GUZZINI ENGINEERING

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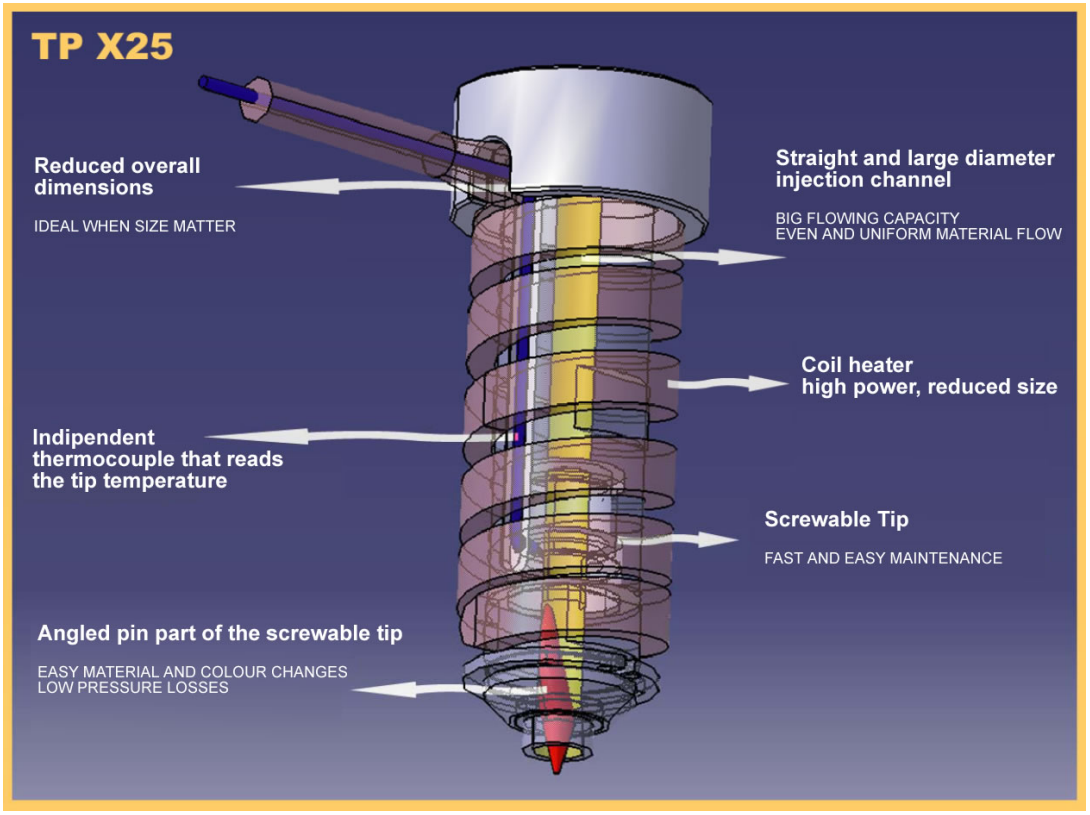
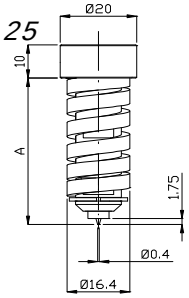
TP x25 series torpedo nozzles

When size matter

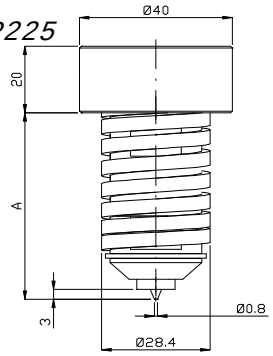
TP x25 series torpedo nozzles features a large diameter straight injection channel and reduced overall dimensions. The straight and free injection channel enable really low pressure losses and easy color and material change. The reduced overall dimensions make these nozzles suitable also when size matter.



