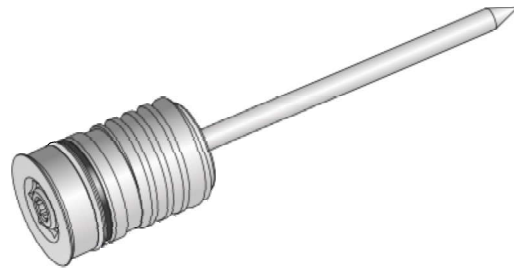
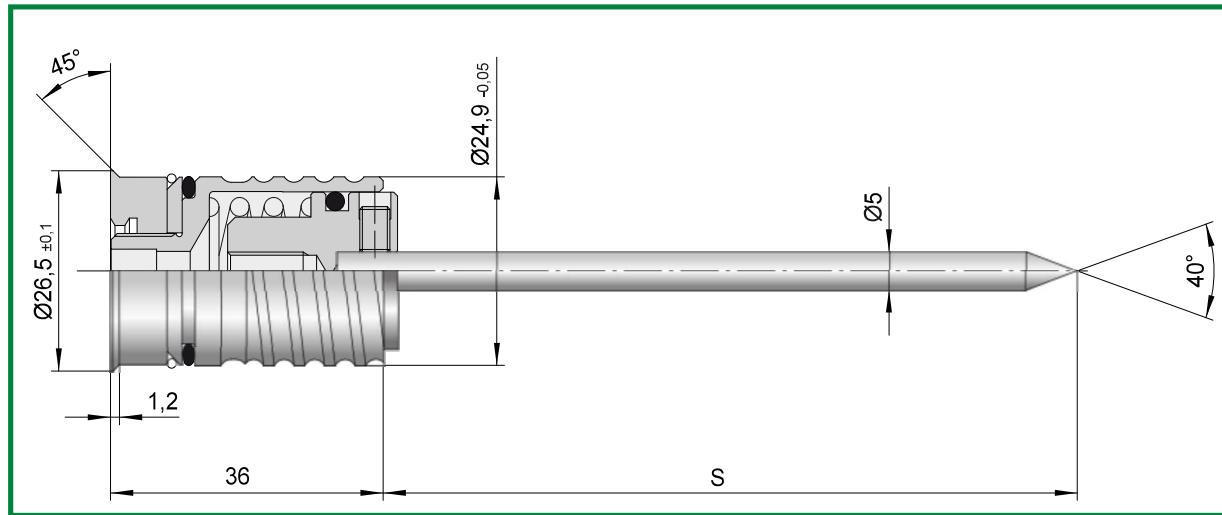


