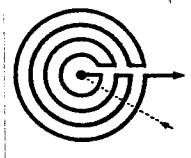
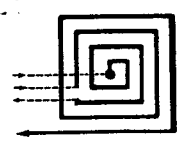


"W": épaisseur de paroi de la pièce (mm)	"d": diamètre des canaux (mm)	"a": entre-axe vis à vis des empreintes	"b": entre-axe des canaux
2	8 - 10		
2 - 4	10 - 12		
4 - 6	12 - 14	$1,5 - 2 d$	$2 - 3 d$



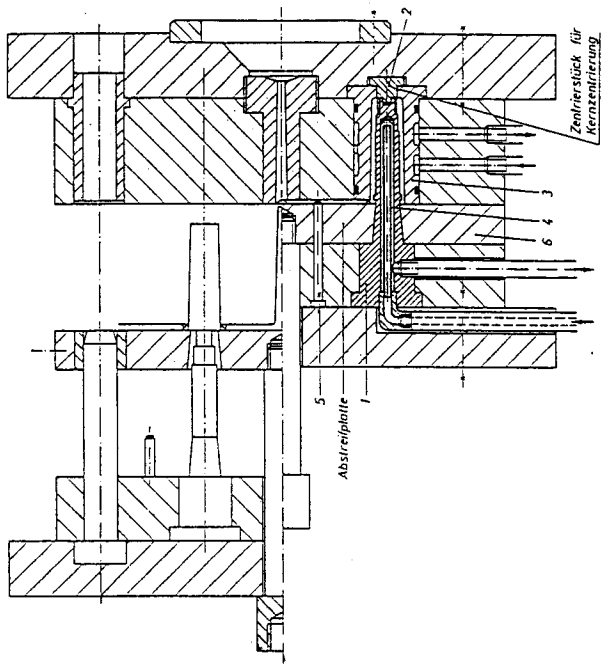
Configuration du refroidissement spirale, à un circuit



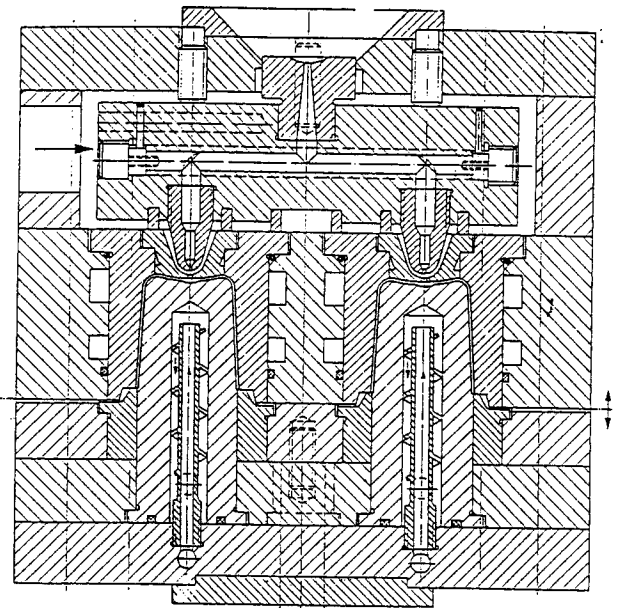
Configuration du refroidissement en spirale, à deux circuits

REG-F1

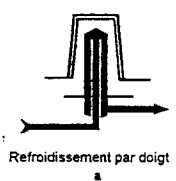
P.C.A.S



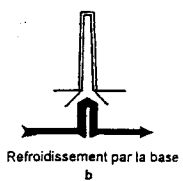
FONCTION REFOUDDISSEMENT
 Système de refroidissement amélioré en forme de puits sur un moule à plusieurs empreintes pour gobelets en Hostalen GC 6465.



