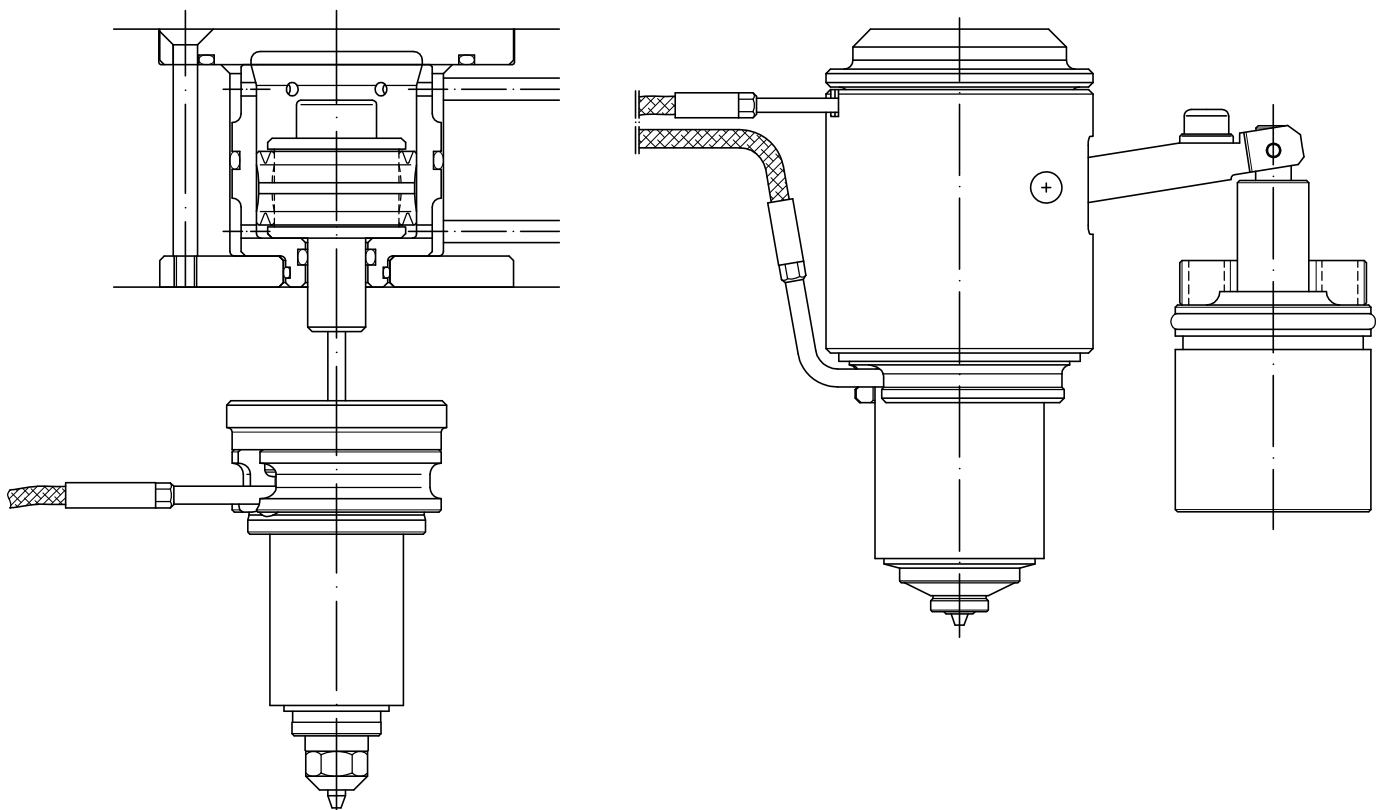


## DPO

Iniettore con otturatore centrale, singoli o multipli non lascia testimone sul pezzo ed offre le migliori condizioni di lavoro con elevati standard di qualità e ottimi riempimenti. Per piccole, medie e grandi portate.

Nozzle with central valve, leaves no witness mark on the part and offers the best working conditions with high quality standards and excellent filling. For single and multiple small, mean and high capacities.



Rev. 00

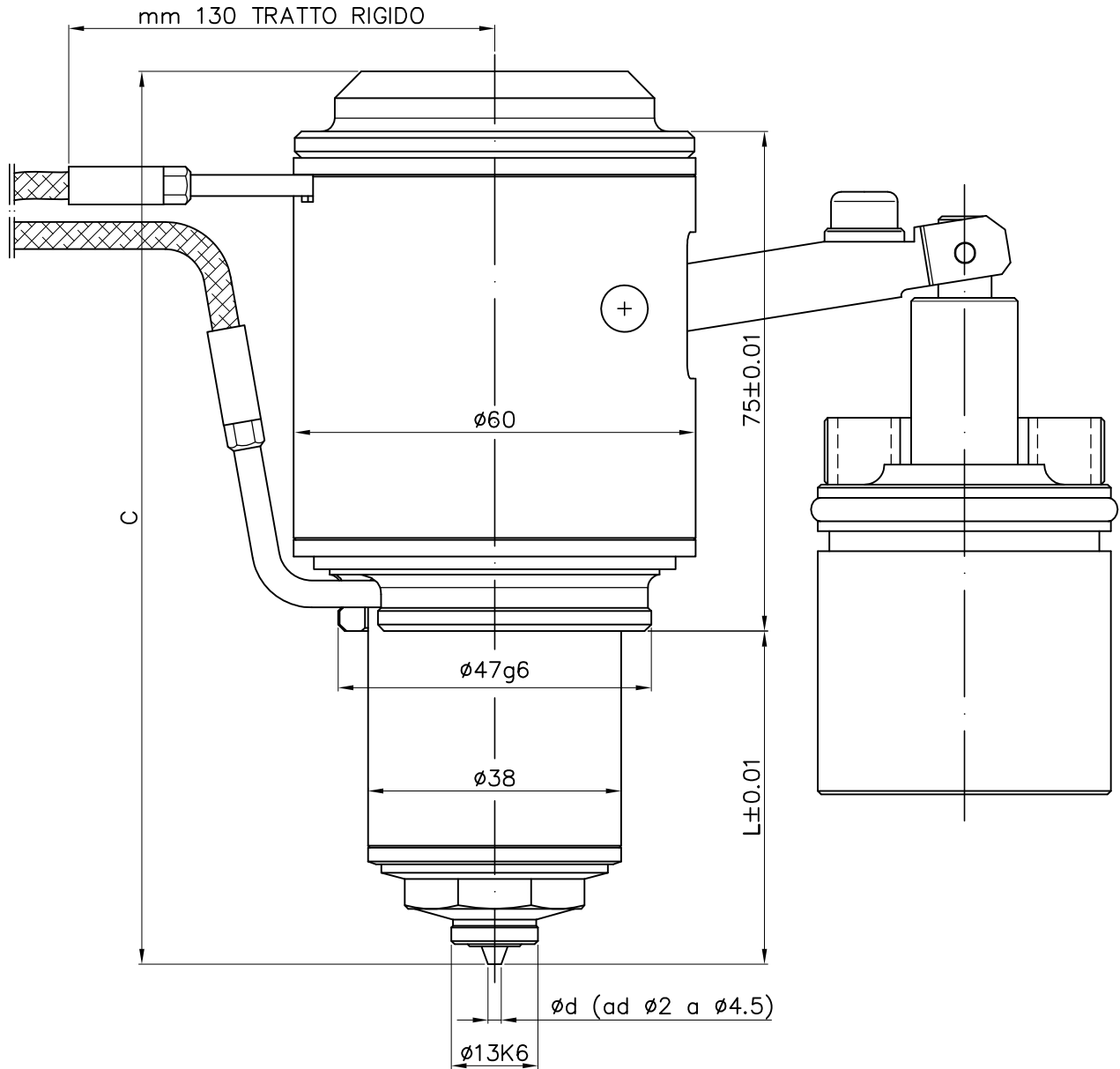
NOTE

Lined area for notes.



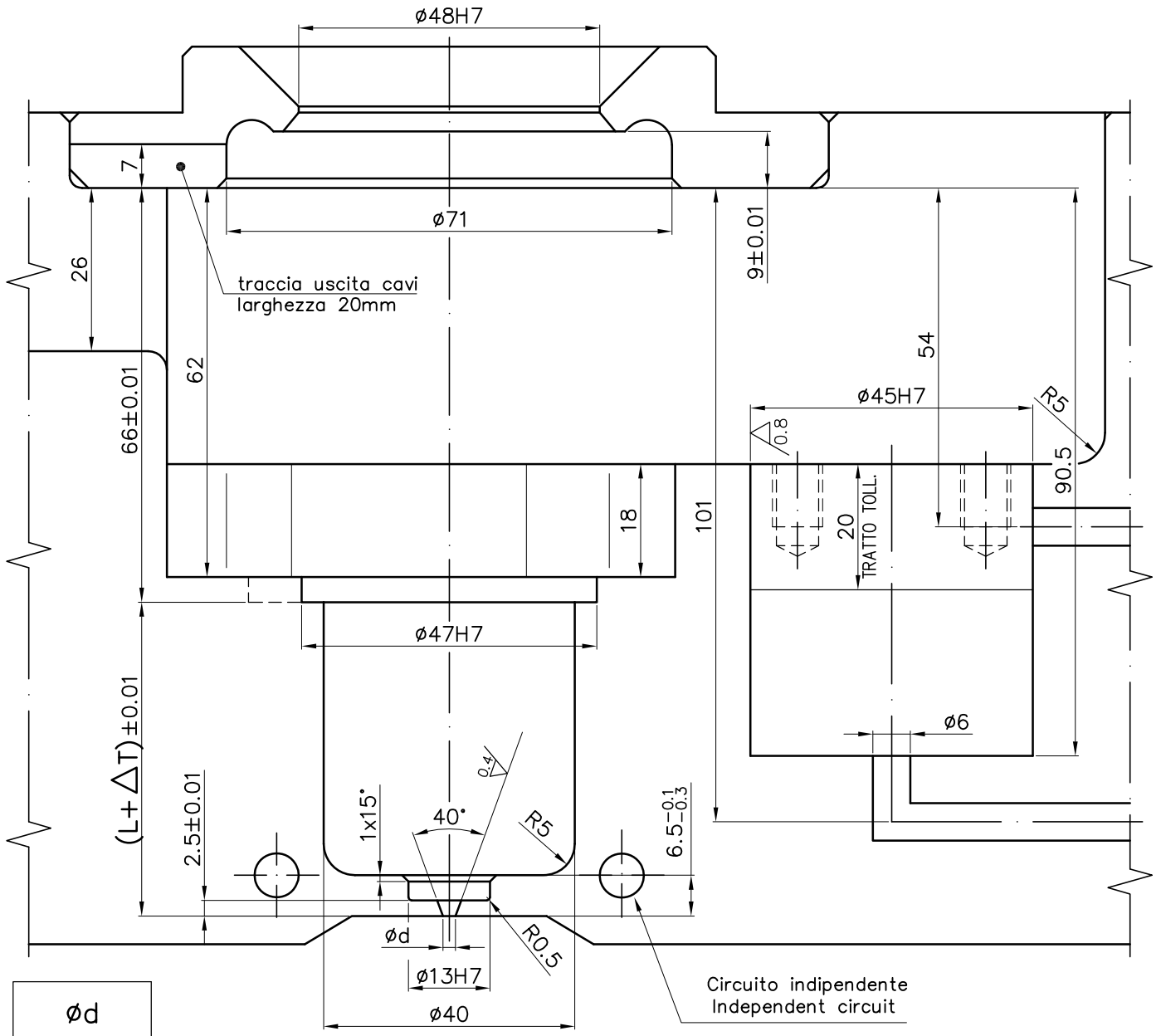
CODICE INIETTORE Nozzle code	L±0.01	C
104007T	49,84	133,84
104012T	74,77	158,77
104017T	99,70	183,70

