PET Hot Runner maintenance guidelines



Regular preventive maintenance of PET hot runners is critical to ensure maximum productivity. Even one blocked cavity can have a significant impact on your bottom line. By using genuine Husky OEM parts and Hot Runner Preventive Maintenance Kits in your production, you can minimize low part quality and maintain the highest levels of functioning cavities.

96 Cavity Case Study

With two down cavities on a 96 cavity mold, production losses exceed more than 480,000 preforms per month.

Mold cavitation	96	cavities
Number of cavities switched off	**2**	**cavities**
Cycle time	10	s
Production availability	96%	
Nominal available time per year	8400	hours
Production with FULL cavitation		
Number of preforms produced per year	**278,691,840**	preforms
Number of preforms produced per month	**23,224,320**	preforms
Production with PARTIAL cavitation		
Number of preforms produced per year	**272,885,760**	preforms
Number of preforms produced per month	**22,740,480**	preforms
Missing preforms per month:	**483,840**	**preforms**

Husky recommends the following basic maintenance schedule for your hot runner:

- 2M to 4M cycles for solid skirt hot runners
- 3M to 4M cycles for non-HPP5 hot runners
- 4M to 5M cycles for HPP5 hot runners

Hot Runner Maintenance Kits–Now Available

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