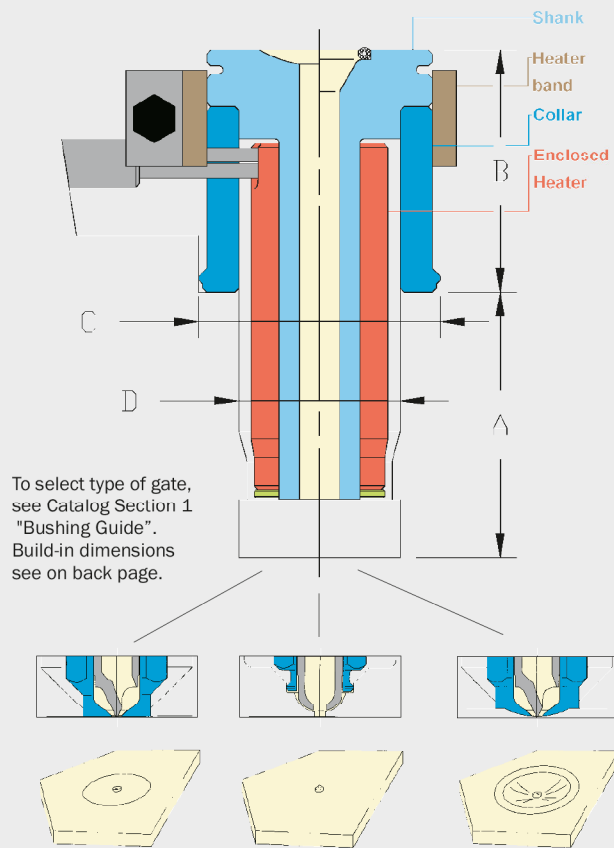


MFR for single-cavity, cold runner, cold sprue shortening and "floating" manifold

2.1E



To select type of gate, see Catalog Section 1 "Bushing Guide". Build-in dimensions see on back page.



- * Basic shank for most types of screw in end caps and gates.
- * Minimum melt breakdown.
- * High conductive heater enclosure gives you more exact and even melt temperature.
- * Economic and fast colour change.
- * Heavy duty and long life proof.

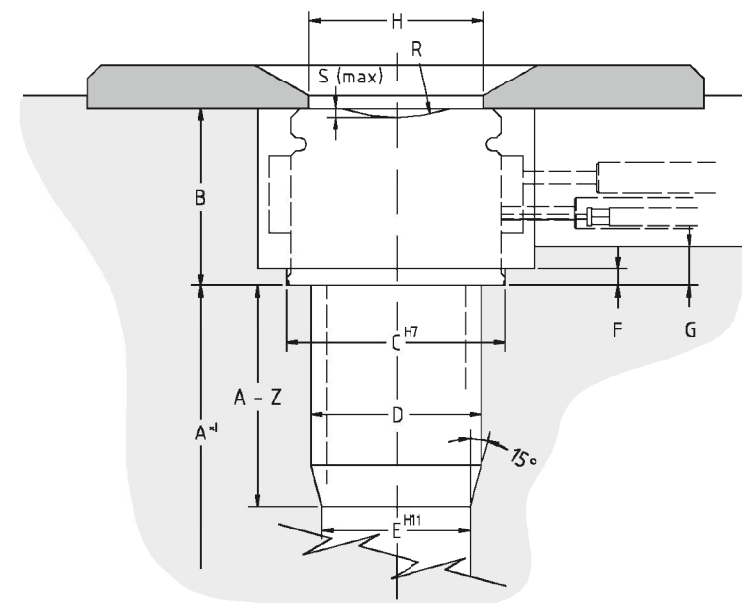
Series	Description	A	B	∅C	∅D	Heater encl./band	
20	MFR20 034	34				MFH20 034/059	MFVBT 028/012
	MFR20 054	54				MFH20 054/079	
	MFR20 074	74	29	30	20	MFH20 074/099	
	MFR20 094	94				MFH20 094/119	
	MFR20 114	114				MFH20 114/139	
	MFR20 134	134				MFH20 134/159	
30	MFR30 034	34				MFH30 034/059	MFVBT 038/014
	MFR30 054	54				MFH30 054/079	
	MFR30 074	74				MFH30 074/099	
	MFR30 094	94	30	40	30	MFH30 094/119	
	MFR30 114	114				MFH30 114/139	
	MFR30 134	134				MFH30 134/159	
40	MFR40 041	41				MFH40 041/074	MFVBT 049/017
	MFR40 066	66				MFH40 066/099	
	MFR40 091	91				MFH40 091/124	
	MFR40 116	116	39	50	39	MFH40 116/149	
	MFR40 141	141				MFH40 141/174	
	MFR40 166	166				MFH40 166/199	
50	MFR50 050	50				MFH50 050/089	MFVBT 058/018
	MFR50 080	80				MFH50 080/119	
	MFR50 110	110				MFH50 110/149	
	MFR50 140	140	44	60	48	MFH50 140/179	
	MFR50 170	170				MFH50 170/209	
	MFR50 200	200				MFH50 200/239	

