

SXTG Technical Guide

SXTG13

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 13 TT)	✓	✓	✓
One-hole Torpedo Tip (X 13 IT)	✓	✓	✓
Open Tip (X 13 OT)	✓	✗	✓

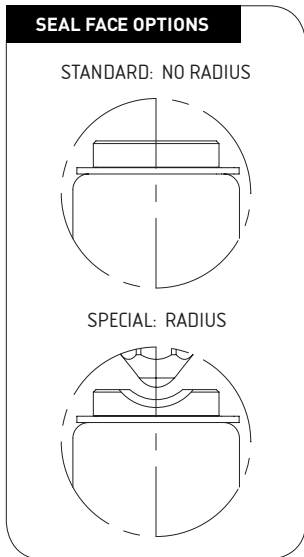
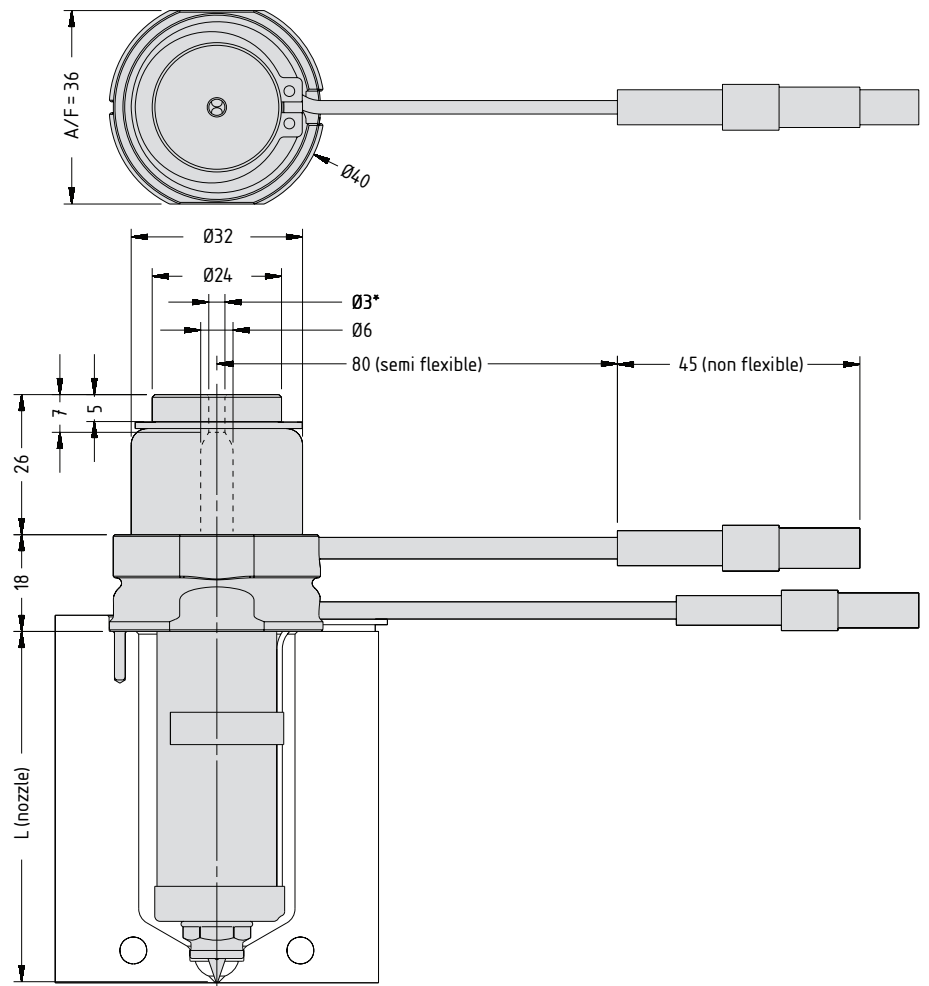
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIT13175 G5 Radius=0)

To order a tip:

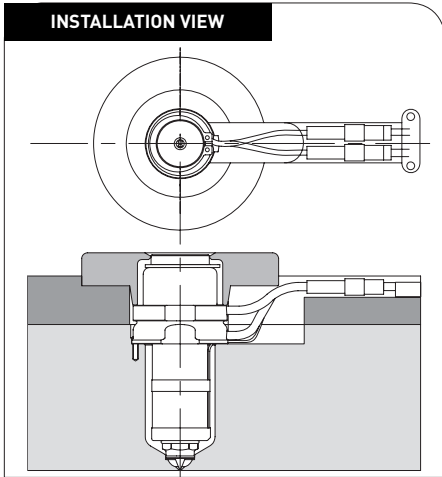
Provide the Tip Code + Grade
 (Order example: X 13 IT G5)

Nozzle Dimensions



Note

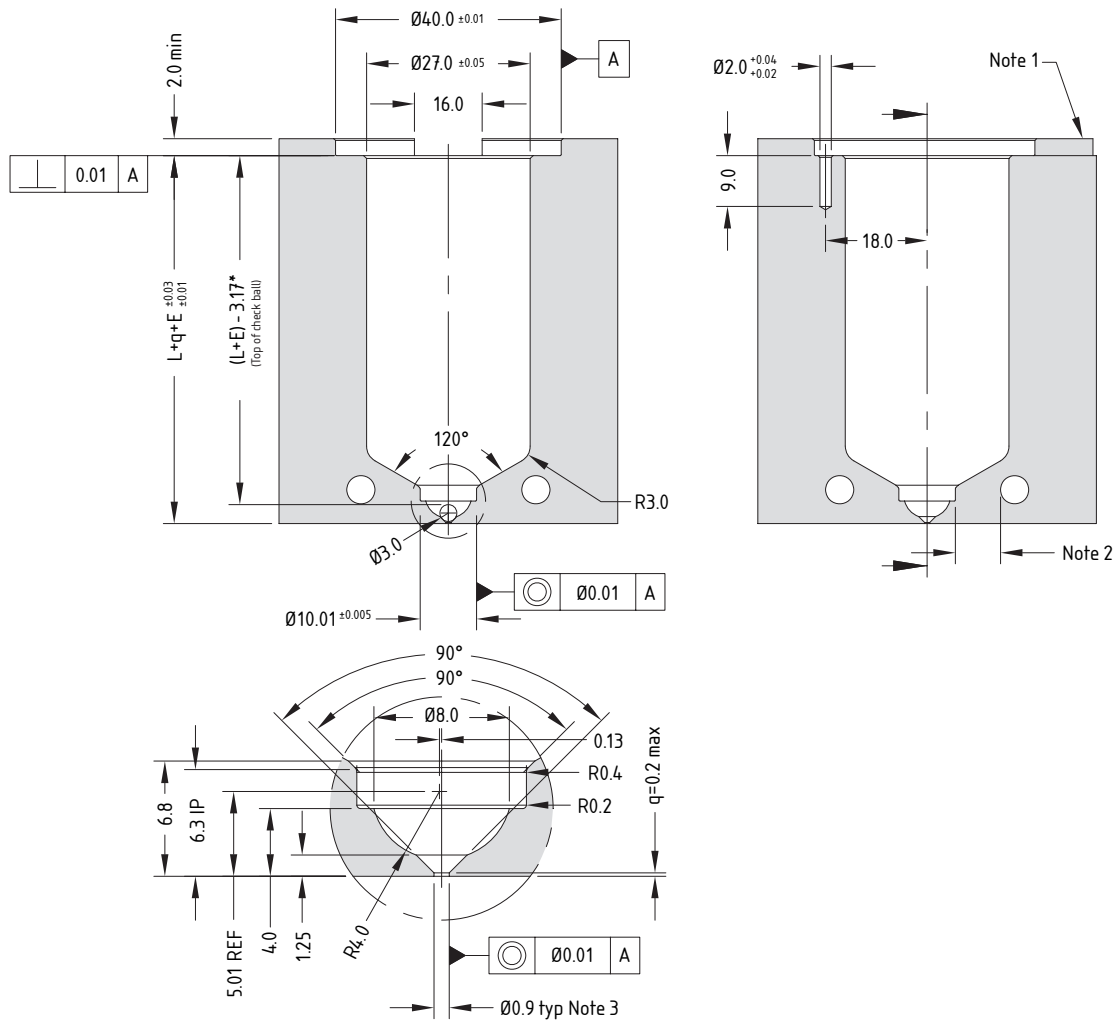
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTT13045	SXIT13045	SXOT13045	45	0.12	0.15
SXTT13055	SXIT13055	SXOT13055	55	0.15	0.18
SXTT13065	SXIT13065	SXOT13065	65	0.17	0.21
SXTT13075	SXIT13075	SXOT13075	75	0.20	0.25
SXTT13095	SXIT13095	SXOT13095	95	0.25	0.31
SXTT13115	SXIT13115	SXOT13115	115	0.30	0.38
SXTT13145	SXIT13145	SXOT13145	145	0.38	0.48
SXTT13175	SXIT13175	SXOT13175	175	0.46	0.58

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
 - Minimum strength (σ_y) of nozzle plate 800MPa.
 - * With 0.9 gate, +0.05mm per 0.1mm increase in gate diameter.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 13 TT)	✓	✓	✓	✗
One-hole Torpedo Tip (X 13 IT)	✓	✓	✓	✗
Open Tip (X 13 OT)	✓	✗	✓	✗

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	0.9
H1	1.1

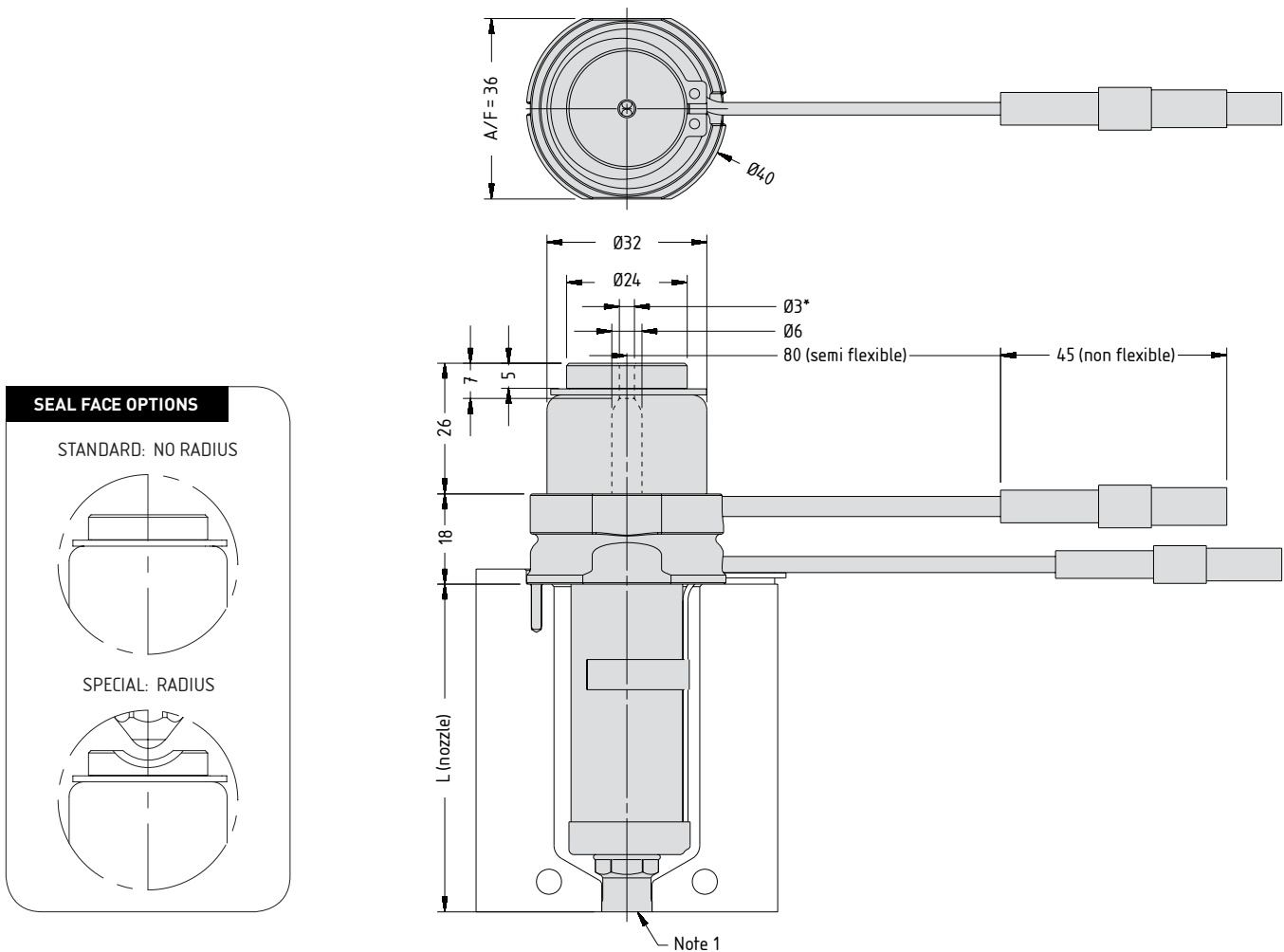
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIBE13075 G5 Radius=0)

To order a tip:

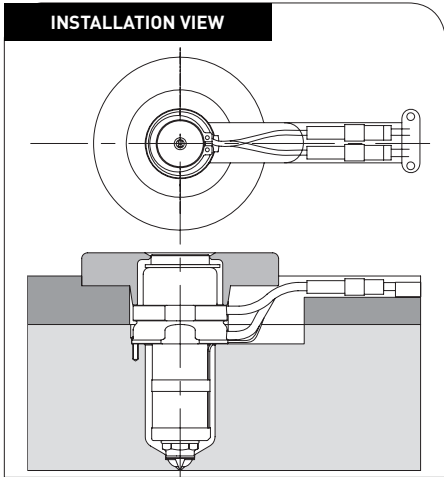
Provide the Tip Code + Grade
 (Order example: X 13 IT G5)

Nozzle Dimensions



Note

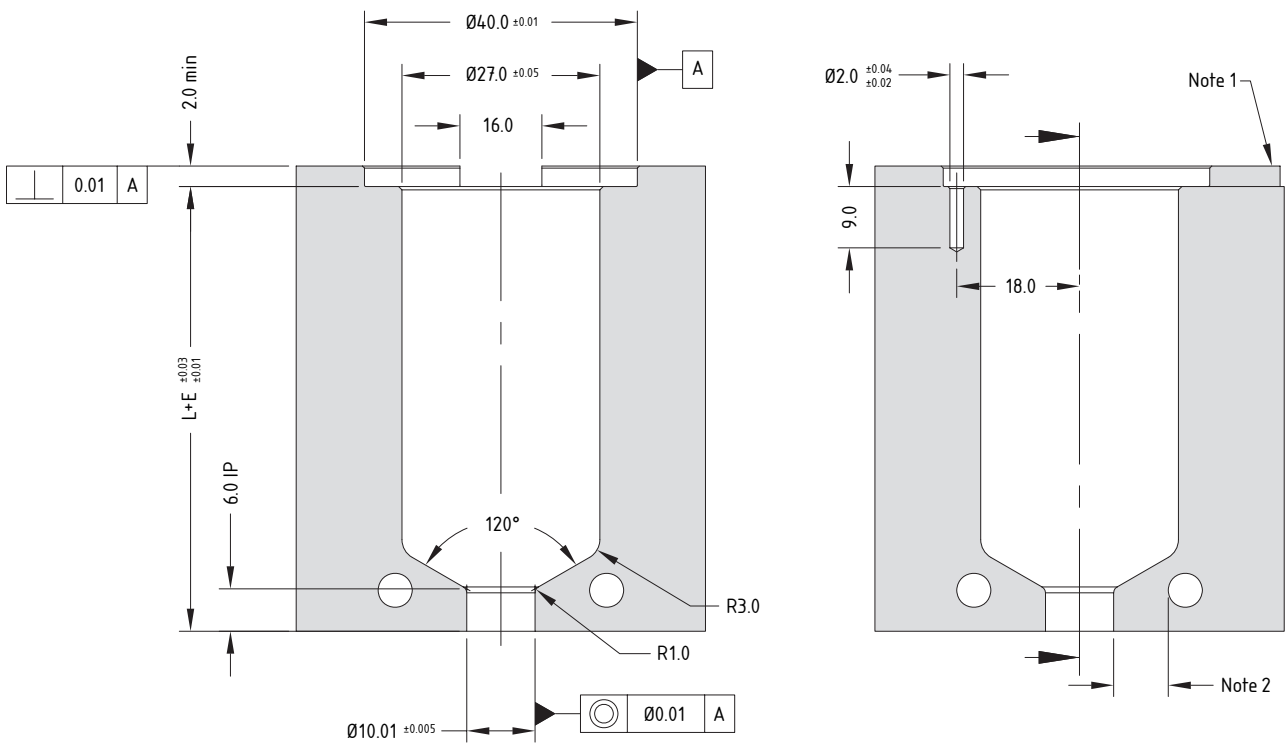
- Modify the contact area and the bush nut to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
 - Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
 - * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTBE13045	SXIBE13045	SXOBE13045	45.2	0.12	0.15
SXTBE13055	SXIBE13055	SXOBE13055	55.2	0.15	0.18
SXTBE13065	SXIBE13065	SXOBE13065	65.2	0.17	0.22
SXTBE13075	SXIBE13075	SXOBE13075	75.2	0.20	0.25
SXTBE13095	SXIBE13095	SXOBE13095	95.2	0.25	0.31
SXTBE13115	SXIBE13115	SXOBE13115	115.2	0.30	0.38
SXTBE13145	SXIBE13145	SXOBE13145	145.2	0.38	0.48
SXTBE13175	SXIBE13175	SXOBE13175	175.2	0.46	0.58

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 13 TT)	✓	✓	✓	✓
One-hole Torpedo Tip (X 13 IT)	✓	✓	✓	✓
Open Tip (X 13 OT)	✓	✗	✓	✓

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	0.9
H1	1.1
H5	1.3

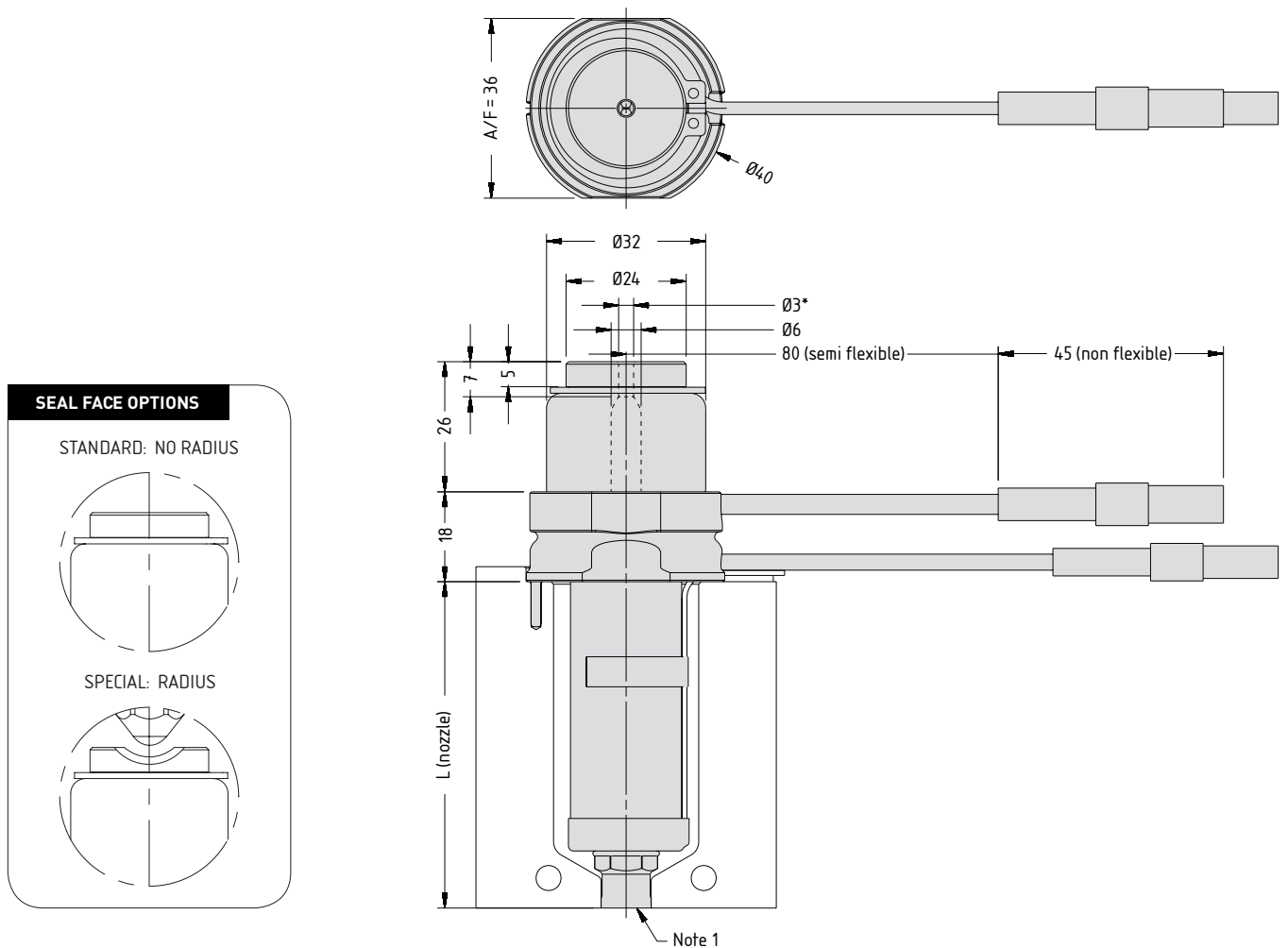
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIBN13075 G5 Radius=0)

To order a tip:

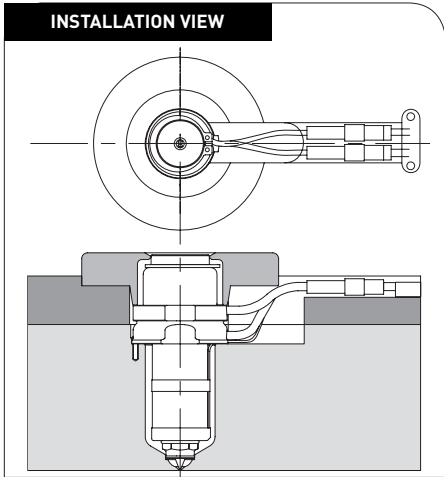
Provide the Tip Code + Grade
 (Order example: X 13 IT G5)

Nozzle Dimensions



Note

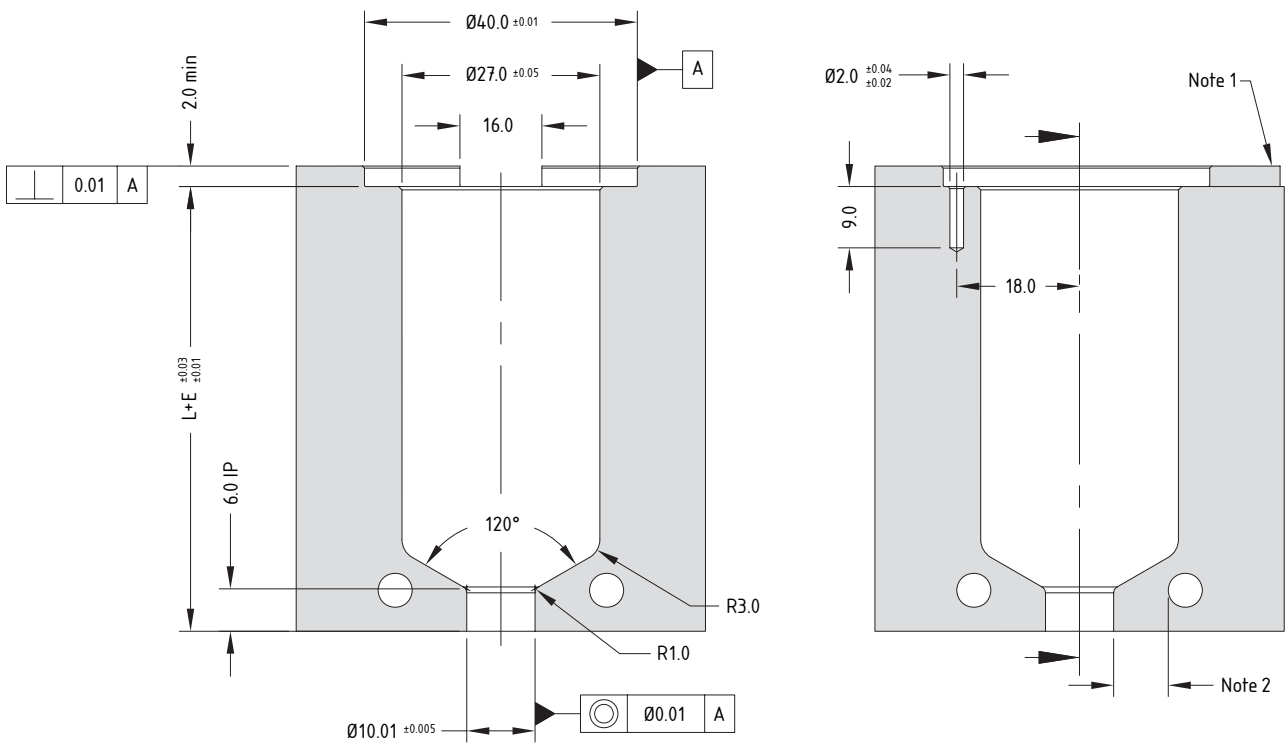
1. Modify the contact area and the bush nut to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
 - Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
 - * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTBN13045	SXIBN13045	SXOBN13045	45.2	0.12	0.15
SXTBN13055	SXIBN13055	SXOBN13055	55.2	0.15	0.18
SXTBN13065	SXIBN13065	SXOBN13065	65.2	0.17	0.22
SXTBN13075	SXIBN13075	SXOBN13075	75.2	0.20	0.25
SXTBN13095	SXIBN13095	SXOBN13095	95.2	0.25	0.31
SXTBN13115	SXIBN13115	SXOBN13115	115.2	0.30	0.38
SXTBN13145	SXIBN13145	SXOBN13145	145.2	0.38	0.48
SXTBN13175	SXIBN13175	SXOBN13175	175.2	0.46	0.58

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 13 TT)	✓	✓	✓	✓
One-hole Torpedo Tip (X 13 IT)	✓	✓	✓	✓
Open Tip (X 13 OT)	✓	✗	✓	✓

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	0.9
H1	1.3
H5	1.6

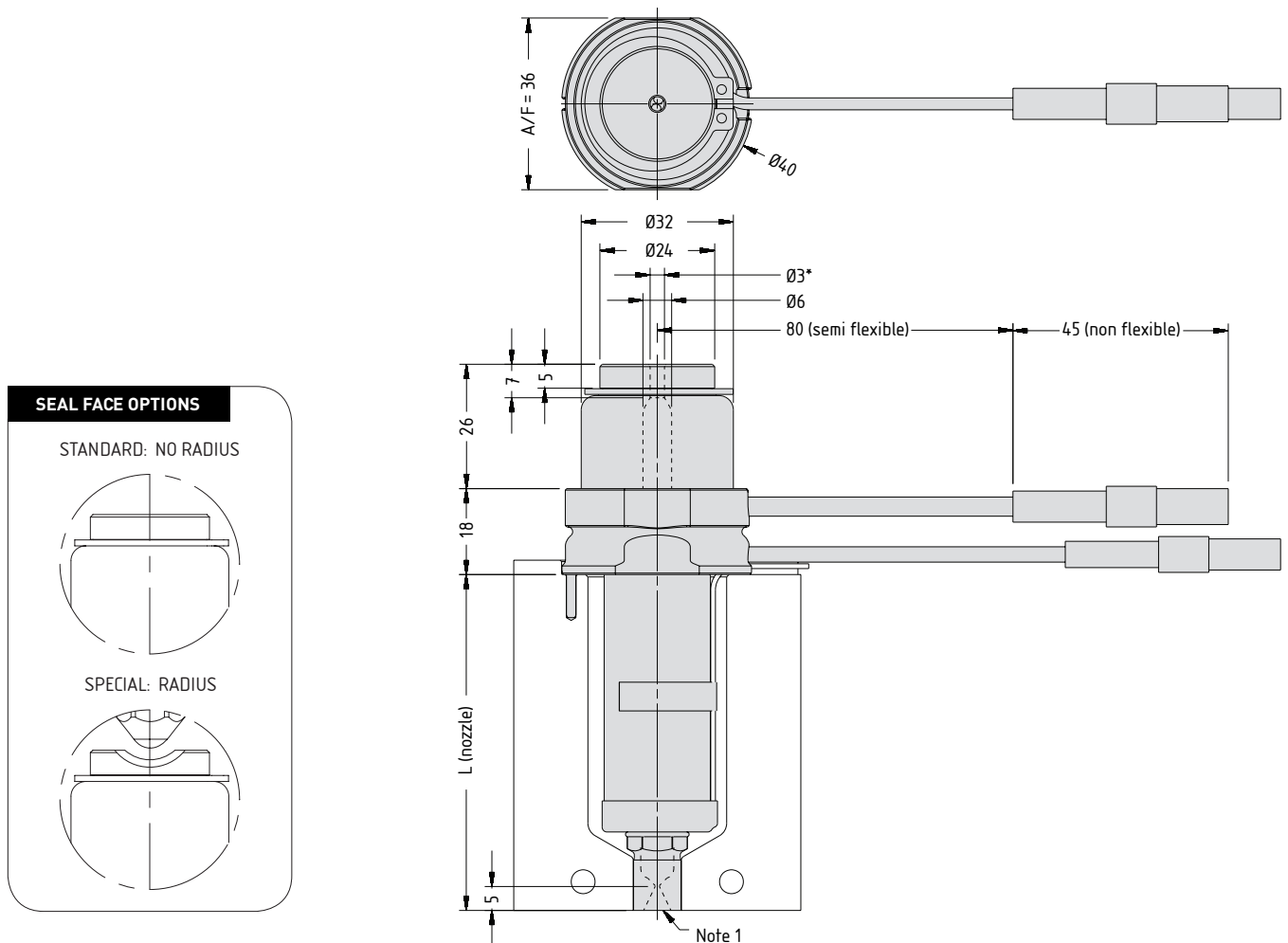
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXISN13075 G5 Radius=0)

To order a tip:

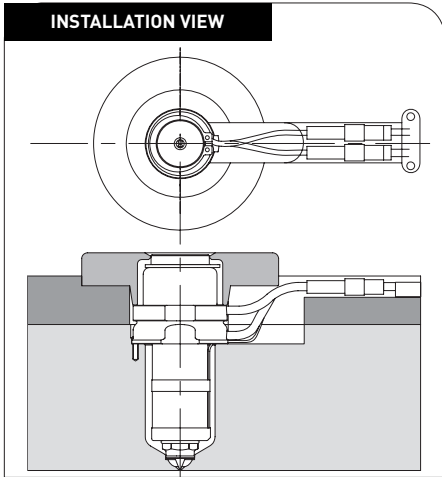
Provide the Tip Code + Grade
 (Order example: X 13 IT G5)

Nozzle Dimensions



Note

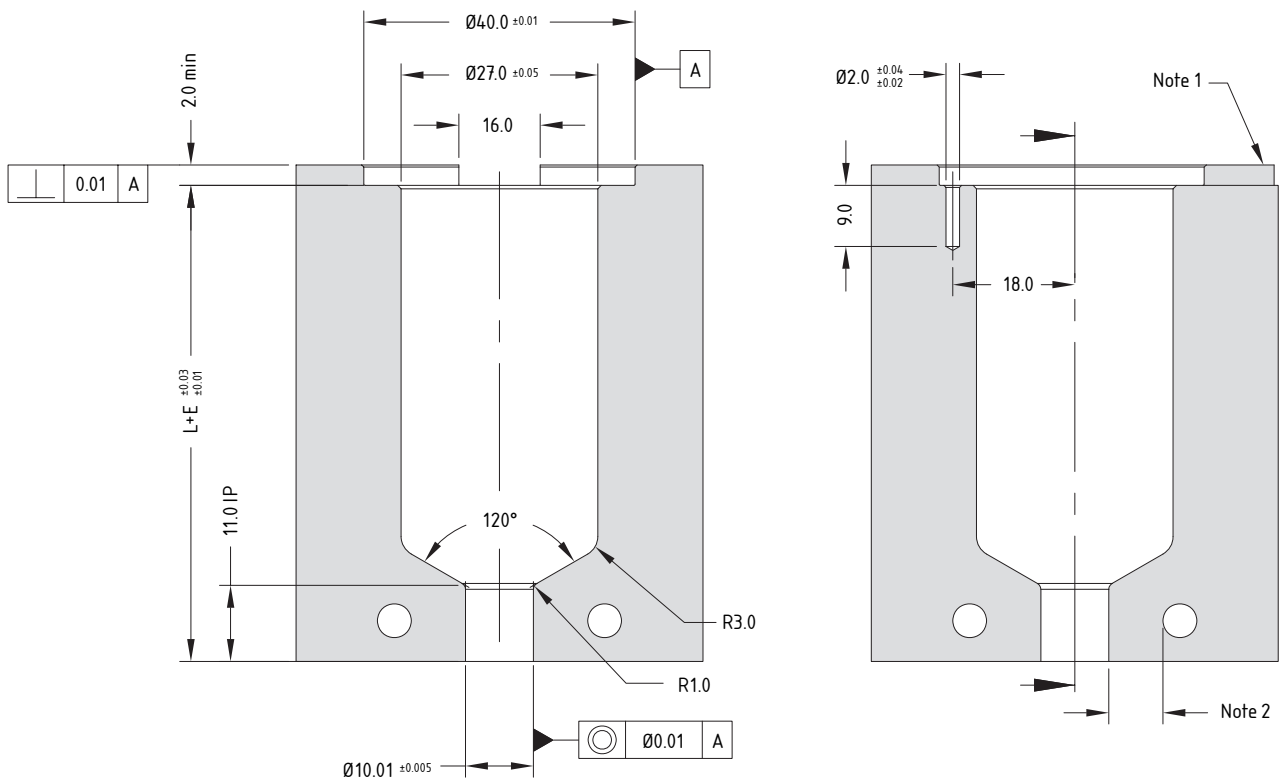
1. Modify the contact area and the sprue nut to suit the application.
- See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
 - * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	$E\Delta T = 200C$	$E\Delta T = 250C$
SXTSN13045	SXISN13045	SXOSN13045	50.2	0.13	0.17
SXTSN13055	SXISN13055	SXOSN13055	60.2	0.16	0.20
SXTSN13065	SXISN13065	SXOSN13065	70.2	0.17	0.23
SXTSN13075	SXISN13075	SXOSN13075	80.2	0.22	0.26
SXTSN13095	SXISN13095	SXOSN13095	100.2	0.26	0.33
SXTSN13115	SXISN13115	SXOSN13115	120.2	0.32	0.40
SXTSN13145	SXISN13145	SXOSN13145	150.2	0.40	0.50
SXTSN13175	SXISN13175	SXOSN13175	180.2	0.48	0.59

