HOTSYS HOTRUNNER SYSTEM

HRS supplies exchange cycle & Warranty Manual

HOTSYS R&D CENTER

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HOTSYS
HOT RUNNER TOTAL SOLUTION

HRS supplies exchange cycle & Warranty

HRS supplies : Parts to be replaced regularly due to wear and aging

HRS Supplies	Section	Warranty	HRS Usage Environment	Remark
Heater& Sensor	Nozzle	1 Year	1. Recommend using a controller with Soft-Start function 2. Usage voltage : 220V±10% 3. Heater insulation resistance : Over 50MaΩ	Insulation resistance may be destroyed by moisture in the atmosphere during standby and shutdown . Please be aware of the system management.
	Manifold	1 Year		
	Sprue Bush	1 Year		
Valve Pin& Pin Guide	Slide Operation (Warranty is applied first item to be expired between period and number of operation)	6 Month / 40,000 Shot	higher grade flame retardant (Grade V0) / More than GF30%	When using the flame retardant, share the prior information. Appropriate corrosion protection measures should be taken for the materials concerned As wear varies depending on the amount of additives, check the wear condition during regular inspection to determine if parts are exchanged
		1 Year / 60,000 Shot	Less than GF30% / Special additives	
		1 Year / 150,000 Shot	Inj temp over 300℃, No additive	
		1 Year / 300,000 Shot	Inj temp under 250℃~300℃, No additive	
		1 Year / 500,000 Shot	Inj temp under 250℃, No additive	
O-Ring	Air Piston actuating parts	50,000 times	Mold temp conditions over 70℃	Unable to guarantee as non-HOTSYS production (in-market purchase)
		100,000 times	Mold temp conditions Less than 70℃	
Sol. valve	Air Piston actuating parts	100,000 times	1. Mold temp conditions Less than 70℃ 2. Pneumatic pressure is base on 8bar, 3. The air used shall not contain impurities or moisture.	
Manifold& Nozzle	Basic parts	Semi-permanent (Can not be guranteed "Warranty Exception according to HRS use environmet ")	1. This is a condition in which sequential control is not used. 2. When using sequential control, the warranty period cannot be guaranteed due to overpressure.	Max permissible pressure : 1800bar
Nozzle Guide	Assembly with Mold	2 Year	Compliance with the criteria of the tolerances indicated on the drawings.	Max permissible pressure : 1300bar
MOLD BASE	Assembly with HRS		If the thickness indicated on the drawing is not within the tolerance, the quality assurance for leakage cannot be provided.	Attention to tolerance and deformation of PLATE

HRS supplies exchange cycle & Warranty Exception according to hrs use environmet

1. Damage caused by incorrect assembly of Mould and Hot runner system (Incorrect wiring, Overvoltage, Overpressure, Water leak or Oil leak, Use non-specified parts)
2. Damage and scratches caused by valve pin operation without system heating sufficiently.
3. Problem due to unguaranteed use of temperature controller
4. Damage caused by excessive force on the HRS while not fully melting. (Wait about 30 minutes after reaching the set temperature to allow the completely dissolved resin to flow before purging at a pressure of not more than 50 bar. Then the injection starts when normal purges are made.)
5. Problems with overheating, carbonation caused by incorrect thermocouple type(I.C,(J) C.A(K) TYPE) settings
6. Problems caused by user's arbitrary use of unsuitable parts (non-HOTSYS standard parts)
7. Problems caused by excessive pressure on HRS by setting injection delay time of more than 5 seconds when using Valve Gate
8. Problem caused by the use of different resin from the order.
9. Problem caused by the use of recycled resin.
10. Problems caused by leaving HRS stationary for more than 5 minutes during injection
11. Basically, the performance of color exchange is not warrantable. (However, HRS consisting of SARS Manifold and STGE NOZZLE, which used under prior consultation, can improve performance of color Change depending on resin)
12. Damage and deformation of screws may occur during disassembly and reassembly of nozzle body and tip, and It can not be guaranteed the problem of resin leakage that may result from this.

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