Regula
P.C.A.S



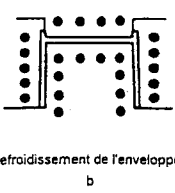
Refrddissement par doigt



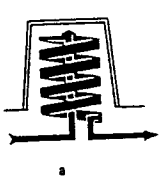
Refrddissement par la base



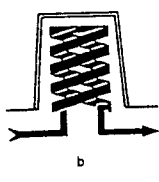
Refrddissement de la soupape



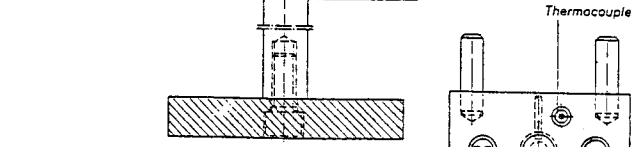
Refrddissement de l'enveloppe



a



b



Thermocouple

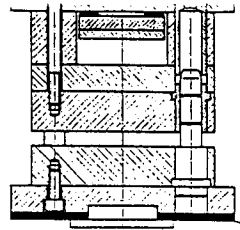
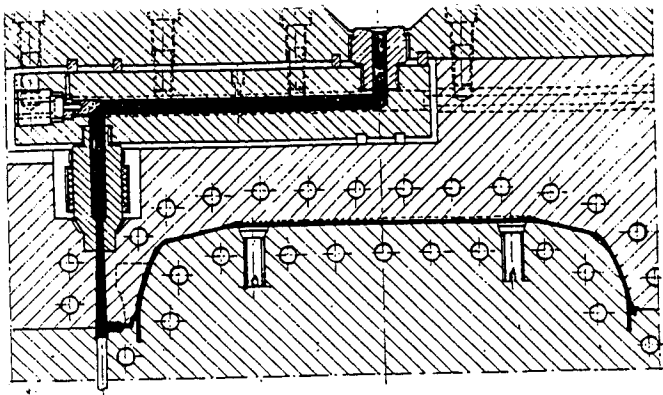
Cartouche chauffante
500 W, 230 V
vue dans le sens de la flèche



Refrddissement du plateau en série



Refrddissement du plateau en parallèle



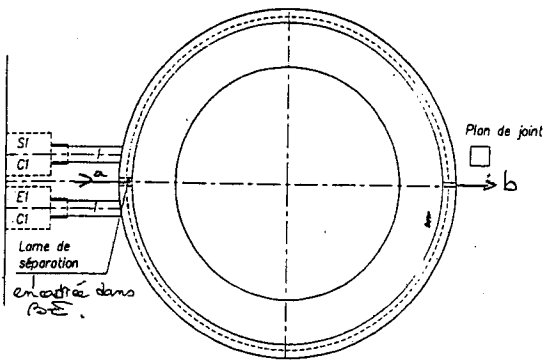
P-CAS

ation
es
r

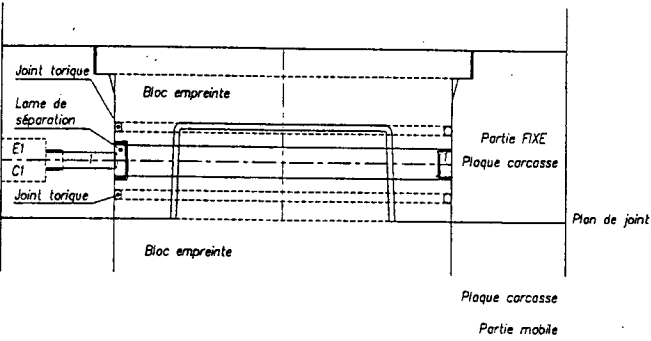
REG-FL

REG-F3 LAG

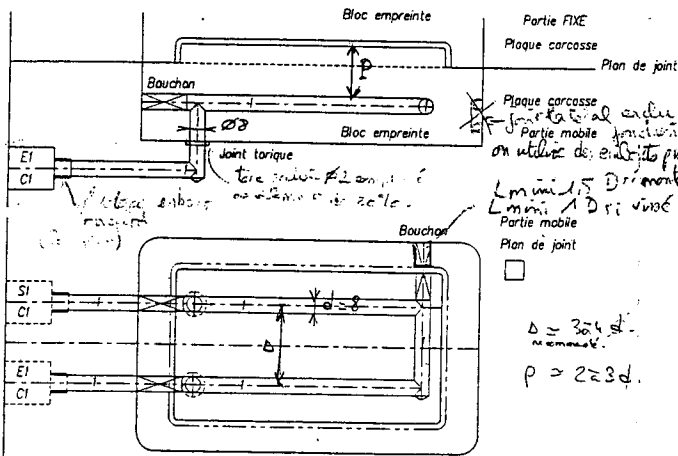
Ceinture



variante $E_1 = 0$
 $S_1 = 0$
 (sans lame de séparation)



Circuit Réseau



Plaque carcasse en aluminium anodisé pour la partie fixe et en acier inoxydable pour la partie mobile. On utilise des bouchons pré-insérés.