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 13 TT)	✓	✓	✓
One-hole Torpedo Tip (X 13 IT)	✓	✓	✓
Open Tip (X 13 OT)	✓	✗	✓

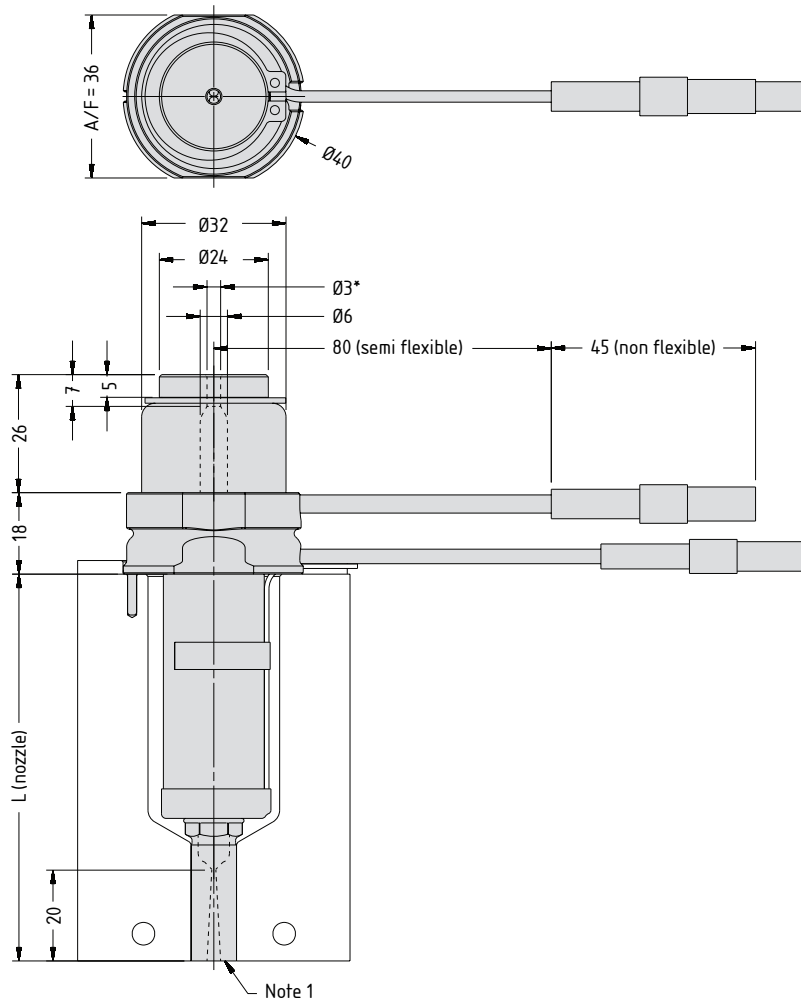
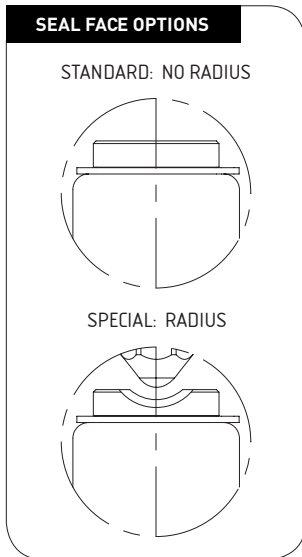
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXISX13115 G5 Radius=0)

To order a tip:

Provide the Tip Code + Grade
 (Order example: X 13 IT G5)

Nozzle Dimensions



Note

1. Modify the contact area and the sprue nut to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 13 TT)	✓	✓	✓
One-hole Torpedo Tip (X 13 IT)	✓	✓	✓
Open Tip (X 13 OT)	✓	✗	✓

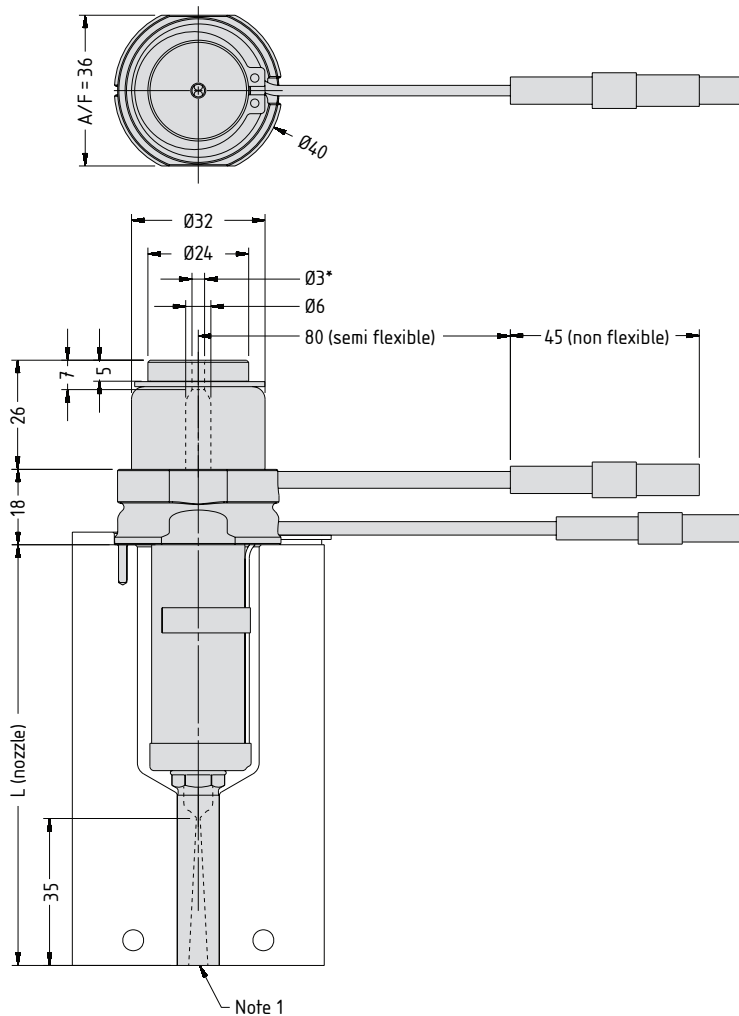
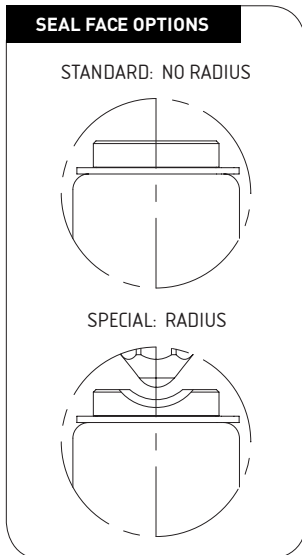
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXISL13075 G5 Radius=0)

To order a tip:

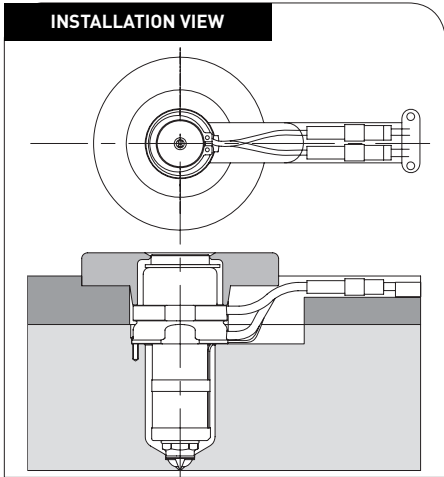
Provide the Tip Code + Grade
 (Order example: X 13 IT G5)

Nozzle Dimensions



Note

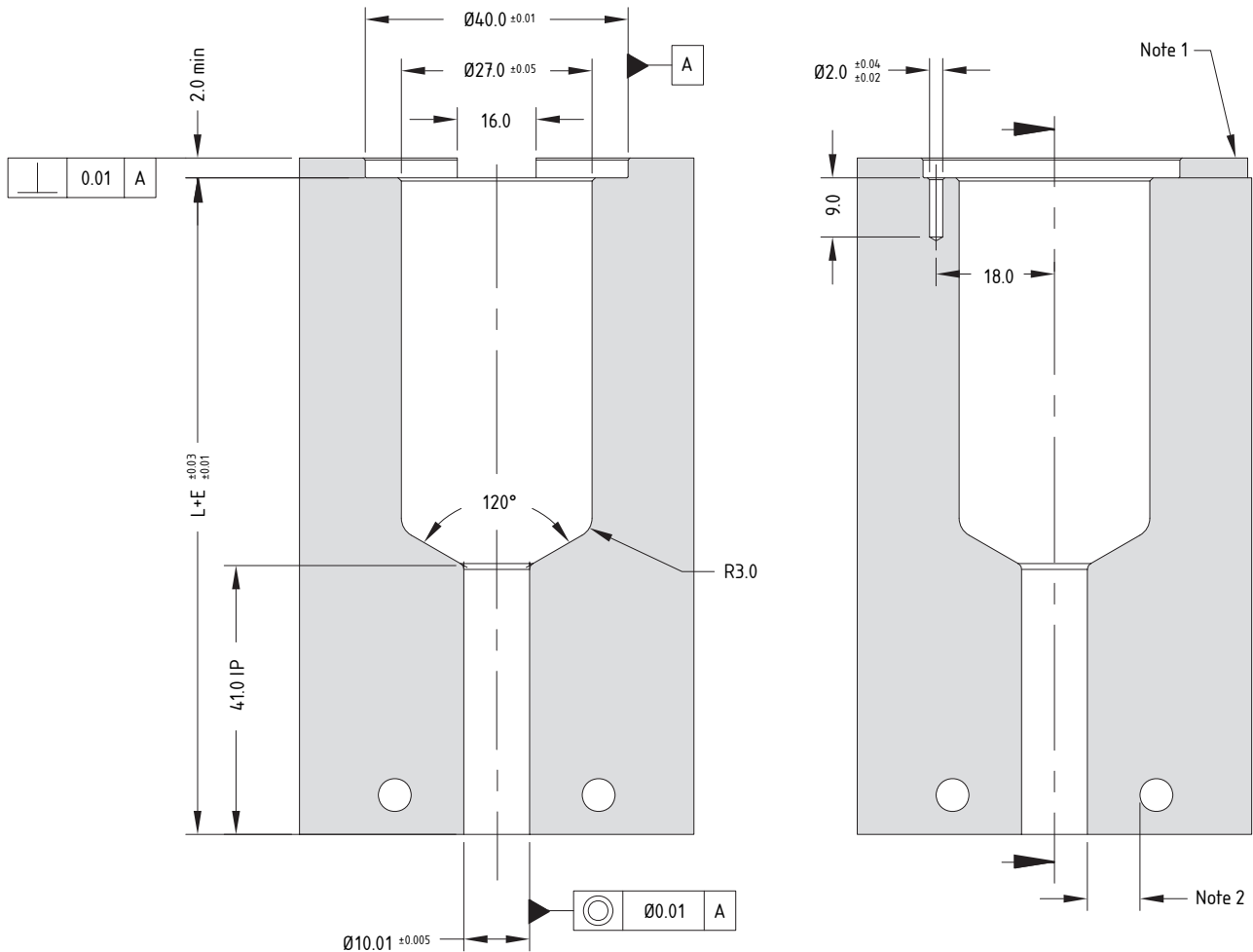
1. Modify the contact area and the sprue nut to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTSL13045	SXISL13045	SXOSL13045	80.2	0.21	0.26
SXTSL13055	SXISL13055	SXOSL13055	90.2	0.24	0.30
SXTSL13065	SXISL13065	SXOSL13065	100.2	0.26	0.33
SXTSL13075	SXISL13075	SXOSL13075	110.2	0.29	0.36
SXTSL13095	SXISL13095	SXOSL13095	130.2	0.34	0.43
SXTSL13115	SXISL13115	SXOSL13115	150.2	0.40	0.50
SXTSL13145	SXISL13145	SXOSL13145	180.2	0.48	0.59
SXTSL13175	SXISL13175	SXOSL13175	210.2	0.55	0.69

Nozzle Fitment and Gate Dimensions

$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. Supplied with Ø0.9 → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

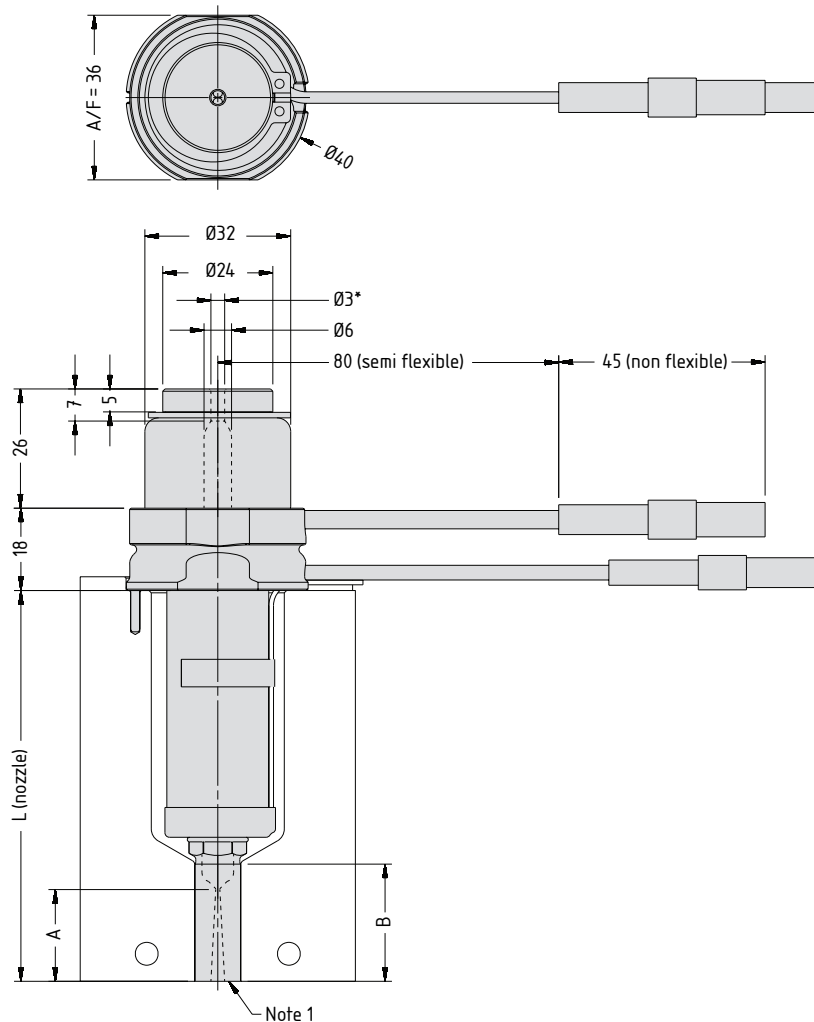
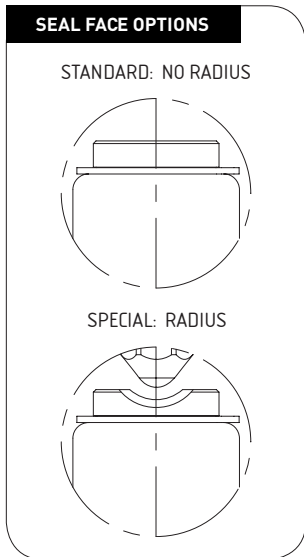
Nozzle Dimensions

Style	A	B
P7	25	Contact Mastip
P4	28	
N3	35	

To order a nozzle assembly:

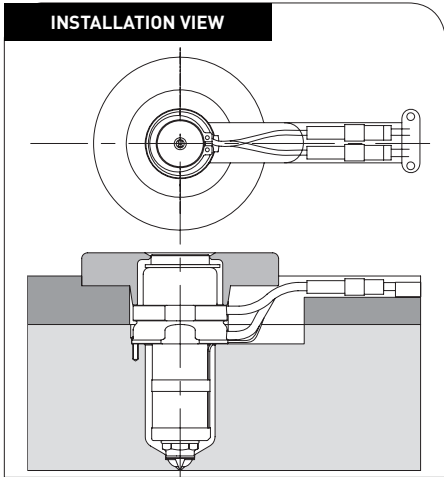
Provide the Nozzle Code + Style
 (Order example: SXYCN13115 P4 Radius=0)

Refer to the System Selection Guide for selecting the appropriate material specific nut (P7, P4 or N3) profile.



Note

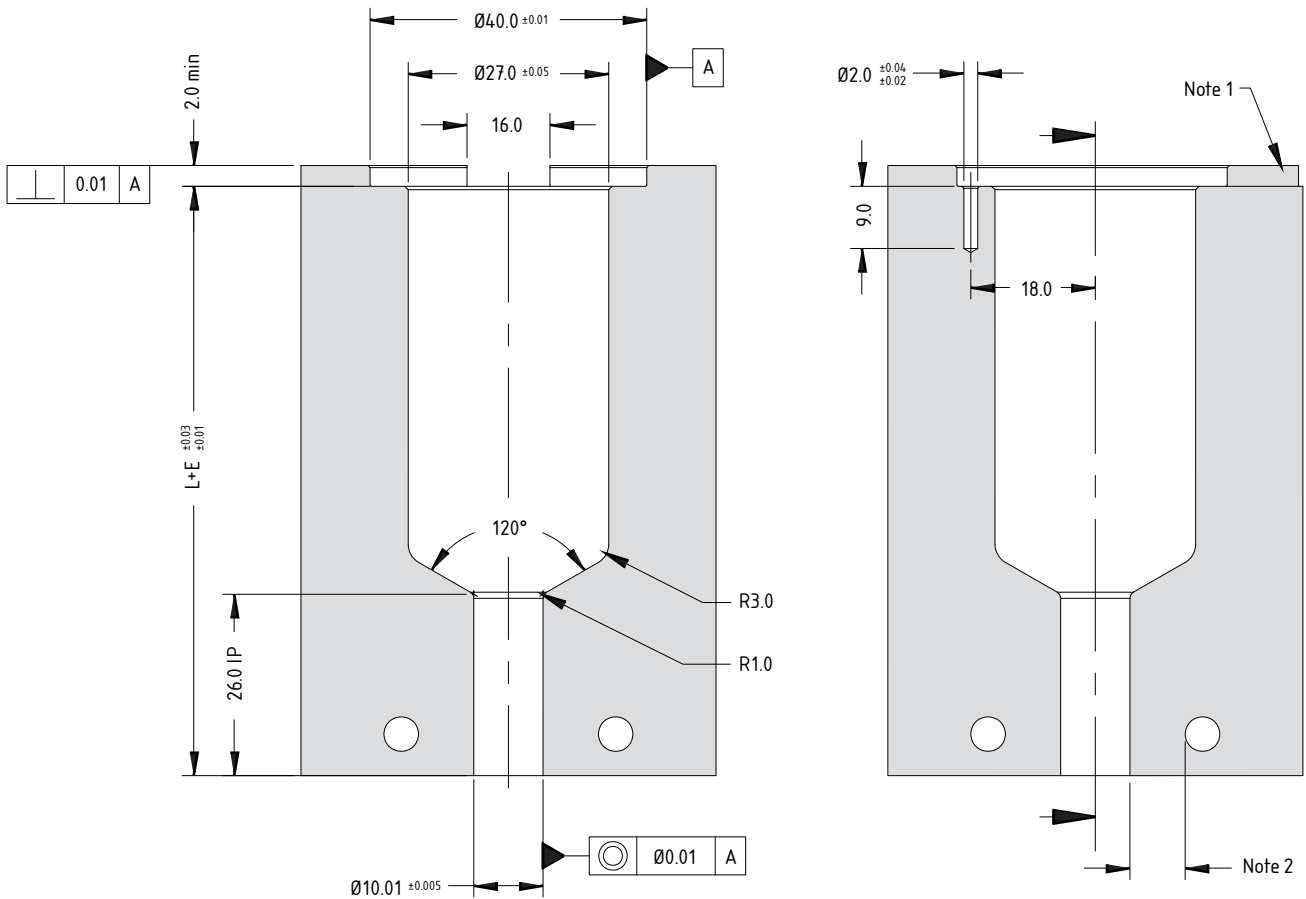
1. Modify the contact area and the sprue nut to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
 - * Open to suit machine nozzle size.



P7	P4	N3	L	E@ΔT =200C	E@ΔT =250C
SXYCN13045	SXYCN13045	SXYCN13045	65.2	0.17	0.22
SXYCN13055	SXYCN13055	SXYCN13055	75.2	0.20	0.25
SXYCN13065	SXYCN13065	SXYCN13065	85.2	0.23	0.28
SXYCN13075	SXYCN13075	SXYCN13075	95.2	0.25	0.31
SXYCN13095	SXYCN13095	SXYCN13095	115.2	0.30	0.38
SXYCN13115	SXYCN13115	SXYCN13115	135.2	0.36	0.45
SXYCN13145	SXYCN13145	SXYCN13145	165.2	0.44	0.55
SXYCN13175	SXYCN13175	SXYCN13175	195.2	0.52	0.64

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 13 TT+5)	✓	✓	✗
One-hole Torpedo Tip (X 13 IT+5)	✓	✓	✗
Open Tip	✗	✗	✗

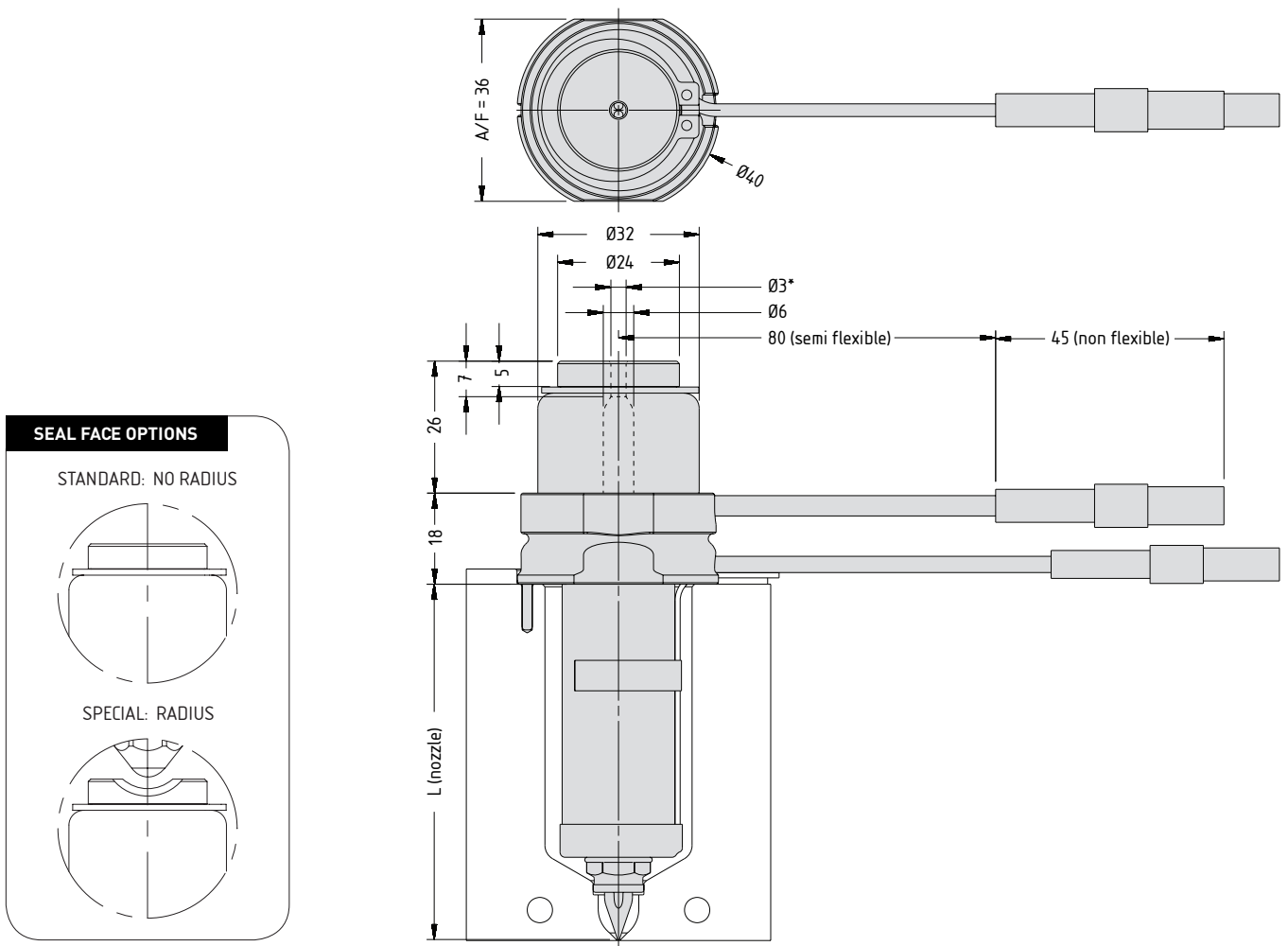
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIT13115+5 G1 Radius=0)

To order a tip:

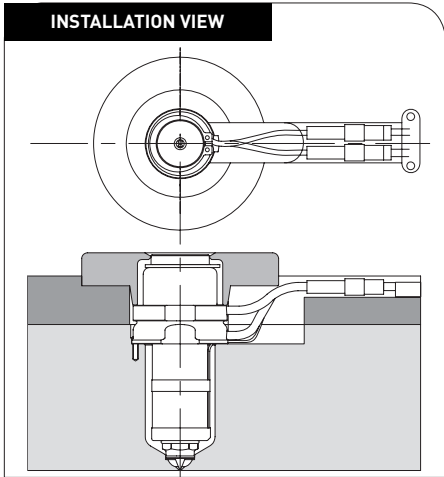
Provide the Tip Code + Grade
 (Order example: X 13 IT+5 G1)

Nozzle Dimensions



Note

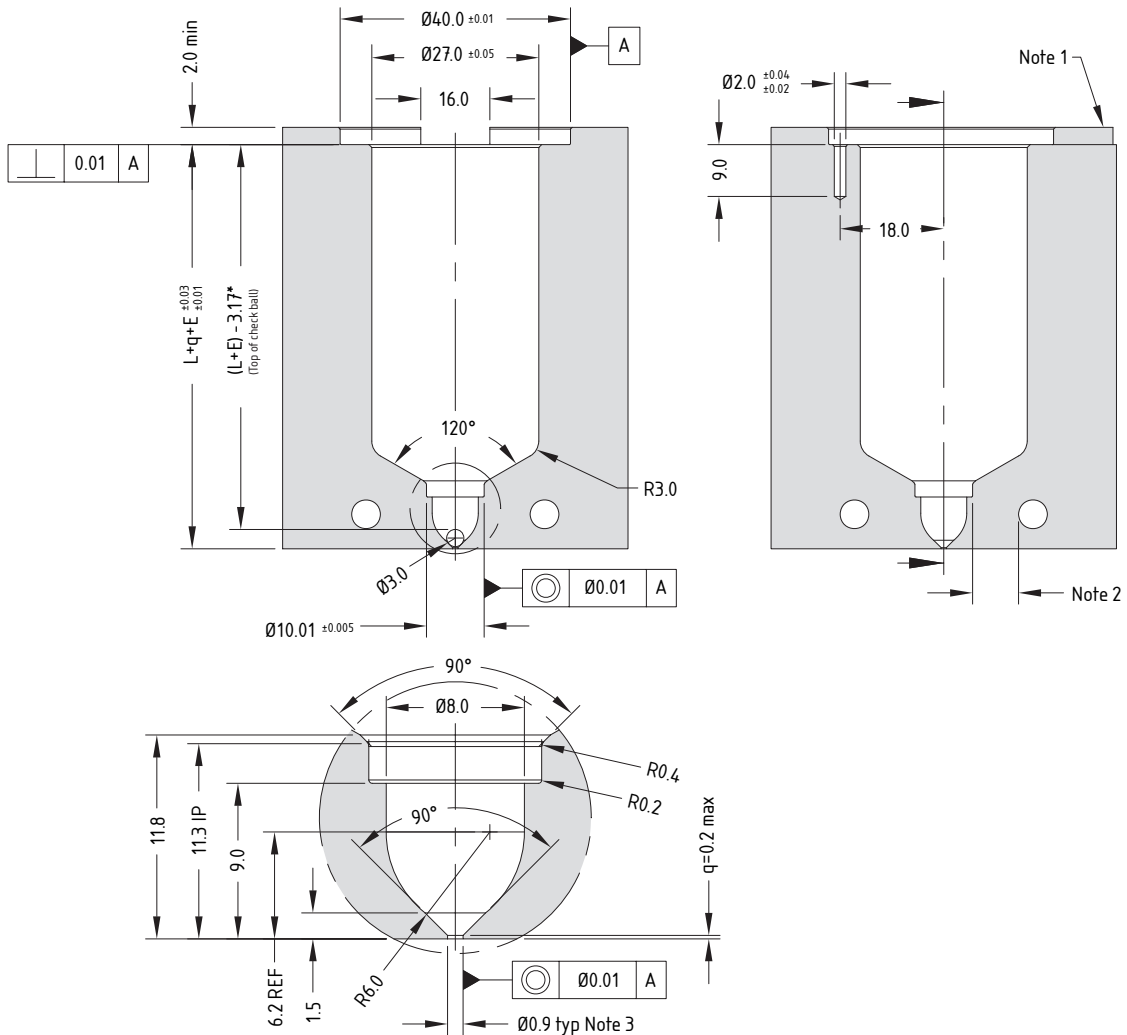
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTT13045+5	SXIT13045+5	50	0.13	0.17
SXTT13055+5	SXIT13055+5	60	0.16	0.20
SXTT13065+5	SXIT13065+5	70	0.18	0.23
SXTT13075+5	SXIT13075+5	80	0.21	0.26
SXTT13095+5	SXIT13095+5	100	0.26	0.33
SXTT13115+5	SXIT13115+5	120	0.32	0.40
SXTT13145+5	SXIT13145+5	150	0.40	0.50
SXTT13175+5	SXIT13175+5	180	0.48	0.59

Nozzle Fitment and Gate Dimensions

$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$



Note

- Wire channel to suit mould.
- Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
- Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
 - Minimum strength (σ_t) of nozzle plate 800MPa.
 - * With 0.9 gate, +0.05mm per 0.1mm increase in gate diameter.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 13 TT+10)	✓	✓	✗
One-hole Torpedo Tip (X 13 IT+10)	✓	✓	✗
Open Tip	✗	✗	✗