$\Delta T$ = ALLUNGAMENTO TERMICO Heat extension					
L±0.01	175°	200°	225°	250°	300°
49,84	0,14	0,16	0,18	0,20	0,25
74,77	0,20	0,23	0,26	0,29	0,35
99,70	0,27	0,30	0,34	0,38	0,46

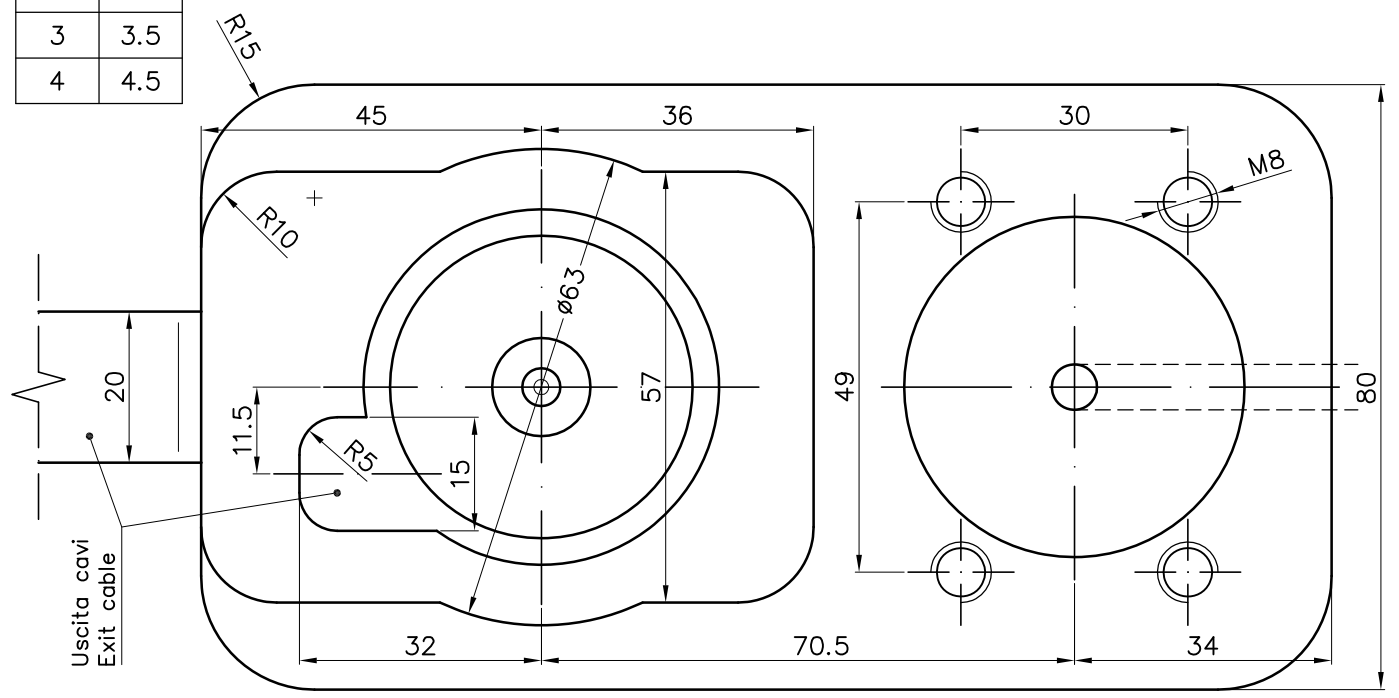


RICAMBI			Spare part	
CODICE INIETTORE Nozzle code	1 PUNZONE Valve pin	2 RESISTENZA IN FUSIONE Fusion Heater V230	3 TERMOCOPIA Thermocouple	4 CORPO INFERIORE Lower body
104007T	ZO4007	SO4007F	TEO4007	C104007
104012T	ZO4012	SO4012F	TEO4012	C104012
104017T	ZO4017	SO4017F	TEO4017	C104017

