

Machine Shut Off Nozzles 82 Filtering & Mixing Nozzles





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Filtering & Mixing Nozzles **Machine Shut Off Nozzles**

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Recover Quicker for a Faster Cycle

Eliminate Drooling Caused by Back Pressure

No More Plugged Gates - 2021

Filter & Mix Resin Before Shot Enters the Mold

Machine Shut-Off (MSO)



MSO - MACHINE SHUT OFF



MSO - MACHINE SHUT OFF



NOTE: For sizes other than shown, please contact Osco Tech Service.

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* Note: The information given here should be used as a guide. A variation in growth of any nozzle from the formulation is possible due to cooling conditions or mold configuration. It is advisable to allow a margin of safety. For some very critical applications, an empirical factor may have to be obtained.

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DUO-FLO FILTERS

UNFILTERED MATERIAL FLOW

(FROM MACHINE BARREL)

Filter and Mix the Resin for a More Homogeneous Melt Before the Shot Enters the Mold

Two-Stage Filtration of Contaminaints

- Totally eliminate downtime from plugged gates.
- A MUST for uninterupted service.
- Easy to clean and reuse.
- Better color mixing.



First Stage Filtering

Material Flows into the center of the core and is directed outward through the many Ø1/16" holes. The holes prevent large particles of contaminant from continuing on with the material, trapping it in the center of the core.

- Two Stages
- Linear Filtering
- More Homogeneous Melt
- **Replaceable Filter Core**

Second Stage Filtering

Material Flows over the .020" or .040" linear relief ribs and into the supply channels. The linear relief runs the entire supply channel length, preventing secondary particles from reaching the nozzle.

DUO-FLO FILTERS



						ASSEMBLY INCLUDES			
FILTER SIZE	MACHINE BARREL CAPACITY	UNIT CATALOG NUMBER	SCREEN CORE GAUGE	FILTERING AREA (SQ. IN.)	ORDER #	SCREEN CORE CATALOG NUMBER	HEATER DESCRIPTION AND CATALOG NUMBER	THERMOCOUPLE DESCRIPTION AND CATALOG NUMBER	
S-20	UP TO 18 OUNCES	AFILA12	.020	1.037	SFS20	DAFILSCN12	BH-FIL-3530 DHAF03500300625048T	FTC/250-28 x 48" DUF250280048	
		AFILA14	.040	1.265	SFS40	DAFILSCN14			
B-20	18 OUNCES AND GREATER	AFILA22	.020	1.466	LFS20	DAFILSCN22	BH-FIL-3550 DHAF03500501200048T		
		AFILA24	.040	1.791	LFS40	DAFILSCN24			
HOW TO ORDER									
Specify: • Complete Units - Specify Unit Catalog Number									

Replacement Parts - Specify Onlit Catalog Number

For Thread Sizes Other Than Shown, Please Contact OSCO Technical Support.



Installation Instructions:

1.) Remove Nozzle from Machine Barrel.

- 2.) Clean Barrel threaded areas.
- 3.) Secure Filter Assembly to Machine Barrel

4.) Install and Tighten the Machine to the Duo-Flow Filter, using high heat grease on threaded areas.

5.) Connect Heater and Thermocouple (Type "J") to an adequate temperature controller. Wait for proper molding temperature to be reached at the unit and purge through.

6.) Any increase on pressure drop is an indication that the filter needs cleaning. Refer to cleaning instructions.

Cleaning Instructions:

To clean the filtering screen, remove front plug and purge machine barrel. Screen will be forced to come out. Remove plastic and contaminants from screen.

CAUTION: Before purging machine barrel, be sure filter heater is on and the plastic within, is at molten temperature.

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