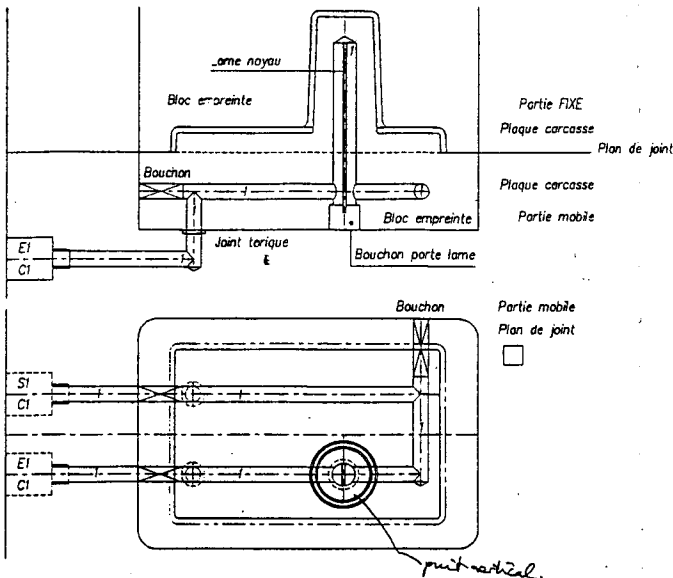
Le mini 15 D est en aluminium.

Le mini 1 D est en acier inoxydable.

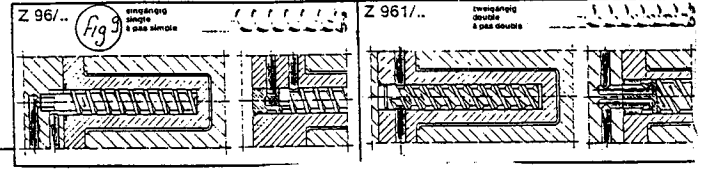
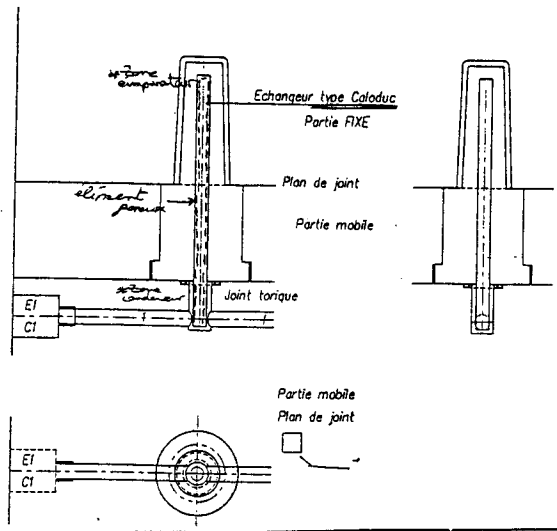
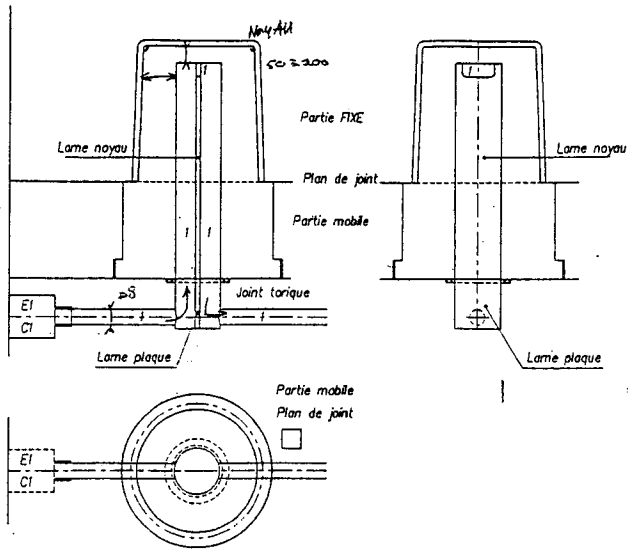
épaisseur pièce 2 à 3 mm
 circuit $\varnothing 8$