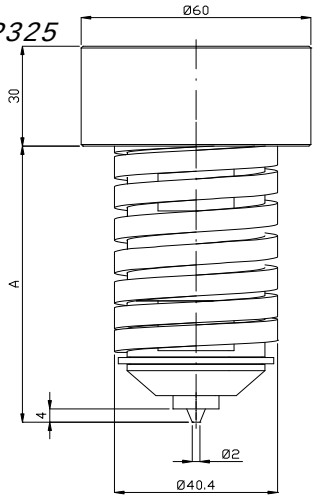
TP125



TP225



TP325



Lenght and Powers

A =	44	54	56	64	74	76	84	94	96	116
TP 125	1x250	1x250	******	1x300	1x300	******	1x300	1x350	******	******
TP 225	******	******	1X460	******	******	1X610	******	******	1X690	******
TP 325	******	******	******	******	******	1X950	******	******	1X950	1X950

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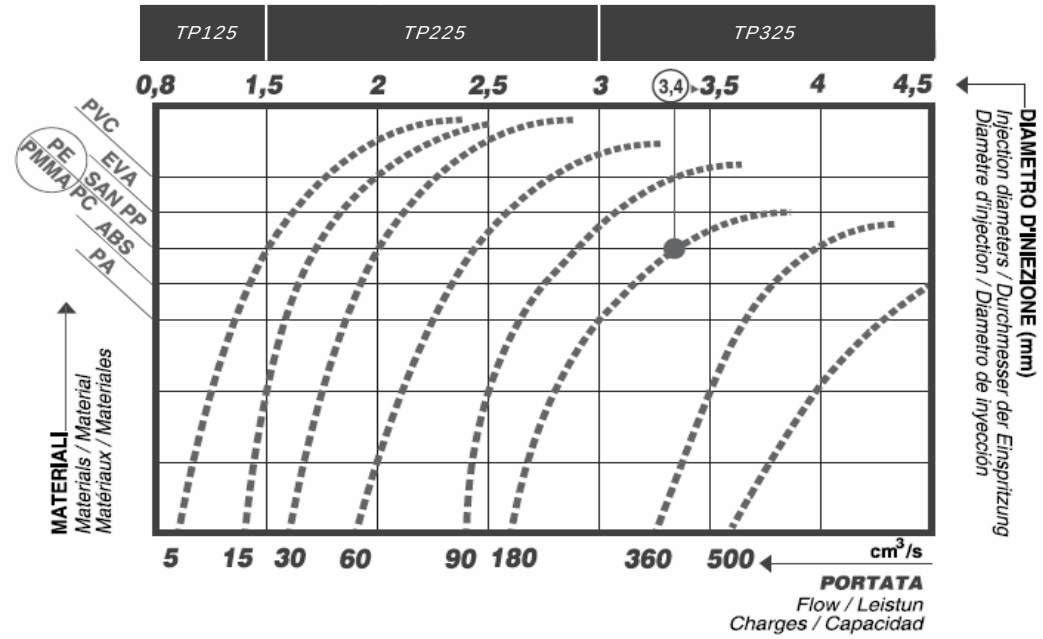
Flowing Capacity



ESEMPIO:

per determinare il tipo di ugello ed il diametro d'iniezione di un particolare in PMMA del peso di 1080 gr stampato con un tempo d'iniezione di 5 sec, procedere come segue:

- ***Selezionare il tipo di materiale sulla riga materiali.***
- ***Calcolare la portata richiesta nel seguente modo:***

$$\text{Ⓐ } \textbf{PORTATA} \text{ (LEISTUNG / FLOW CHARGE / CAPACIDAD)} = \frac{\textbf{Peso}\ \text{(Weight / Gewicht / Poids / Peso)}}{\textbf{Densità x Tempo d'iniezione}\ \text{(Dichte x Einspritzzeitt / Density x Injection Time; Densité x Temps d'Injection / Densidad x Tiempo de inyección)}} = \frac{1080}{1,2 \times 5} = 180\ cm^3/s$$

- ***Trovare l'intersezione tra la curva della portata e la linea del materiale.***
- ***Tracciare una riga verticale e vedere il diametro del punto d'iniezione (3,4) arrotondando il valore che si è trovato alla misura standard superiore (3,5).***

EXAMPLE:

to determine the right type of nozzle and the right injection gate size needed to mold a PMMA product weighting 1080 gr. and molded with an injection time of 5 seconds, the following procedure has to be followed:

- *Select the PMMA material on the materials axes.*
- *Calculate the needed injection flow as Ⓐ*
- *Select the injection flow curve correspondent to 180 cm^3/s.*
- *Find the intersection between the selected curve and the PMMA material line.*
- *The correspondent injection gate diameter is (3,4).This value has to be rounded to the nearest standard higher size (3,5).*