

Mainfold Heaters

CE



Manifold Heaters

Product Description

Construction

Hot Runner Manifold Heaters are made to order using 6.5mm, 8mm or 10.5mm diameter Incoloy tubular heating elements. Commonly specified terminations include threaded stud or wire leads.

Important Information for Forming

Precise forming of the tubular heater is required for it to seat properly into the milled slot in the manifold. To ensure this fit, we use the physical template as an inspection tool in the forming process to verify bending accuracy.

The template is a reproduction of the milled slot in the form of a plastic or aluminum plate. It can be customer supplied or manufactured by us. Only through the use of a forming template is bending accuracy guaranteed.

Resistance Tolerance

Tubular heating elements have an Industry Standard Resistance Tolerance of +10%, -5% which translates to a Wattage Tolerance of +5%, -10%.

Features

- ▶ Formed into specified shape, diameter options of 6mm, 8mm
- ▶ Sheath material options of S.S.304 / S.S.316 / S.S.321 / S.S.310 / Incoloy 800 / S.S. termination
- ▶ Watt density 50 watts per sq inch

Application

- ▶ Hot runner moulds, manifolds

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Technical Specification

Sheath material	Nickel Chrome Steel		
Max. Sheath Temperature	650 ° C		
Insulation Material	High Purity MgO		
Heating Element	Ni/Cr 80:20		
Voltage Rating	12 V to 440 V		
Power Rating For Diameter	6mm	8mm	10.5mm
	35 W / in ²	50 W / in ²	65 W / in ²
Power Tolerance	± 10%		
High Voltage Strength	= 1500 V – AC		
Insulation Resistance	= 5 Mega ?		
Current Leakage	< 0.5mA		
Heater tube Diameter (in mm)	○ 6.5mm, 8mm, 10.5mm		
Minimum Length	200mm		
Maximum Length	6000mm		
Lead Terminals For tube Diameters (in mm)	M3	M4	
	6.5mm, 8mm	8mm, 10.5mm	
Lead Length	Standard 25mm (fitted with brass nut and washer)		
Unheated Length	50mm at the both end. Larger lengths available on request.		