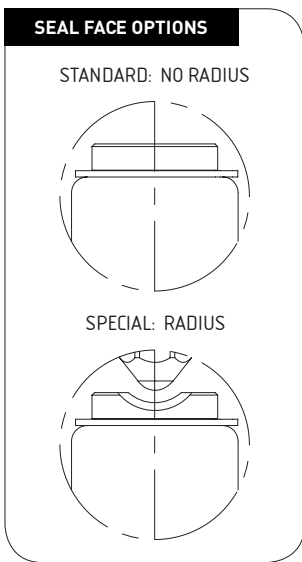
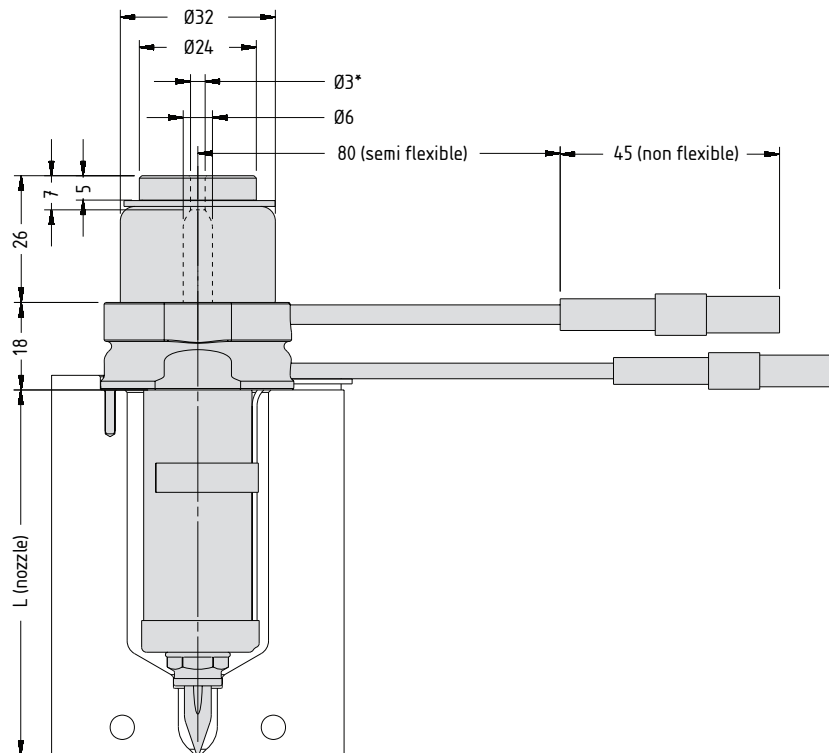
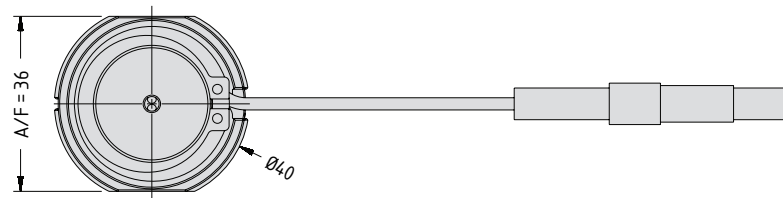
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIT13115+10 G4 Radius=0)

To order a tip:

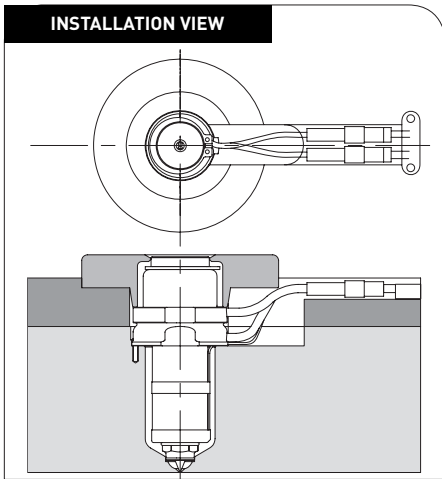
Provide the Tip Code + Grade
 (Order example: X 13 IT+10 G2)

Nozzle Dimensions



Note

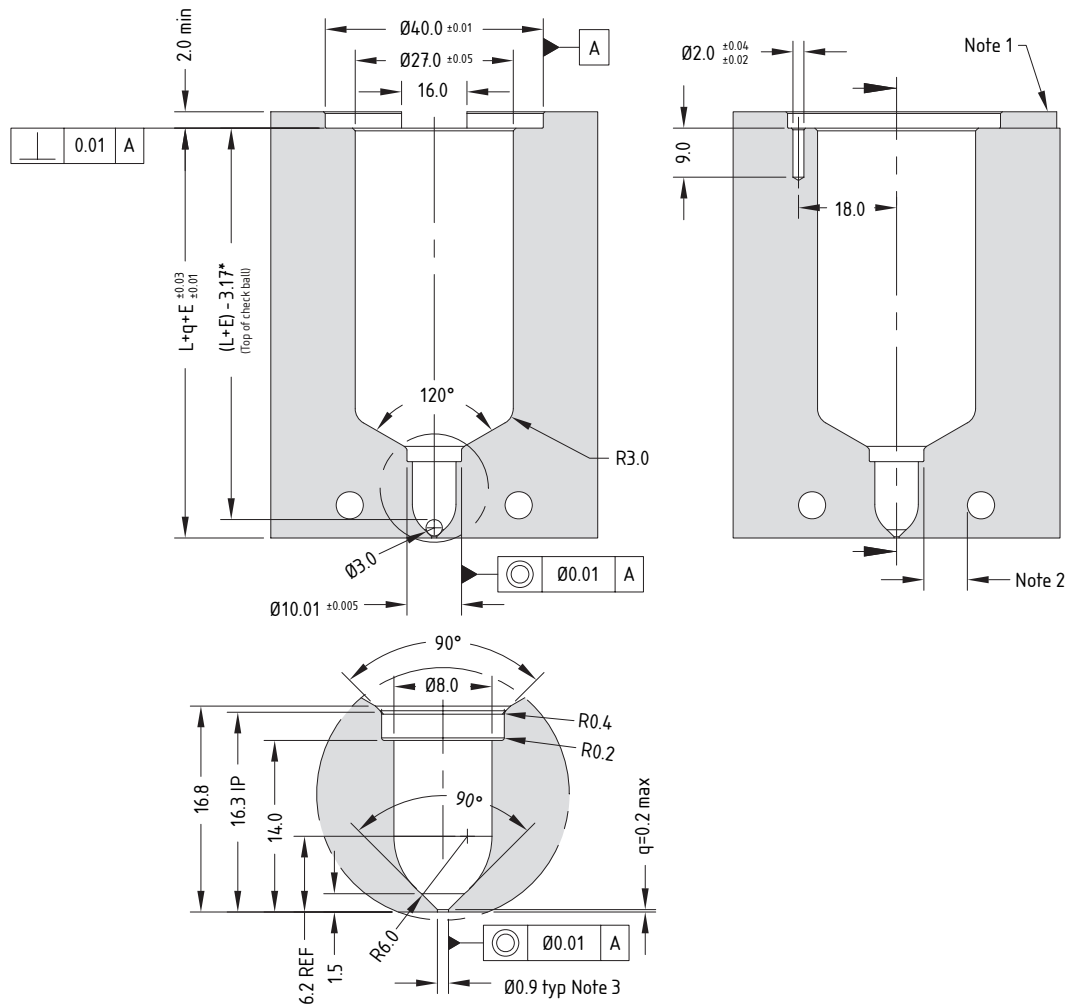
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTT13045+10	SXIT13045+10	55	0.15	0.18
SXTT13055+10	SXIT13055+10	65	0.17	0.21
SXTT13065+10	SXIT13065+10	75	0.20	0.25
SXTT13075+10	SXIT13075+10	85	0.22	0.28
SXTT13095+10	SXIT13095+10	105	0.28	0.35
SXTT13115+10	SXIT13115+10	125	0.33	0.41
SXTT13145+10	SXIT13145+10	155	0.41	0.51
SXTT13175+10	SXIT13175+10	185	0.49	0.61

Nozzle Fitment and Gate Dimensions

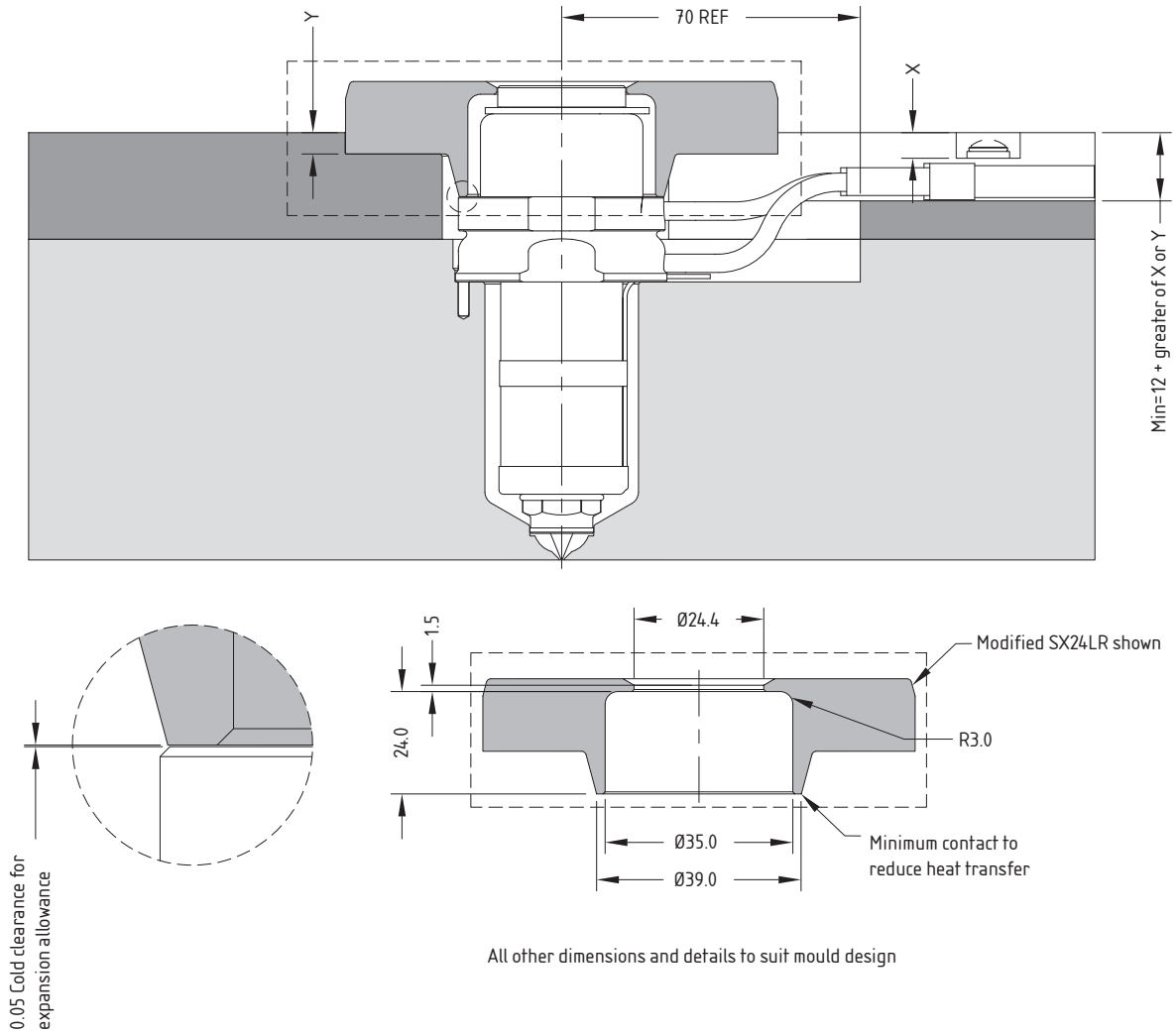
$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



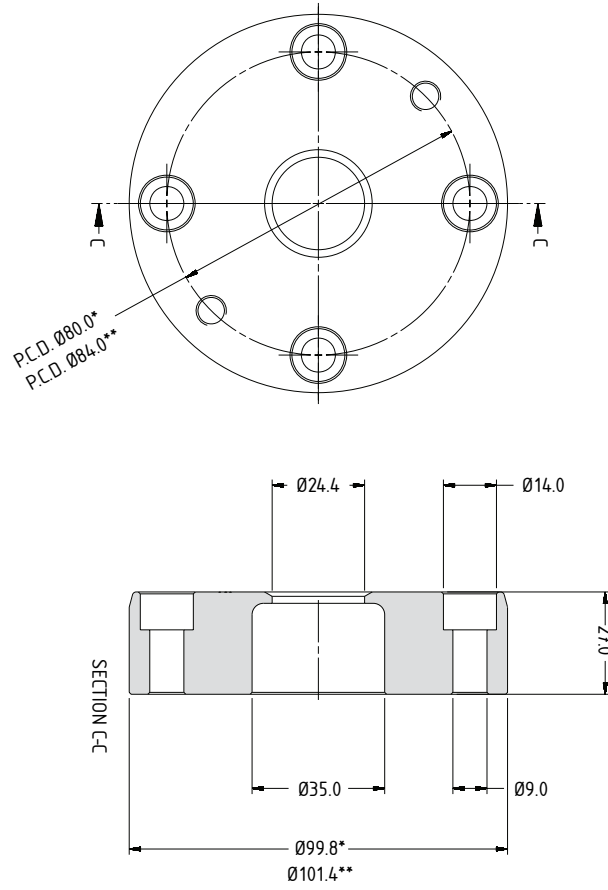
Note

1. Wire channel to suit mould.
2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
 - Minimum strength (σ_y) of nozzle plate 800MPa.
 - * With 0.9 gate, +0.05mm per 0.1mm increase in gate diameter.

Installation Example



Locating Rings



Note

- Locating Ring may require finishing to suit mould.
- Go to www.mastip.com to download the CAD Model.
- * Order Code SX24LR-METRIC
- ** Order Code SX24LR-IMPERIAL

SXTG16

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 16 TT)	✓	✓	✓
One-hole Torpedo Tip (X 16 IT)	✓	✓	✓
Open Tip (X 16 OT)	✓	✗	✓

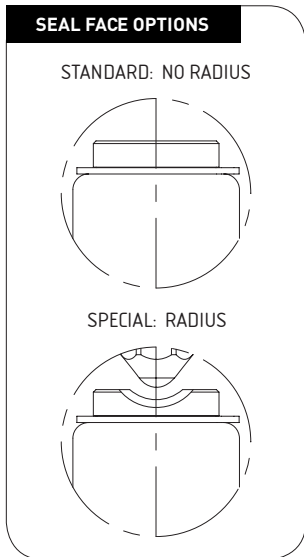
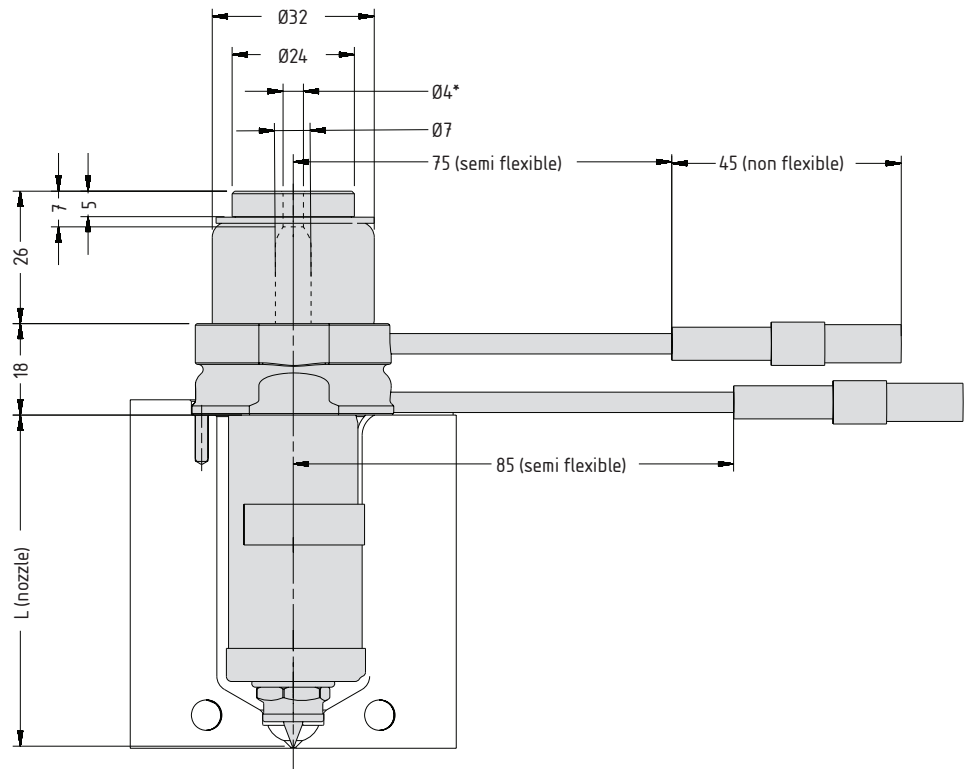
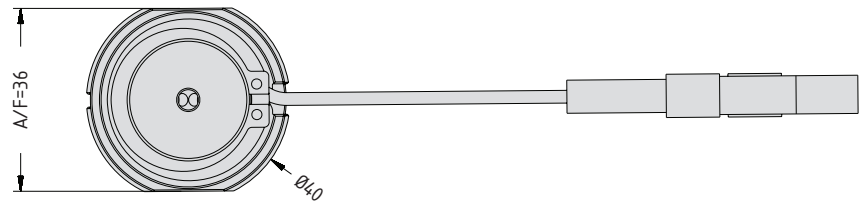
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIT16055 G5 Radius=0)

To order a tip:

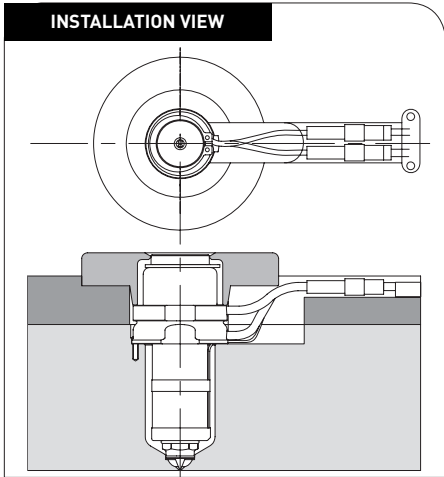
Provide the Tip Code + Grade
 (Order example: X 16 IT G5)

Nozzle Dimensions



Note

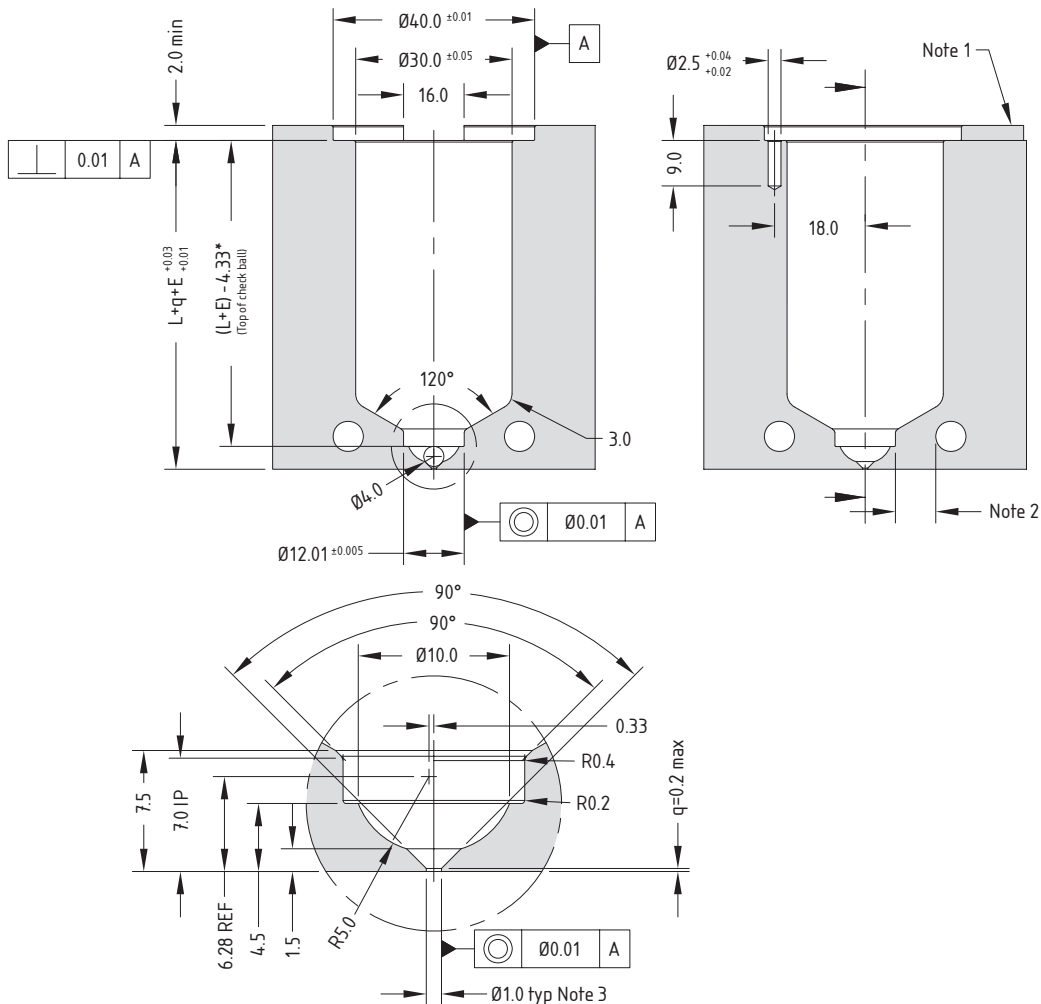
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTT16045	SXIT16045	SXOT16045	45	0.12	0.15
SXTT16055	SXIT16055	SXOT16055	55	0.15	0.18
SXTT16065	SXIT16065	SXOT16065	65	0.17	0.21
SXTT16075	SXIT16075	SXOT16075	75	0.20	0.25
SXTT16095	SXIT16095	SXOT16095	95	0.25	0.31
SXTT16115	SXIT16115	SXOT16115	115	0.30	0.38
SXTT16145	SXIT16145	SXOT16145	145	0.38	0.48
SXTT16175	SXIT16175	SXOT16175	175	0.46	0.58

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

- Wire channel to suit mould.
- Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
- Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
 - Minimum strength (σ_y) of nozzle plate 800MPa.
 - * With 0.9 gate, +0.05mm per 0.1mm increase in gate diameter.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 16 TT)	✓	✓	✓	✗
One-hole Torpedo Tip (X 16 IT)	✓	✓	✓	✗
Open Tip (X 16 OT)	✓	✗	✓	✗

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	1.0
H1	1.2

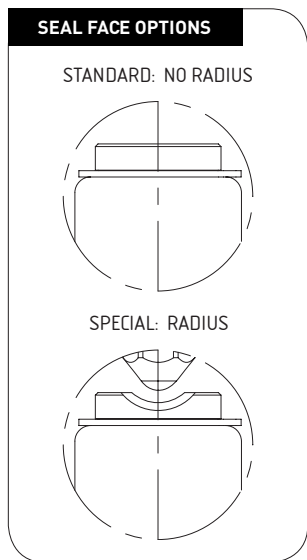
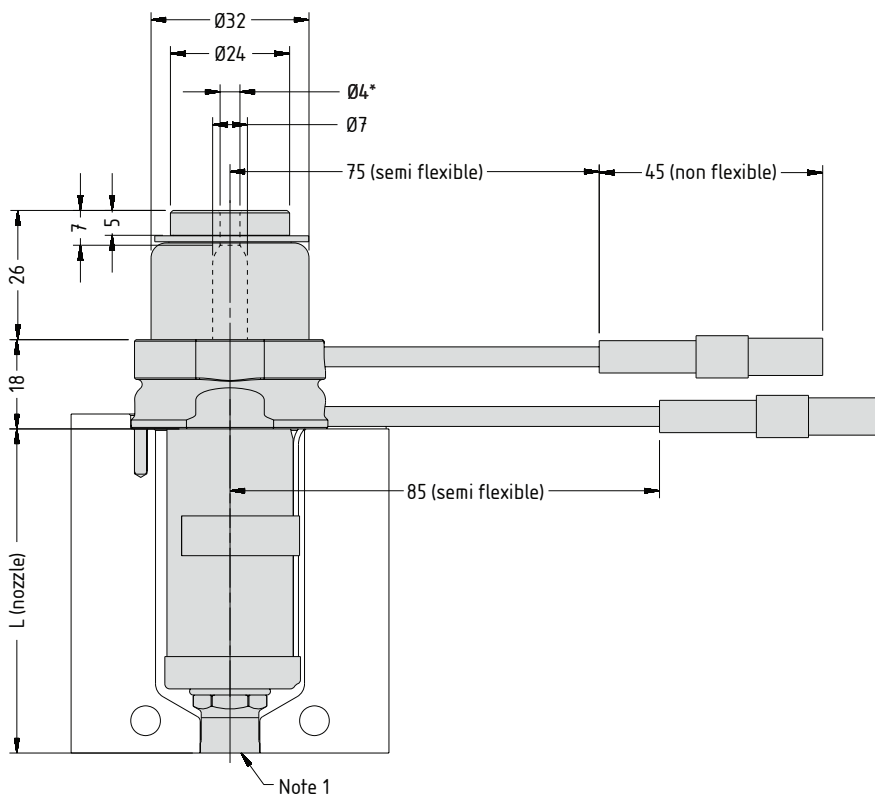
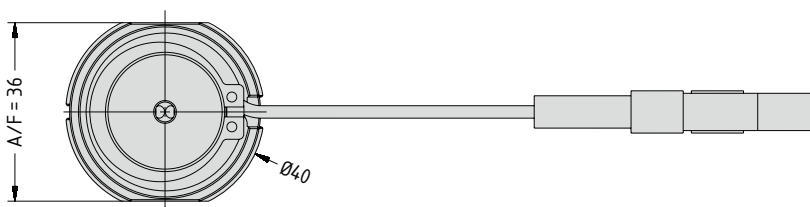
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIBE16055 G5 Radius=0)

To order a tip:

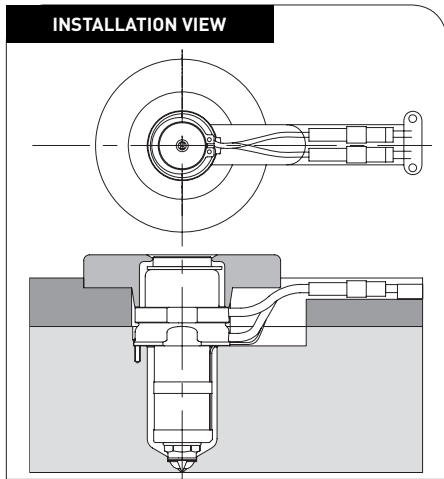
Provide the Tip Code + Grade
 (Order example: X 16 IT G5)

Nozzle Dimensions



Note

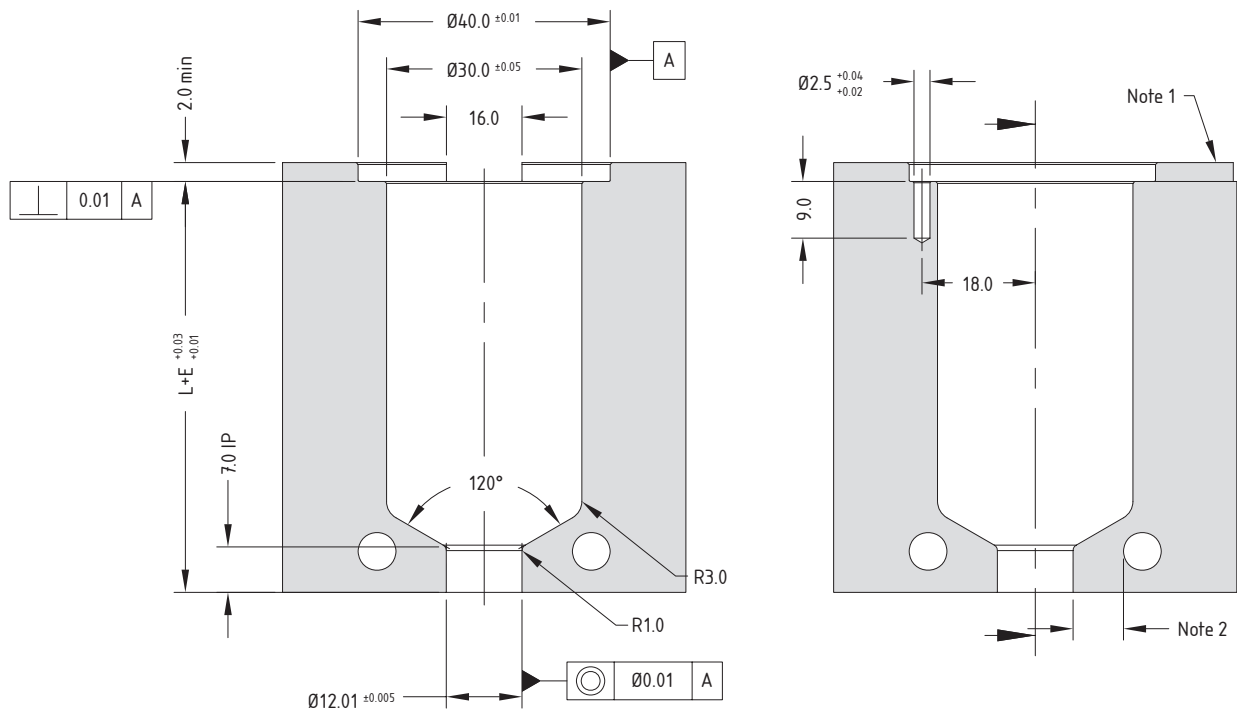
1. Modify the contact area to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	$E @ \Delta T = 200C$	$E @ \Delta T = 250C$
SXTBE16045	SXIBE16045	SXOBE16045	45.2	0.12	0.15
SXTBE16055	SXIBE16055	SXOBE16055	55.2	0.15	0.18
SXTBE16065	SXIBE16065	SXOBE16065	65.2	0.17	0.22
SXTBE16075	SXIBE16075	SXOBE16075	75.2	0.20	0.25
SXTBE16095	SXIBE16095	SXOBE16095	95.2	0.25	0.31
SXTBE16115	SXIBE16115	SXOBE16115	115.2	0.30	0.38
SXTBE16145	SXIBE16145	SXOBE16145	145.2	0.38	0.48
SXTBE16175	SXIBE16175	SXOBE16175	175.2	0.46	0.58

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 16 TT)	✓	✓	✓	✓
One-hole Torpedo Tip (X 16 IT)	✓	✓	✓	✓
Open Tip (X 16 OT)	✓	✗	✓	✓

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	1.0
H1	1.2
H5	1.5

To order a nozzle assembly:

Provide the Nozzle Code + Grade

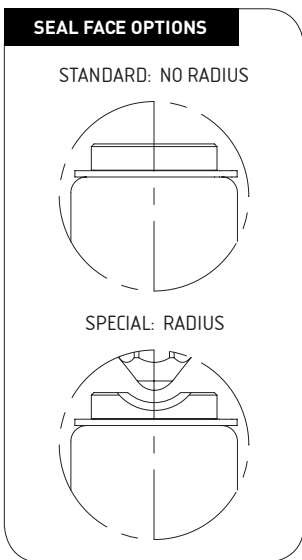
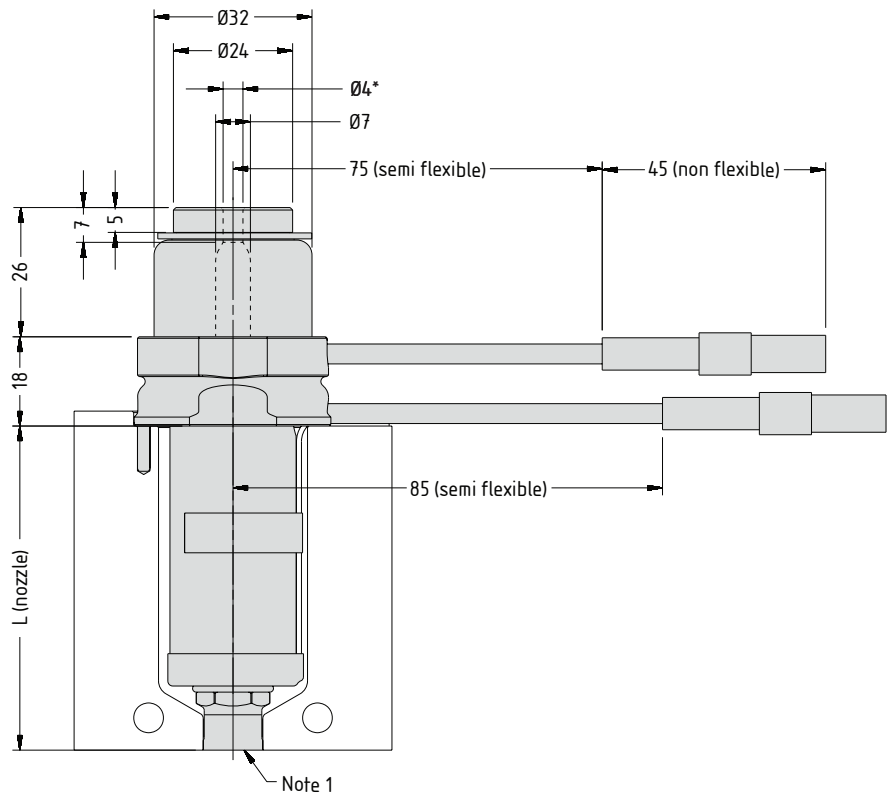
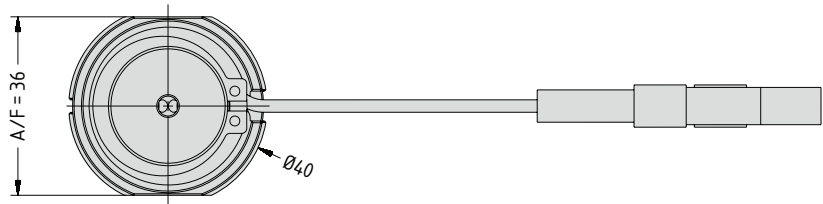
(Order example: SXIBN16055 G5 Radius=0)

To order a tip:

Provide the Tip Code + Grade

(Order example: X 16 IT G5)

Nozzle Dimensions



Note

1. Modify the contact area to suit the application.

→ See Gate Modifications and Cooling sections in the Technical Specifications.

• Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.

