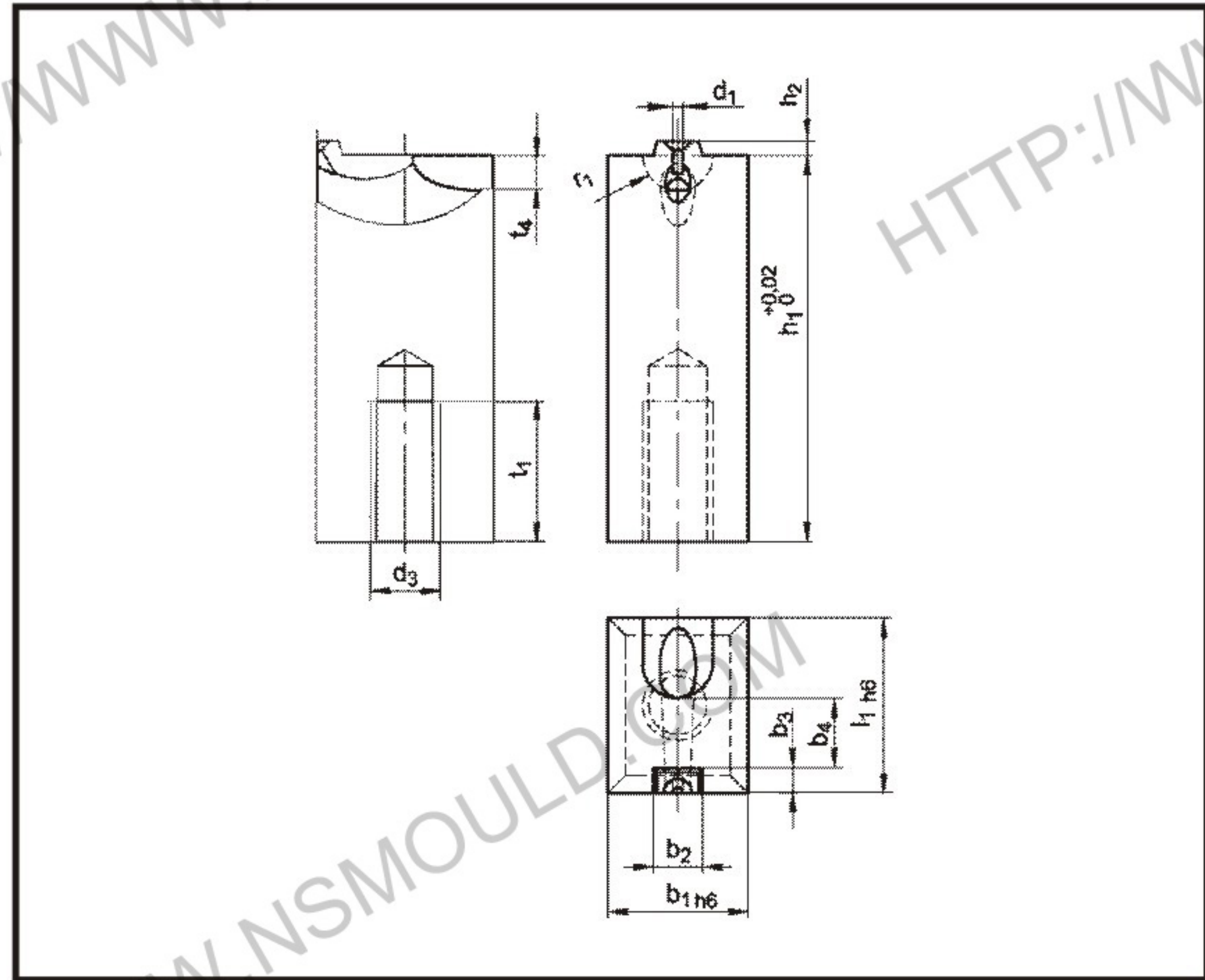




Material:718



Ref	r ₁	t ₁	t ₄	b ₂	b ₃	b ₄	d ₃	h ₂	l ₁	b ₁	h ₁	d ₁
LRD-8x17	1.5	8	2	2.6	1.3	3.7	M4	0.8	8	6	17	0.4 0.6 0.8
LRD-10x22	2		2	2.6	1.3	3.7			10	8	22	0.6 0.8 1
LRD-12x10	2.25	10	2.25	3.0	1.5	4.5	M5		12	10	27	0.6 0.8 1
LRD-15x12	2.5		2.5	3.5	1.75	5	M6		15	12	0.9 1 1.2	

Latent runner device is a runner in latent mode replacing the push-cut mode, pull-cut mode, and secondary gate runner mode. White halo will be generated on the surface of plastic cast in push-cut mode for high pressure, and the runner is still to be chipped off manually. Traces on the runner may be left behind on surface of the plastic cast for pull-cut mode, while there exists the same defect in the secondary gate runner mode as that in the push- and pull-cut modes. The latent runner device has simplified the structure of mould runner and it adopts the tunnel type for running from the end face of the product wall thickness. Such cut-off mode in runner structure has ensured a smooth disengagement of plastic products, for the top end of the runner to be free from obvious traces, with inward plastic running resistance much reduced relative to other latent modes, so that the quality of plastic cast is further enhanced.

Characteristic

1. The runner and the mould will automatically disengage from each other at stripping.
2. Standard cast is formed at the runner part, for easy replacement.
3. Very adaptable to plastic components of plane type of thin wall type.
4. Diameters of the runner includes 1.5, 2, 2.25, and 2.5mm 4 specifications.
5. Standard spacer block can be used to adjust the height of installation.

Installation

1. A distance of 4-7 gate runner diameter is to be maintained between the nozzle of runner and the ejecting point of mandril for the gate runner, as per hardness of plastic, so that an enough stripping can be left for the runner because of its own adhesive force (A diameter for about 2-5 gate runners is to be required for the space). Standard runner spacer block is to be selected and used: L=15, 25, 35, 45mm for the spacer block to be adjusted based on the height of molding board.