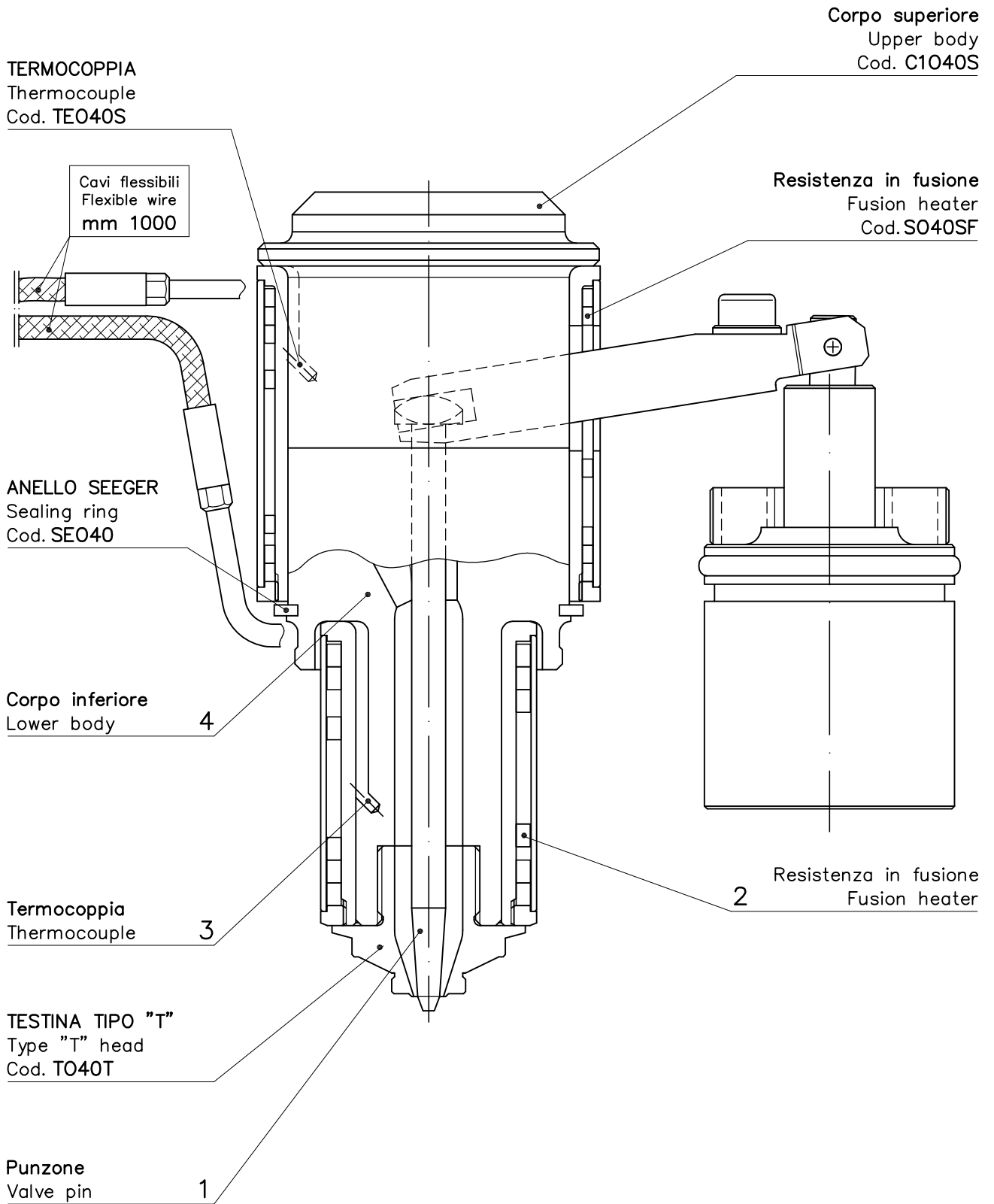
Rev. 00



$\phi d$	
2	2.5
3	3.5
4	4.5



Rev. 00

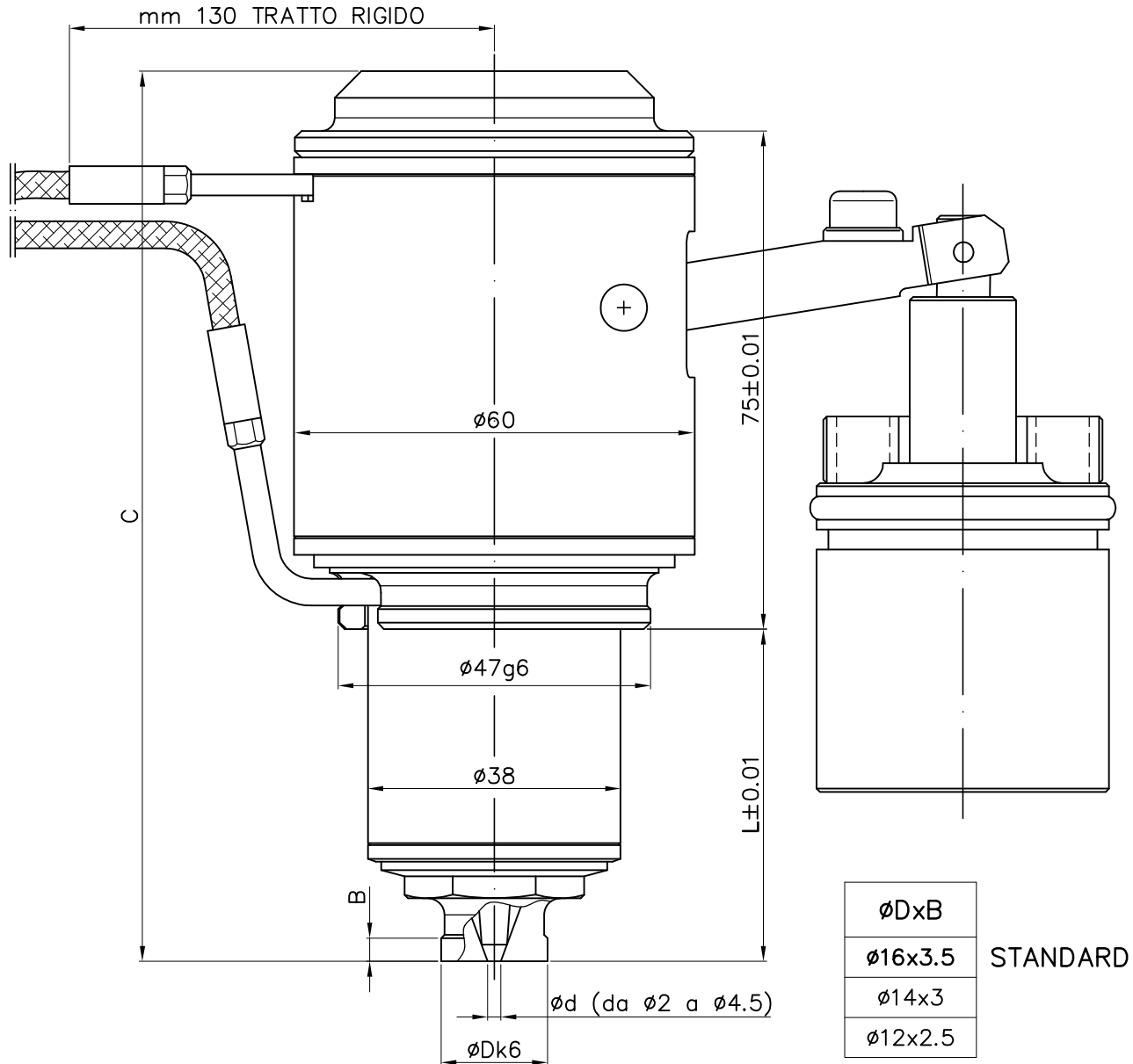


Rev. 00



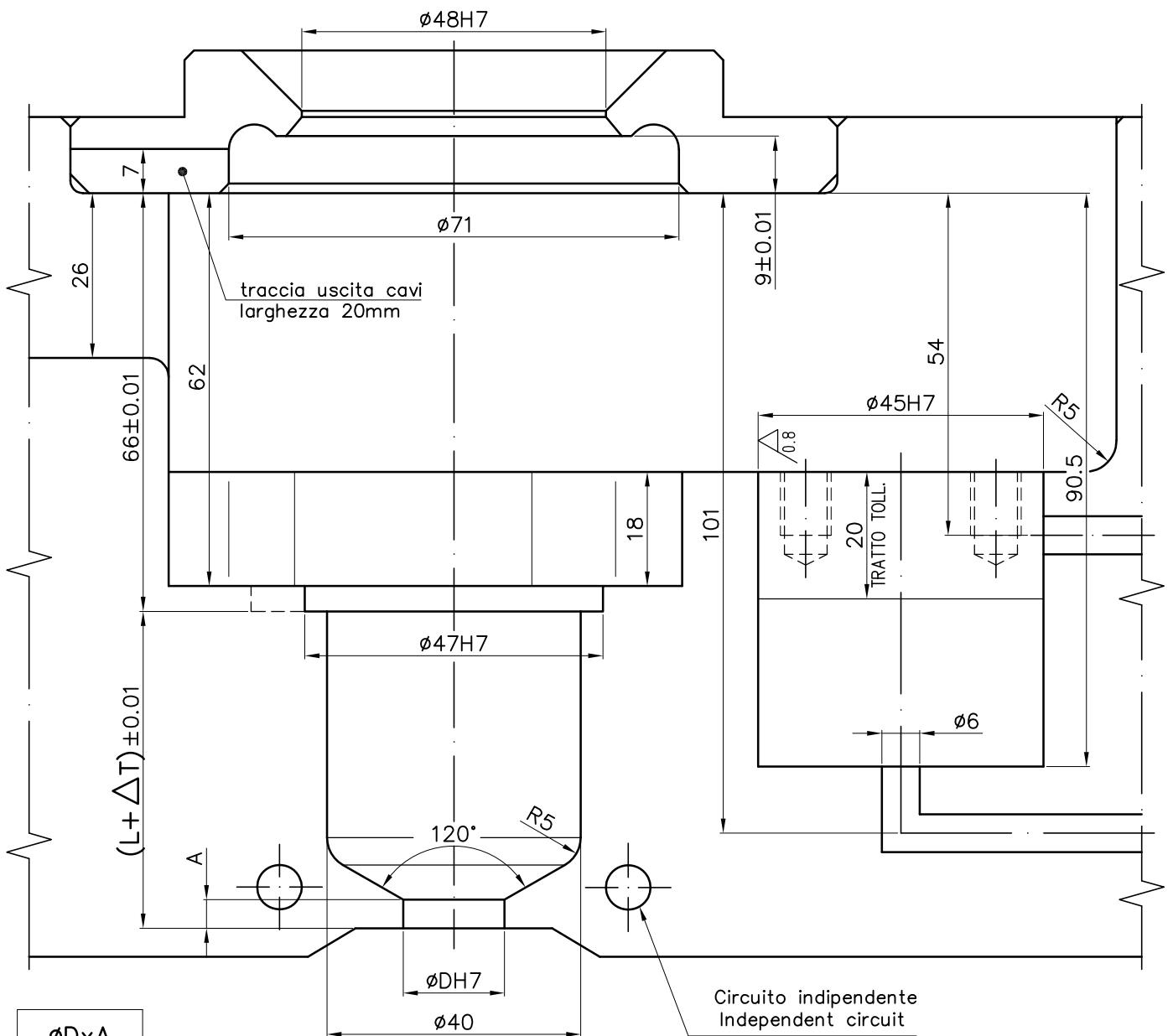
CODICE INIETTORE Nozzle code	L±0.01	C
104007B	49,84	133,84
104012B	74,77	158,77
104017B	99,70	183,70

$\Delta T$ = ALLUNGAMENTO TERMICO Heat extension					
L±0.01	175°	200°	225°	250°	300°
49,84	0,14	0,16	0,18	0,20	0,25
74,77	0,20	0,23	0,26	0,29	0,35
99,70	0,27	0,30	0,34	0,38	0,46



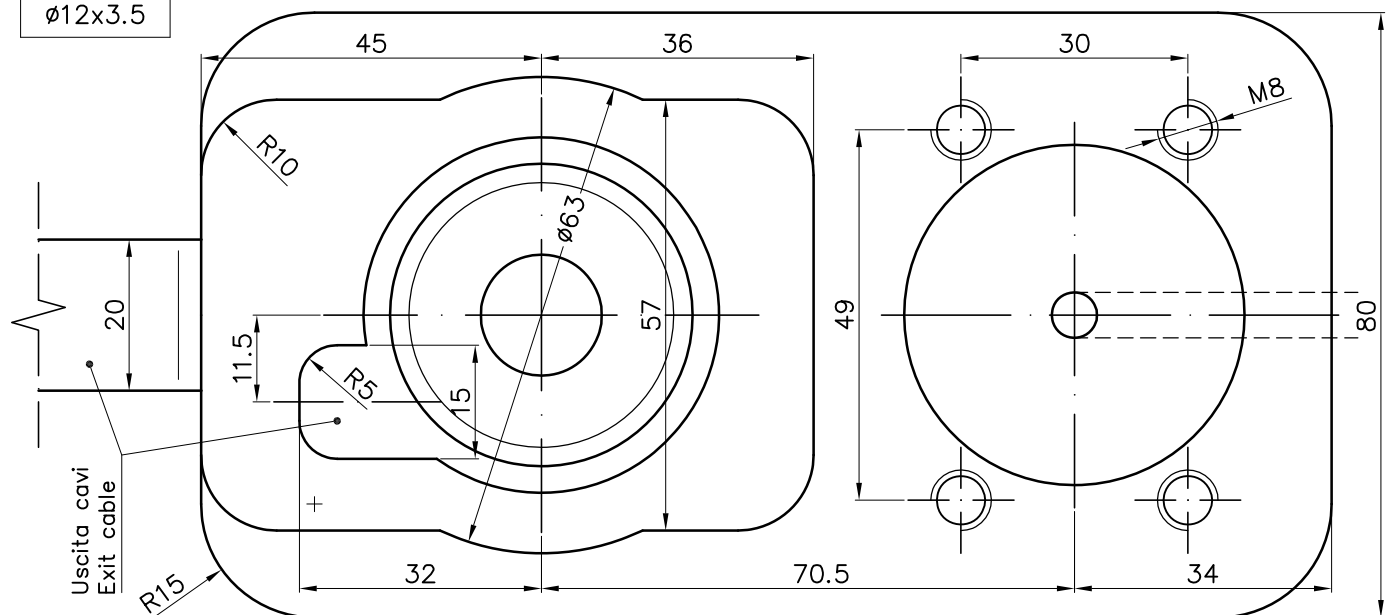
RICAMBI			Spare part	
CODICE INIETTORE Nozzle code	1 PUNZONE Valve pin	2 RESISTENZA IN FUSIONE Fusion Heater V230	3 TERMOCOPPIA Thermocouple	4 CORPO INFERIORE Lower body
104007B	ZO4007	SO4007F	TEO4007	C104007
104012B	ZO4012	SO4012F	TEO4012	C104012
104017B	ZO4017	SO4017F	TEO4017	C104017

Rev. 00



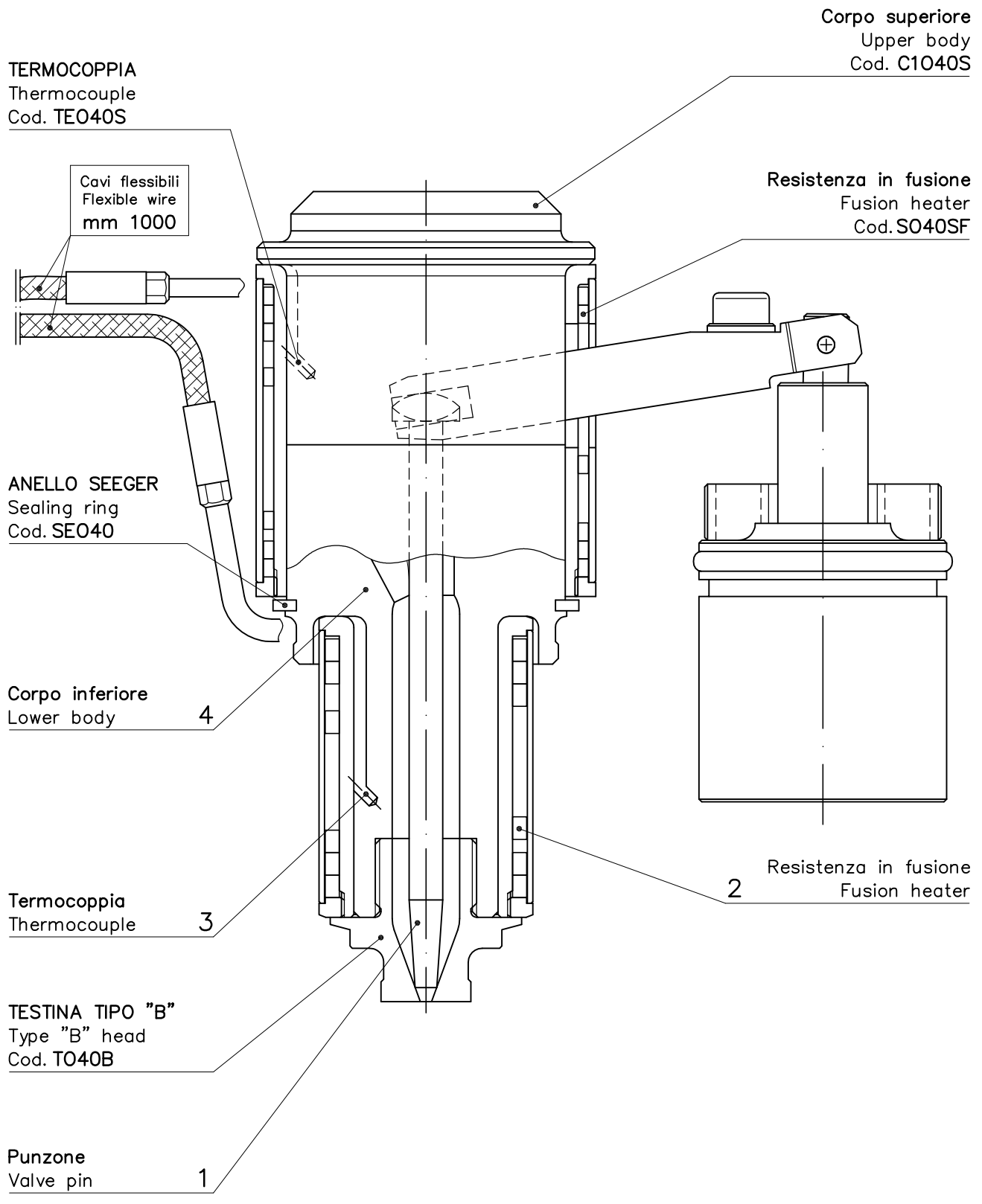
$\phi D \times A$
$\phi 16 \times 4.5$
$\phi 14 \times 4$
$\phi 12 \times 3.5$

STANDARD



Rev. 00





Rev. 00



Via Giuseppe di Vittorio, int. 5/5 - 50145 Firenze - Italia  
Telefono +39 055 316053 r.a. - Fax +39 055 373940