* Open to suit machine nozzle size.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 16 TT)	✓	✓	✓	✓
One-hole Torpedo Tip (X 16 IT)	✓	✓	✓	✓
Open Tip (X 16 OT)	✓	✗	✓	✓

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	1.0
H1	1.4
H5	1.7

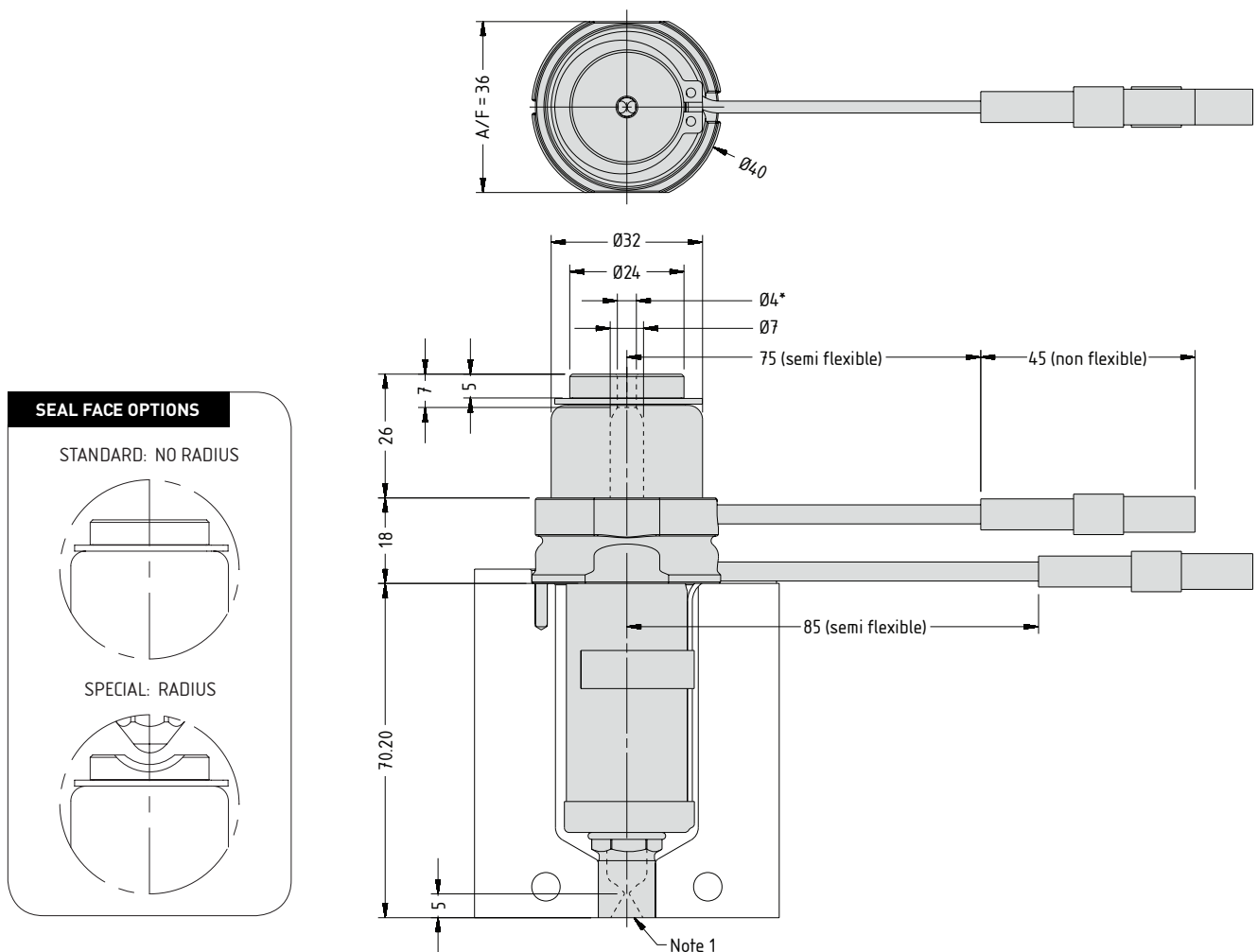
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXISN16065 G5 Radius=0)

To order a tip:

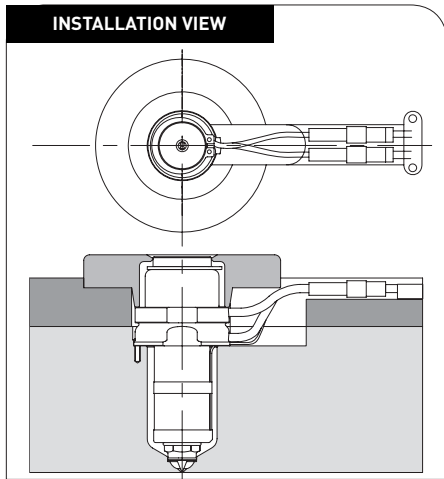
Provide the Tip Code + Grade
 (Order example: X 16 IT G5)

Nozzle Dimensions



Note

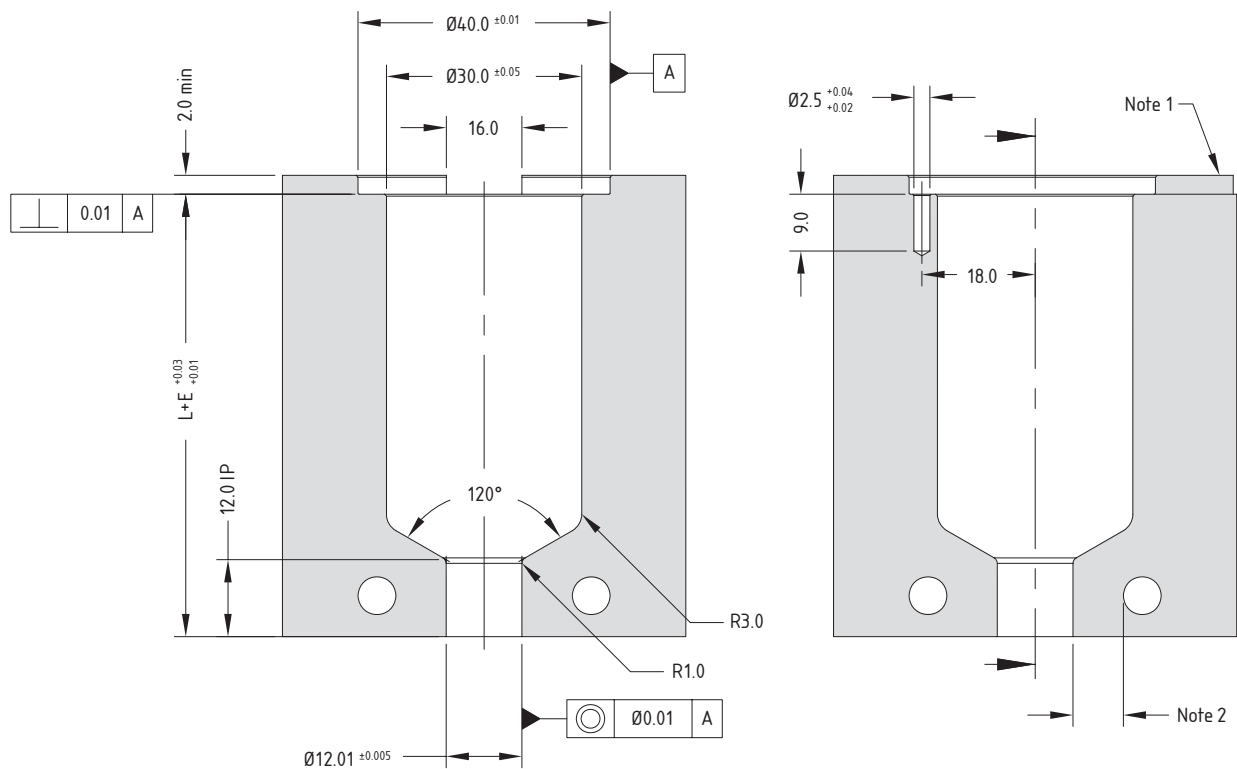
1. Modify the contact area and the sprue nut to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
 - * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	$E\Delta T = 200C$	$E\Delta T = 250C$
SXTSN16045	SXISN16045	SXOSN16045	50.2	0.13	0.17
SXTSN16055	SXISN16055	SXOSN16055	60.2	0.16	0.20
SXTSN16065	SXISN16065	SXOSN16065	70.2	0.19	0.23
SXTSN16075	SXISN16075	SXOSN16075	80.2	0.21	0.26
SXTSN16095	SXISN16095	SXOSN16095	100.2	0.26	0.33
SXTSN16115	SXISN16115	SXOSN16115	120.2	0.32	0.40
SXTSN16145	SXISN16145	SXOSN16145	150.2	0.40	0.50
SXTSN16175	SXISN16175	SXOSN16175	180.2	0.48	0.59

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 16 TT)	✓	✓	✓
One-hole Torpedo Tip (X 16 IT)	✓	✓	✓
Open Tip (X 16 OT)	✓	✗	✓

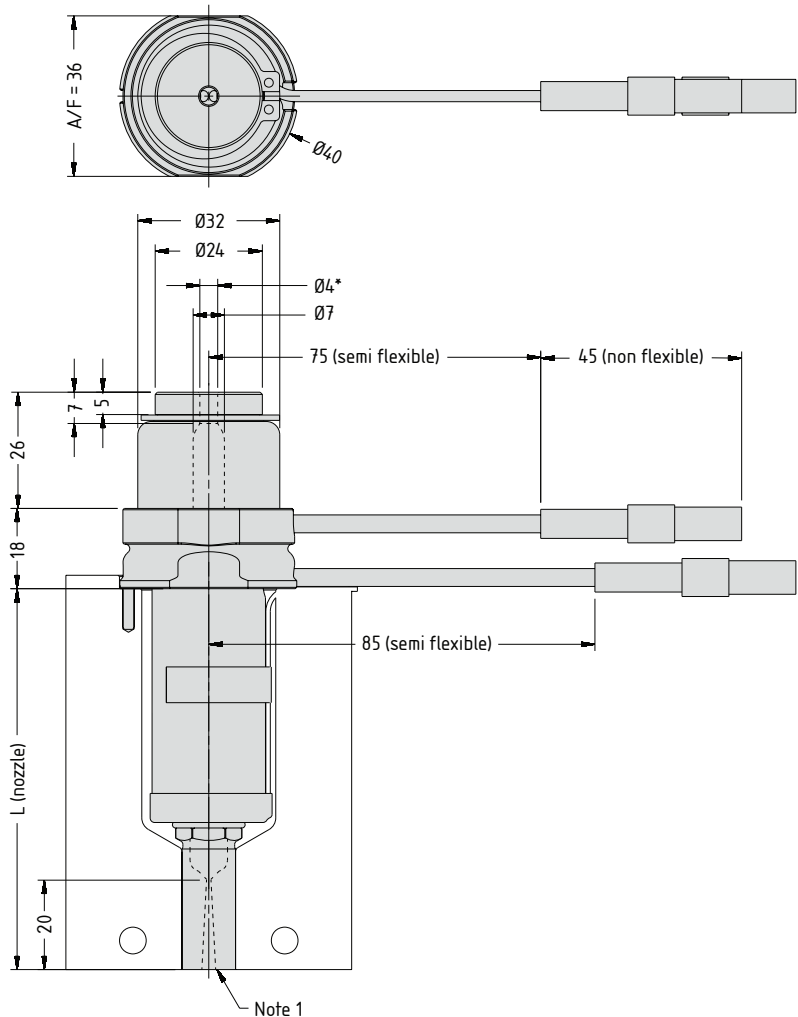
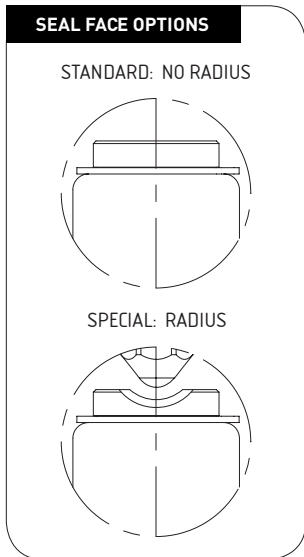
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXISX16095 G5 Radius=0)

To order a tip:

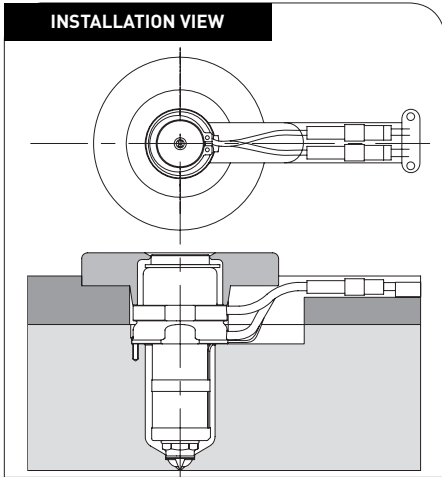
Provide the Tip Code + Grade
 (Order example: X 16 IT G5)

Nozzle Dimensions



Note

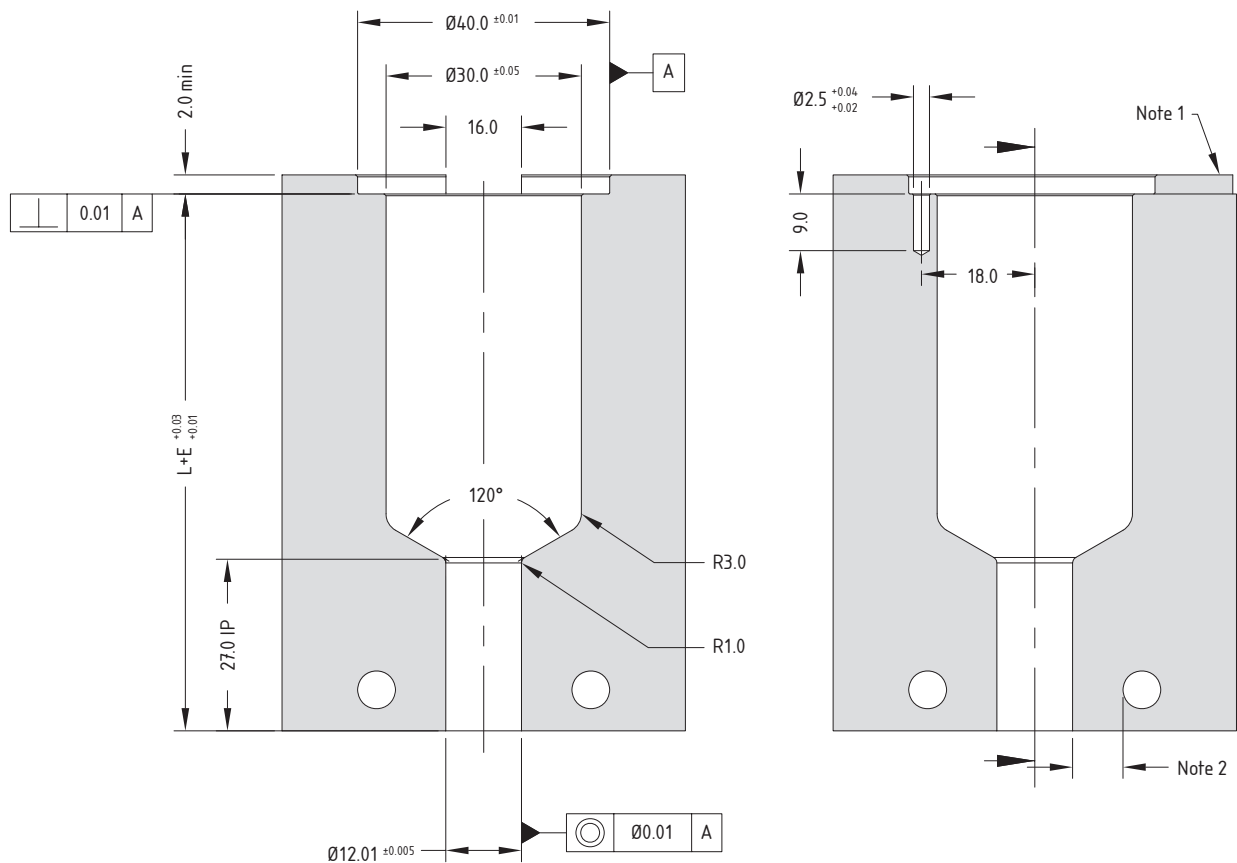
1. Modify the contact area and the sprue nut to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
 - * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	$E @ \Delta T = 200C$	$E @ \Delta T = 250C$
SXTSX16045	SXISX16045	SXOSX16045	65.2	0.17	0.22
SXTSX16055	SXISX16055	SXOSX16055	75.2	0.20	0.25
SXTSX16065	SXISX16065	SXOSX16065	85.2	0.22	0.28
SXTSX16075	SXISX16075	SXOSX16075	95.2	0.25	0.31
SXTSX16095	SXISX16095	SXOSX16095	115.2	0.30	0.38
SXTSX16115	SXISX16115	SXOSX16115	135.2	0.36	0.45
SXTSX16145	SXISX16145	SXOSX16145	165.2	0.44	0.55
SXTSX16175	SXISX16175	SXOSX16175	195.2	0.52	0.64

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. Supplied with Ø1.0 → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 16 TT)	✓	✓	✓
One-hole Torpedo Tip (X 16 IT)	✓	✓	✓
Open Tip (X 16 OT)	✓	✗	✓

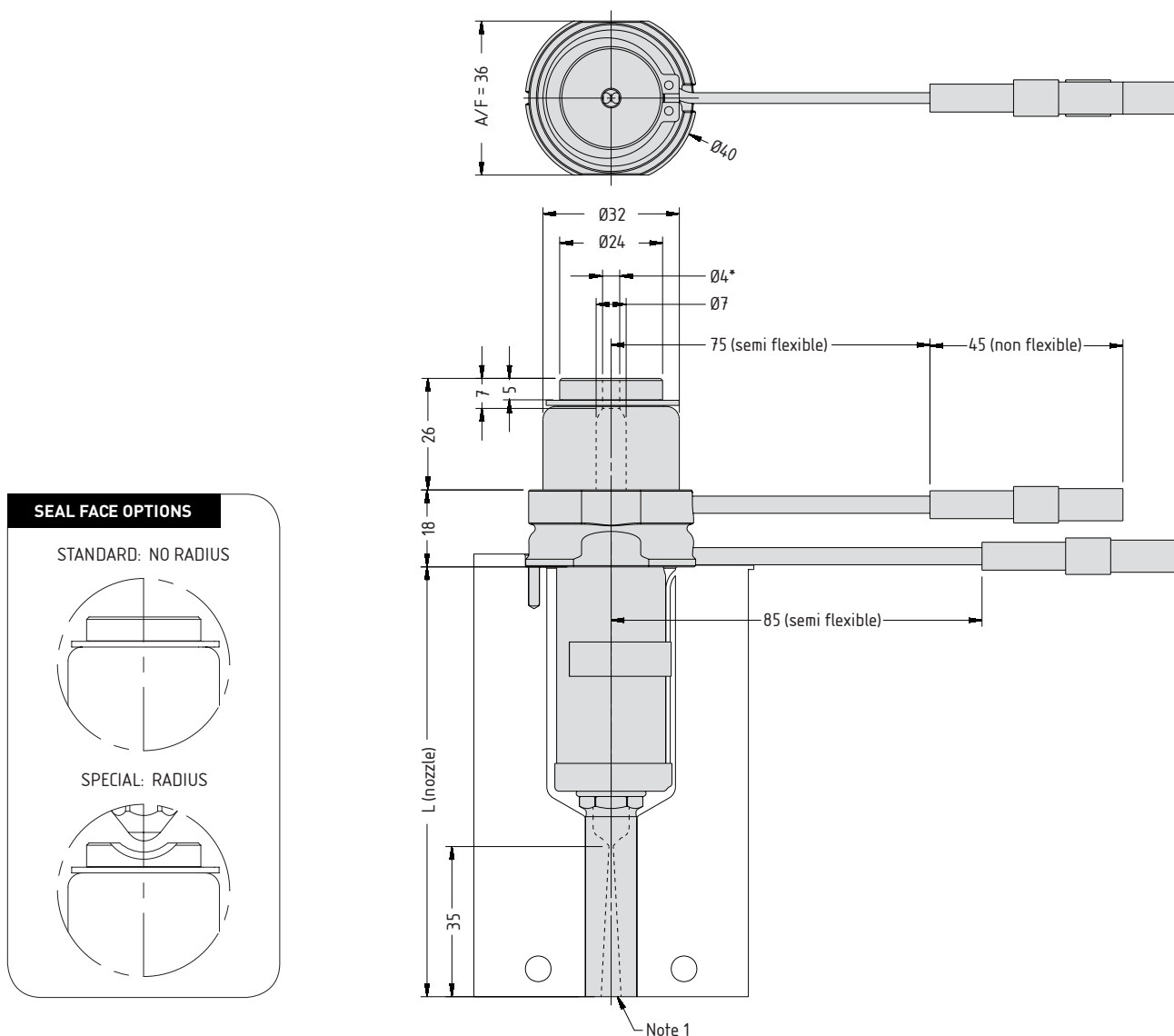
To order a nozzle assembly:

Provide the Nozzle Code + Grade
(Order example: SXISL16115 G5 Radius=0)

To order a tip:

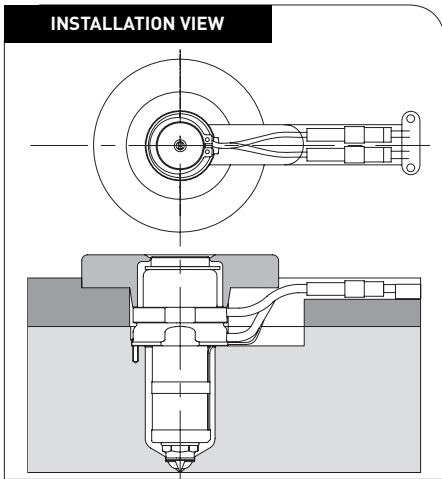
Provide the Tip Code + Grade
(Order example: X 16 IT G5)

Nozzle Dimensions



Note

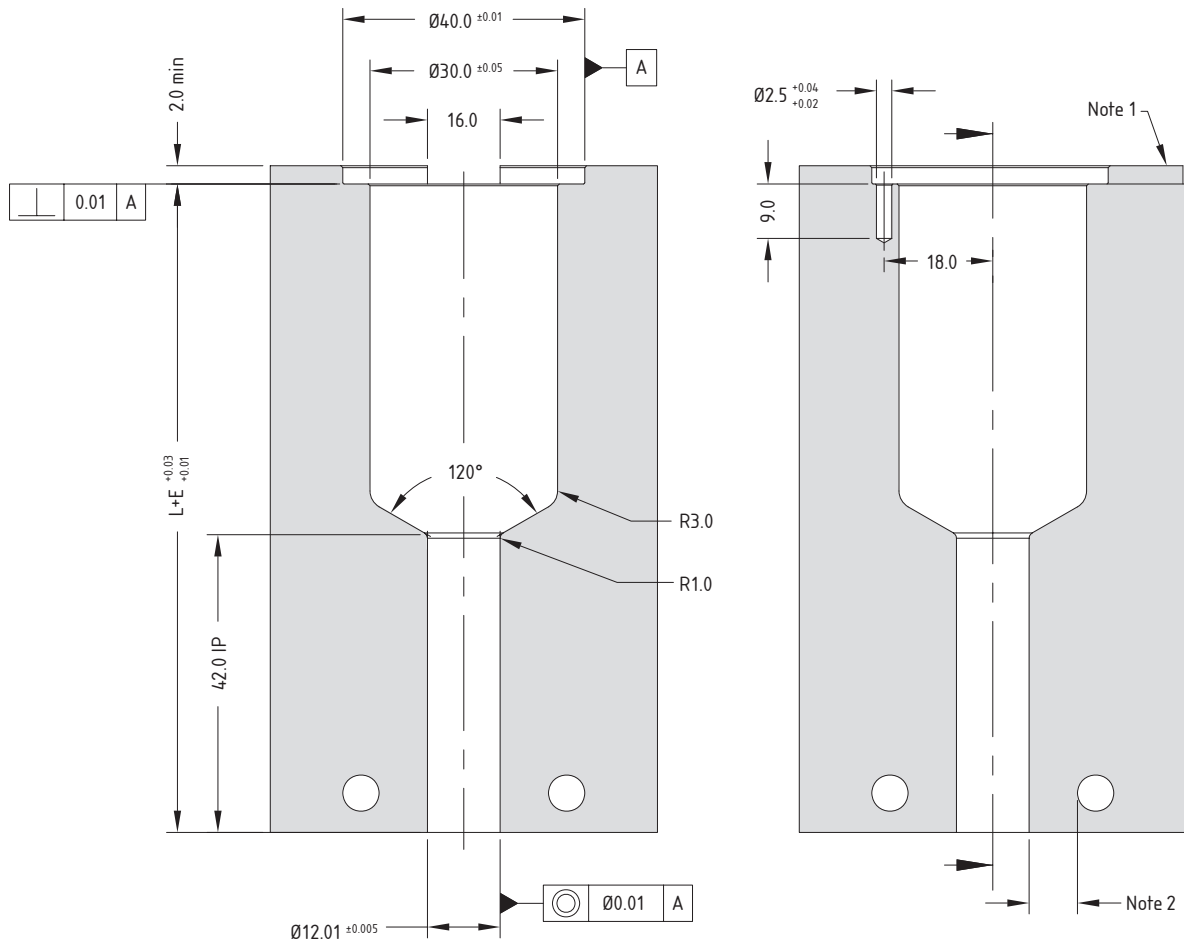
1. Modify the contact area and the sprue nut to suit the application.
→ See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
 - * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	$E @ \Delta T = 200C$	$E @ \Delta T = 250C$
SXTSL16045	SXISL16045	SXOSL16045	80.2	0.21	0.26
SXTSL16055	SXISL16055	SXOSL16055	90.2	0.24	0.30
SXTSL16065	SXISL16065	SXOSL16065	100.2	0.26	0.33
SXTSL16075	SXISL16075	SXOSL16075	110.2	0.29	0.36
SXTSL16095	SXISL16095	SXOSL16095	130.2	0.34	0.43
SXTSL16115	SXISL16115	SXOSL16115	150.2	0.40	0.50
SXTSL16145	SXISL16145	SXOSL16145	180.2	0.48	0.59
SXTSL16175	SXISL16175	SXOSL16175	210.2	0.55	0.69

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. Supplied with $\varnothing 1.0$ → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

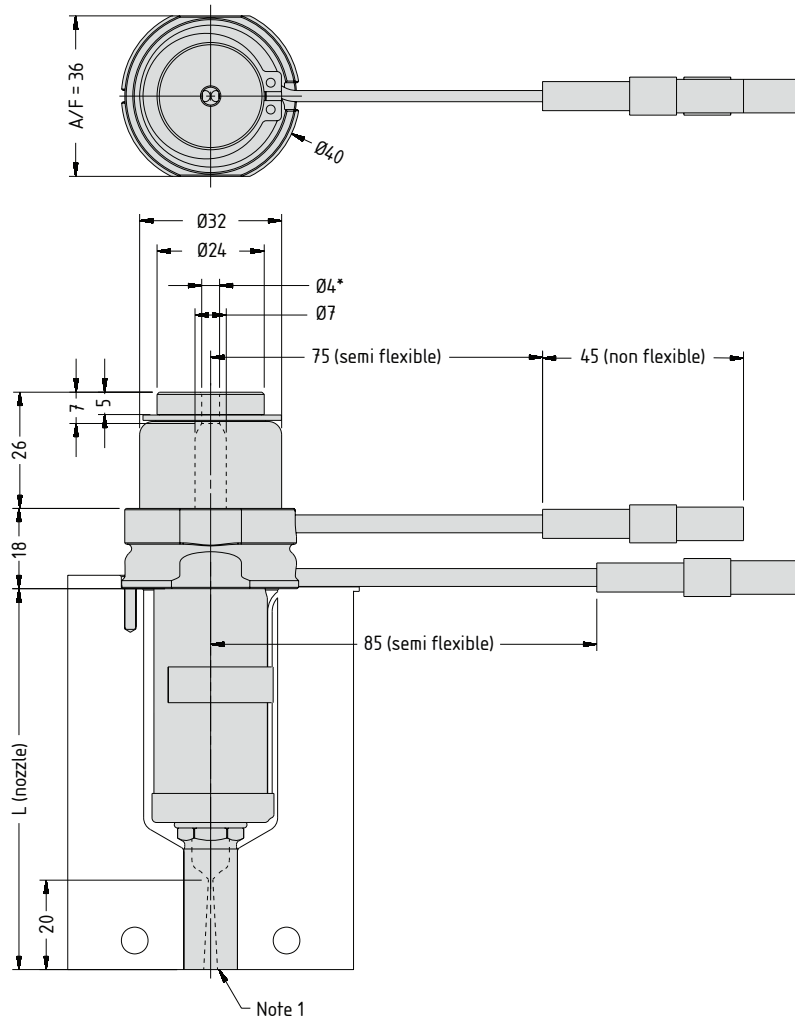
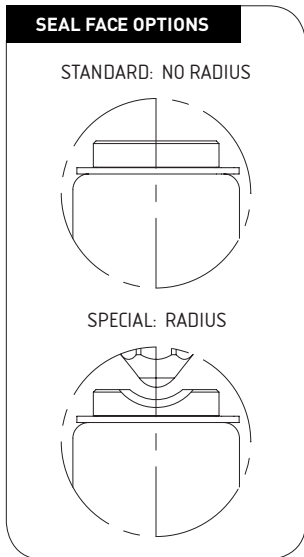
Nozzle Dimensions

Style	A	B
P7	26	Contact Mastip
P4	29	
N3	36	

To order a nozzle assembly:

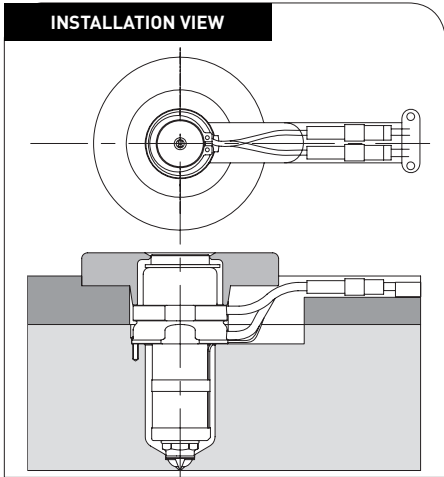
Provide the Nozzle Code + Style
 (Order example: SYCN16115 P4 Radius=0)

Refer to the System Selection Guide for selecting the appropriate material specific nut (P7, P4 or N3) profile.