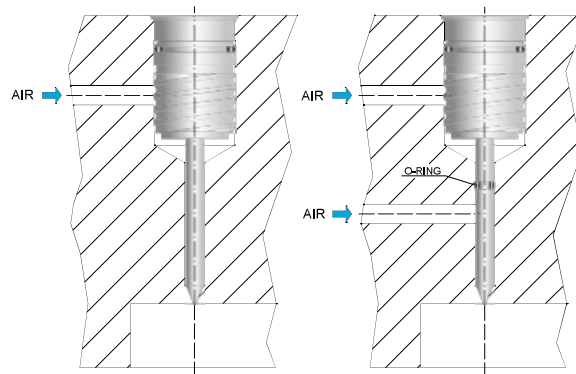
AIR NEEDLE VALVE



CODE: VASP



CODE	S
VASP-C	100
VASP-L	200



SINGLE AIR
FEEDING

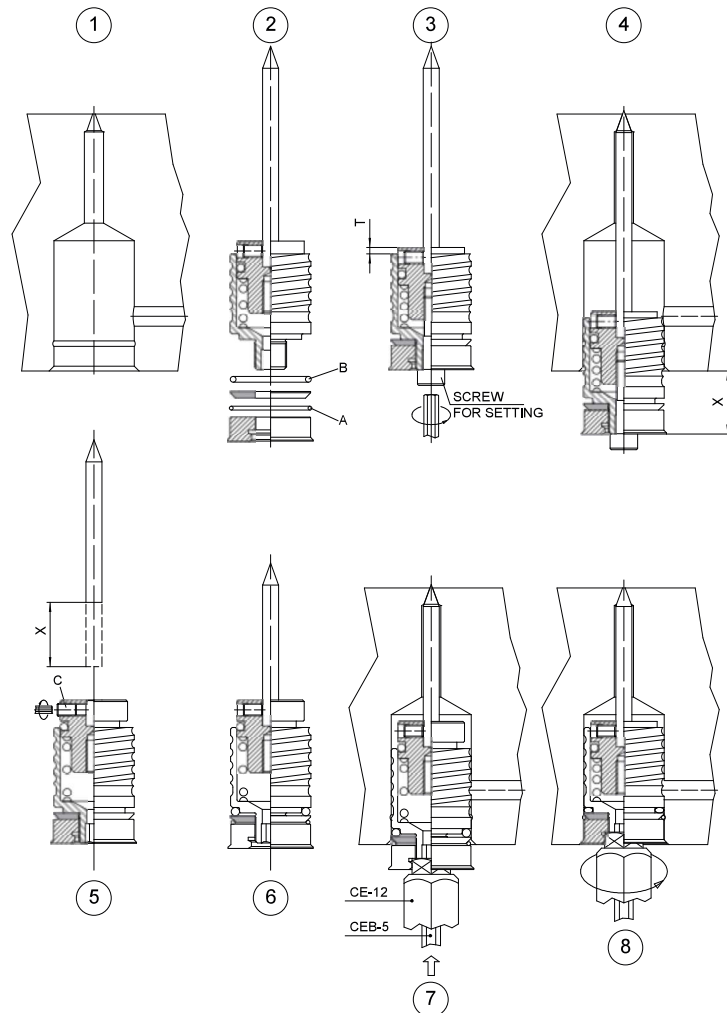
DOUBLE AIR
FEEDING

CHARACTERISTICS

- 1) VERY LIMITED ENCUMBRANCE;
- 2) LIMITED JAMMING RISK;
- 3) IDEAL IN CASE OF AESTHETIC SURFACES;
- 4) USABLE AS SELF-CLEANING GAS OUTLET POINT (by means of special needle shaping);
- 5) MAXIMUM WORKING TEMPERATURE 200°C;
- 6) DOUBLE AIR FEEDING APPLICATION TO MAXIMIZE AIR FLOW RATE INTO THE CAVITY.

APPLICATION PROCESS

1. Machine the seat.
2. Take off the metal ring "A" and the O-ring "B", re-assemble the washer and the ring nut until it reaches the mechanic stop .
3. Set the "T" dimension with the setting screw.
4. Insert the air valve into the seat and take the "X" dimension.
5. Take off the setting screw, unloose the dowel "C", remove the needle and shorten it in the rear part of the dimension "X" .
6. Re-assemble the metal ring "A" and the O-ring "B".
7. Insert the valve into the seat.
8. Fix the valve with the proper keys pressing simultaneously the valve toward the inside.



SETTING

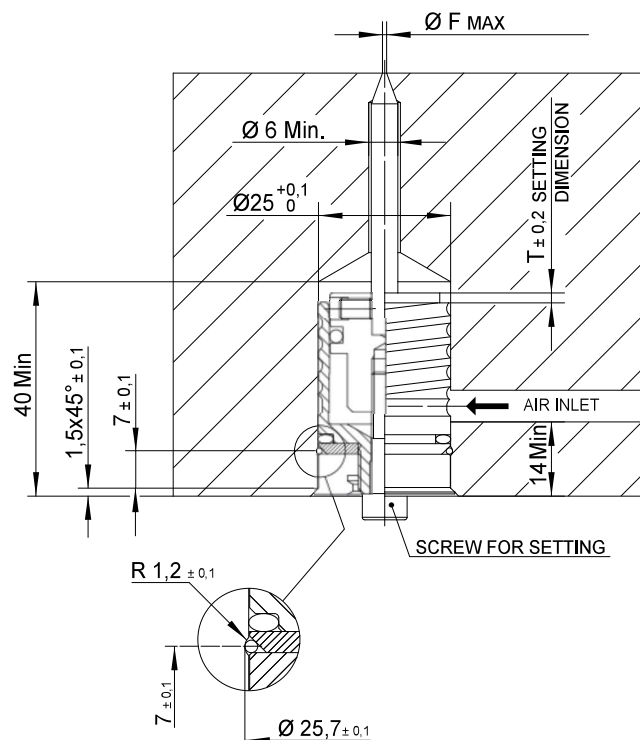
AVAILABLE PRESSURE (bar)	ØF MAX (mm)	SETTING T ±0,2mm
6+8	0,8	3,5
8+10	1,0	2
10+12	1,2	1

N.B.:

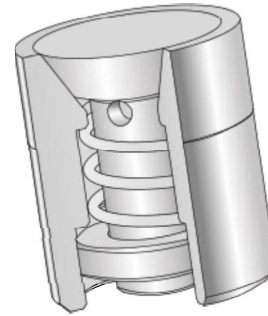
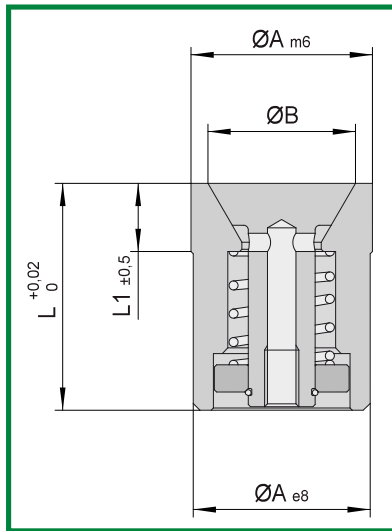
The values expressed in the schedule refer to a moulding pressure of 1000Kg/cm² Max.

In case of higher pressure the diameter of the "F" hole in the mold should be redimensioned.

SEAT DIMENSIONS



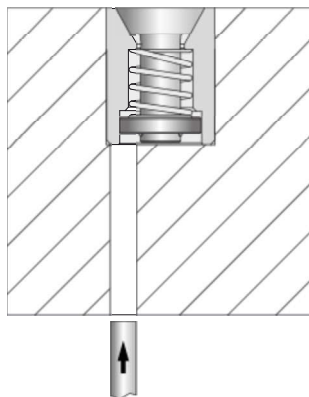
AIR VALVES



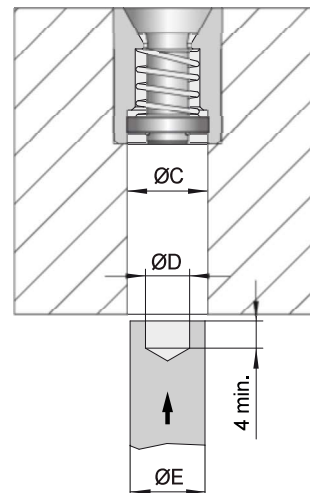
CODE: VA

CODE	A	B	L	L1	C	D	E
VA-4	4	3,4	8	4	3,5	2,8	3
VA-6	6	5	10	4	5	4	4,5
VA-8	8	5,6	12	4	6,5	5	6
VA-10	10	8	14	5	7,5	5	7
VA-12	12	10	14	5	9	5,5	8,5
VA-16	16	12	20	6	12	6,5	11
VA-20	20	16	20	6	12	6,5	11

TECHNICAL NOTES FOR AIR VALVES DISASSEMBLY



SOLUTION 1



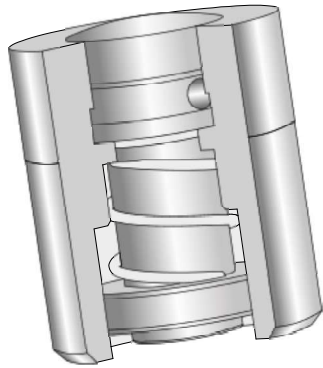
SOLUTION 2

CHARACTERISTICS

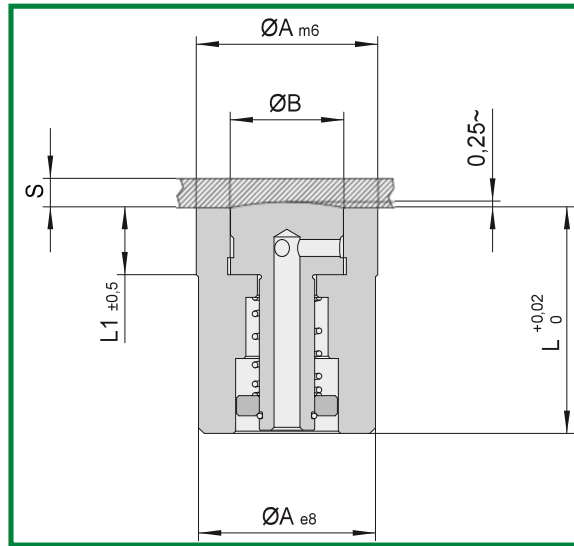
- 1) STAINLESSNESS, MAT. STAINLESS STEEL AISI 420 50+55 HRC;
- 2) FULLY GRINDED;
- 3) COMPACT STRUCTURE (avoid the breakage in case of disassembly).