Because of our program of continuous product improvements, MasterFlow reserves the right to change specifications and design without notice and without incurring obligation.

MasterFlow is an approved quality system for moulding with hot runner technology. Our engineers have considered both old and new experiences when designing the system. For moulding sensitive components, only verified solutions are chosen. With more than 35 years in hot runner business and thousands of hot runner systems delivered, we can guarantee best assistance from mold design to production optimization. **MasterFlow** is manufactured in Sweden by skilled workers and engineers. High quality, fast and competent service, satisfied customers and reasonable price.

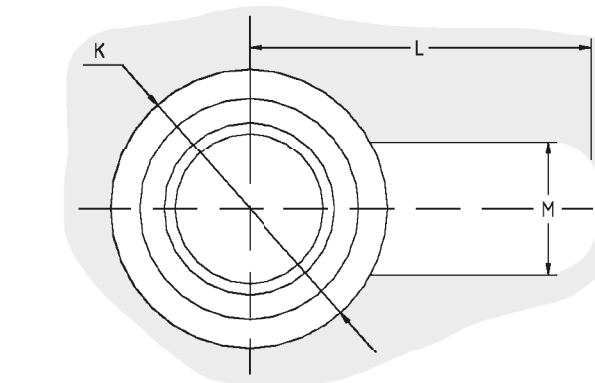
2.1Eb

MFR Boring Details for MFR bushings



Low temperature and less heat sensitive materials do not always need a heaterband. We recommend that you give place, if later needed. "A"-dim is important. Bushing is expanding when heated up. See expansion calculation below or quick guide on page 1.3E. Mold locating ring should always have minimum contact.

Series	20	30	40	50
B	29	30	39	44
∅ C	30	40	50	60
∅ D	20	30	39	48
∅ E	18	28	37	46
F	3	4	4	4
G	8	8	10	15
∅ H	25	33	44	52
∅ K	43	53	63	75
L	~100	~100	~100	~100
M	30	30	30	45
R	Delivery R = 0			
S (max)	2	2	3	4
Z	12	20	25	35



x) "A"-dim + heat expansion (Exp.);
Exp. = "A" * (Temp_{melt} - Temp_{mold}) * 13,2*10⁻⁶
Exempel: A = 91mm, Temp_{melt} = 210 °C, Temp_{mold} = 20°C, gives
Exp. = 91*(210-20)*0,0000132 = 0,23 mm
See table, Section 1 page 1.3E.

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Build-in dimensions for end caps and tips under section 2, page 2.7E and 2.8E

Type TG and OG:
Point Gate with small vestige and ring mark.

Type TGT and OGT:
Point Gate with very small vestige.

Type TGD and OGD:
Point Gate with vestige lower than part surface.

Type TGX and OGX:
For slanting surface and sprue gating.