Note

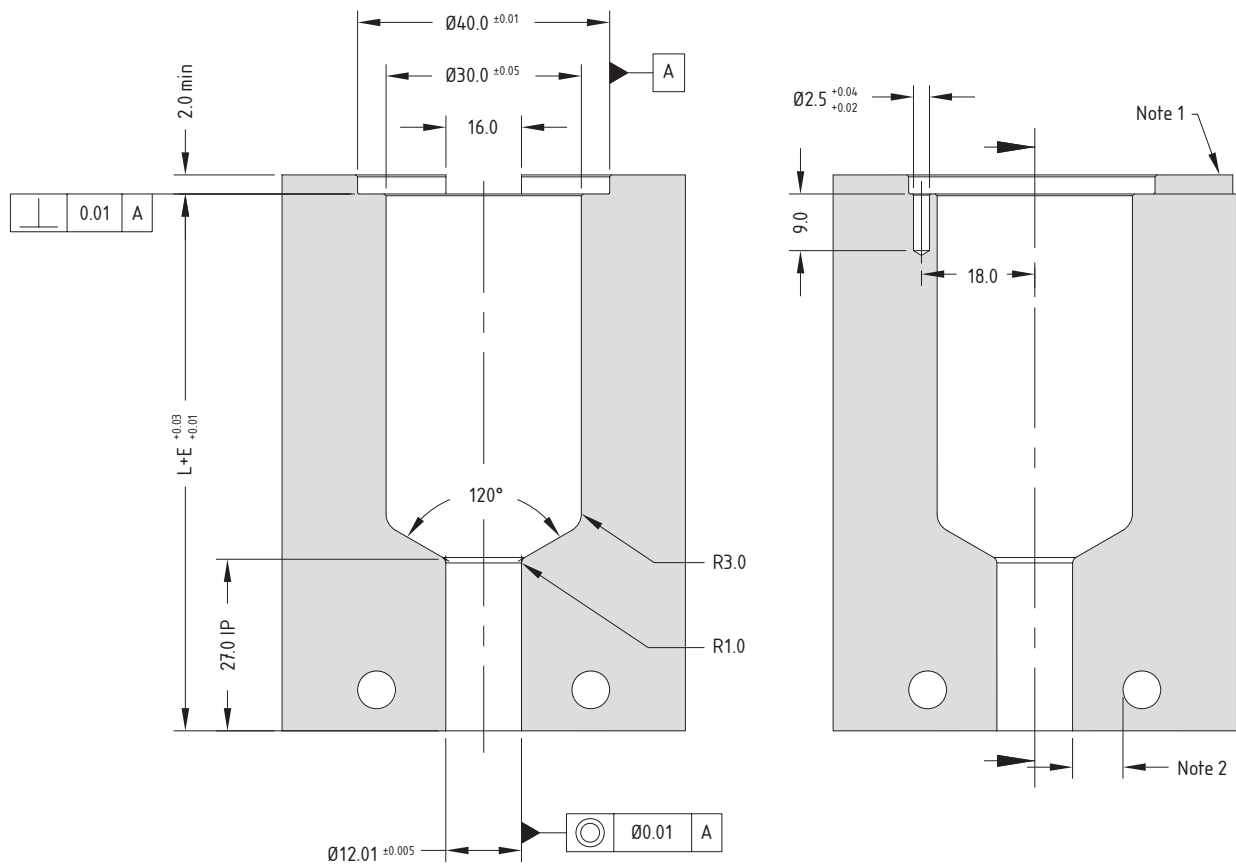
1. Modify the contact area and the sprue nut to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



P7	P4	N3	L	E@ΔT =200C	E@ΔT =250C
SXYCN16045	SXYCN16045	SXYCN16045	65.2	0.17	0.22
SXYCN16055	SXYCN16055	SXYCN16055	75.2	0.20	0.25
SXYCN16065	SXYCN16065	SXYCN16065	85.2	0.22	0.28
SXYCN16075	SXYCN16075	SXYCN16075	95.2	0.25	0.31
SXYCN16095	SXYCN16095	SXYCN16095	115.2	0.30	0.38
SXYCN16115	SXYCN16115	SXYCN16115	135.2	0.36	0.45
SXYCN16145	SXYCN16145	SXYCN16145	165.2	0.44	0.55
SXYCN16175	SXYCN16175	SXYCN16175	195.2	0.52	0.64

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 16 TT+5)	✓	✓	✗
One-hole Torpedo Tip (X 16 IT+5)	✓	✓	✗
Open Tip	✗	✗	✗

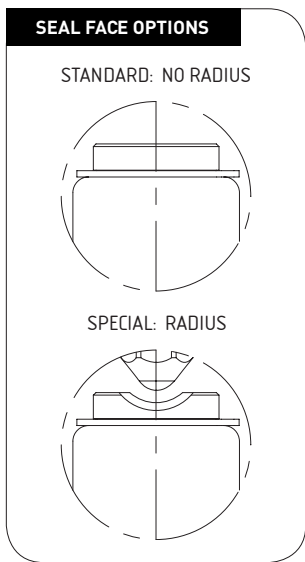
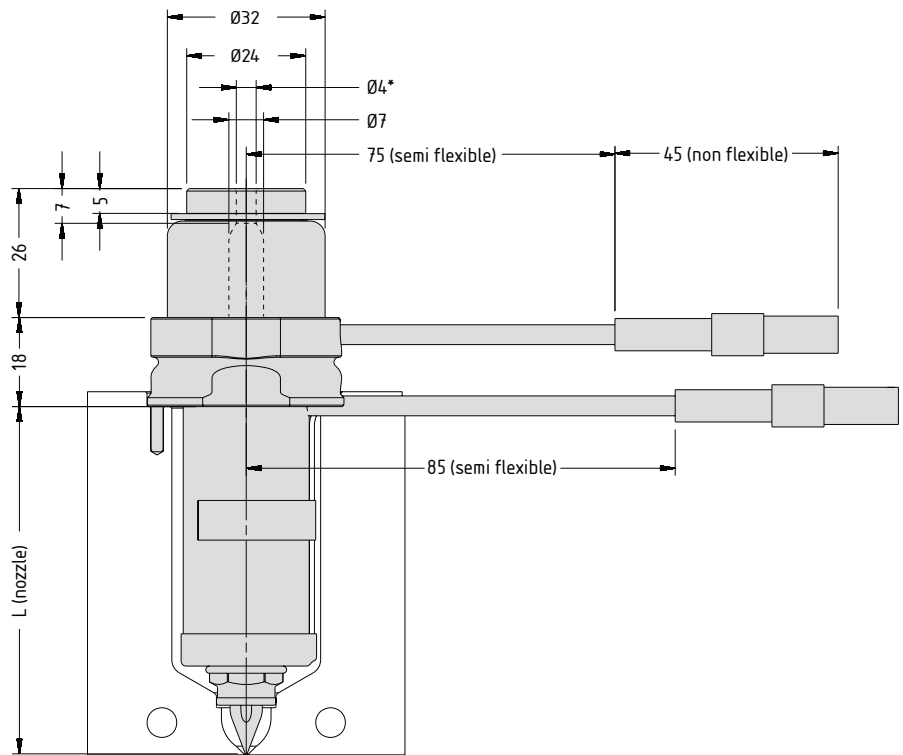
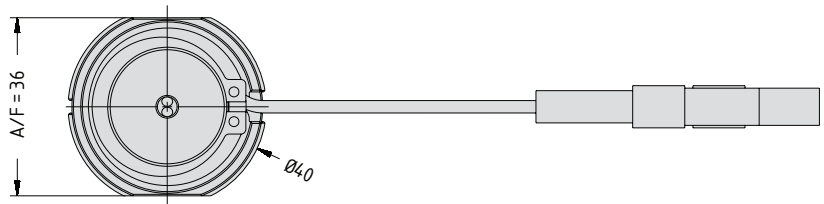
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIT16115+5 G5 Radius=0)

To order a tip:

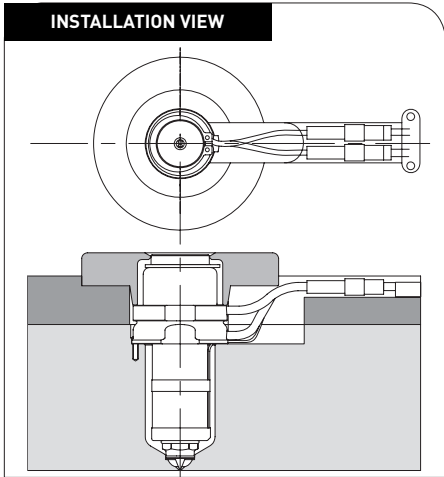
Provide the Tip Code + Grade
 (Order example: X 16 IT+5 G1)

Nozzle Dimensions



Note

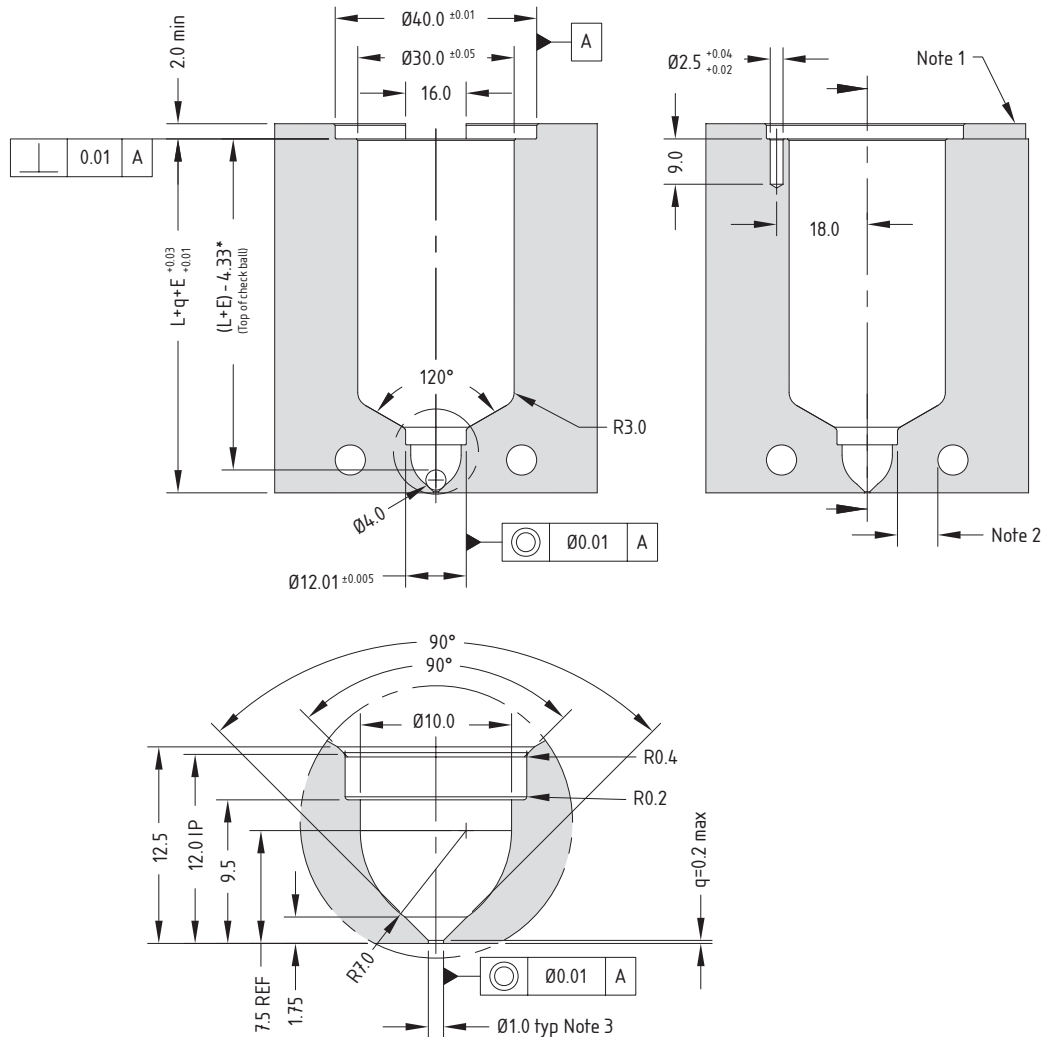
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTT16045+5	SXIT16045+5	50	0.13	0.17
SXTT16055+5	SXIT16055+5	60	0.16	0.20
SXTT16065+5	SXIT16065+5	70	0.18	0.23
SXTT16075+5	SXIT16075+5	80	0.21	0.26
SXTT16095+5	SXIT16095+5	100	0.26	0.33
SXTT16115+5	SXIT16115+5	120	0.32	0.40
SXTT16145+5	SXIT16145+5	150	0.40	0.50
SXTT16175+5	SXIT16175+5	180	0.48	0.59

Nozzle Fitment and Gate Dimensions

$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.
 - * With 0.9 gate, +0.05mm per 0.1mm increase in gate diameter.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 13 TT+10)	✓	✓	✗
One-hole Torpedo Tip (X 13 IT+10)	✓	✓	✗
Open Tip	✗	✗	✗

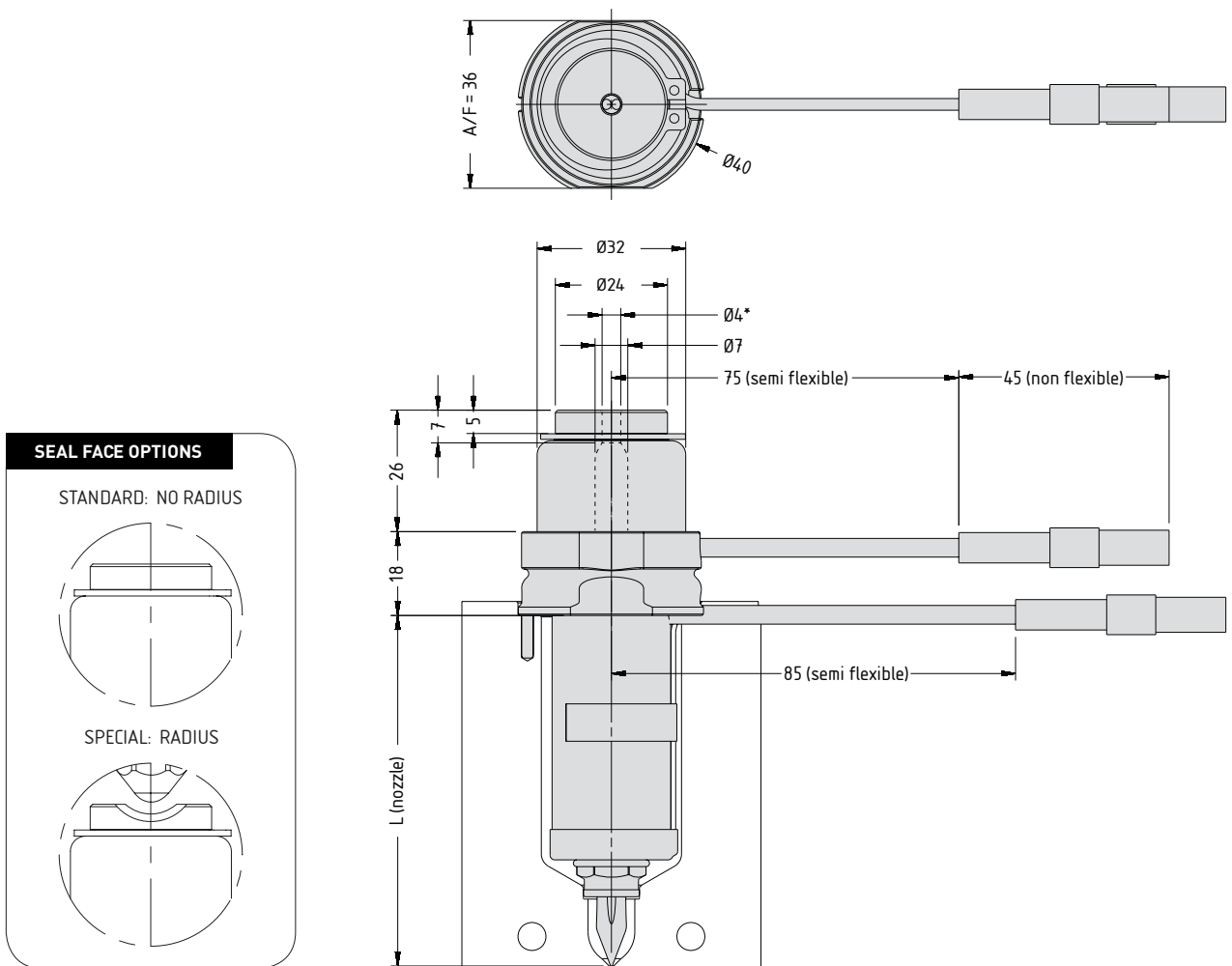
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIT16175+10 G1 Radius=0)

To order a tip:

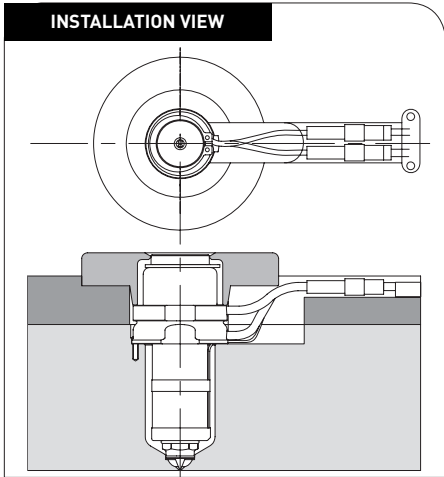
Provide the Tip Code + Grade
 (Order example: X 16 IT+10 G1)

Nozzle Dimensions



Note

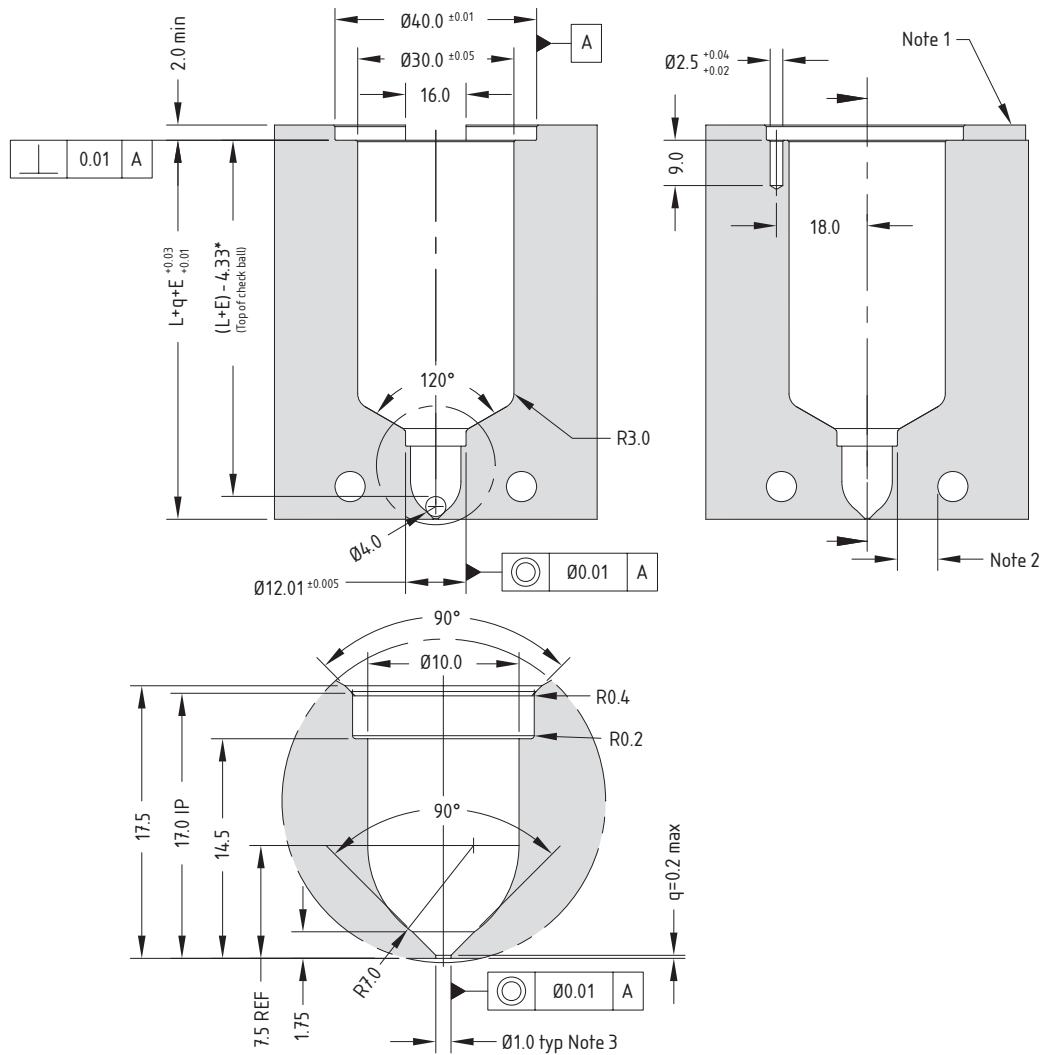
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTT16045+10	SXIT16045+10	55	0.15	0.18
SXTT16055+10	SXIT16055+10	65	0.17	0.21
SXTT16065+10	SXIT16065+10	75	0.20	0.25
SXTT16075+10	SXIT16075+10	85	0.22	0.28
SXTT16095+10	SXIT16095+10	105	0.28	0.35
SXTT16115+10	SXIT16115+10	125	0.33	0.41
SXTT16145+10	SXIT16145+10	155	0.41	0.51
SXTT16175+10	SXIT16175+10	185	0.49	0.61

Nozzle Fitment and Gate Dimensions

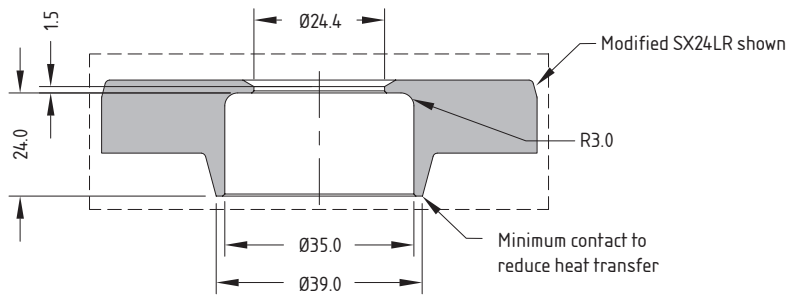
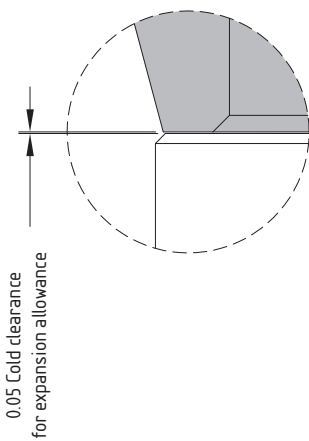
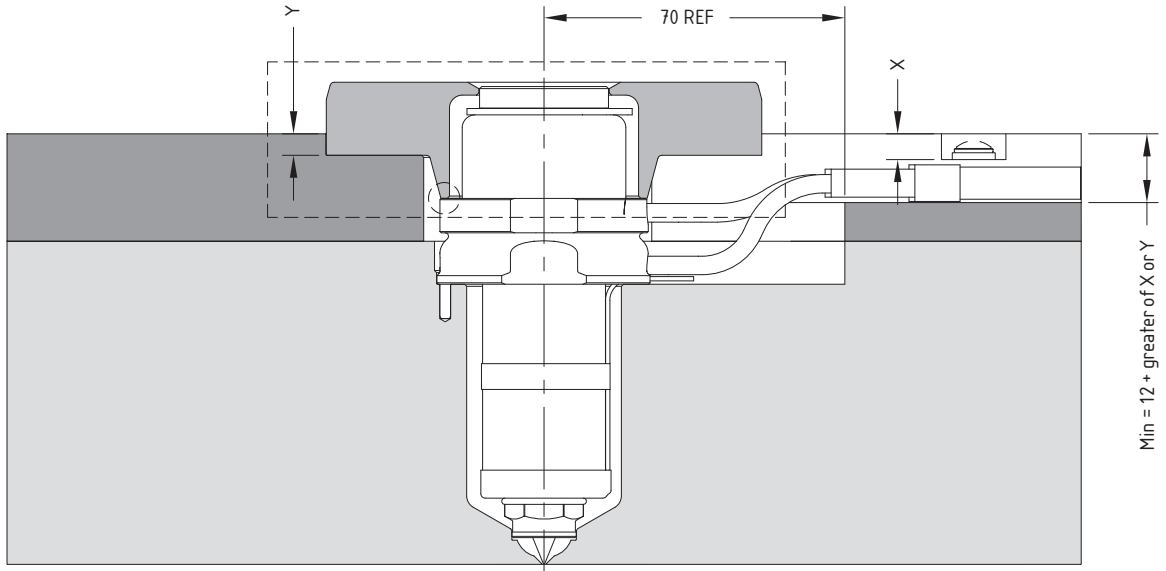
$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

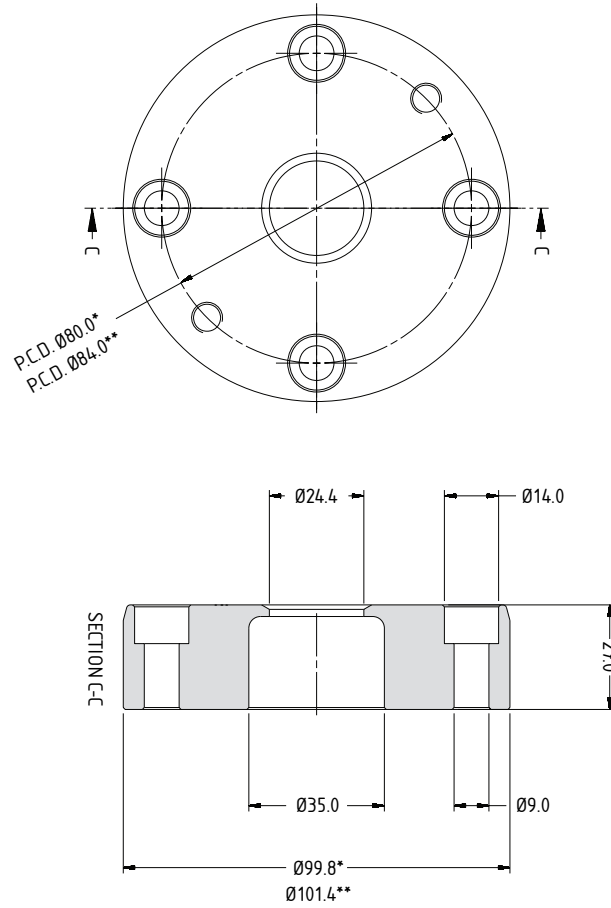
1. Wire channel to suit mould.
2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
 - Minimum strength (σ_y) of nozzle plate 800MPa.
 - * With 0.9 gate, +0.05mm per 0.1mm increase in gate diameter.

Installation Example



All other dimensions and details to suit mould design

Locating Rings



Note

- Locating Ring may require finishing to suit mould.
- Go to www.mastip.com to download the CAD Model.
- * Order Code SX24LR-METRIC
- ** Order Code SX24LR-IMPERIAL

SXTG19

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 19 TT)	✓	✓	✓
One-hole Torpedo Tip (X 19 IT)	✓	✓	✓
Open Tip (X 19 OT)	✓	✗	✓

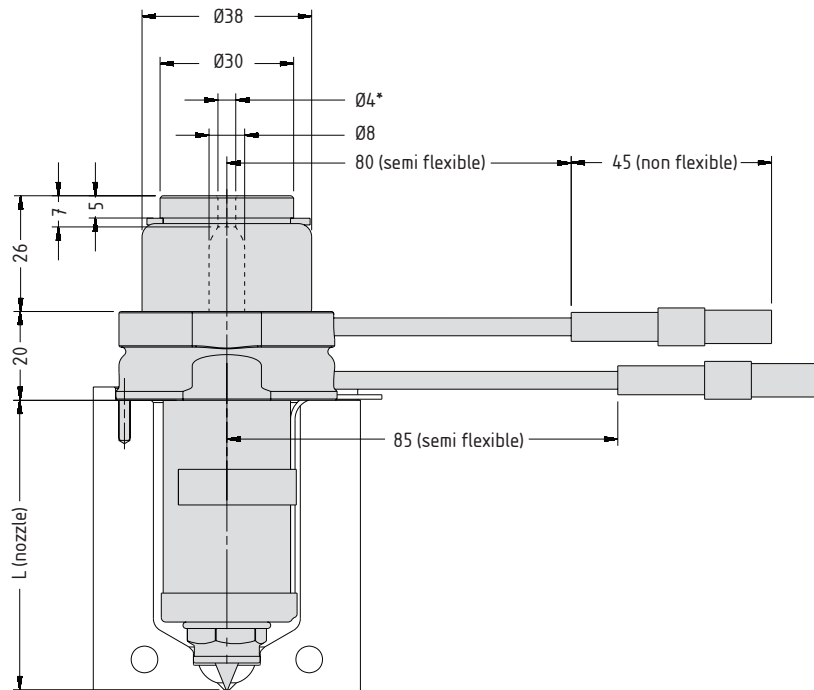
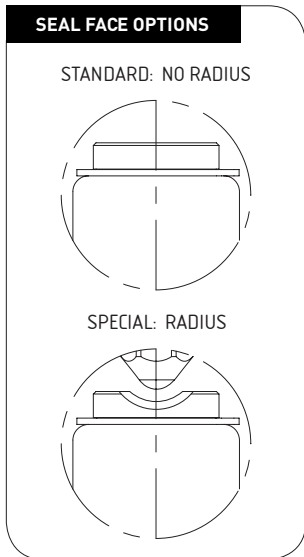
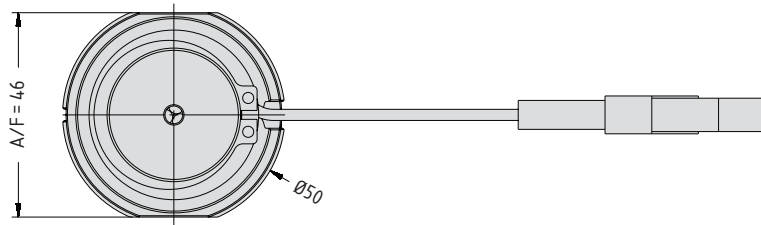
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIT19055 G5 Radius=0)

To order a tip:

Provide the Tip Code + Grade
 (Order example: X 19 IT G5)

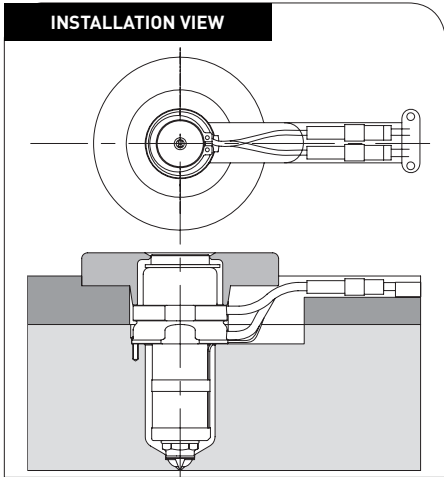
Nozzle Dimensions



Note

- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.

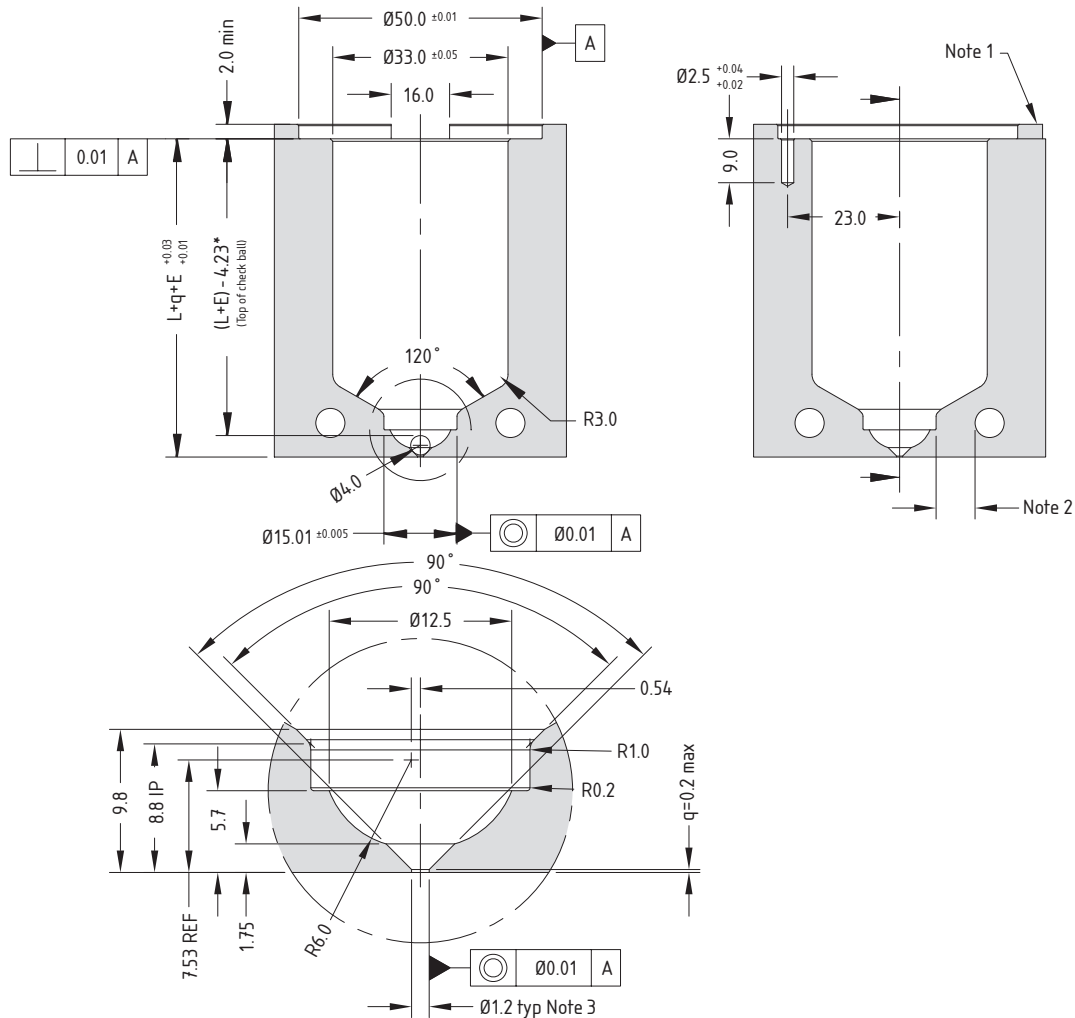
* Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTT19055	SXIT19055	SXOT19055	55	0.15	0.18
SXTT19065	SXIT19065	SXOT19065	65	0.17	0.21
SXTT19075	SXIT19075	SXOT19075	75	0.20	0.25
SXTT19095	SXIT19095	SXOT19095	95	0.25	0.31
SXTT19115	SXIT19115	SXOT19115	115	0.30	0.38
SXTT19145	SXIT19145	SXOT19145	145	0.38	0.48
SXTT19175	SXIT19175	SXOT19175	175	0.46	0.58

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.
 - * With 0.9 gate, +0.05mm per 0.1mm increase in gate diameter.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 19 TT)	✓	✓	✓	✗
One-hole Torpedo Tip (X 19 IT)	✓	✓	✓	✗
Open Tip (X 19 OT)	✓	✗	✓	✗