GUARANTEED LOCKING AIR VALVES

(PATENT REGISTERED)



CODE: VABA

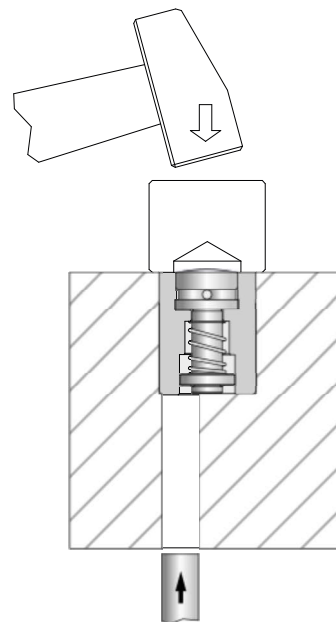


CODE	A	B	L	L1	S
VABA-8	8	5	12	4	1
VABA-12	12	7	14	5	1,5
VABA-16	16	10	20	6	2,5

S= maximum thickness of the moulded part

TECHNICAL NOTES FOR THE APPLICATION

- 1) In order to disassembly the air valve and avoid damaging, we recommend drilling a feeding hole as pictured.
- 2) In order to insert the air valve properly, we recommend not to push the poppet but to operate only on the external crown as pictured.



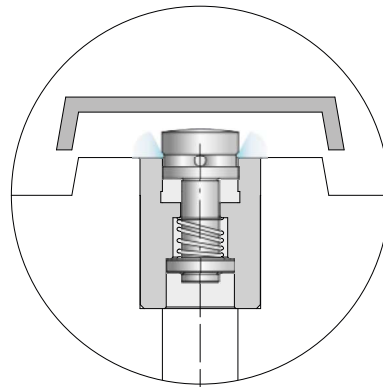
CHARACTERISTICS

- 1) LOCKING UP IS GUARANTEED IN SPITE OF VALVE JAMMING;
- 2) STAINLESSNESS, MAT. STAINLESS STEEL AISI 420 50+55 HRC;
- 3) FULLY GRINDED;
- 4) MAXIMUM AIR PRESSURE: 10 BAR.

One of the most recurring and onerous problems with the air valves is the jamming and the subsequent clogging of them and of their air feeding holes. This problems generate long production downtime and costs for the restoration of the mould. With the BALZI air valve the clogging problem is definitively excluded and it may be necessary only a routine maintenance to guarantee the best efficiency of the valve.

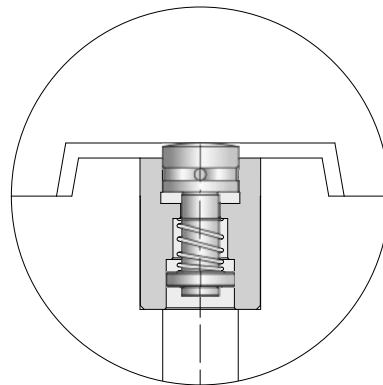
1)

In the ejection phase the BALZI air valve introduces air in the cavity of the mould, first in limited quantity through the space between the body of the valve and the convex poppet, than in big quantity through the proper bleeds.



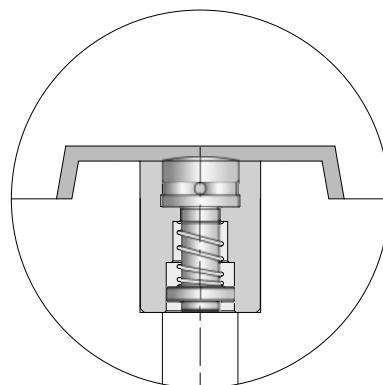
2)

In the closure phase of the mould, in case of valve jamming or solenoid valve malfunction, the push of the matrix guarantee the first closing of the convex poppet that moves in anti-clogging position.