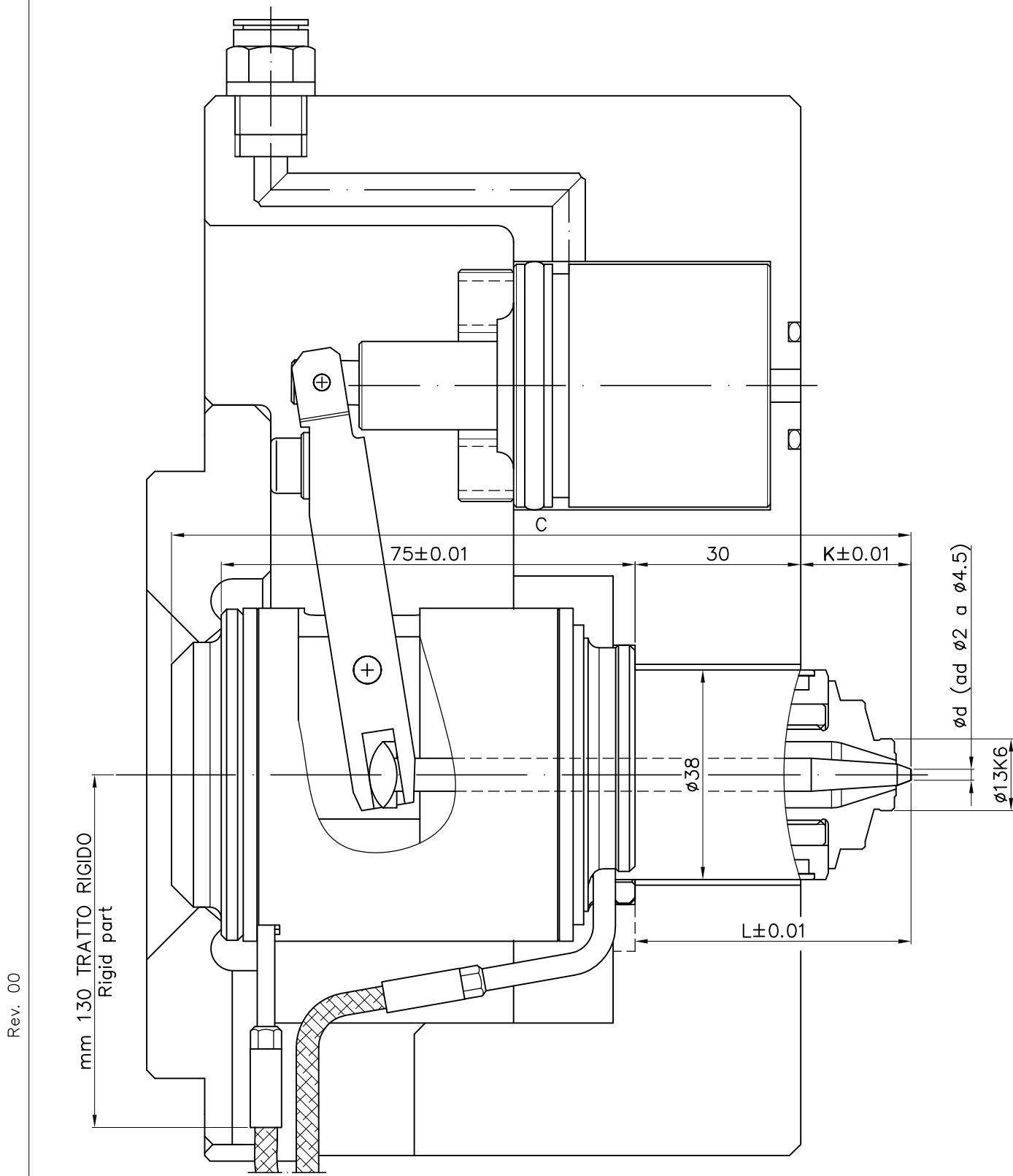
www.asso.it  
tecnico@asso.it - commerciale@asso.it

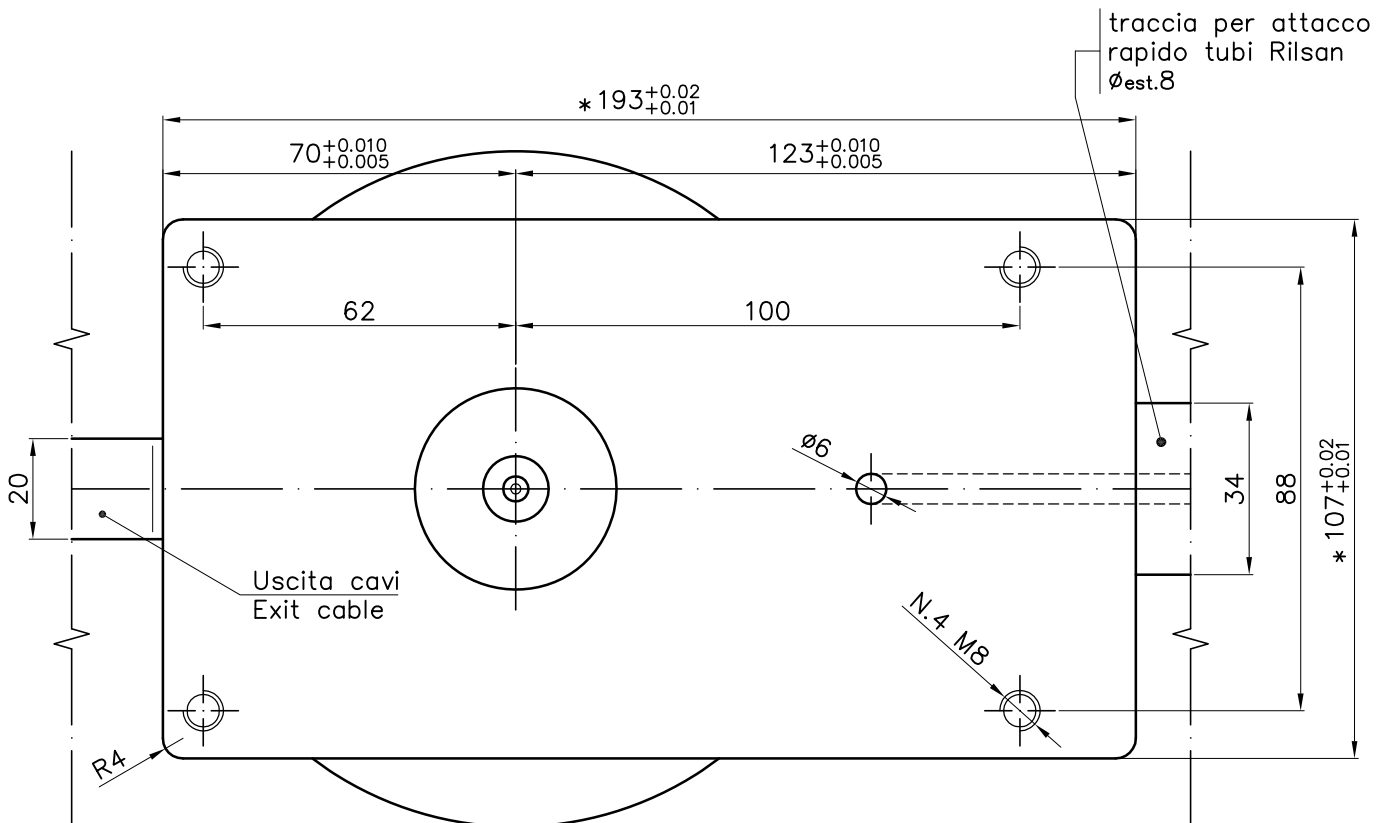
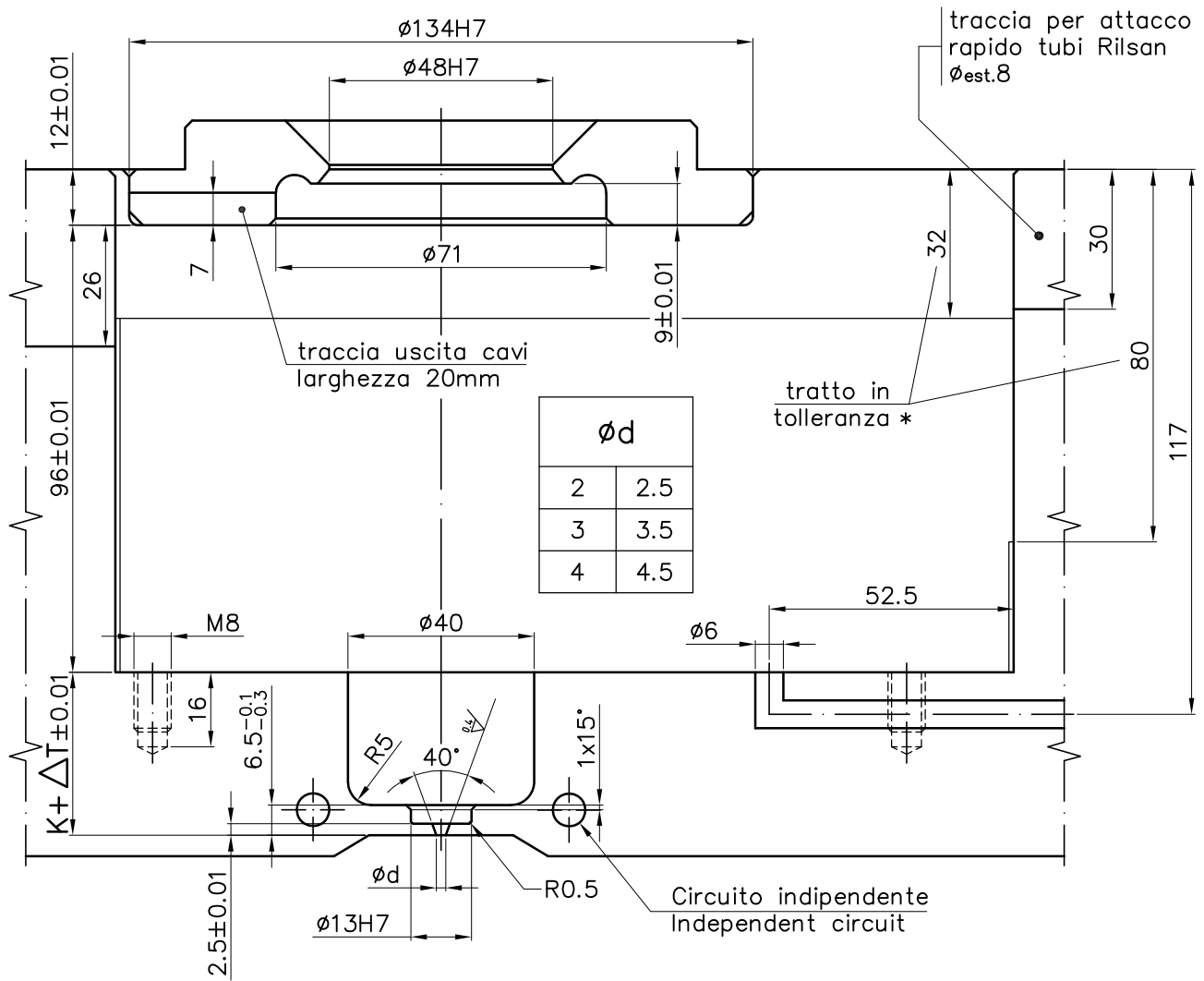


CODICE INIETTORE Nozzle code	$K \pm 0.01$	$L \pm 0.01$	C
104007TBL	19,84	49,84	133,84
104012TBL	44,77	74,77	158,77
104017TBL	69,70	99,70	183,70