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	1.2
H1	1.4

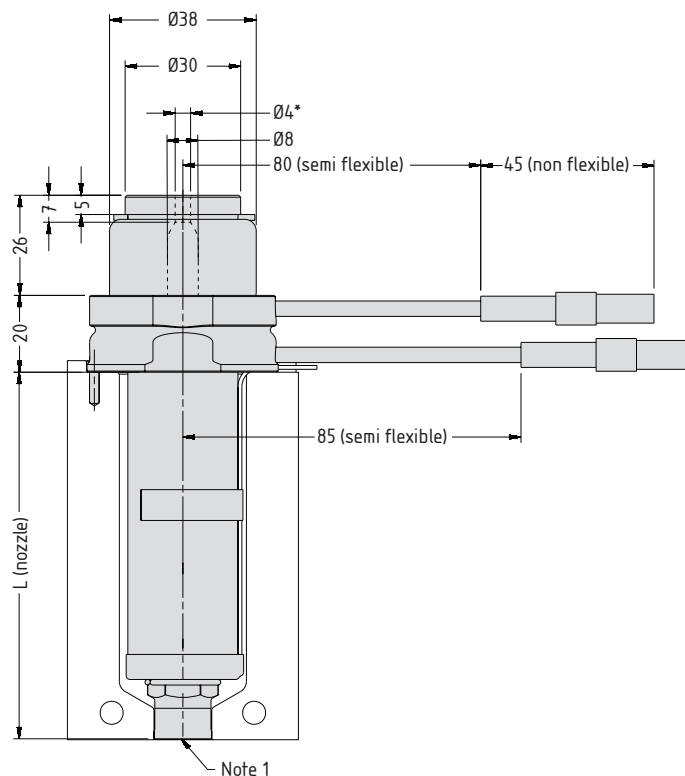
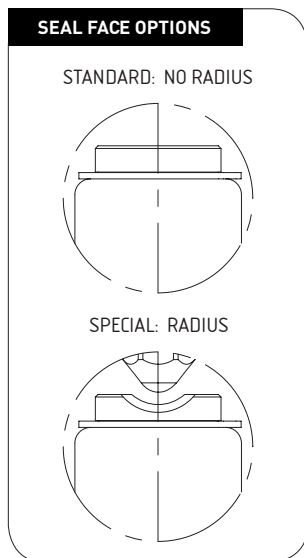
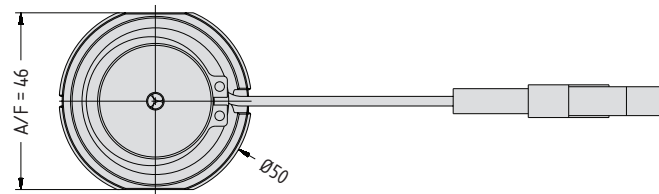
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIBE19065 G5 Radius=0)

To order a tip:

Provide the Tip Code + Grade
 (Order example: X 19 IT G5)

Nozzle Dimensions



Note

1. Modify the contact area to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 19 TT)	✓	✓	✓	✓
One-hole Torpedo Tip (X 19 IT)	✓	✓	✓	✓
Open Tip (X 19 OT)	✓	✗	✓	✓

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	1.2
H1	1.4
H5	1.7

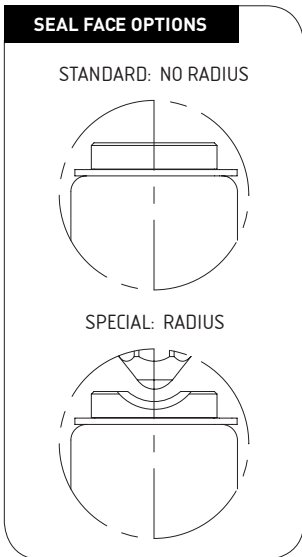
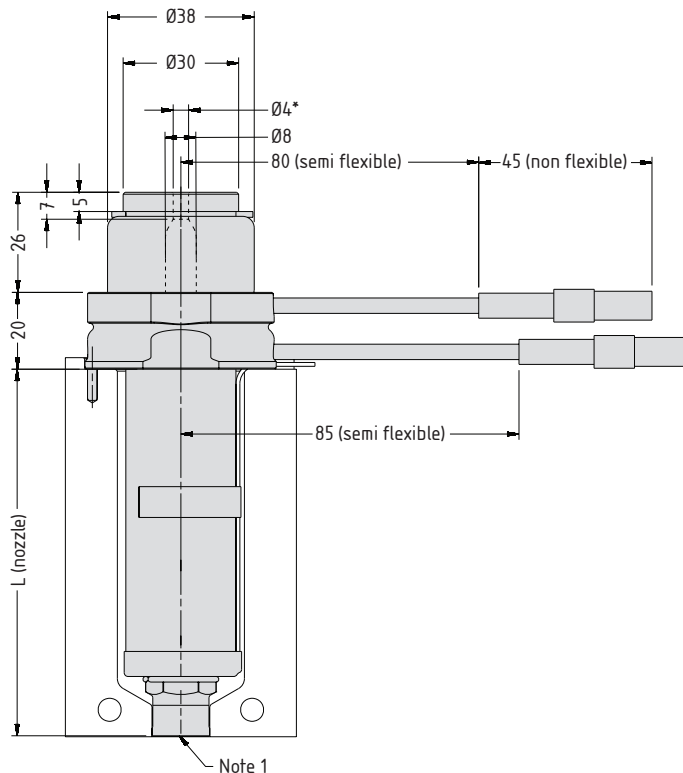
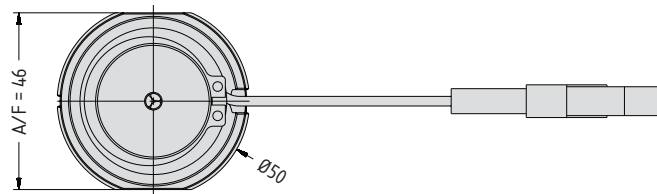
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIBN19065 G5 Radius=0)

To order a tip:

Provide the Tip Code + Grade
 (Order example: X 19 IT G5)

Nozzle Dimensions



Note

- Modify the contact area to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
 - Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 19 TT)	✓	✓	✓	✓
One-hole Torpedo Tip (X 19 IT)	✓	✓	✓	✓
Open Tip (X 19 OT)	✓	✗	✓	✓

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	1.2
H1	1.6
H5	2.0

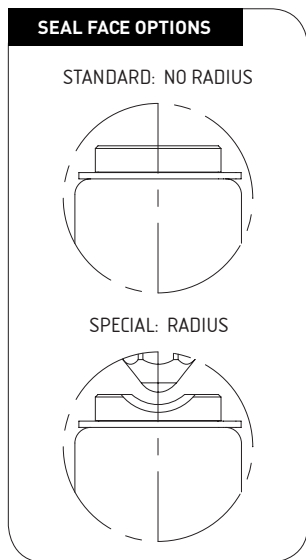
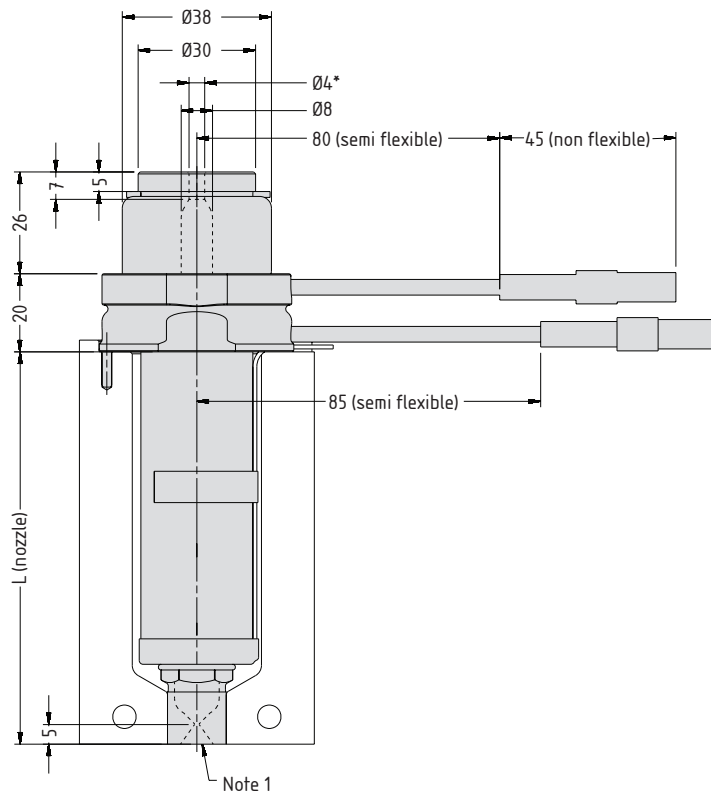
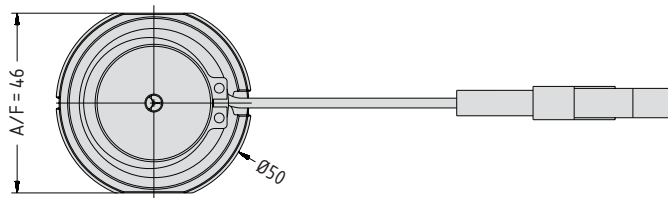
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXISN19075 G5 Radius=0)

To order a tip:

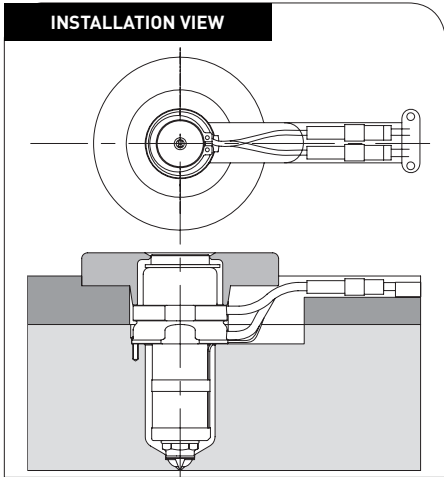
Provide the Tip Code + Grade
 (Order example: X 19 IT G5)

Nozzle Dimensions



Note

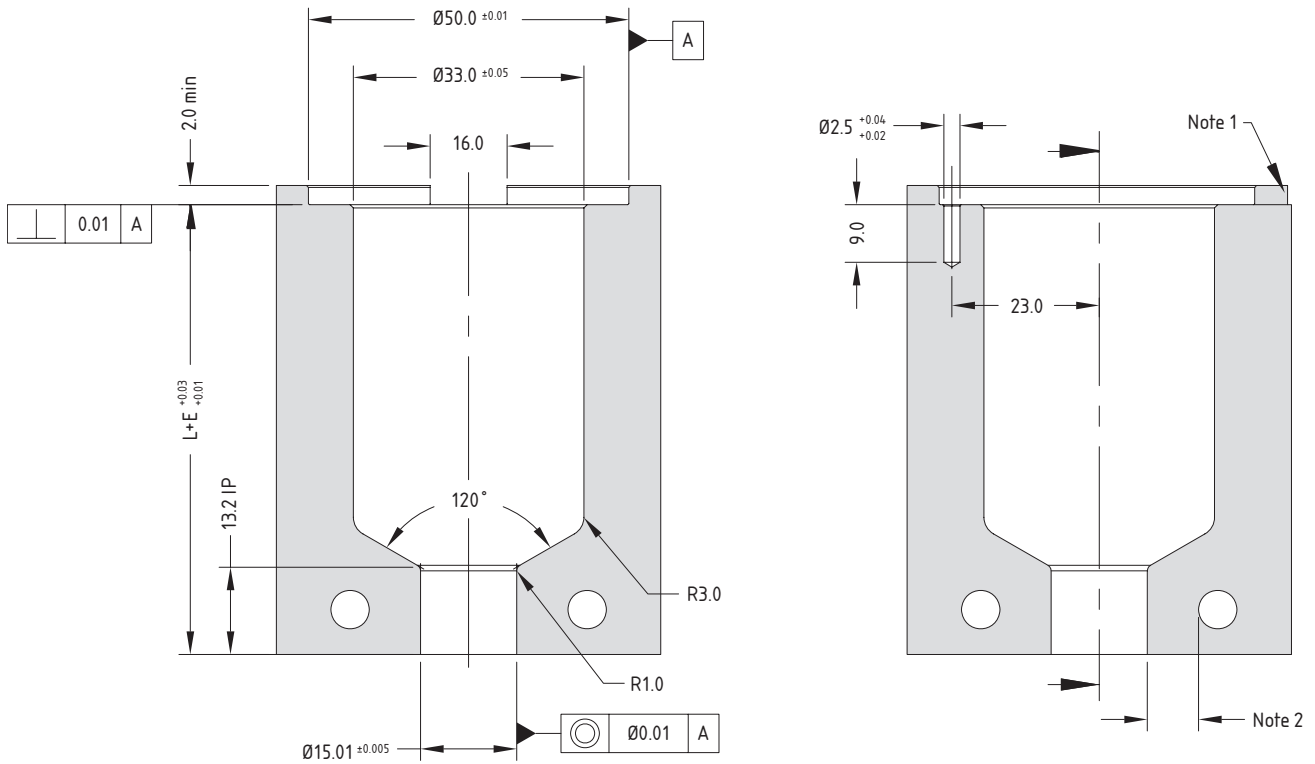
1. Modify the contact area and the sprue nut to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
 - * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	$E\Delta T = 200C$	$E\Delta T = 250C$
SXTSN19055	SXISN19055	SXOSN19055	60.2	0.20	0.25
SXTSN19065	SXISN19065	SXOSN19065	70.2	0.23	0.28
SXTSN19075	SXISN19075	SXOSN19075	80.2	0.25	0.31
SXTSN19095	SXISN19095	SXOSN19095	100.2	0.30	0.38
SXTSN19115	SXISN19115	SXOSN19115	120.2	0.36	0.45
SXTSN19145	SXISN19145	SXOSN19145	150.2	0.40	0.50
SXTSN19175	SXISN19175	SXOSN19175	180.2	0.48	0.59

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 19 TT)	✓	✓	✓
One-hole Torpedo Tip (X 19 IT)	✓	✓	✓
Open Tip (X 19 OT)	✓	✗	✓

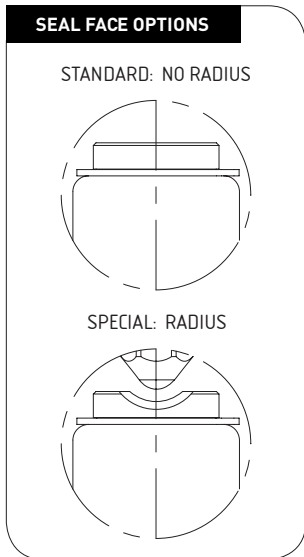
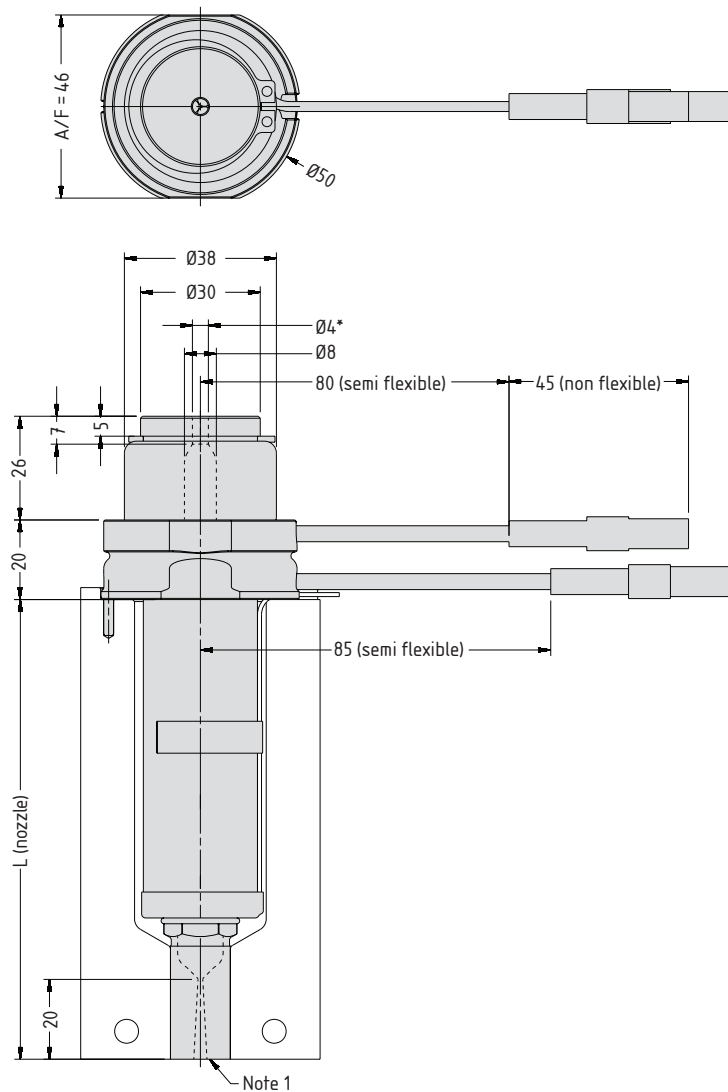
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXISX19075 G5 Radius=0)

To order a tip:

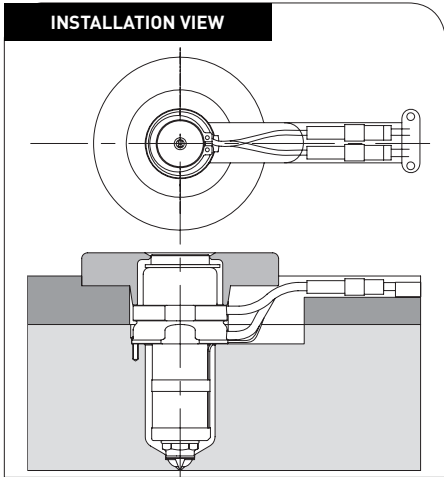
provide the Tip Code + Grade
 (Order example: X 19 IT G5)

Nozzle Dimensions



Note

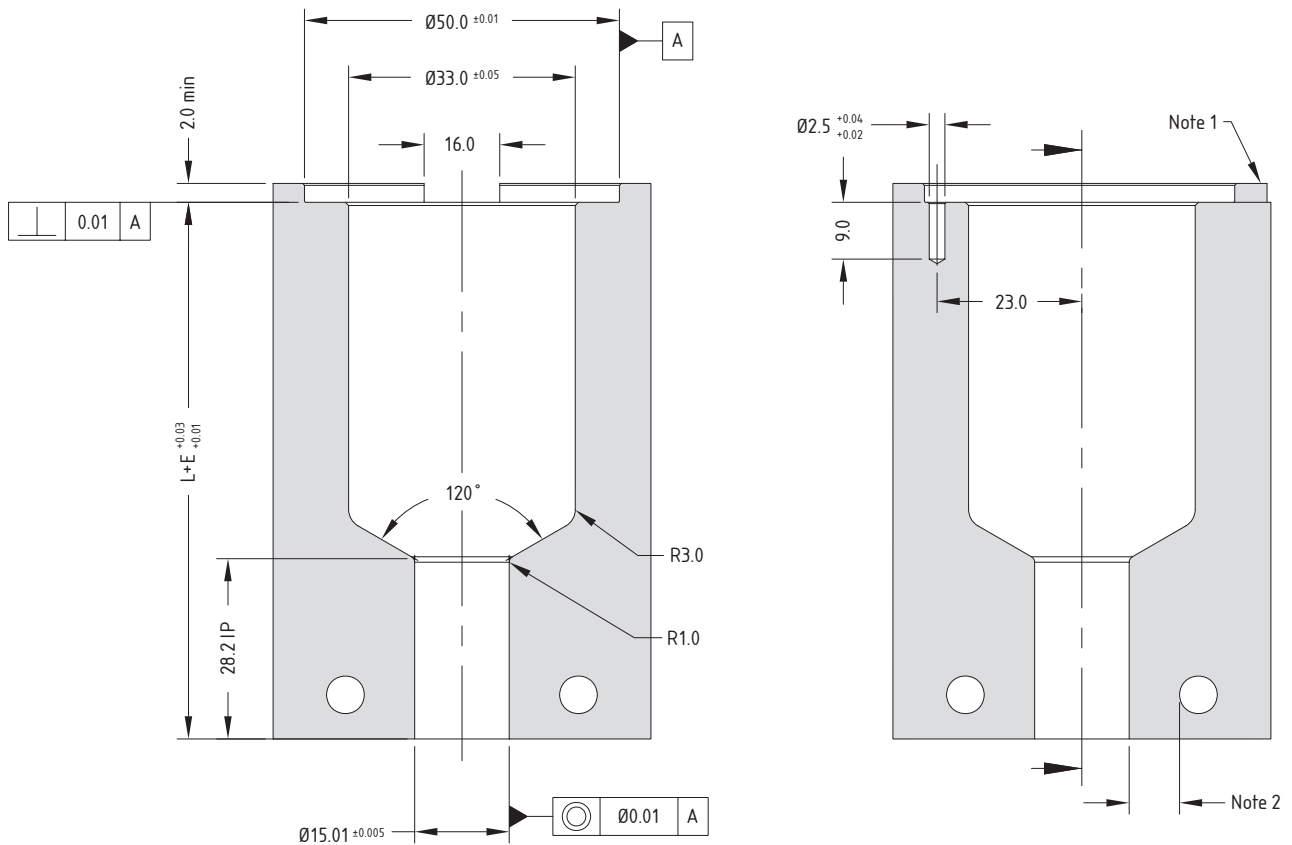
1. Modify the contact area and the sprue nut to suit the application.
- See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
 - * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTSX19055	SXISX19055	SXOSX19055	75.2	0.20	0.25
SXTSX19065	SXISX19065	SXOSX19065	85.2	0.23	0.28
SXTSX19075	SXISX19075	SXOSX19075	95.2	0.25	0.31
SXTSX19095	SXISX19095	SXOSX19095	115.2	0.30	0.38
SXTSX19115	SXISX19115	SXOSX19115	135.2	0.36	0.45
SXTSX19145	SXISX19145	SXOSX19145	165.2	0.44	0.55
SXTSX19175	SXISX19175	SXOSX19175	195.2	0.52	0.64

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. Supplied with Ø1.2 → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 19 TT)	✓	✓	✓
One-hole Torpedo Tip (X 19 IT)	✓	✓	✓
Open Tip (X 19 OT)	✓	✗	✓

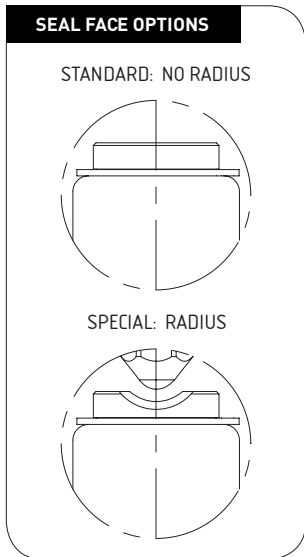
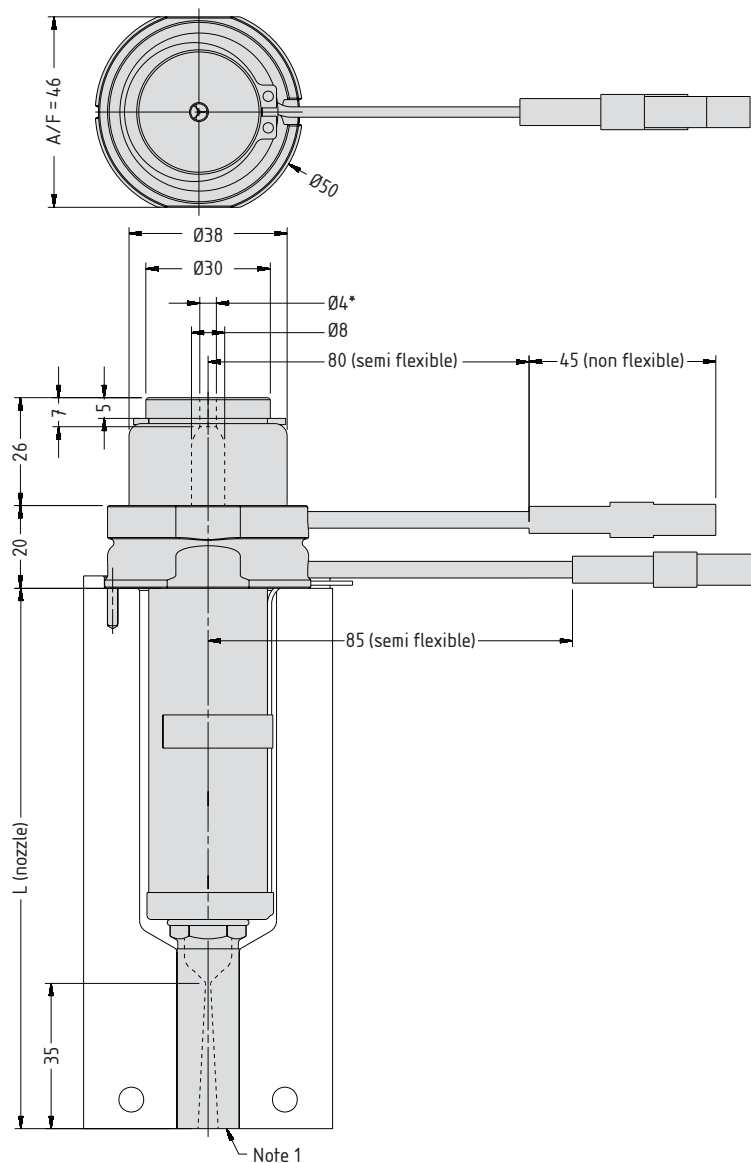
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXISL19075 G5)

To order a tip:

Provide the Tip Code + Grade
 (Order example: X 19 IT G5)

Nozzle Dimensions



Note

1. Modify the contact area and the sprue nut to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.

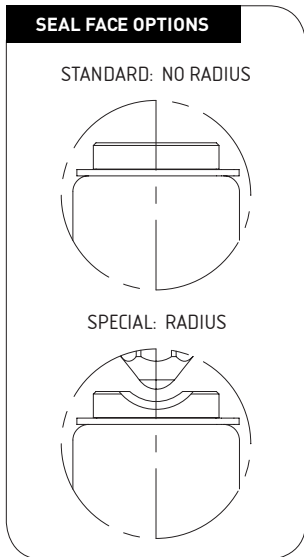
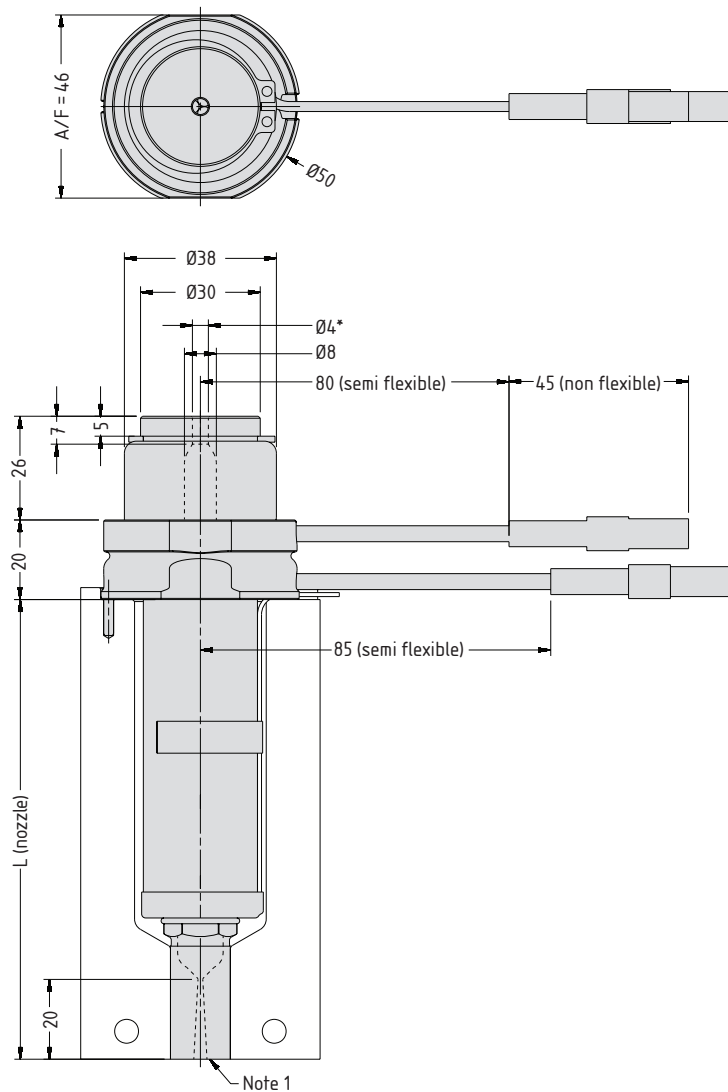
Nozzle Dimensions

Style	A	B
P7	29	Contact Mastip
P4	32	
N3	39	

To order a nozzle assembly:

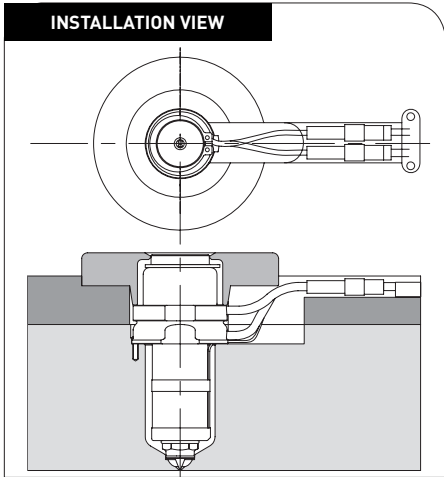
Provide the Nozzle Code + Style
 (Order example: SXYCN19075 P4 Radius=0)

Refer to the System Selection Guide for selecting the appropriate material specific nut (P7, P4 or N3) profile.



Note

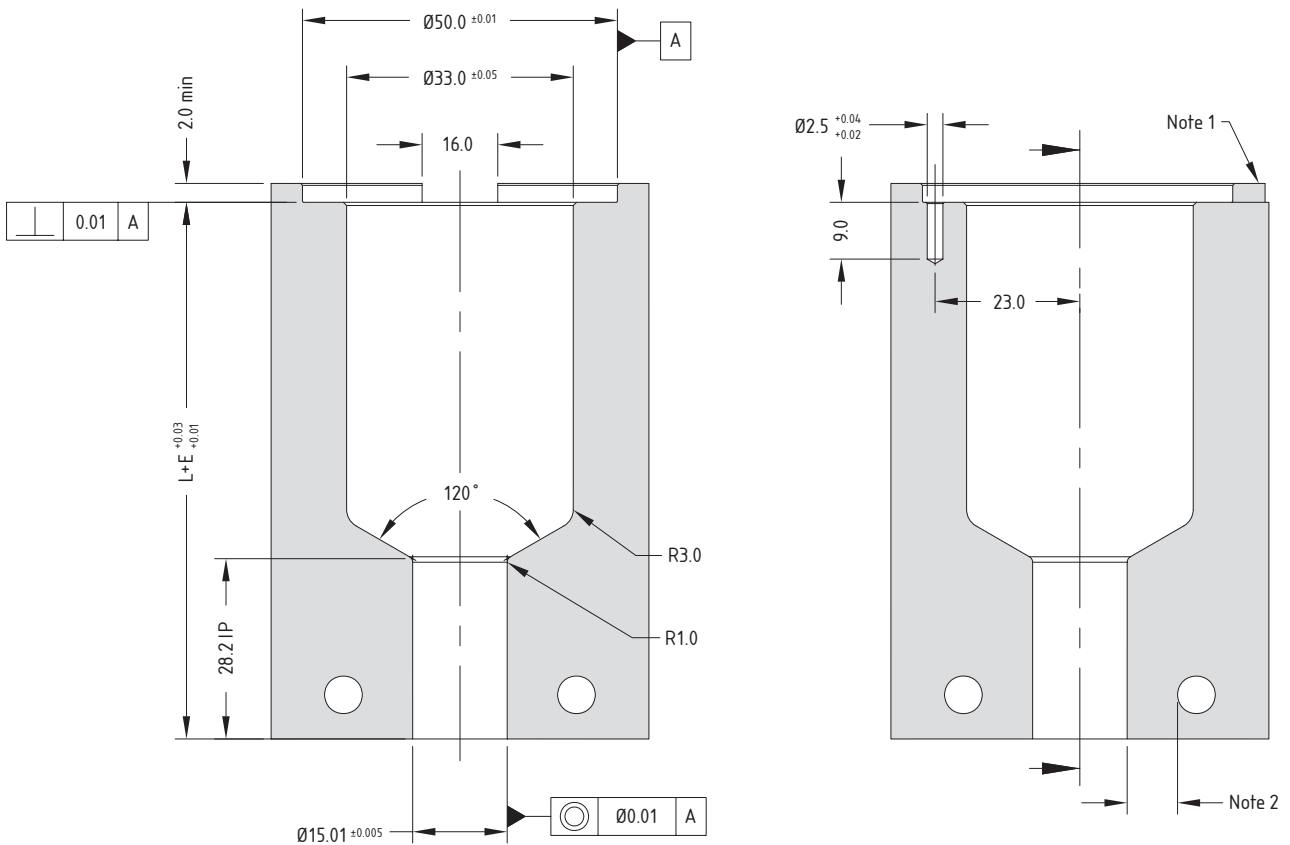
1. Modify the contact area and the sprue nut to suit the application.
 → See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
 - * Open to suit machine nozzle size.



