



不銹鋼---射出模具專用 硬度: RV50 孔径: 0.05

stainless steel:special for ejection mold

Hardness:RV50 Diameter:0.05

銅---中空模具專用 硬度:RV20 孔径:0.35

Copper:special for vacuumed mold

Hardness :Rv20 Diameter:0.03

極微細的排氣孔，能將模具內的瓦斯或空氣立即排出於模具外，簡單而最有效的產品為提升塑膠成型生產性能發揮威力。

有效解決下列之問題:

燒焦

樹脂的填充較排氣快時，空氣受斷熱壓縮,前端部變成高溫,依情形而定，會引起變色,燒焦等問題。

溢料

在結合部前端的樹脂溫度上升，粘度下降，而易發生溢料，另外，空氣造成填充障礙，則射出壓力上升，結果模具微漲，而全體發生溢料。

填充不足

雖然沒有燒焦、溢料發生，但因空氣造成的阻力，減緩了填充比率，造成填充不足的現象。

氣泡銀綫

空氣與樹脂凝縮造成氣泡、銀綫、污點等外觀不良問題。

循環時間延長

若提高樹脂溫度，模具溫度，降低射出速度，雖然這些不良現象不會發生，但使循環時間延長。

節省能源、節省時間、節省成本

若從設計階段開始考慮TX排氣栓的話，模具的試模次數、時間、材料均可減少。

裝入排氣栓的費用與時間約以往的1/3~1/10。

排氣栓使用方法:

- 1.排氣栓在壓入模具時,表面請勿直接打擊。
- 2.排氣栓在壓入模具時，請使用JIS規格H7/S6之公差。

In order to achieve its maximum molding productivities,simply using its ultra micro breathing cell to exhale gas and air from molds.

Common Questions:

1.Burnt

When aberration and burnt issues occurred,it is because resin is filling faster than air exhaling which will result gas vent to overheat.

2.Overflow:

There are 2 possible conditions:

When temperature of resin gets higher at the tip of seaming ,it weakens its bonding strength.

Air can filled up the path and blocks resin to flow functionally which will cause ejection pressure to rise and materials to overflow.

3.Not enough fillings:

Due to air pressure ,it reduces the ratio of the filling speed . Even there is no any sign of burnt or overflow.

4.Cell Streak:

If there are some cells, streaks and mottles occurred,it is because the cells have not been vaporized completely between air and resin.

5.Extensive Cycling Time:

The higher temperature of resin, molds and slower speed of injection cause extensive cycling time, however, it will not affect the quality of final products.

Energy,Time,and Cost Saver:

- 1.It will reduce the trial die, time and materials if users consider to use TX gas vent the beginning of the design.
- 2.It will save up to 1/3 to 1/10 of the total cost and time if installing gas vent

Installation:

- 1.Do not touch the surface when gas vent is in use.
- 2.Use H7/S6 from JIS reference chart .

Catalog No.		L	Price 單價
Type	D		
JH077	4	4.5	
	5	10	
	6	10	
	8	10	
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