$\Delta T$  = ALLUNGAMENTO TERMICO  
Heat extension

$K+30$ $\pm 0.01$	175°	200°	225°	250°	300°
49,84	0,14	0,16	0,18	0,20	0,25
74,77	0,20	0,23	0,26	0,29	0,35
99,70	0,27	0,30	0,34	0,38	0,46

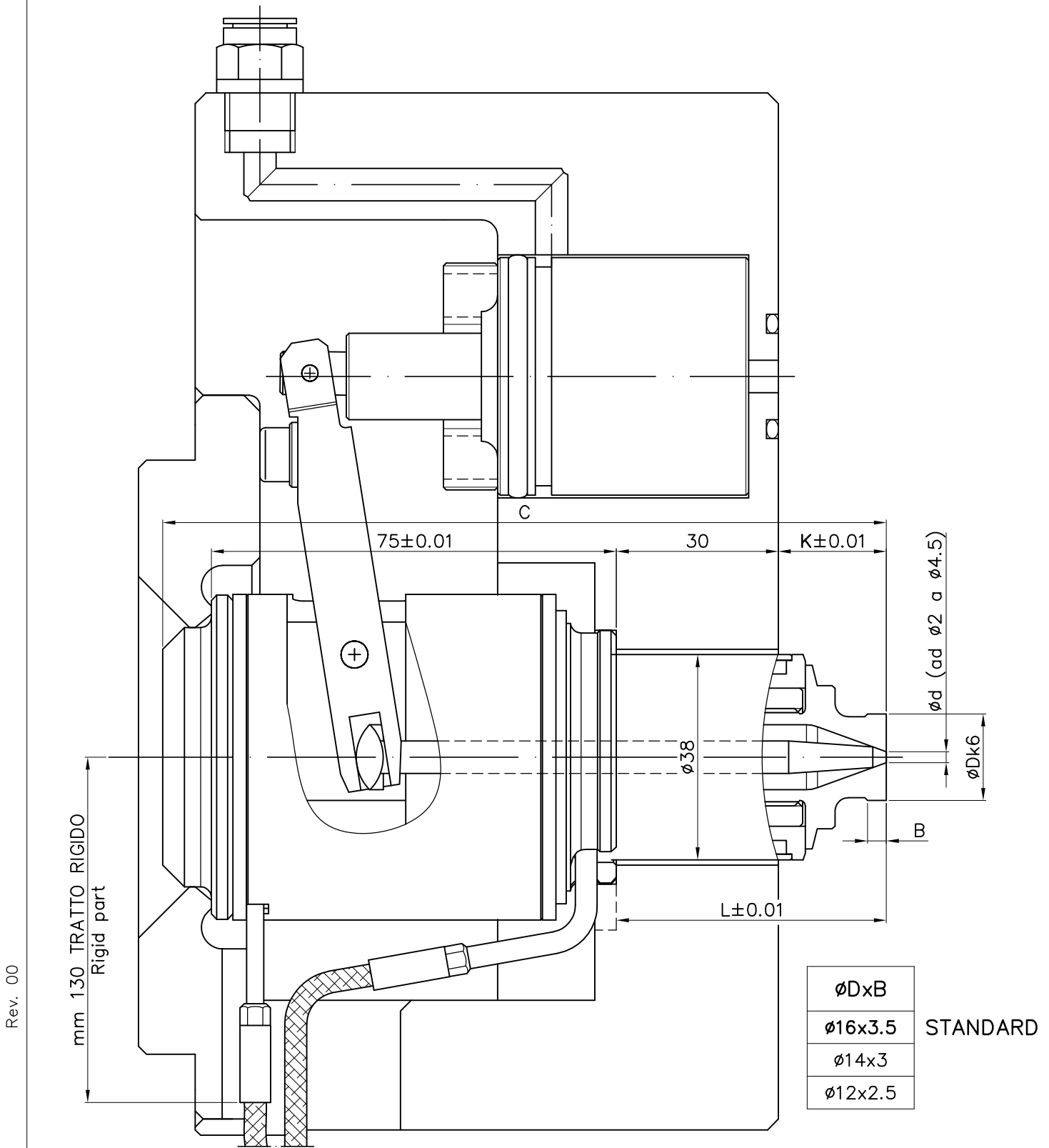


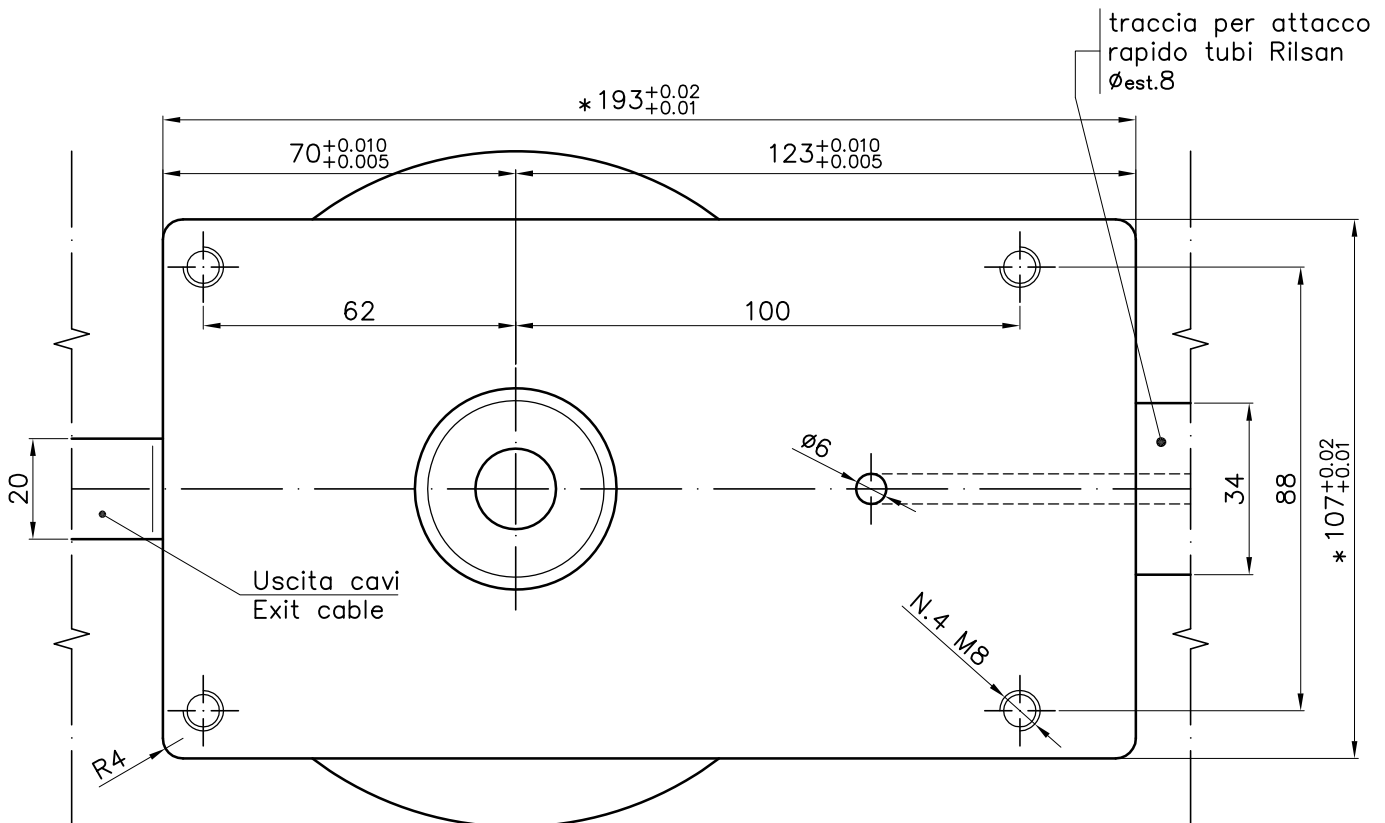
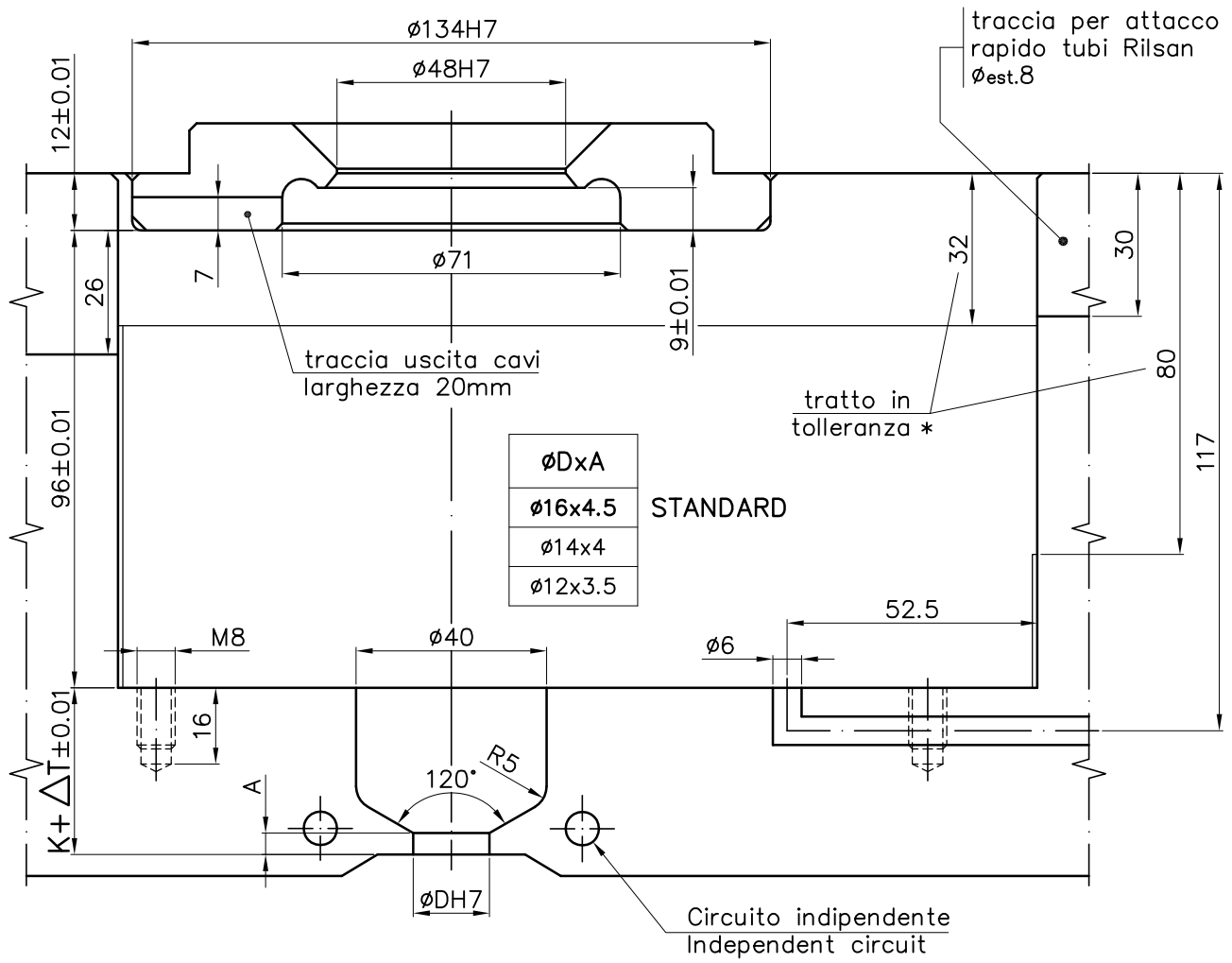