P7	P4	N3	L	E@ΔT =200C	E@ΔT =250C
SXYCN19055	SXYCN19055	SXYCN19055	75.2	0.20	0.25
SXYCN19065	SXYCN19065	SXYCN19065	85.2	0.23	0.28
SXYCN19075	SXYCN19075	SXYCN19075	95.2	0.25	0.31
SXYCN19095	SXYCN19095	SXYCN19095	115.2	0.30	0.38
SXYCN19115	SXYCN19115	SXYCN19115	135.2	0.36	0.45
SXYCN19145	SXYCN19145	SXYCN19145	165.2	0.44	0.55
SXYCN19175	SXYCN19175	SXYCN19175	195.2	0.52	0.64

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 19 TT+5)	✓	✓	✗
One-hole Torpedo Tip (X 19 IT+5)	✓	✓	✗
Open Tip	✗	✗	✗

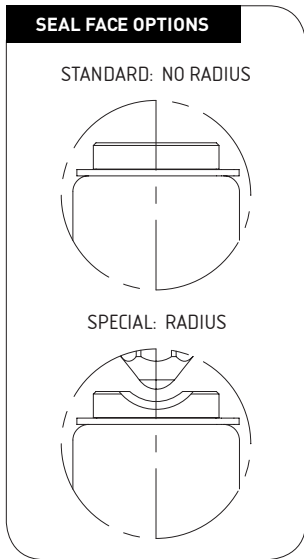
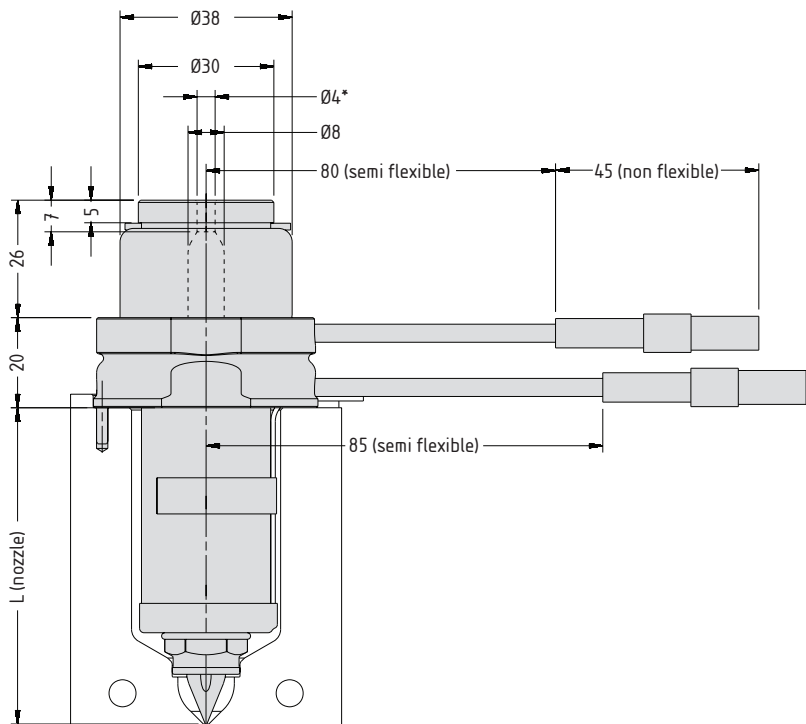
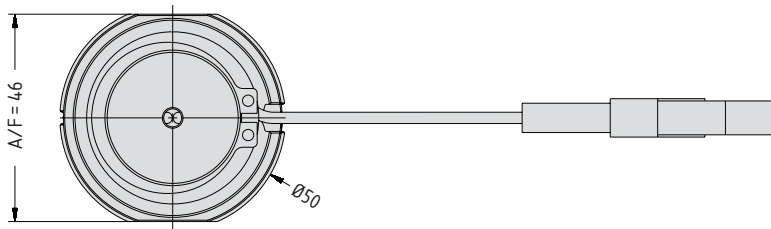
To order a nozzle assembly:

Provide the Nozzle Code + Grade
 (Order example: SXIT19065+5 G5 Radius=0)

To order a tip:

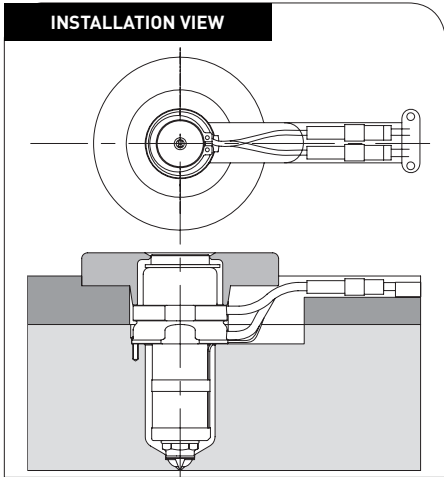
Provide the Tip Code + Grade
 (Order example: X 19 IT+5 G2)

Nozzle Dimensions



Note

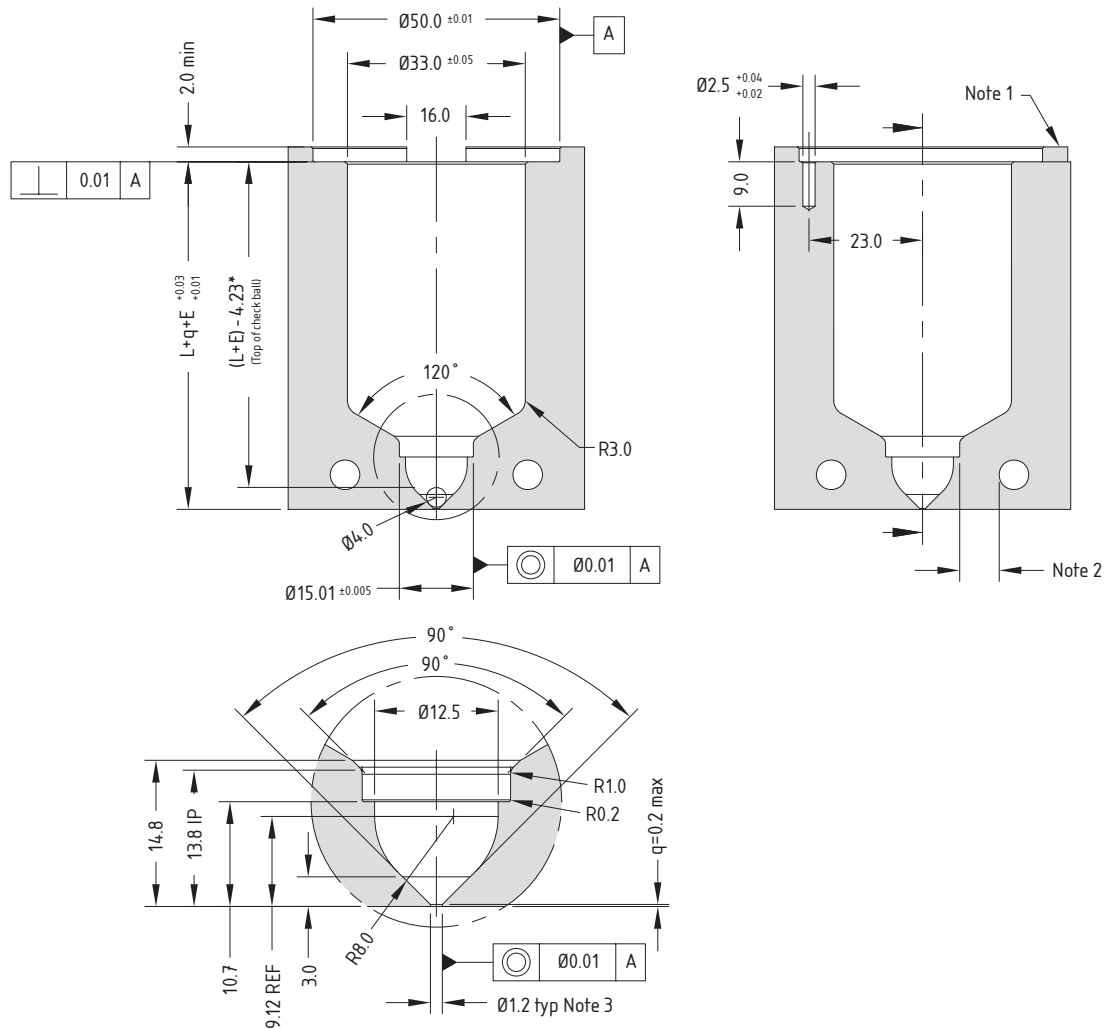
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTT19055+5	SXIT19055+5	60	0.16	0.20
SXTT19065+5	SXIT19065+5	70	0.18	0.23
SXTT19075+5	SXIT19075+5	80	0.21	0.26
SXTT19095+5	SXIT19095+5	100	0.26	0.33
SXTT19115+5	SXIT19115+5	120	0.32	0.40
SXTT19145+5	SXIT19145+5	150	0.40	0.50
SXTT19175+5	SXIT19175+5	180	0.48	0.59

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
 - Minimum strength (σ_y) of nozzle plate 800MPa.
 - * With 0.9 gate, +0.05mm per 0.1mm increase in gate diameter.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 19 TT+10)	✓	✓	✗
One-hole Torpedo Tip (X 19 IT+10)	✓	✓	✗
Open Tip	✗	✗	✗

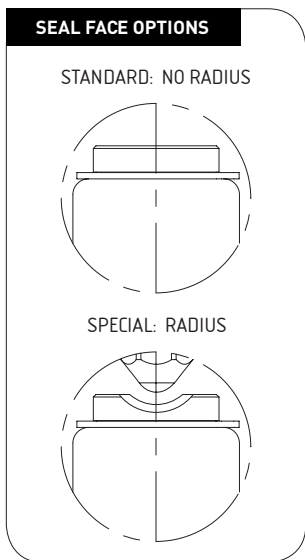
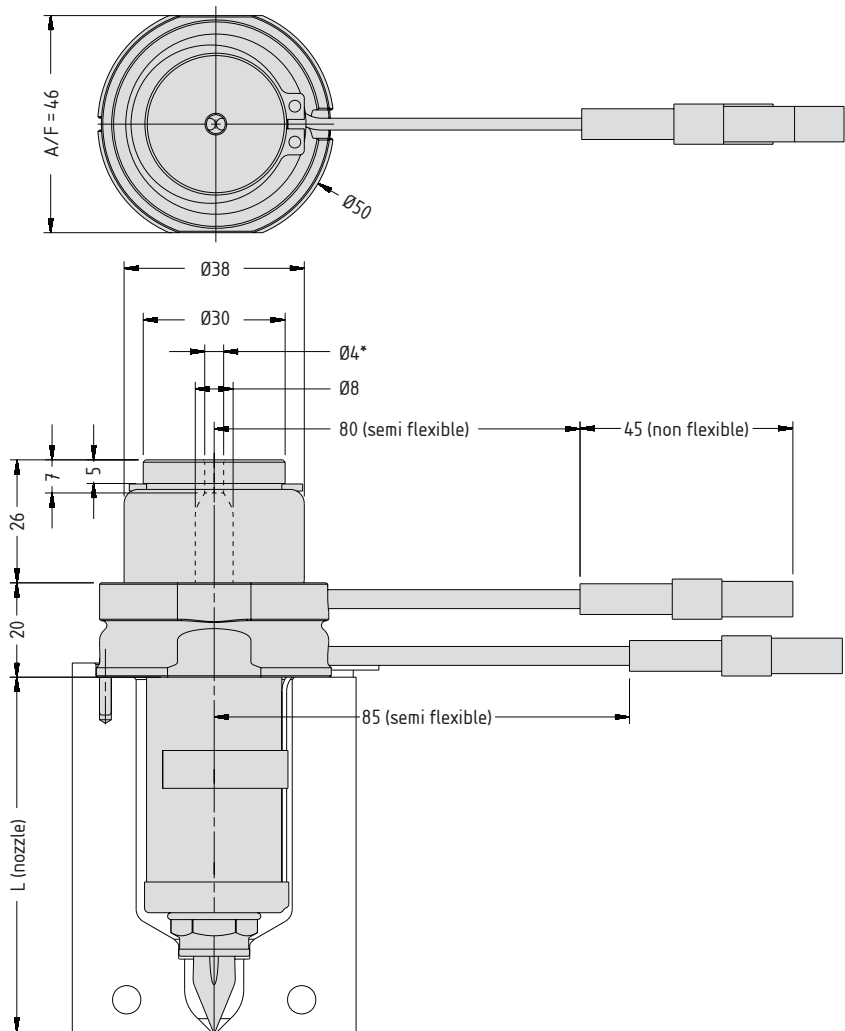
To order a nozzle assembly:

Provide the Nozzle Code + Grade
(Order example: SXIT19075+10 G1 Radius=0)

To order a tip:

Provide the Tip Code + Grade
(Order example: X 19 IT+10 G1)

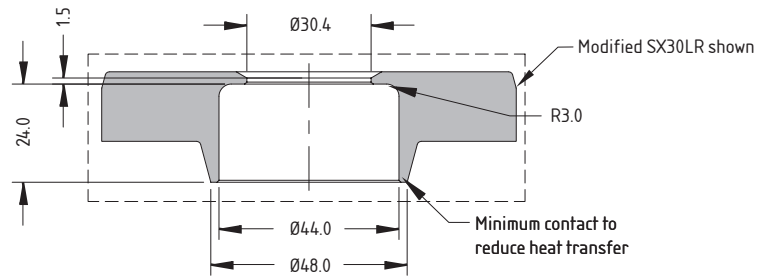
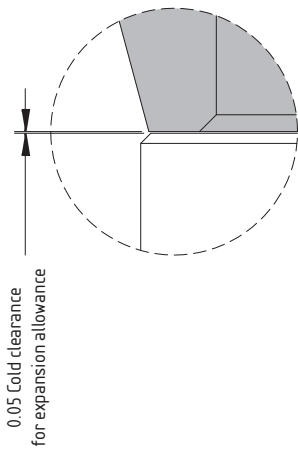
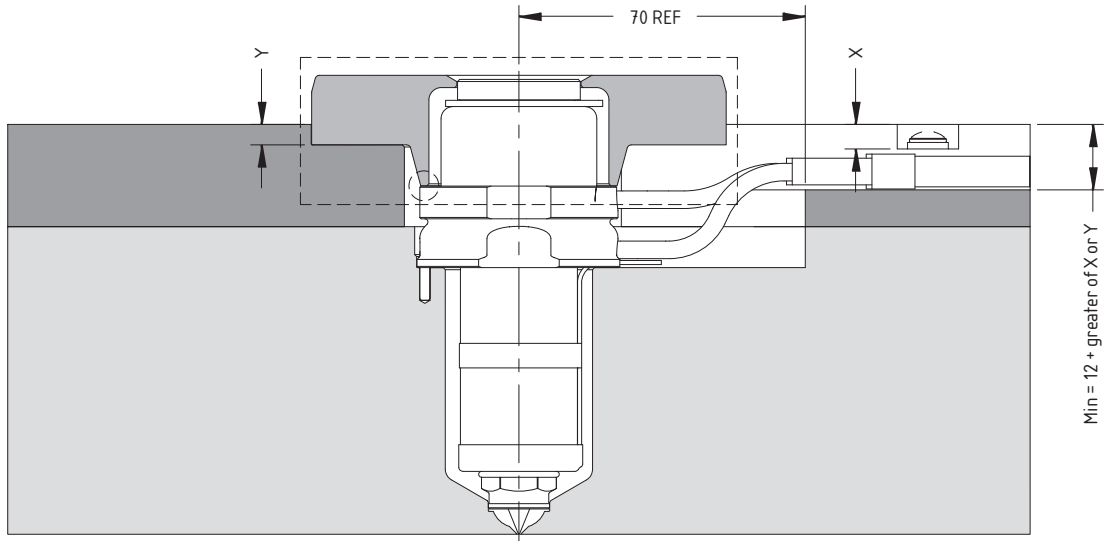
Nozzle Dimensions



Note

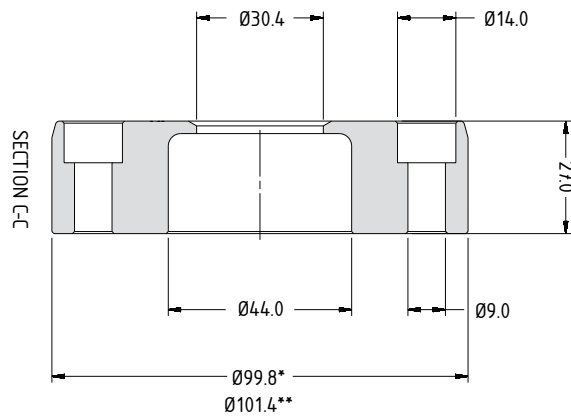
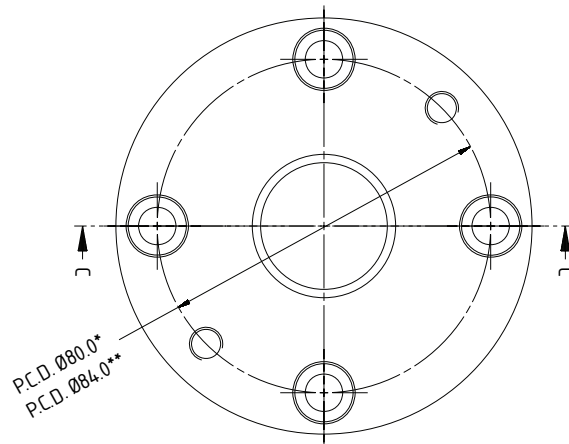
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.

Installation Example



All other dimensions and details to suit mould design

Locating Rings



Note

- Locating Ring may require finishing to suit mould.
- Go to www.mastip.com to download the CAD Model.
- * Order Code SX30LR-METRIC
- ** Order Code SX30LR-IMPERIAL

SXTG27

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 27 TT)	✓	✓	✓
One-hole Torpedo Tip (X 27 IT)	✓	✓	✓
Open Tip (X 27 OT)	✓	✗	✓

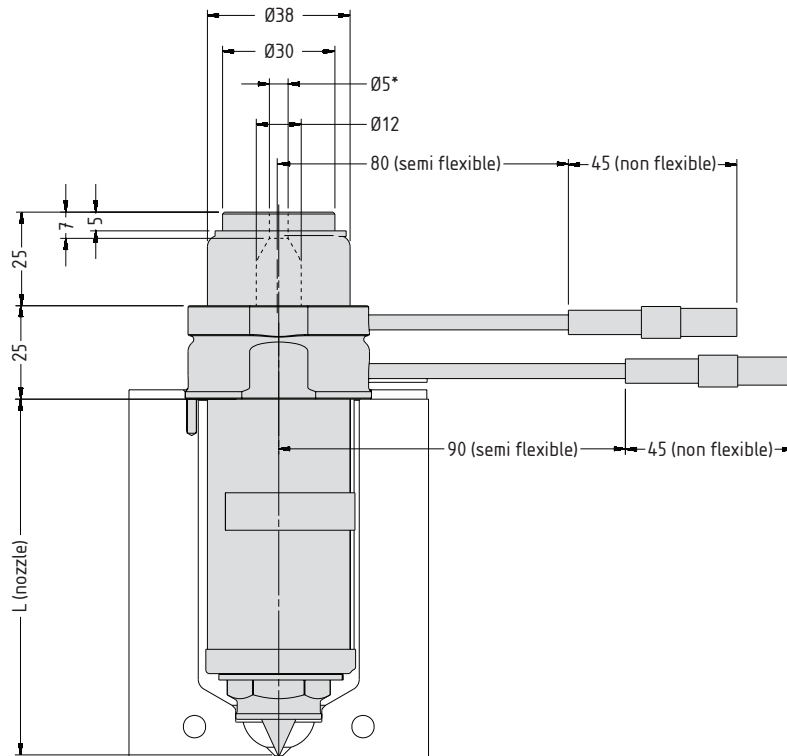
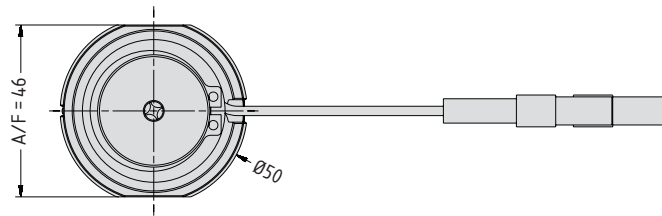
To order a nozzle assembly:

Provide the Nozzle Code + Grade
(Order example: SXIT27175 G5)

To order a tip:

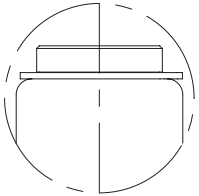
Provide the Tip Code + Grade
(Order example: X 27 IT G5)

Nozzle Dimensions

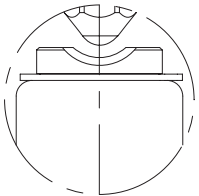


SEAL FACE OPTIONS

STANDARD: NO RADIUS

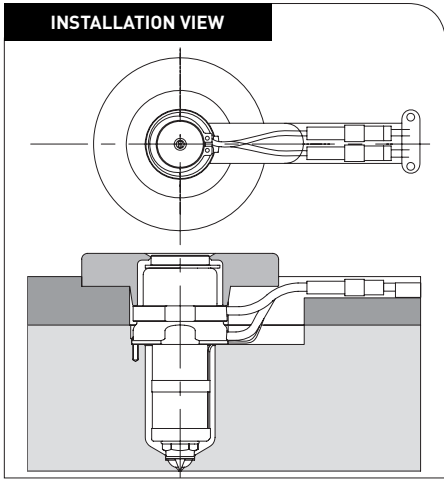


SPECIAL: RADIUS



Note

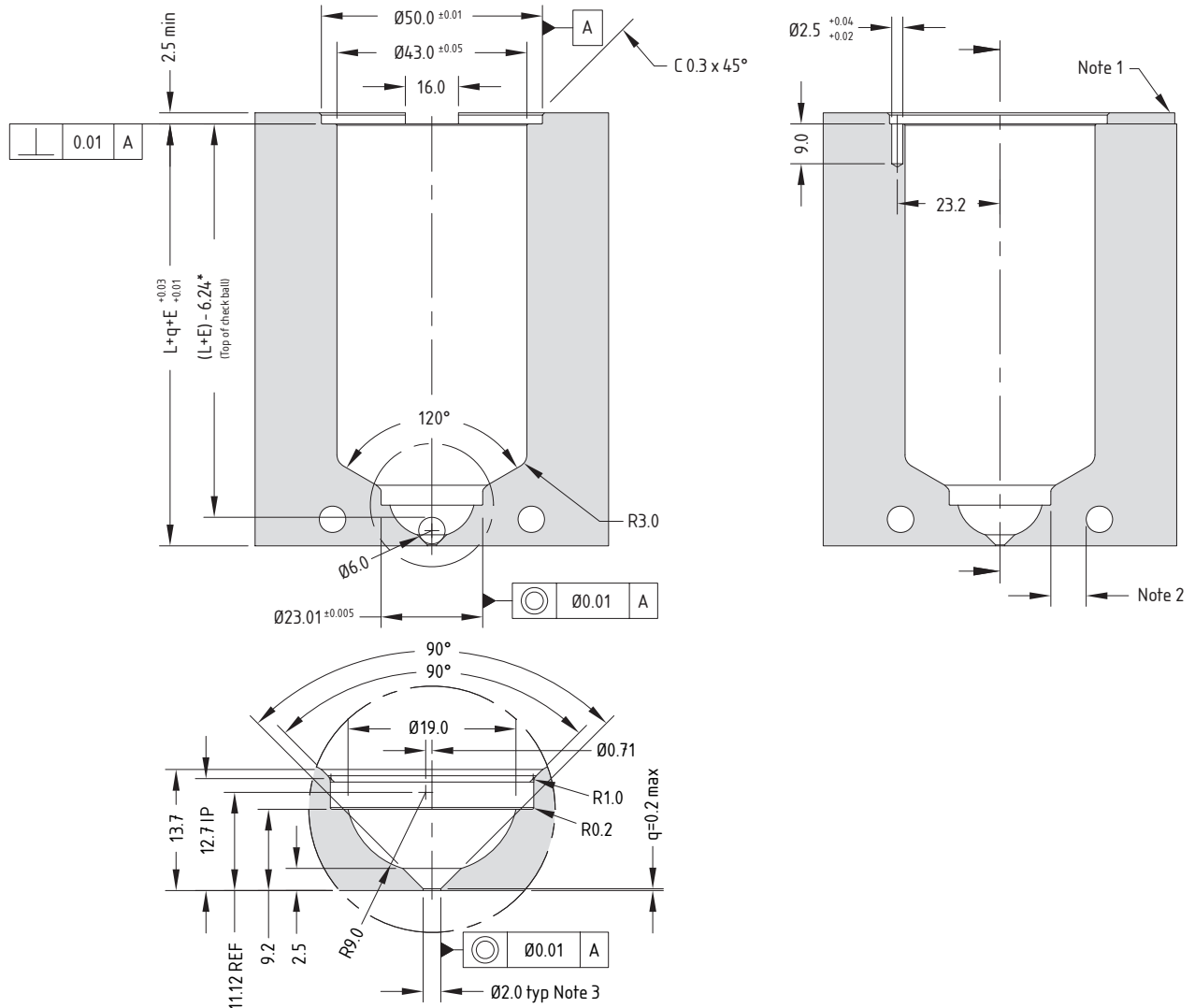
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTT27075	SXIT27075	SXOT27075	75	0.20	0.25
SXTT27095	SXIT27095	SXOT27095	95	0.25	0.31
SXTT27115	SXIT27115	SXOT27115	115	0.30	0.38
SXTT27145	SXIT27145	SXOT27145	145	0.38	0.48
SXTT27175	SXIT27175	SXOT27175	175	0.46	0.58
SXTT27225	SXIT27225	SXOT27225	225	0.59	0.74
SXTT27275	SXIT27275	SXOT27275	275	0.73	0.91

Nozzle Fitment and Gate Dimensions

$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.
 - * With 0.9 gate, +0.05mm per 0.1mm increase in gate diameter.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 27 TT)	✓	✓	✓	✗
One-hole Torpedo Tip (X 27 IT)	✓	✓	✓	✗
Open Tip (X 27 OT)	✓	✗	✓	✗

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	2.0
H1	2.3

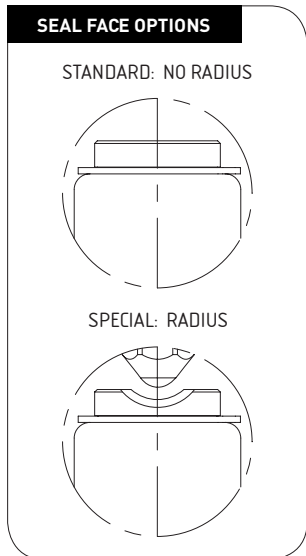
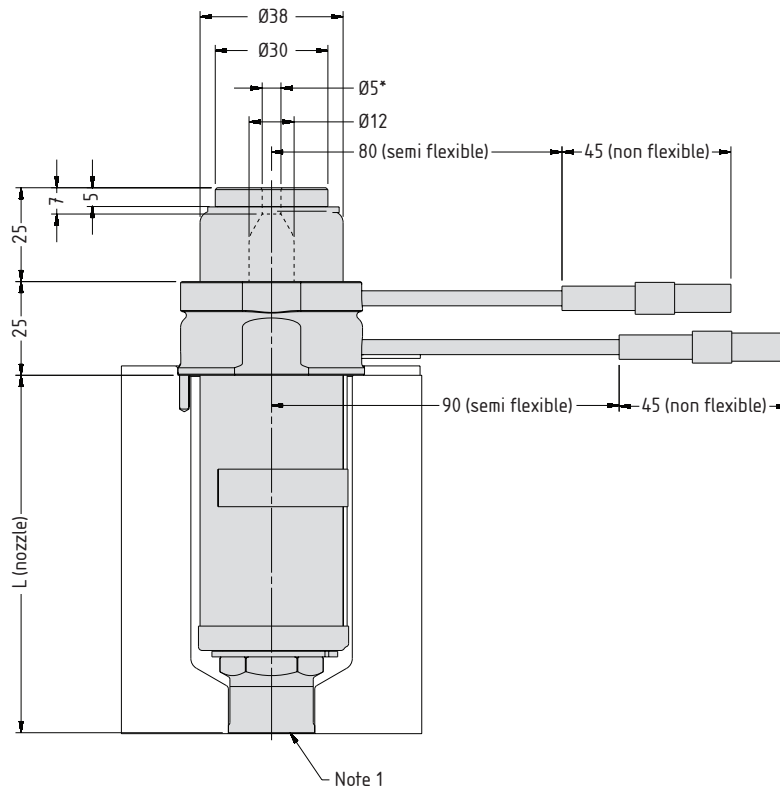
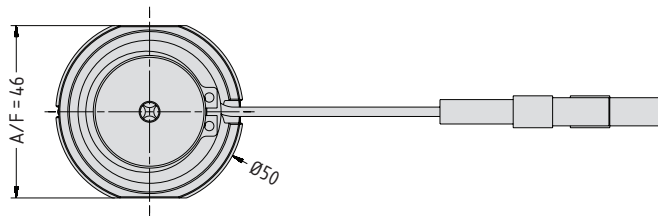
To order a nozzle assembly:

Provide the Nozzle Code + Grade
(Order example: SXIBE27175 G5)

To order a tip:

Provide the Tip Code + Grade
(Order example: X 27 IT G5)

Nozzle Dimensions



Note

- Modify the contact area to suit the application.
→ See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 27 TT)	✓	✓	✓	✓
One-hole Torpedo Tip (X 27 IT)	✓	✓	✓	✓
Open Tip (X 27 OT)	✓	✗	✓	✓

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	2.0
H1	2.3
H5	2.6

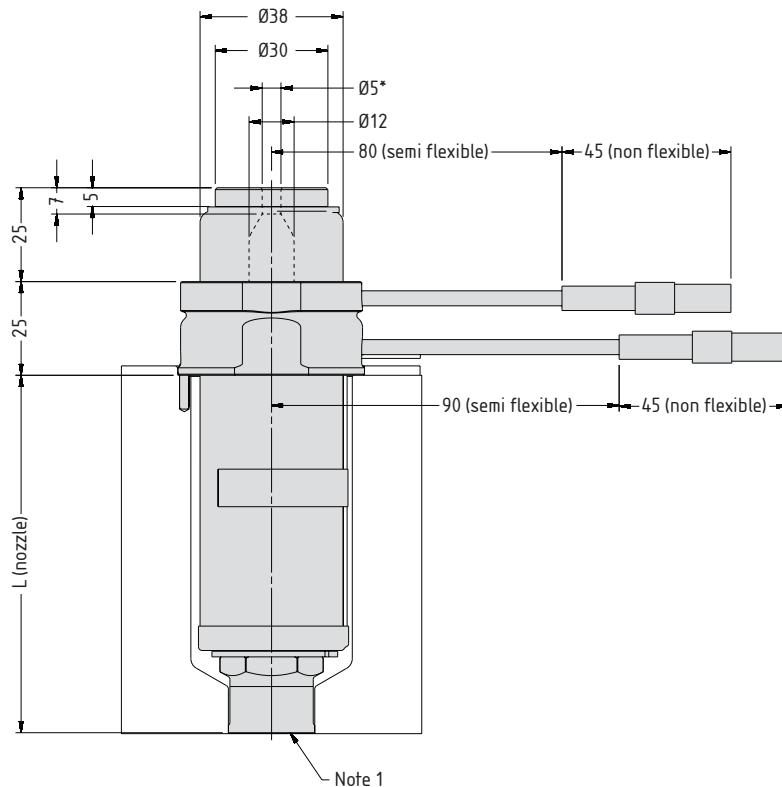
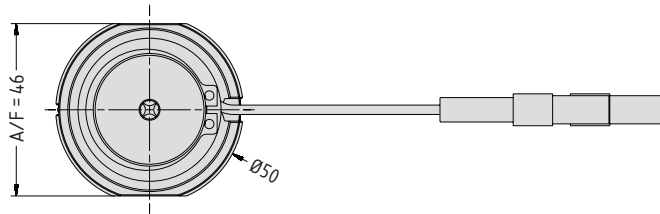
To order a nozzle assembly:

Provide the Nozzle Code + Grade
(Order example: SXIBN27175 G5)

To order a tip:

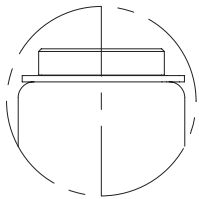
Provide the Tip Code + Grade
(Order example: X 27 IT G5)