Regul
 LAG

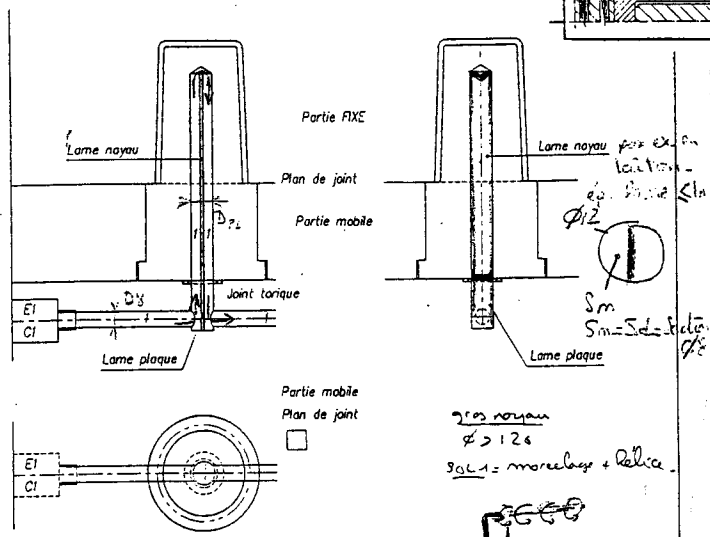
Réseau+Puit



puit vertical.

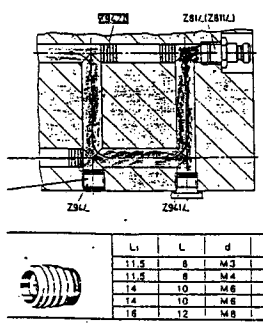
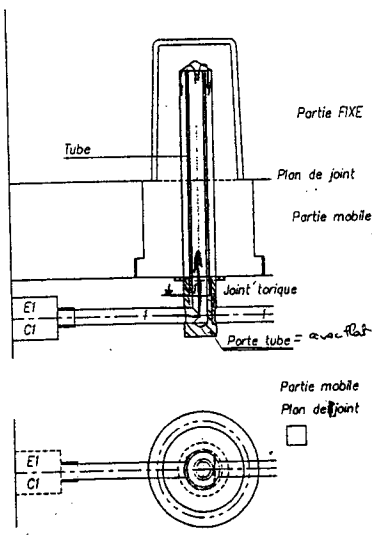


Puit à lames

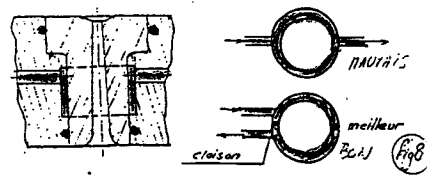
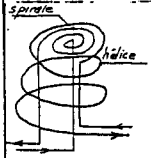
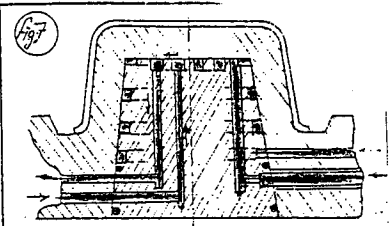


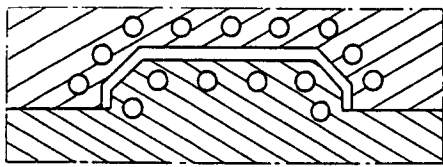
gros noyau
 $\phi > 126$
 SOL1 = morsures + hélice
 SOL2 = huit à lames en
 série dans le
 noyau.