Rev. 00

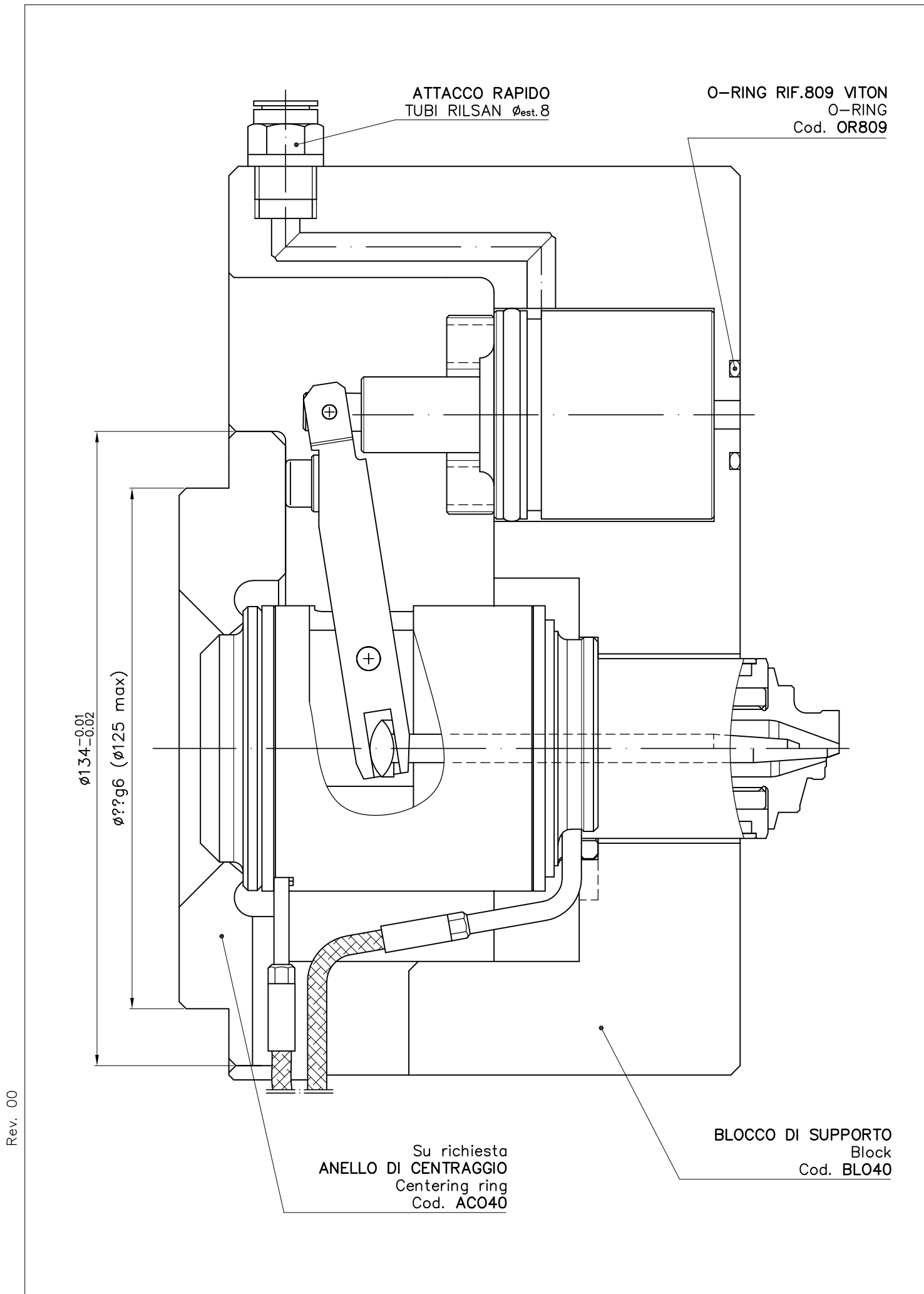
CODICE INIETTORE Nozzle code	K±0.01	L±0.01	C
104007BBL	19,84	49,84	133,84
104012BBL	44,77	74,77	158,77
104017BBL	69,70	99,70	183,70

$\Delta T$ = ALLUNGAMENTO TERMICO Heat extension					
K+30 ±0.01	175°	200°	225°	250°	300°
49,84	0,14	0,16	0,18	0,20	0,25
74,77	0,20	0,23	0,26	0,29	0,35
99,70	0,27	0,30	0,34	0,38	0,46





Rev. 00



**PERNO + SEEGER**

Pin + seeger  
Cod. PEO40  
Seeger 2.3 UNI 7434-75

**VITE TCCE M6x6**

Screw  
Cod. VO606

**RONDELLA**

Seal ring  
Cod. RO612

**SPINA 5x25 UNI 1707**

Pin  
Cod. S0525

**LEVA**

Lever  
Cod. LO40

**O-RING RIF.129**

O-RING  
Cod. OR129

**CILINDRO**

Cylinder  
Cod. CIO40

**O-RING RIF.029**

O-RING  
Cod. OR029

**STELO**

Stem  
Cod. ST040

**VITE TCCE M8x25**

Screw  
Cod. VO825

**O-RING RIF.809**

O-RING  
Cod. OR809

**PIASTRINA**

Small plate  
Cod. PA040

**SPINA 3x30 UNI 1707**

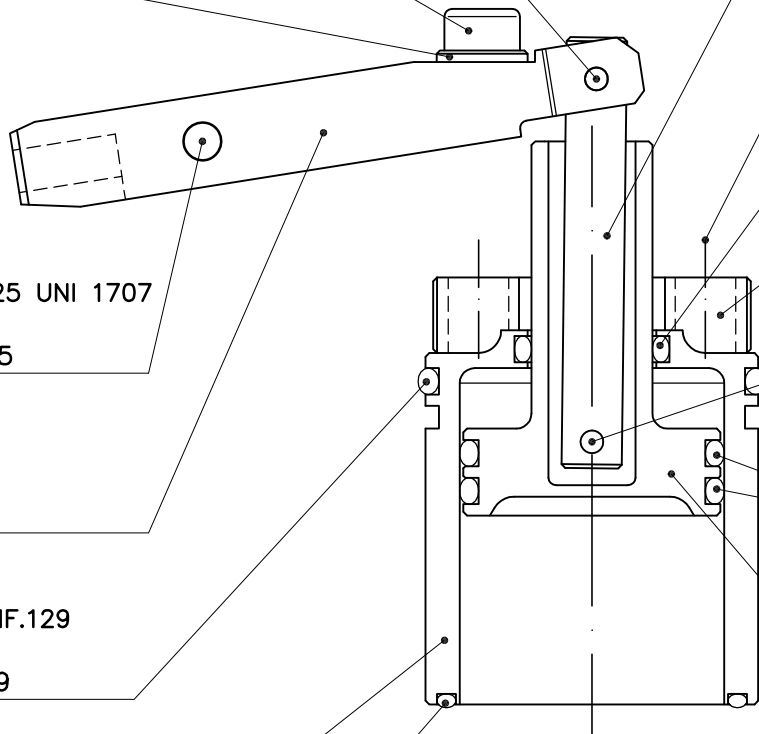
Pin  
Cod. S0330

**O-RING RIF.123**

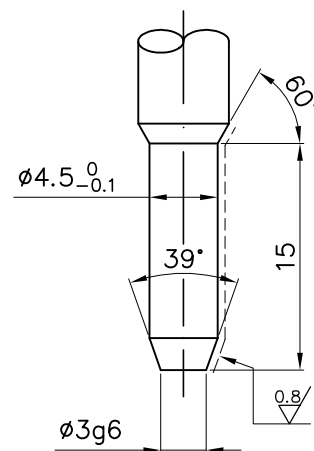
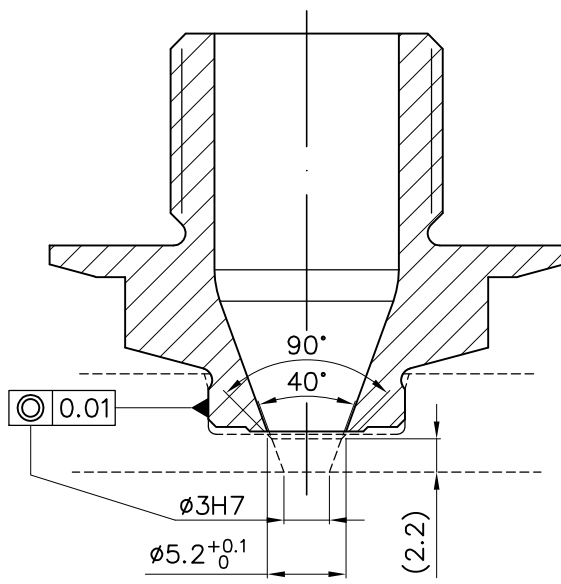
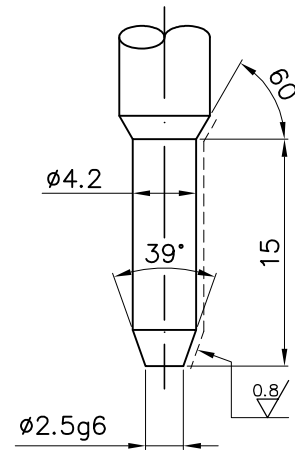
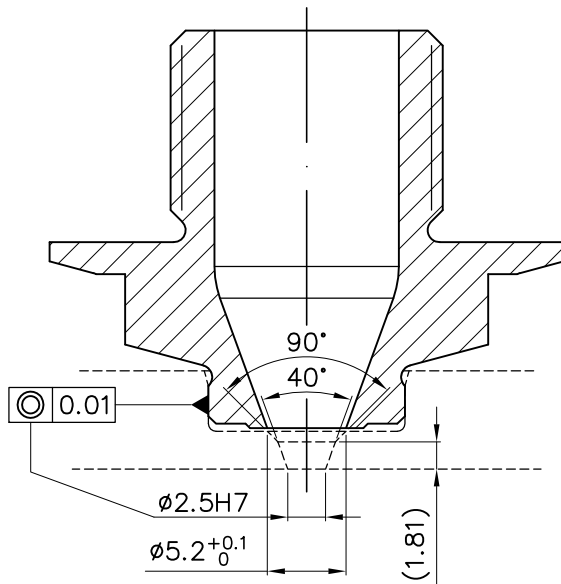
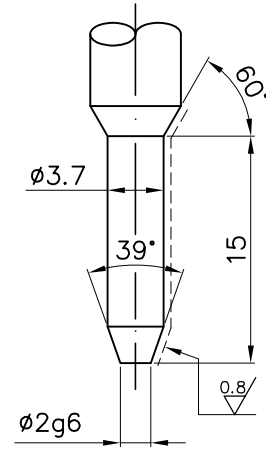
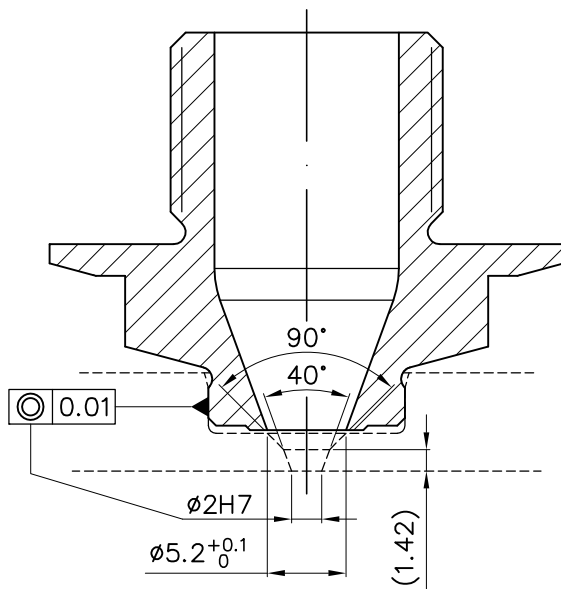
O-RING  
Cod. OR123