Nozzle Dimensions

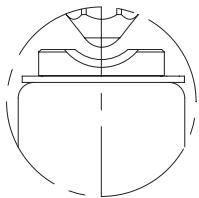


SEAL FACE OPTIONS

STANDARD: NO RADIUS

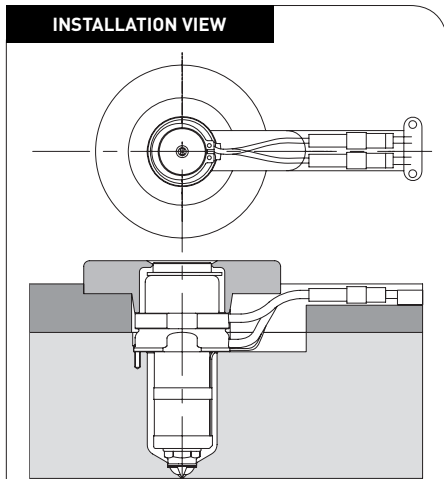


SPECIAL: RADIUS



Note

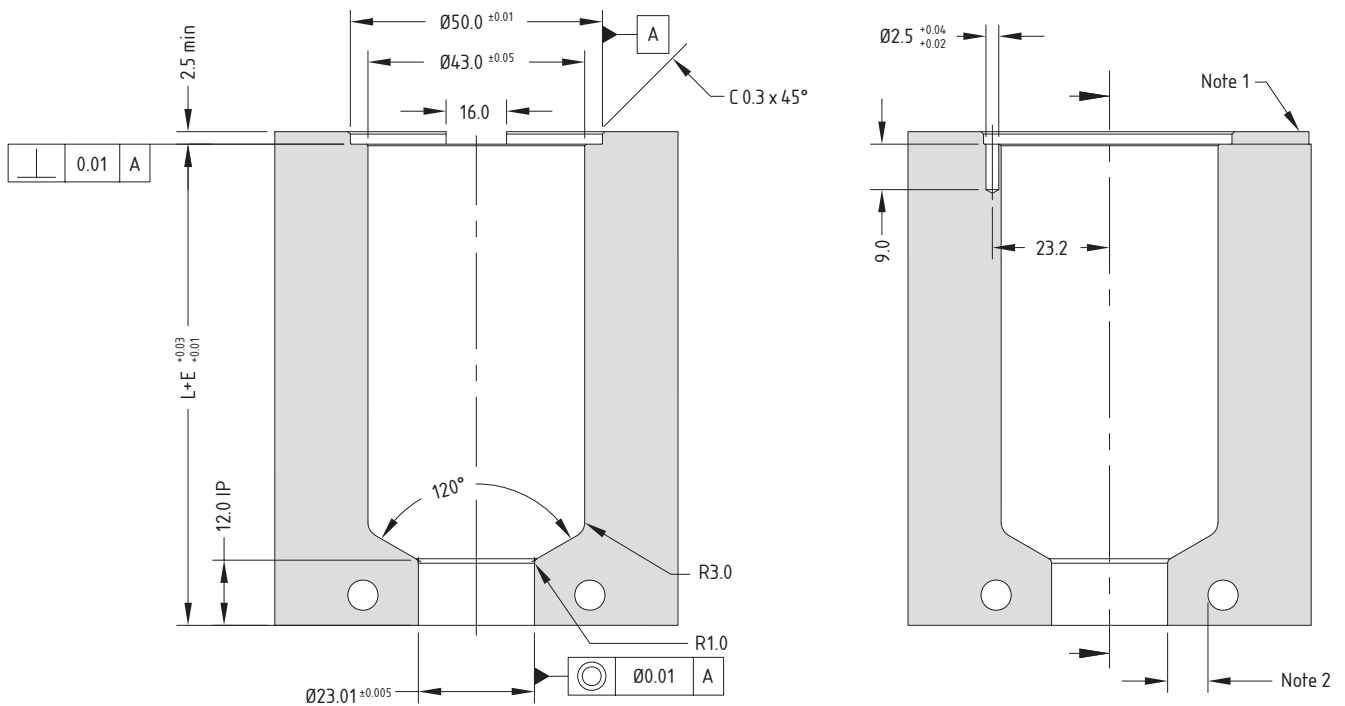
- Modify the contact area to suit the application.
→ See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	$E @ \Delta T = 200C$	$E @ \Delta T = 250C$
SXTBN27075	SXIBN27075	SX0BN27075	75.2	0.20	0.25
SXTBN27095	SXIBN27095	SX0BN27095	95.2	0.25	0.31
SXTBN27115	SXIBN27115	SX0BN27115	115.2	0.30	0.38
SXTBN27145	SXIBN27145	SX0BN27145	145.2	0.38	0.48
SXTBN27175	SXIBN27175	SX0BN27175	175.2	0.46	0.58
SXTBN27225	SXIBN27225	SX0BN27225	225.2	0.60	0.74
SXTBN27275	SXIBN27275	SX0BN27275	275.2	0.73	0.91

Nozzle Fitment and Gate Dimensions

$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Nut Material Grade Availability

Tip (Code)	G1/H1*	G2/H1*	G5/H1*	G5/H5
Multi-hole Torpedo Tip (X 27 TT)	✓	✓	✓	✓
One-hole Torpedo Tip (X 27 IT)	✓	✓	✓	✓
Open Tip (X 27 OT)	✓	✗	✓	✓

*Larger gate diameters are available as standard

Gate Diameter Options

Nut Grade	Dimensions
H1	2.0
H1	2.5
H5	2.8

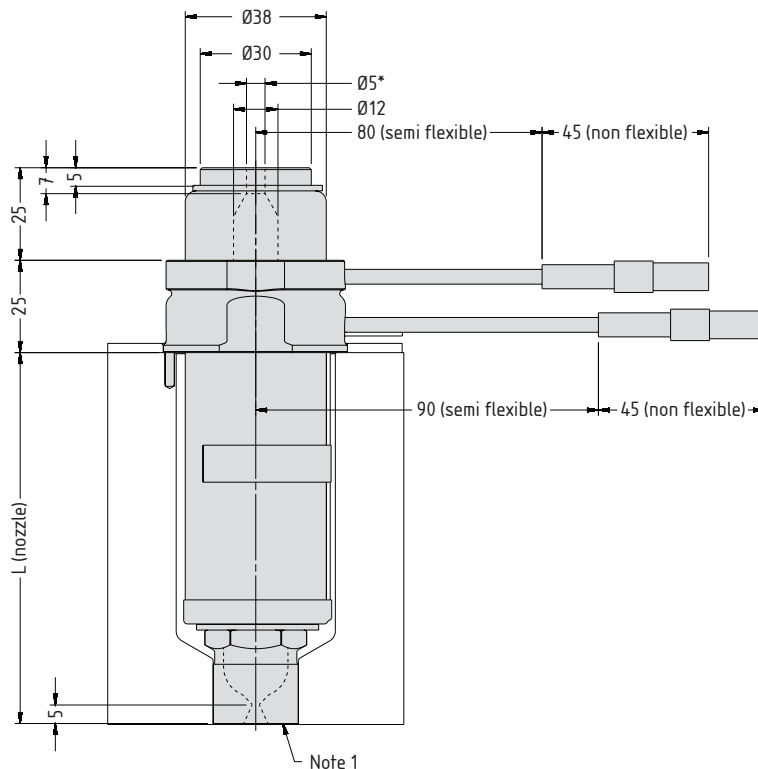
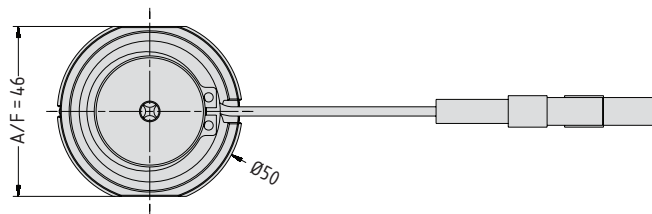
To order a nozzle assembly:

Provide the Nozzle Code + Grade
(Order example: SXISN27175 G5)

To order a tip:

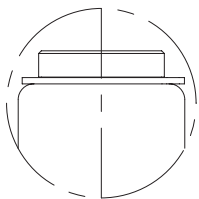
Provide the Tip Code + Grade
(Order example: X 27 IT G5)

Nozzle Dimensions

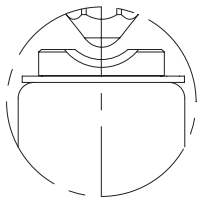


SEAL FACE OPTIONS

STANDARD: NO RADIUS

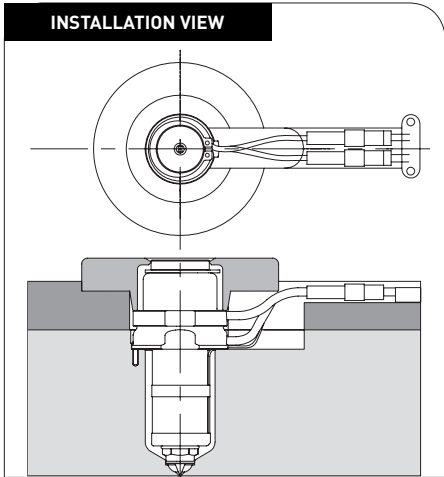


SPECIAL: RADIUS



Note

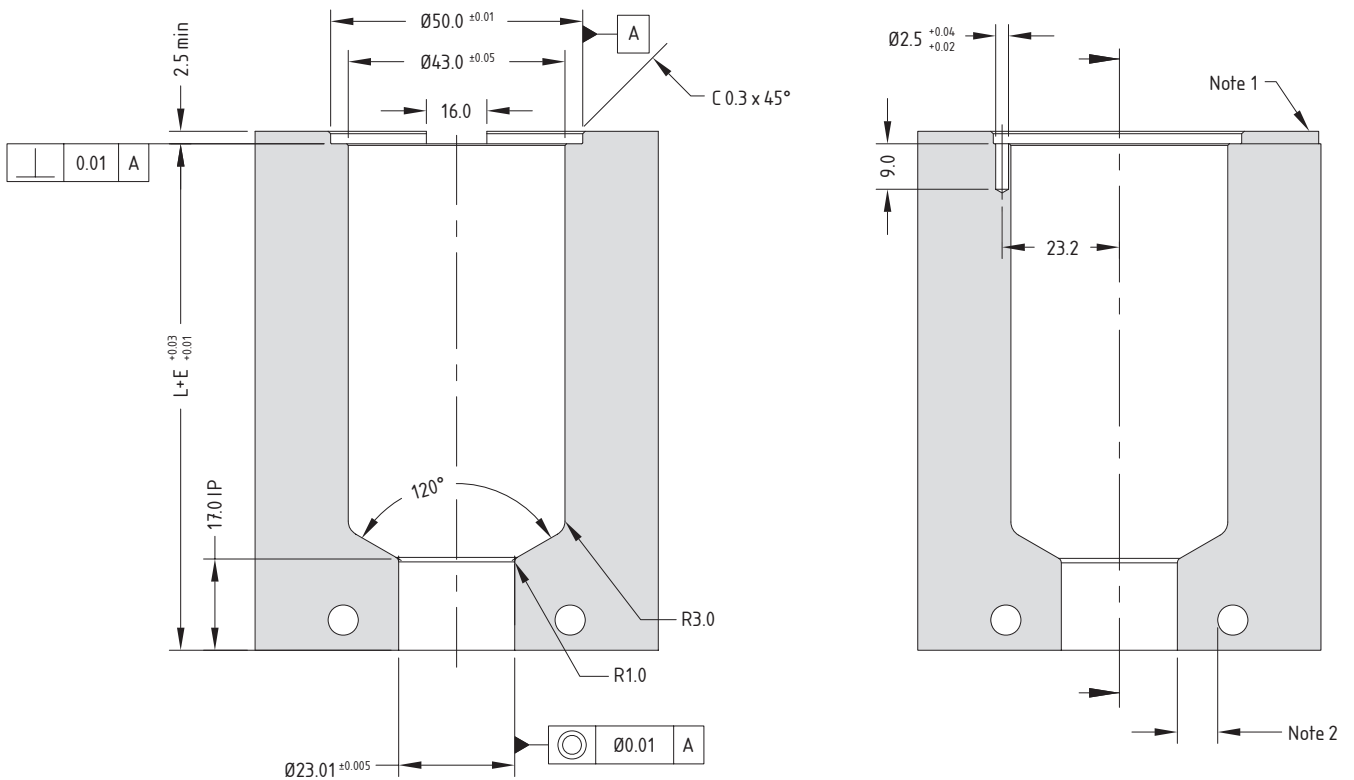
- Modify the contact area and the sprue nut to suit the application.
→ See Gate Modifications and Cooling sections in the Technical Specifications.
 - Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	Open Tip Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTSN27075	SXISN27075	SXOSN27075	80.2	0.21	0.26
SXTSN27095	SXISN27095	SXOSN27095	100.2	0.26	0.33
SXTSN27115	SXISN27115	SXOSN27115	120.2	0.32	0.40
SXTSN27145	SXISN27145	SXOSN27145	150.2	0.40	0.50
SXTSN27175	SXISN27175	SXOSN27175	180.2	0.48	0.59
SXTSN27225	SXISN27225	SXOSN27225	230.2	0.61	0.76
SXTSN27275	SXISN27275	SXOSN27275	280.2	0.74	0.93

Nozzle Fitment and Gate Dimensions

$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$



Note

1. Wire channel to suit mould.
 2. Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 3. Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 27 TT)	✓	✓	✓
One-hole Torpedo Tip (X 27 IT)	✓	✓	✓
Open Tip (X 27 OT)	✓	✗	✓

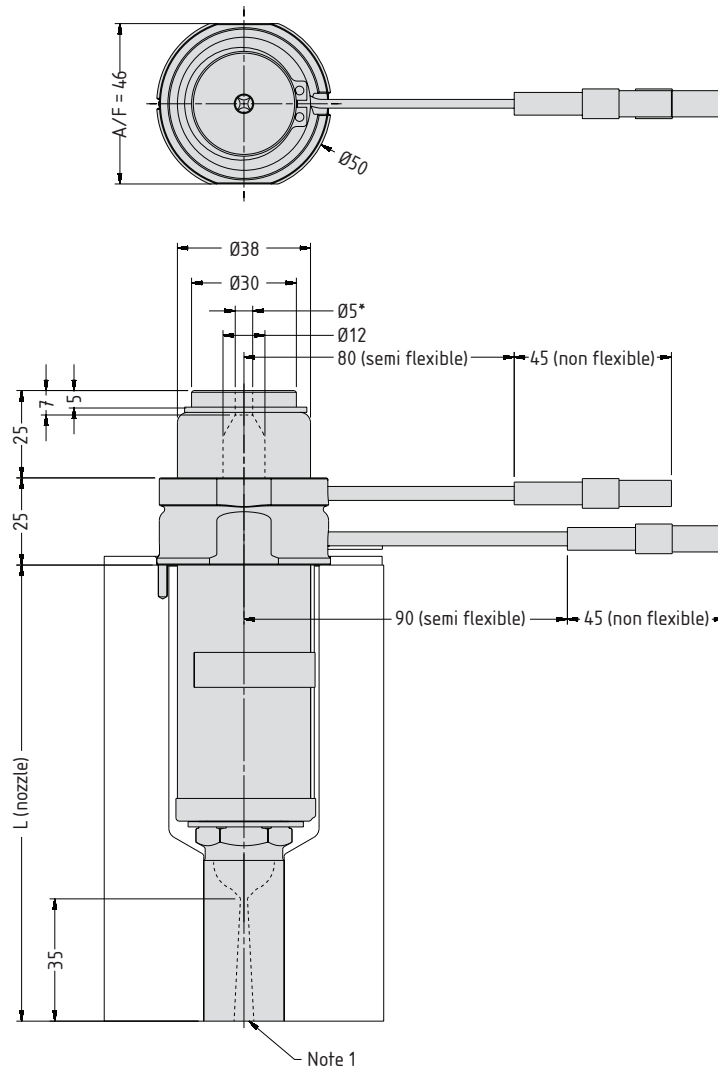
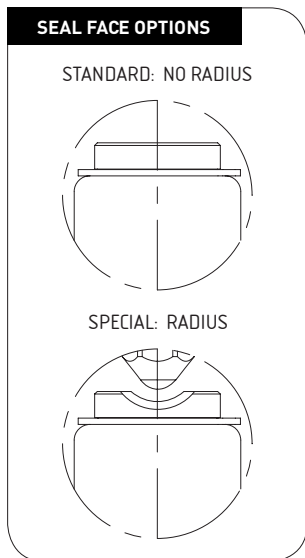
To order a nozzle assembly:

Provide the Nozzle Code + Grade
(Order example: SXISL27175 G5)

To order a tip:

Provide the Tip Code + Grade
(Order example: X 27 IT G5)

Nozzle Dimensions



Note

1. Modify the contact area and the sprue nut to suit the application.
→ See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.

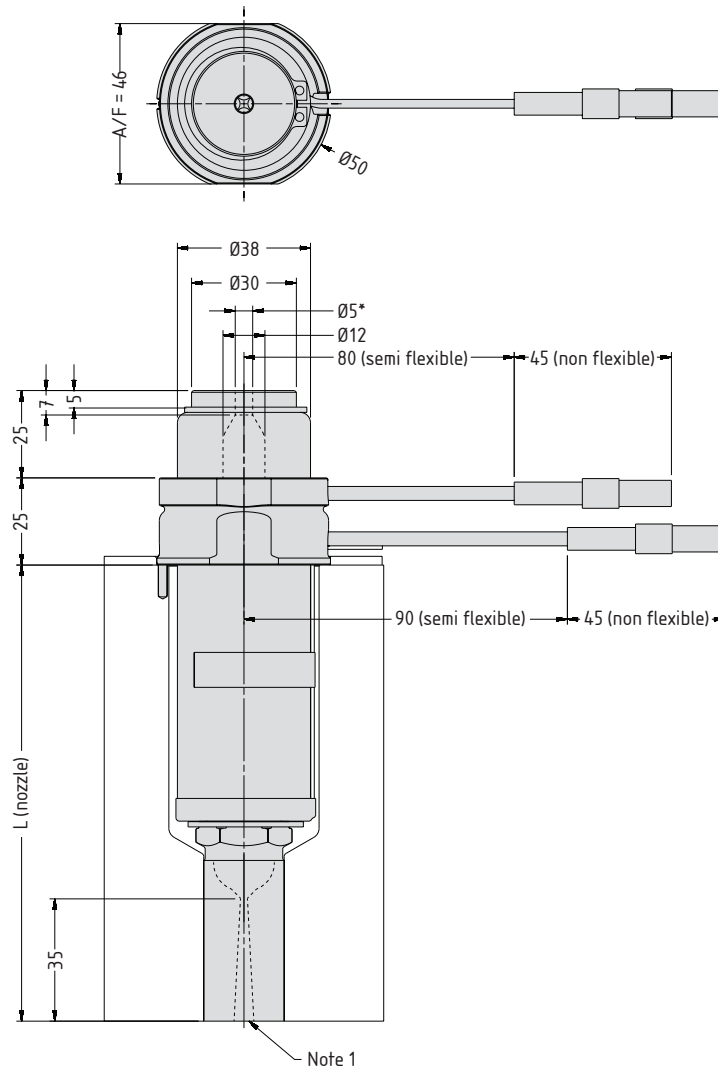
Nozzle Dimensions

Style	A	B
P7	50	Contact Mastip
P4	53	
N3	60	

To order a nozzle assembly:

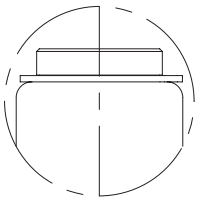
Provide the Nozzle Code + Style
(Order example: SXYCN27175 P4)

Refer to the System Selection Guide for selecting the appropriate material specific nut (P7, P4 or N3) profile.

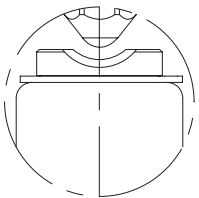


SEAL FACE OPTIONS

STANDARD: NO RADIUS



SPECIAL: RADIUS



Note

1. Modify the contact area and the sprue nut to suit the application.
→ See Gate Modifications and Cooling sections in the Technical Specifications.
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
 - * Open to suit machine nozzle size.

Tip and Material Grade Availability

Tip (Code)	G1	G2	G5
Multi-hole Torpedo Tip (X 27 TT+10)	✓	✓	✗
One-hole Torpedo Tip (X 27 IT+10)	✓	✓	✗
Open Tip	✗	✗	✗

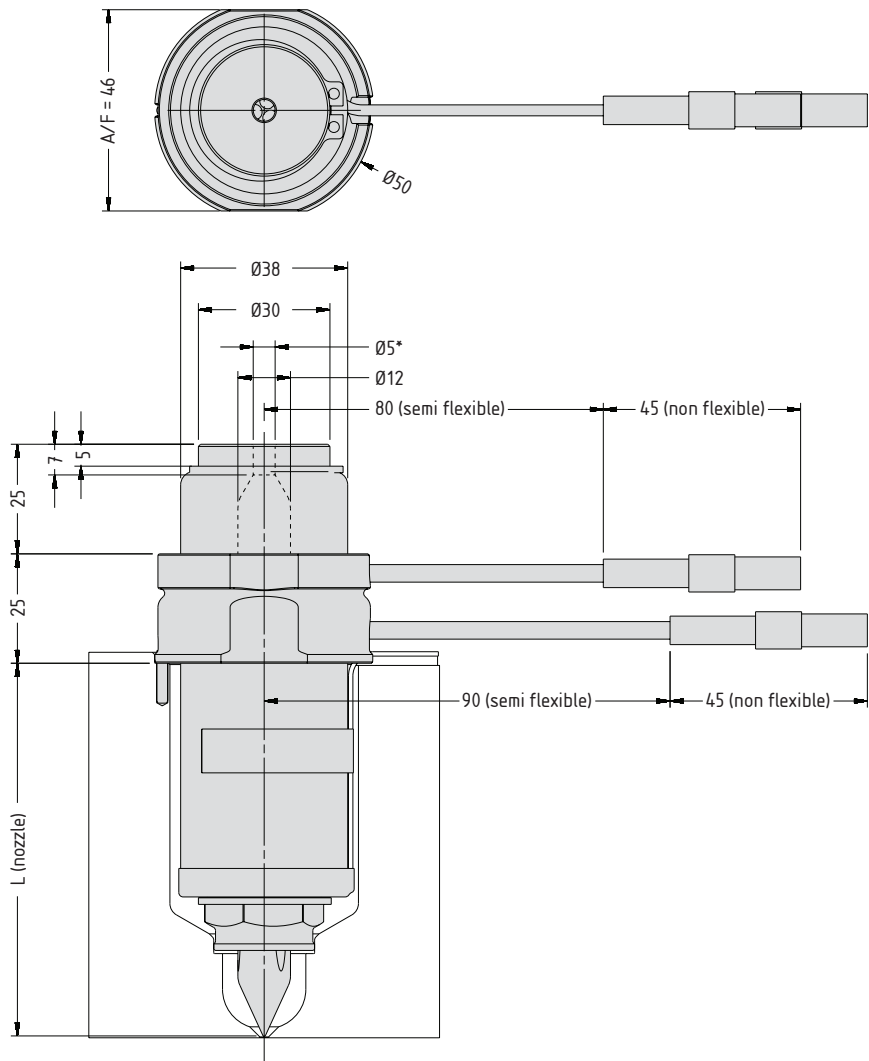
To order a nozzle assembly:

Provide the Nozzle Code + Grade
(Order example: SXIT27175+10 G2)

To order a tip:

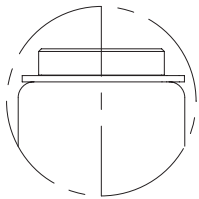
Provide the Tip Code + Grade
(Order example: X 27 IT+10 G2)

Nozzle Dimensions

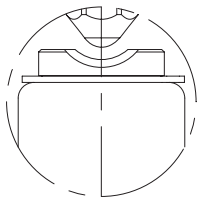


SEAL FACE OPTIONS

STANDARD: NO RADIUS

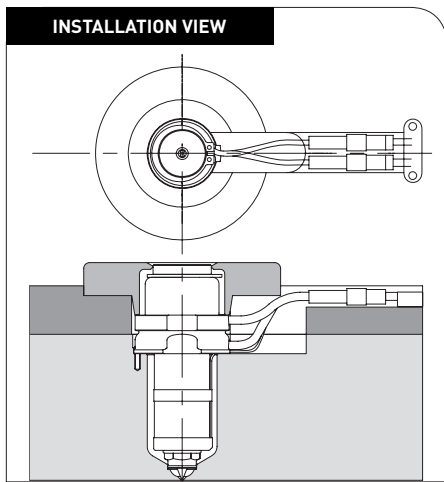


SPECIAL: RADIUS



Note

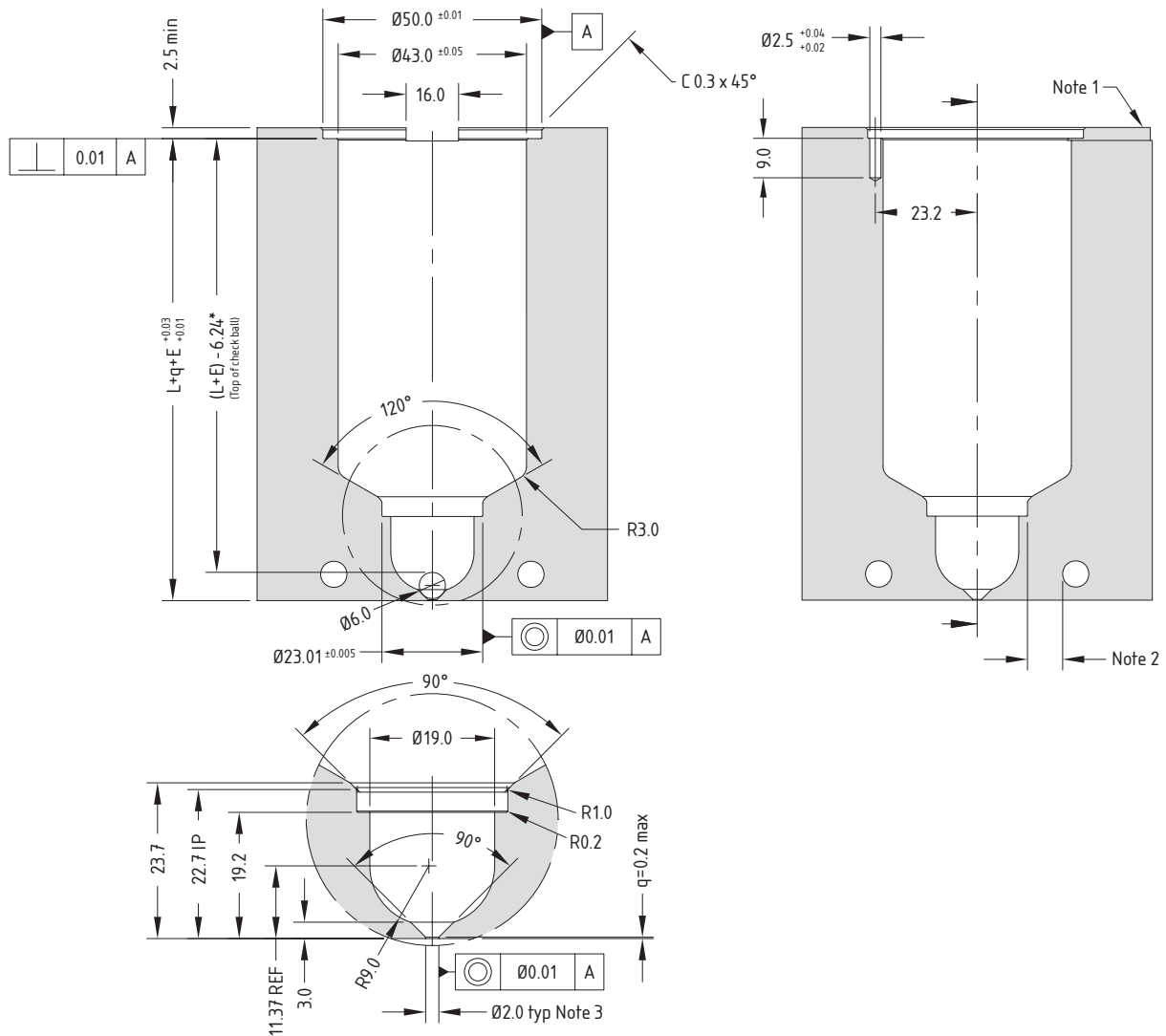
- Before restarting the nozzle remove any plastic residue from nozzle seal face to avoid damaging the nozzle.
- * Open to suit machine nozzle size.



Multi-Hole Torpedo Nozzle Code	One-hole Torpedo Nozzle Code	L	E@ΔT =200C	E@ΔT =250C
SXTT27075+10	SXIT27075+10	85	0.22	0.28
SXTT27095+10	SXIT27095+10	105	0.28	0.35
SXTT27115+10	SXIT27115+10	125	0.33	0.41
SXTT27145+10	SXIT27145+10	155	0.41	0.51
SXTT27175+10	SXIT27175+10	185	0.49	0.61
SXTT27225+10	SXIT27225+10	235	0.62	0.78
SXTT27275+10	SXIT27275+10	285	0.75	0.94

Nozzle Fitment and Gate Dimensions

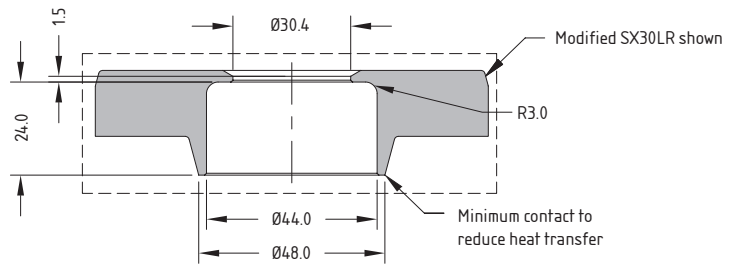
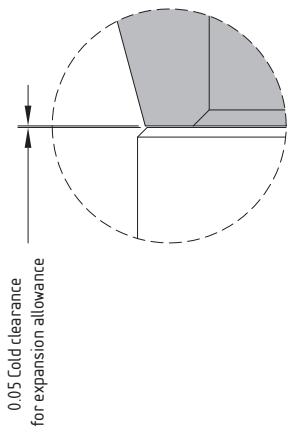
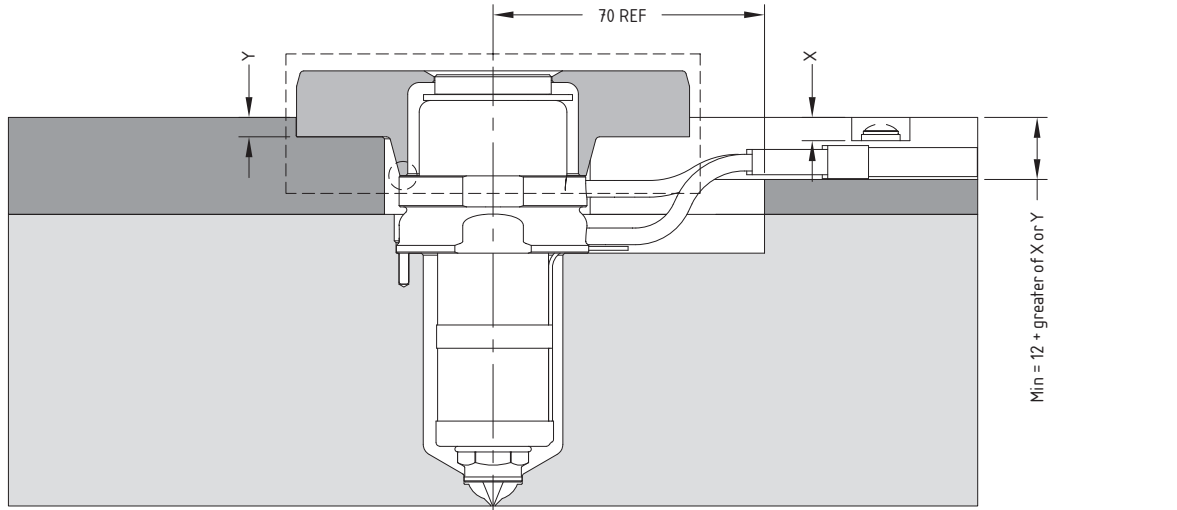
$$E = L \times 0.0000132 \times (\text{nozzle temp. } ^\circ\text{C} - \text{mould temp. } ^\circ\text{C})$$



Note

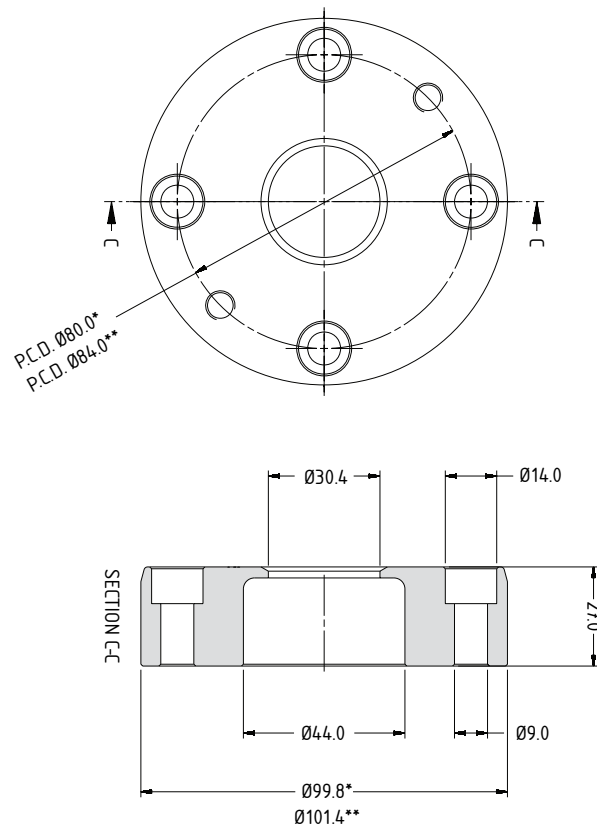
- Wire channel to suit mould.
 - Gate cooling is critical for correct operation and gate quality. → See Cooling section in Technical Specifications.
 - Modify gate diameter and land to suit the part. → See Gate Modifications in Technical Specifications.
- Minimum strength (σ_y) of nozzle plate 800MPa.
- * With 0.9 gate, +0.05mm per 0.1mm increase in gate diameter.

Installation Example



All other dimensions and details to suit mould design

Locating Rings



Note

- Locating Ring may require finishing to suit mould.
- Go to www.mastip.com to download the CAD Model.
- * Order Code SX30LR-METRIC
- ** Order Code SX30LR-IMPERIAL



Mastip Head Office New Zealand

Physical Address

558 Rosebank Road, Avondale
Auckland 1026, New Zealand

Postal Address

PO Box 90651, Victoria St West
Auckland 1142, New Zealand

Phone: +64 9 970 2100
Email: mastip@mastip.com

Mastip Regional Office Europe

Phone: +33 0 809 400 076
Email: europe@mastip.com

Mastip Regional Office North America

Phone: +1 262 644 9400
Email: northamerica@mastip.com

Mastip Regional Office China

Email: china@mastip.com

For a full list of Distributors,
please visit www.mastip.com