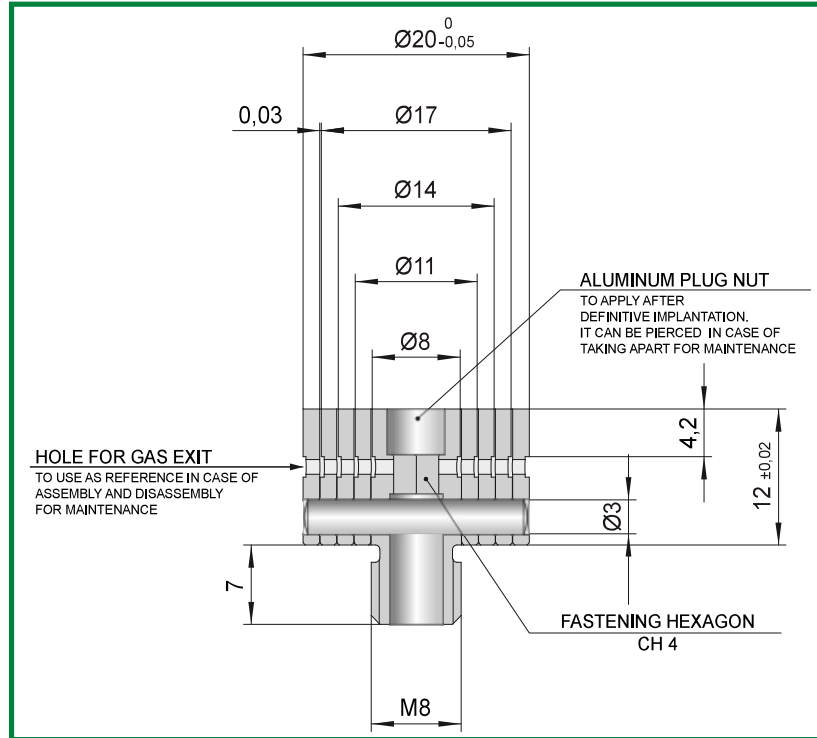
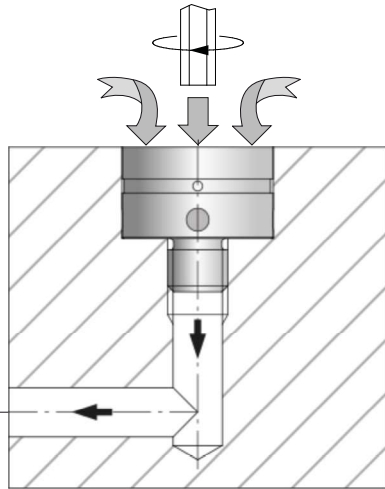


3)

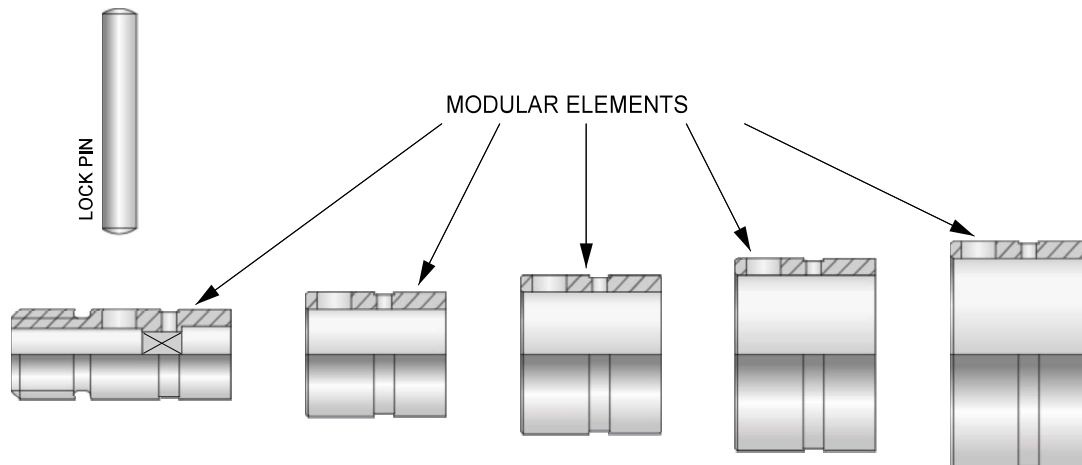
During the injection phase the front flow of the plastic material, getting between the convex poppet and the matrix, brings the convex poppet into the right position.



