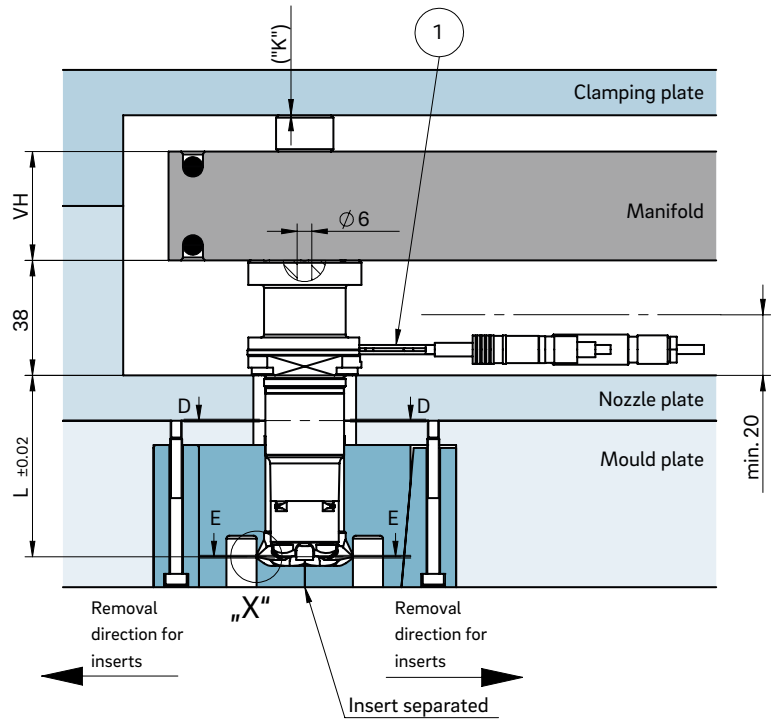
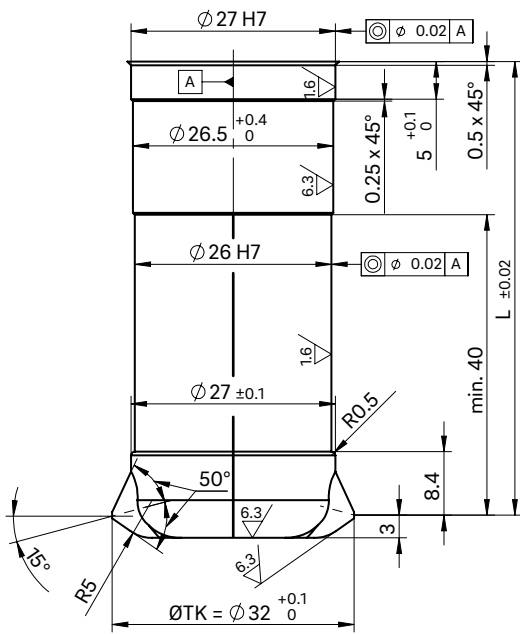


PLUG LOCATION RELATIVE TO TIP

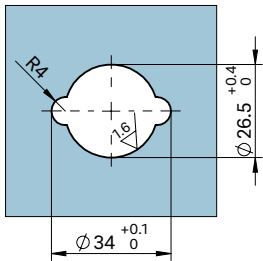




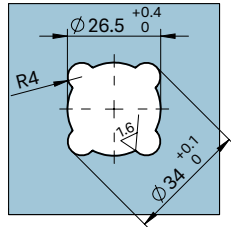
INSTALLATION



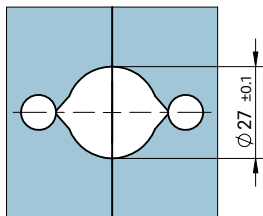
View D-D for two nozzle tips



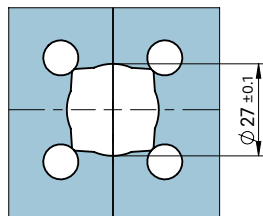
View D-D for four nozzle tips



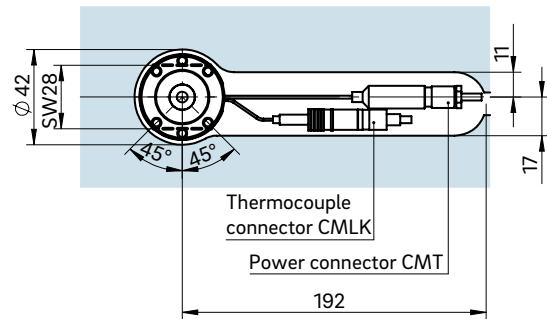
View E-E for two nozzle tips



View E-E for four nozzle tips

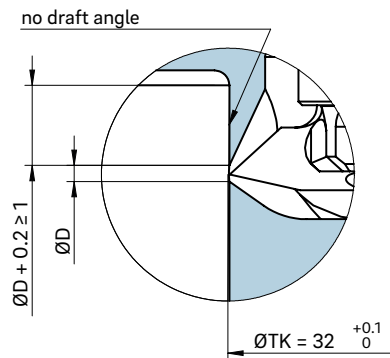


Example cutout for nozzle head, power and thermocouple plug connections

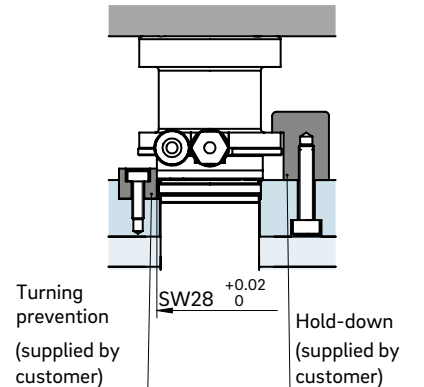


- ① Power and thermocouple plug connections in this area can only be bent once; minimum radius: R8
SW = flat area on nozzle head

Detail "D"



Turning prevention



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VH	ΔT (°C)	100	150	200	250	300	350
36 mm	K (mm)	0.021	0.059	0.098	0.137	0.177	0.217
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