**PISTONE**

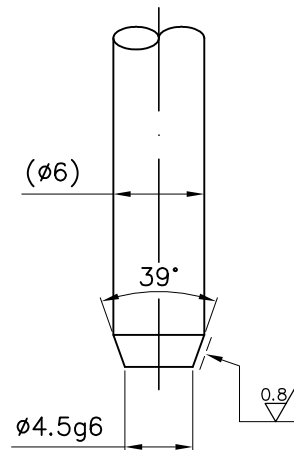
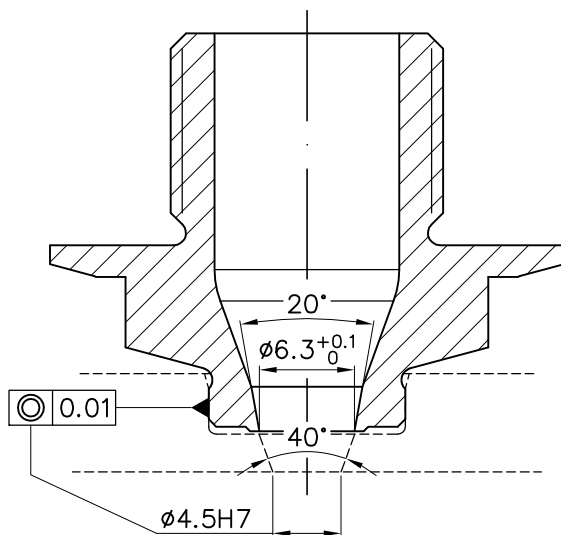
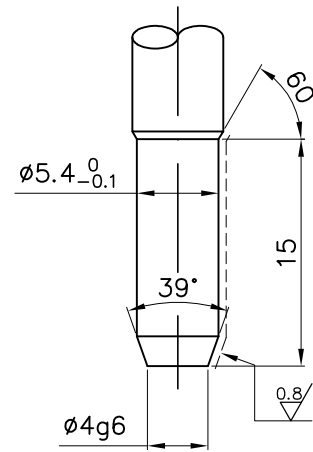
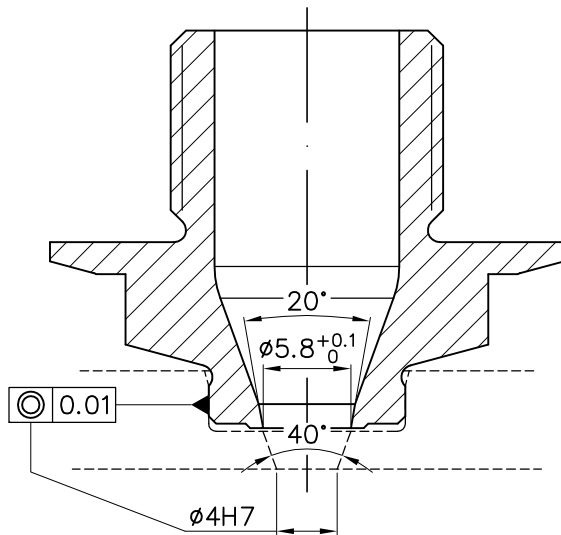
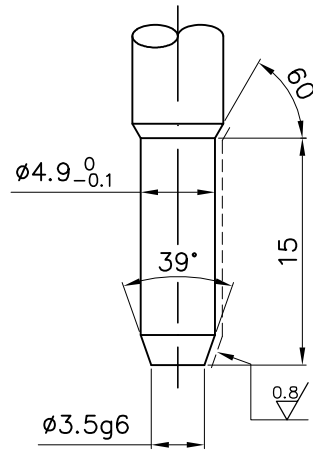
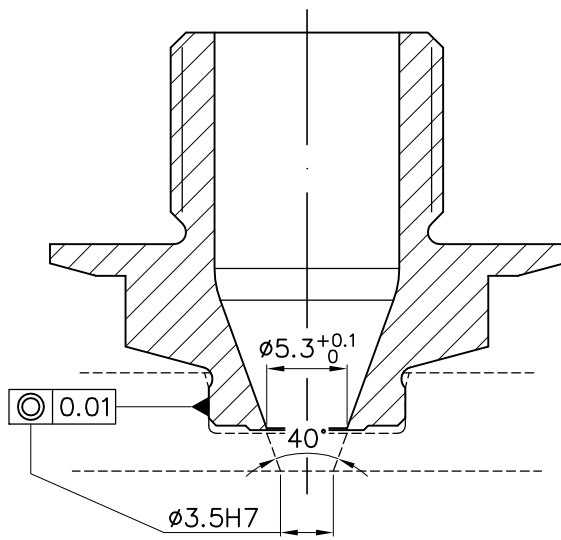
Piston  
Cod. PIO40

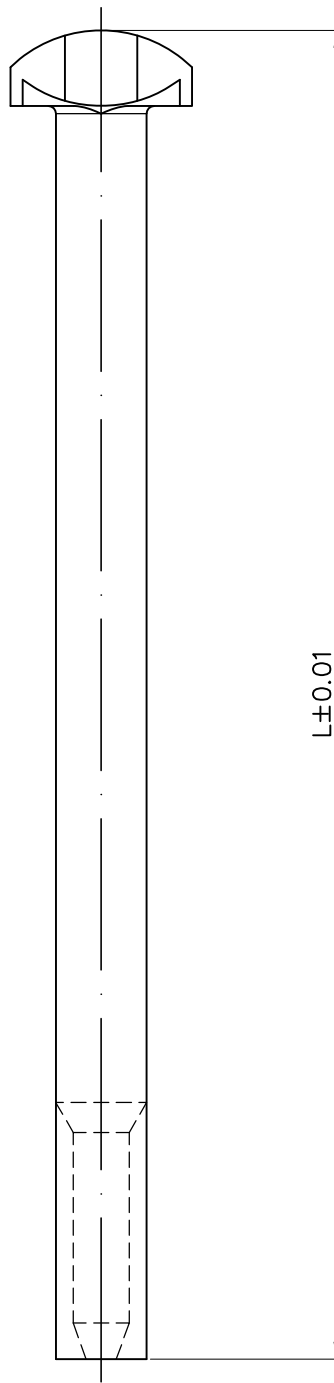






Rev. 01 - 13.10.2014





DPO40.150	ZO4026	198.17
DPO40.100	ZO4017	148.17
DPO40.075	ZO4012	123.17
DPO40.050	ZO4007	98.17
SERIE	CODICE	$L \pm 0.01$
LUNGHEZZE FINITE TEORICHE THEORETICAL LENGHT PIN		

Rev. 00



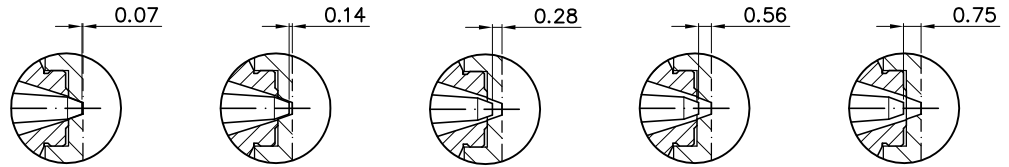
Rev. 00

ATTENZIONE: IN NESSUN CASO PRENDERE L'INIETTORE PER I CAVI ELETTRICI SIANO ESSI DELLA RESISTENZA O DELLA TERMOCOPIA NE MODIFICARE LA CURVATURA ORIGINALE. POTREBBERO ROMPERSI.

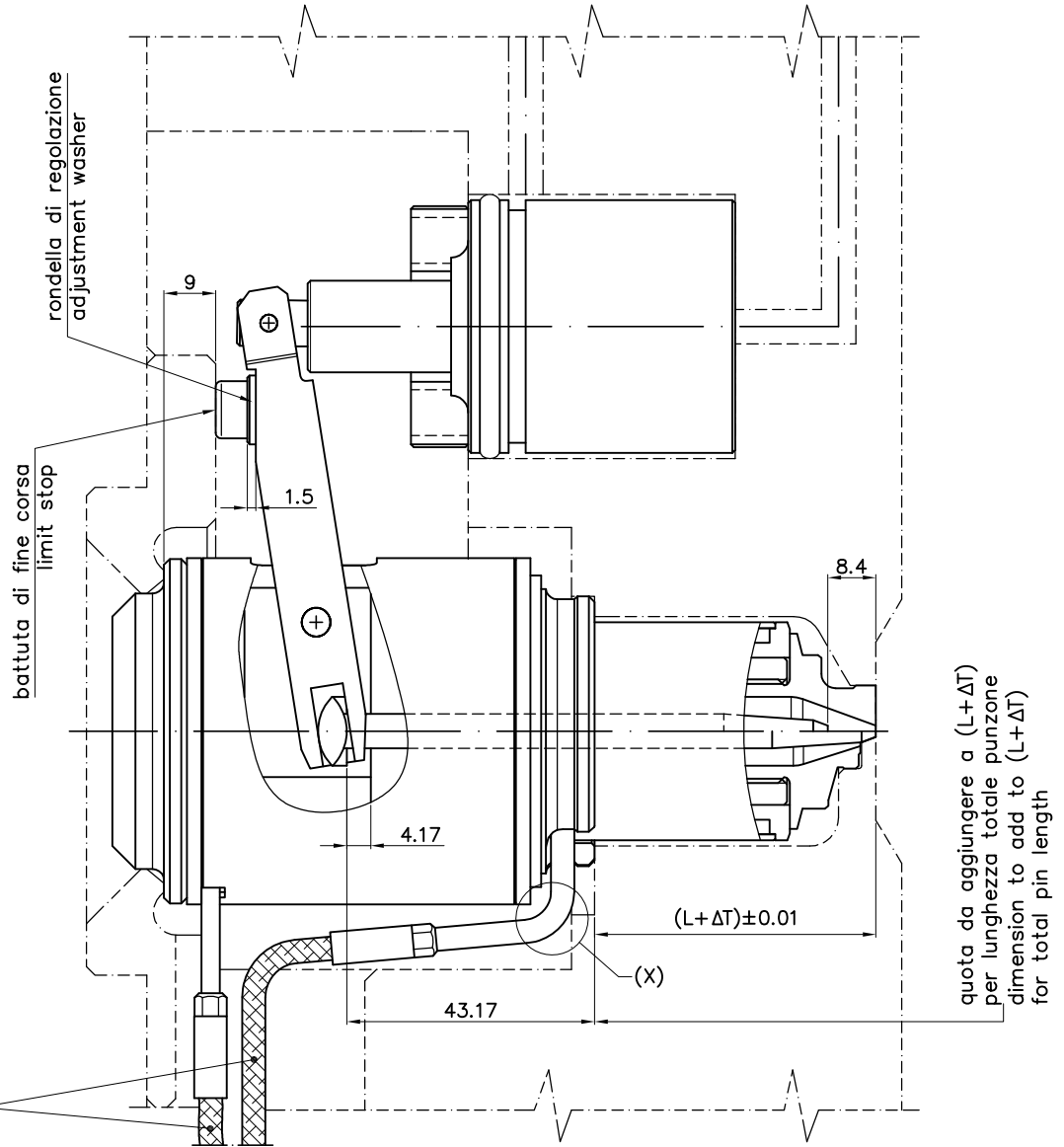
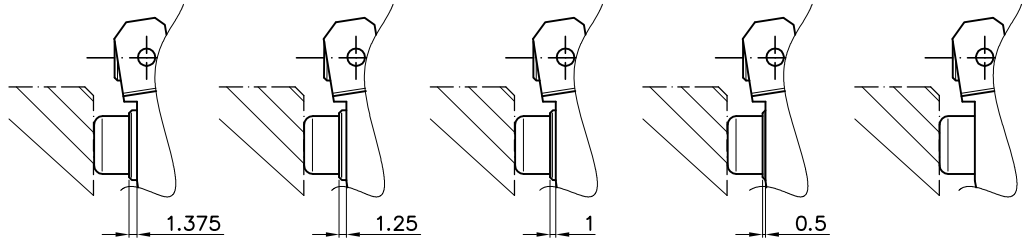
ATTENTION: YOU MUST NEVER TAKE THE NOZZLE BY THE ELECTRICAL HEATER OR THERMOCOUPLE CABLES. YOU MUST NEVER MODIFY THE CURVE OF THE ORIGINAL HEATER (X) BECAUSE IT COULD BREAK.