Puit Fontaine

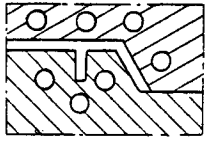


Li	L	d	D
11,5	8	M3	6
11,5	8	M4	8
14	10	M6	10
14	10	M8	12
16	12	M8	16

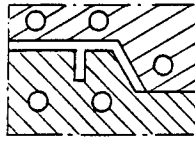




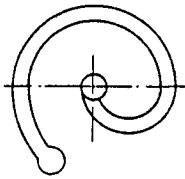
Bon :



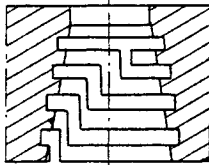
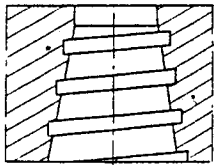
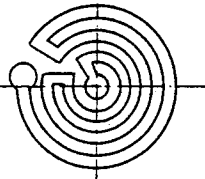
Médiocre :



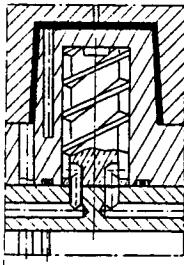
Spirale :



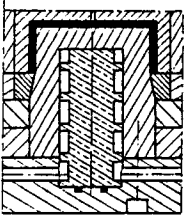
Cercles décalés :



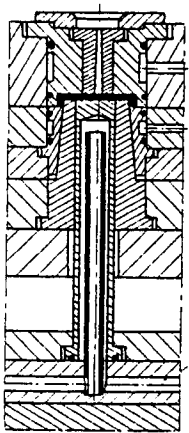
Hélice double :



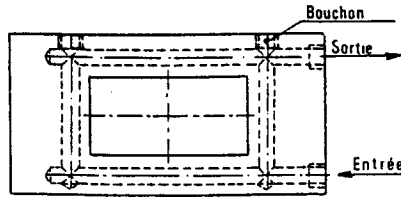
Spirale :



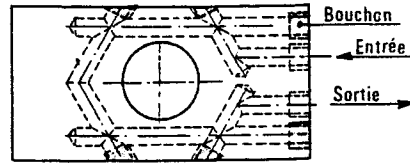
Anneau et tube :



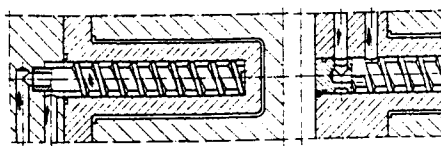
• Refroidissement d'une empreinte rectangulaire :



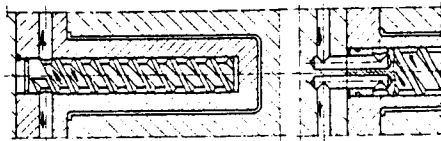
• Refroidissement d'une empreinte circulaire :



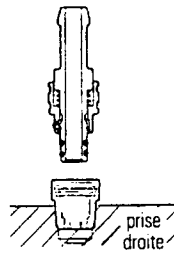
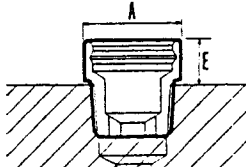
• Hélice simple :



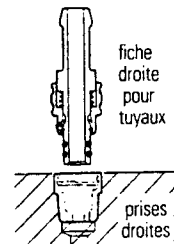
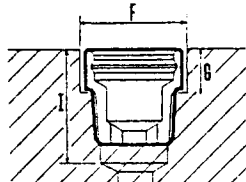
• Hélice double :



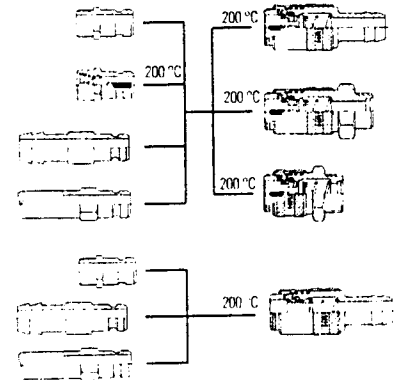
• Vissage avec très faible débordement :



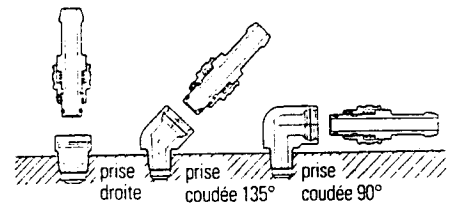
• Vissage encastré :



• Liaisons de refroidissement :



Fiches droites pour tuyau



Le raccordement du moule au réseau d'eau de refroidissement au moment de sa mise en place sur la presse d'injection doit être réalisé très rapidement ; à cet effet, on utilise des coupleurs rapides.