INSERT FOR GAS VENT



CODE: ISG-20

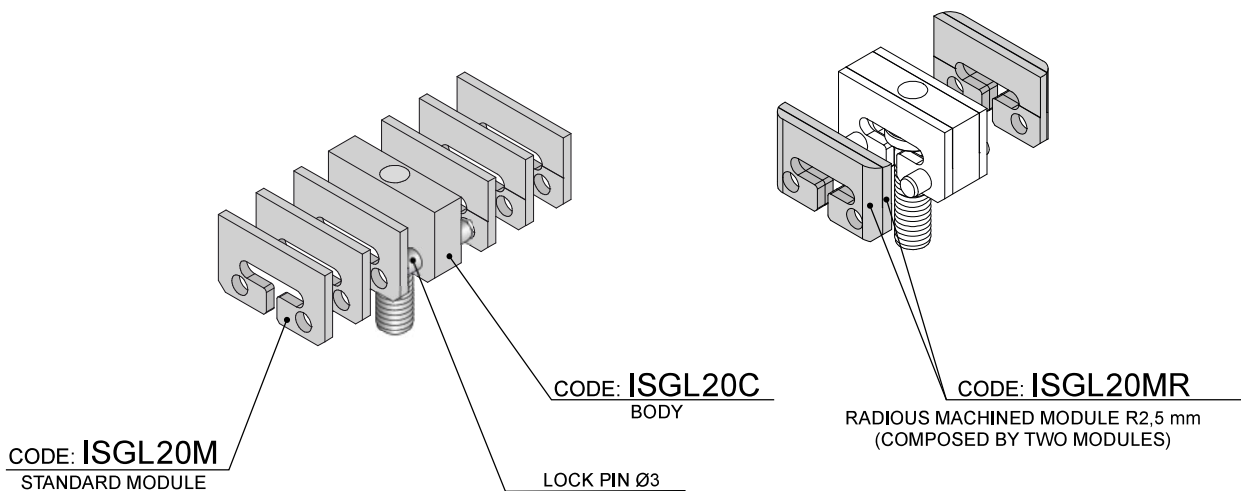
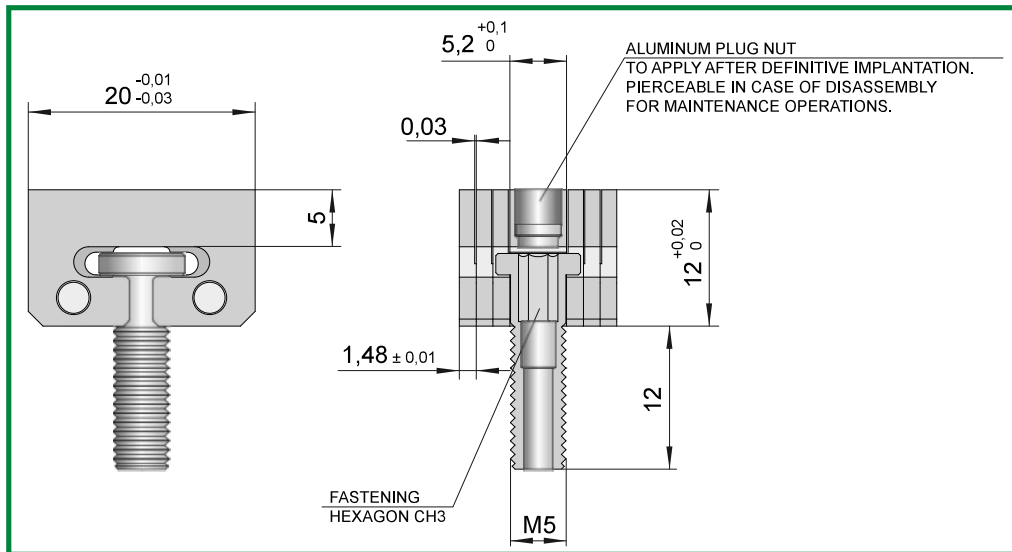


CHARACTERISTICS

- 1) STAINLESSNESS;
- 2) POSSIBILITY OF FRONT ASSEMBLY AND DISASSEMBLY;
- 3) EASE OF MAINTENANCE (because completely dismountable) ;
- 4) POSSIBILITY OF MODIFYING THE EXTERNAL DIAMETER (removing some parts);
- 5) POSSIBILITY TO SHAPE THE INSERT.
- 6) 0,03 mm GAS BREATHING BETWEEN EACH RING ELEMENT.