## REGOLAZIONE OTTURATORE VALVE PIN ADJUSTMENT

SPESORE DEL  
TESTIMONE SUL MANUFATTO  
WITNESS HEIGHT  
ON THE MOLDED PART



SPESORE DELLA RONDELLA  
PER ELIMINARE TESTIMONE  
WASHER HEIGHT  
TO ELIMINATE THE WITNESS



quota da aggiungere a  $(L+\Delta T)$   
per lunghezza totale punzone  
dimension to add to  $(L+\Delta T)$   
for total pin length

ATTENZIONE: IN NESSUN CASO PRENDERE L'INIETTORE PER I CAVI ELETTRICI SIANO ESSI DELLA RESISTENZA O DELLA TERMOCOPIA NE MODIFICARE LA CURVATURA ORIGINALE. POTREBBERO ROMPERSI.

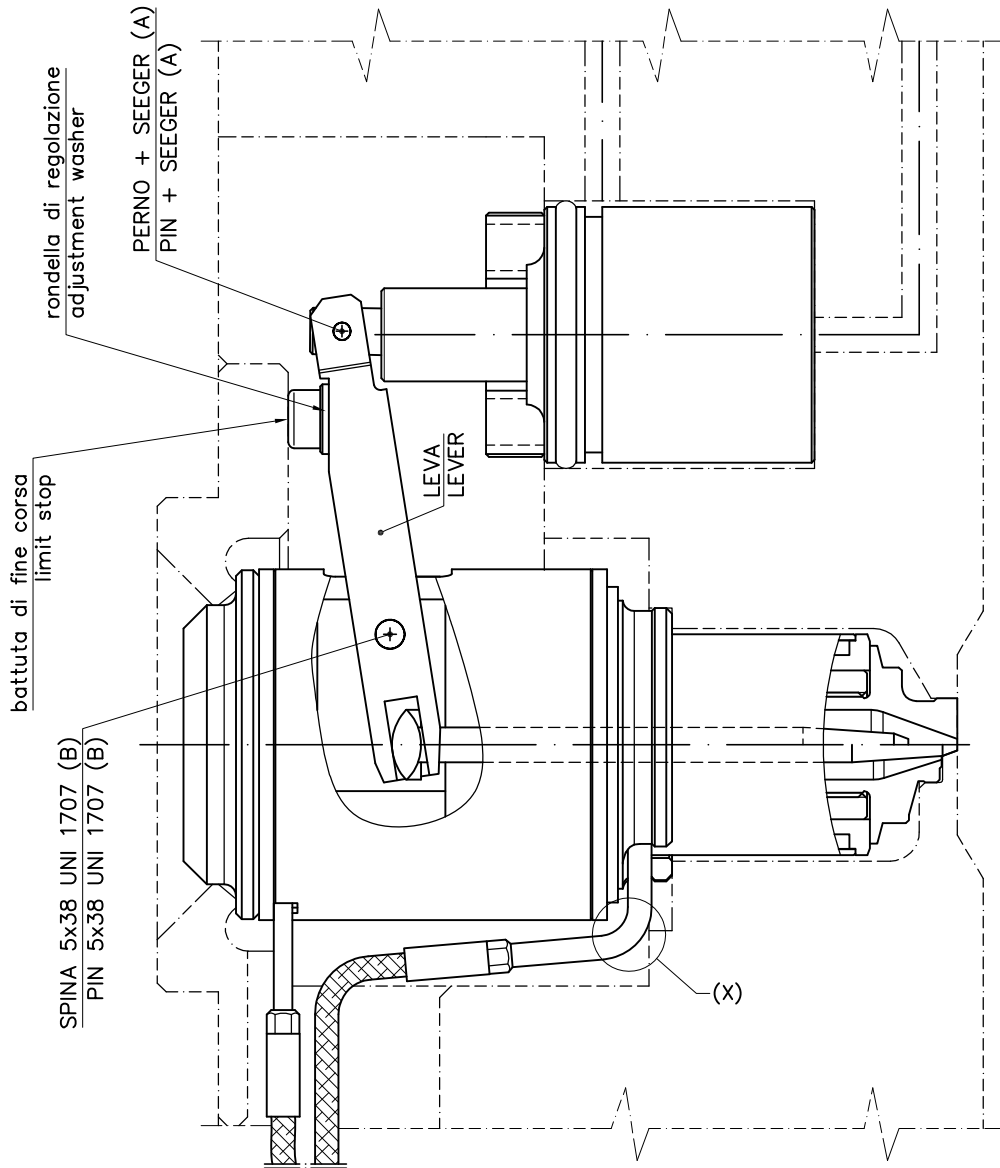
ATTENTION: YOU MUST NEVER TAKE THE NOZZLE BY THE ELECTRICAL HEATER OR THERMOCOUPLE CABLES. YOU MUST NEVER MODIFY THE CURVE OF THE ORIGINAL HEATER (X) BECAUSE IT COULD BREAK.

## SOSTITUZIONE LEVA:

- 1) togliere la spina (B);
- 2) togliere il seeger e il perno (A);
- 3) smontare la battuta e la rondella di regolazione dalla vecchia leva e rimontarla sulla nuova;
- 4) sostituire la leva usurata con la nuova, inserendo la testa dell'attuatore nella parte a "forchetta" della leva;
- 5) reinserire le spine "A" e "B".

## LEVER REPLACEMENT:

- 1) take out the pin (B);
- 2) take out the seeger and the pin (A);
- 3) remove the limit stop and the adjustment washer from the old lever and then putting them back together on the new lever;
- 4) replace the old lever with the new ones, insert the valve pin head in the "forked" part of the lever;
- 5) fit the pin (A) and "B" in.



Rev. 00

ATTENZIONE: IN NESSUN CASO PRENDERE L'INIETTORE PER I CAVI ELETTRICI SIANO ESSI DELLA RESISTENZA O DELLA TERMOCOPPIA NE MODIFICARE LA CURVATURA ORIGINALE. POTREBBERO ROMPERSI.

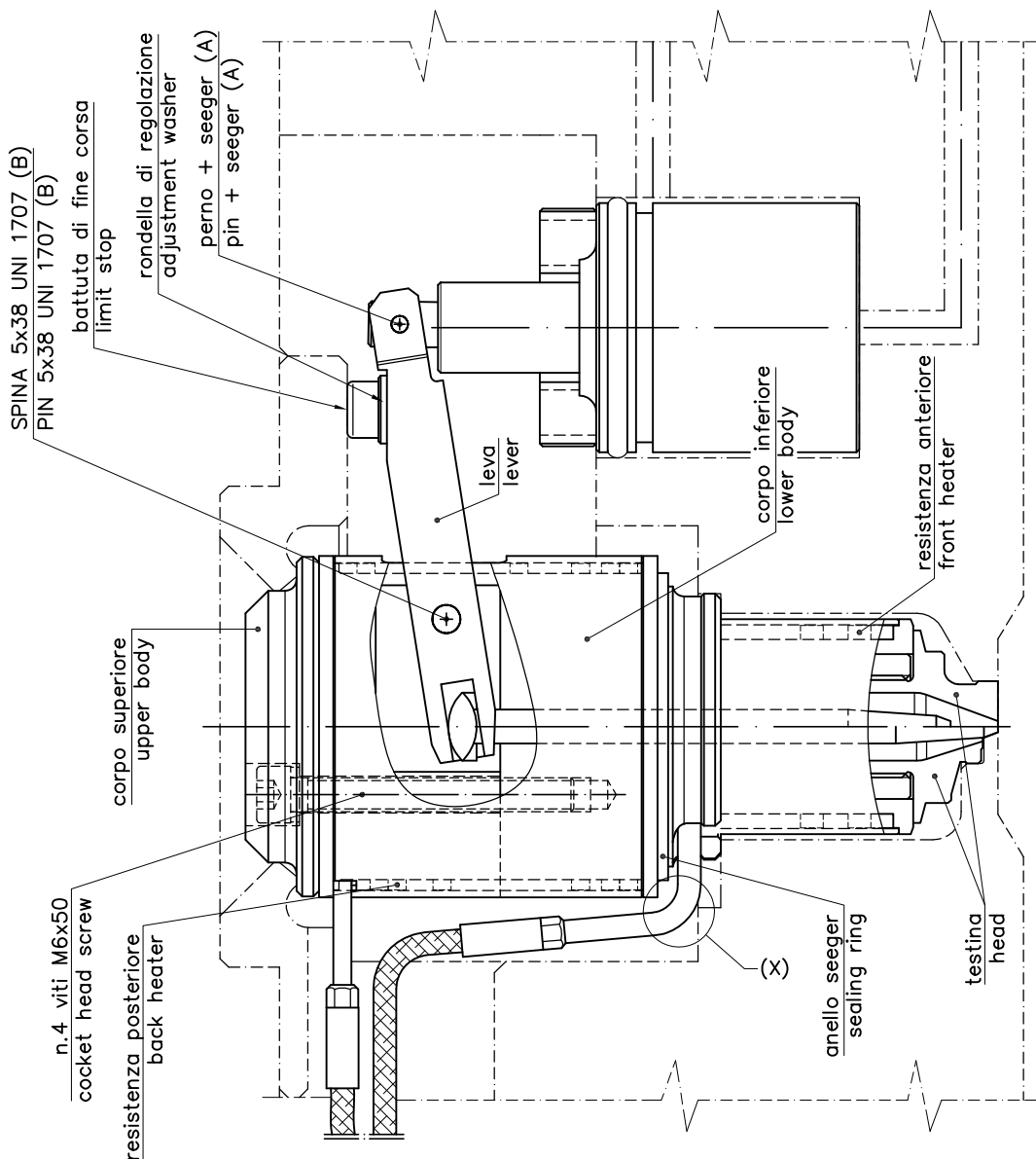
ATTENTION: YOU MUST NEVER TAKE THE NOZZLE BY THE ELECTRICAL HEATER OR THERMOCOUPLE CABLES. YOU MUST NEVER MODIFY THE CURVE OF THE ORIGINAL HEATER (X) BECAUSE IT COULD BREAK.

## SOSTITUZIONE PUNZONE:

- 1) togliere la spina (B);
- 2) svitare la testina tramite la chiave;
- 3) togliere la resistenza anteriore;
- 4) togliere l'anello seeger;
- 5) togliere la resistenza posteriore;
- 6) svitare le nr.4 viti M6 con chiave a brugola;
- 7) separare il corpo superiore dal corpo inferiore prestando attenzione nel rimontarli con il giusto allineamento del foro di alimentazione plastica.

## PIN REPLACEMENT:

- 1) take out the pin (B);
- 2) unscrew the head using the wrench;
- 3) take out the front heater;
- 4) take out the sealing ring;
- 5) take out the back heater;
- 6) unscrew the n.4 M6 screws using the cocket wrench;
- 7) separate the upper and the lower body taking care to put then back together with the right alignment of the injection hole.



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