



Press release

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PRIAMUS Fill with automatic shot-off nozzle control

Today a variety of possibilities to control the melt front in hotrunner molds are widely used. A temperature sensor in the cavity detects automatically a temperature rise when the melt reaches the sensor position. If the melt flow in the cavities changes because of viscosity variations, it will be compensated by adjusting automatically the nozzle temperatures. Thus sequential molding applications can be controlled, weld lines can be selectively moved and multi cavity molds can be balanced automatically.

Especially with slow acting hotrunner systems it may occur that an adjustment of the nozzle temperatures is not efficient to achieve a balanced cavity condition. For such situations an additional control algorithm has been added to the Priamus Fill system in order to control the melt flow alternatively by the shot-off nozzles. The different flow behavior of the individual cavities is being compensated by adjusting automatically the delay time to open the nozzles. This new procedure allows for example to balance and control liquid silicone applications which become more and more important in injection molding. Unlike traditional thermoplastic injection molding, the liquid silicone process knows even more prominent flow differences which have to be balanced. The new procedure optimizes the process automatically and prevents the liquid silicone parts of reacting under different condition which leads inevitable to different parts.

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