LAMELLAR GAS VENT DEVICE

FRONT FIXING

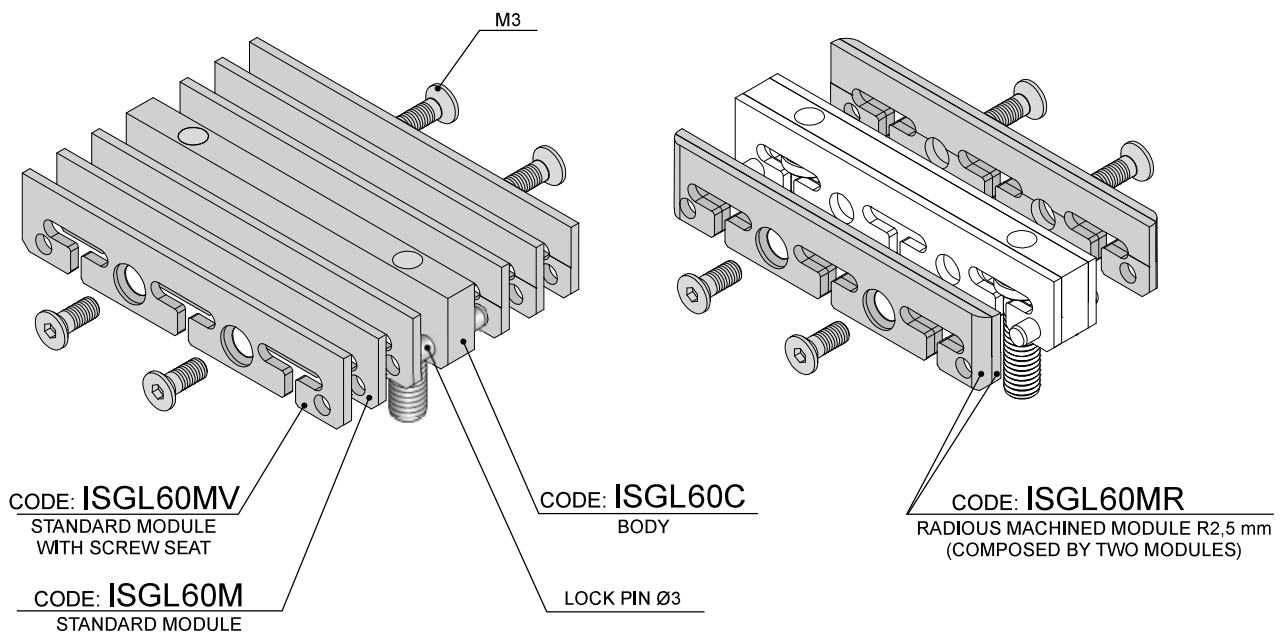
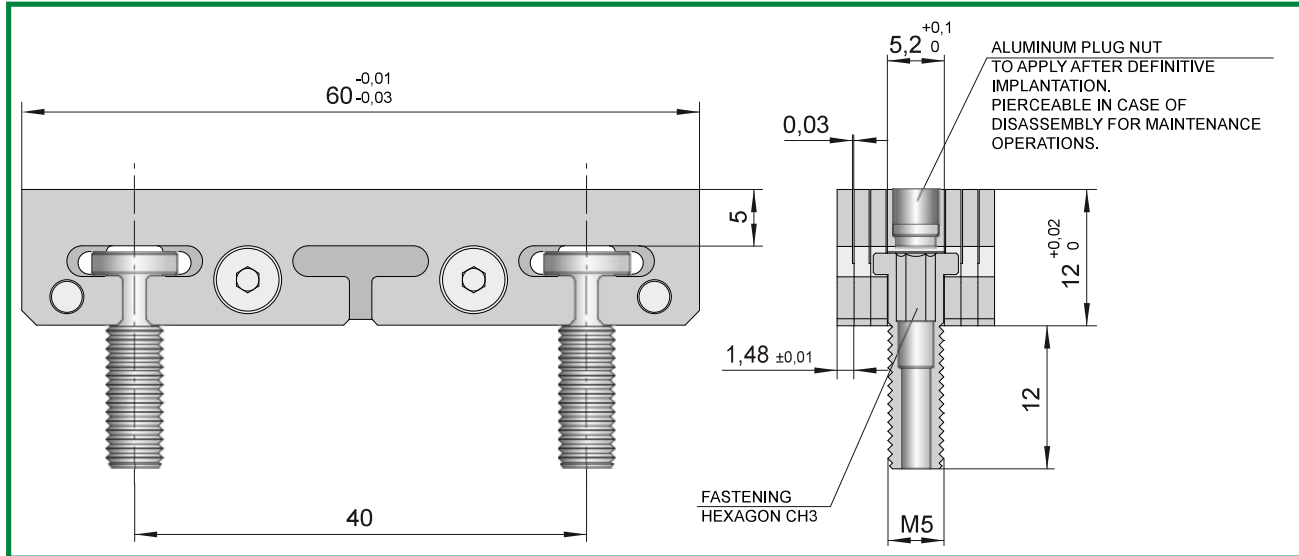


CHARACTERISTICS

- 1) MODULAR SYSTEM (to be fitted in any given space);
- 2) POSSIBILITY OF FRONT ASSEMBLY AND DISASSEMBLY (thanks to the shape of the fixing screw, which also operates as ejecting devices);
- 3) EASE OF MAINTENANCE (thanks to the fully dismantlable set up);
- 4) POSSIBILITY TO SHAPE THE INSERT;
- 5) STAINLESS STEEL;
- 6) RADIUS MACHINED TERMINAL MODULES AVAILABLE.

LAMELLAR GAS VENT DEVICE

FRONT FIXING

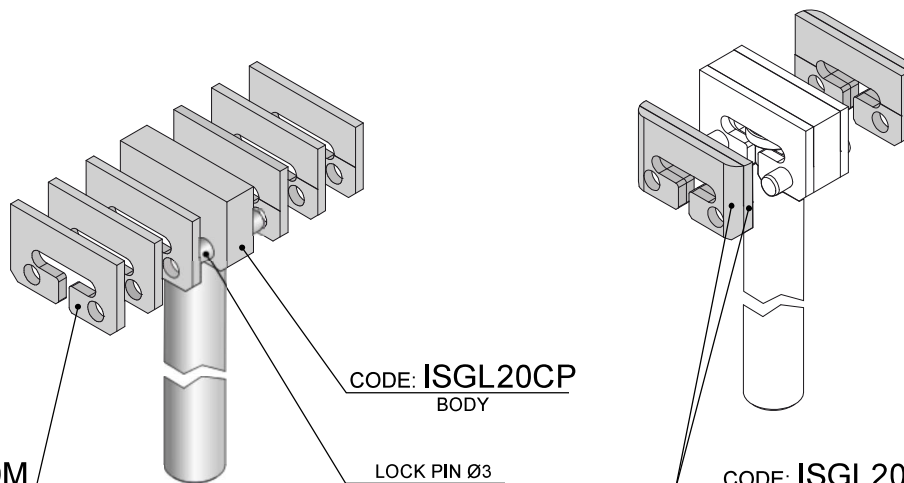
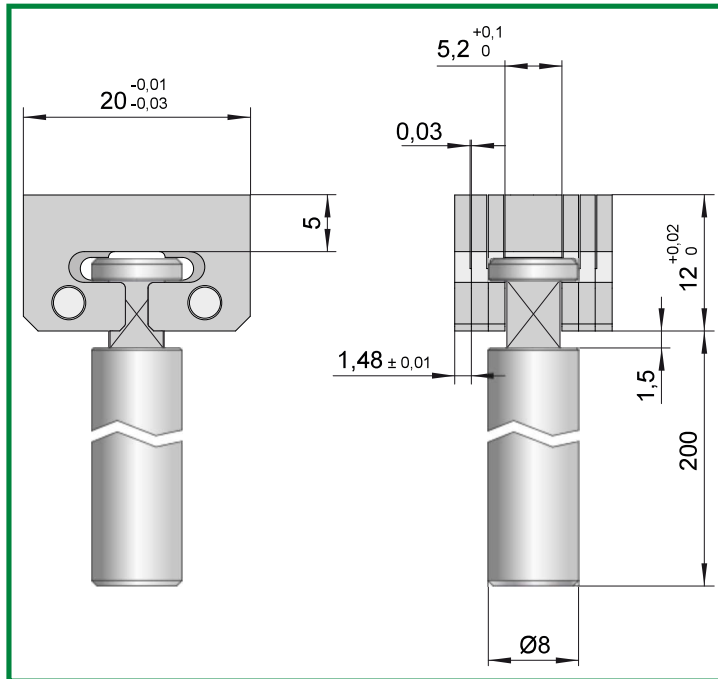


CHARACTERISTICS

- 1) MODULAR SYSTEM (to be fitted in any given space);
- 2) POSSIBILITY OF FRONT ASSEMBLY AND DISASSEMBLY (thanks to the shape of the fixing screws, which also operates as ejecting device);
- 3) EASE OF MAINTENANCE (thanks to the fully dismantlable set up);
- 4) POSSIBILITY TO SHAPE THE INSERT;
- 5) STAINLESS STEEL;
- 6) RADIOUS MACHINED TERMINAL MODULES AVAILABLE.

LAMELLAR GAS VENT DEVICE

BACK FIXING



CODE: **ISGL20M**
STANDARD MODULE

CODE: **ISGL20CP**
BODY

LOCK PIN Ø3

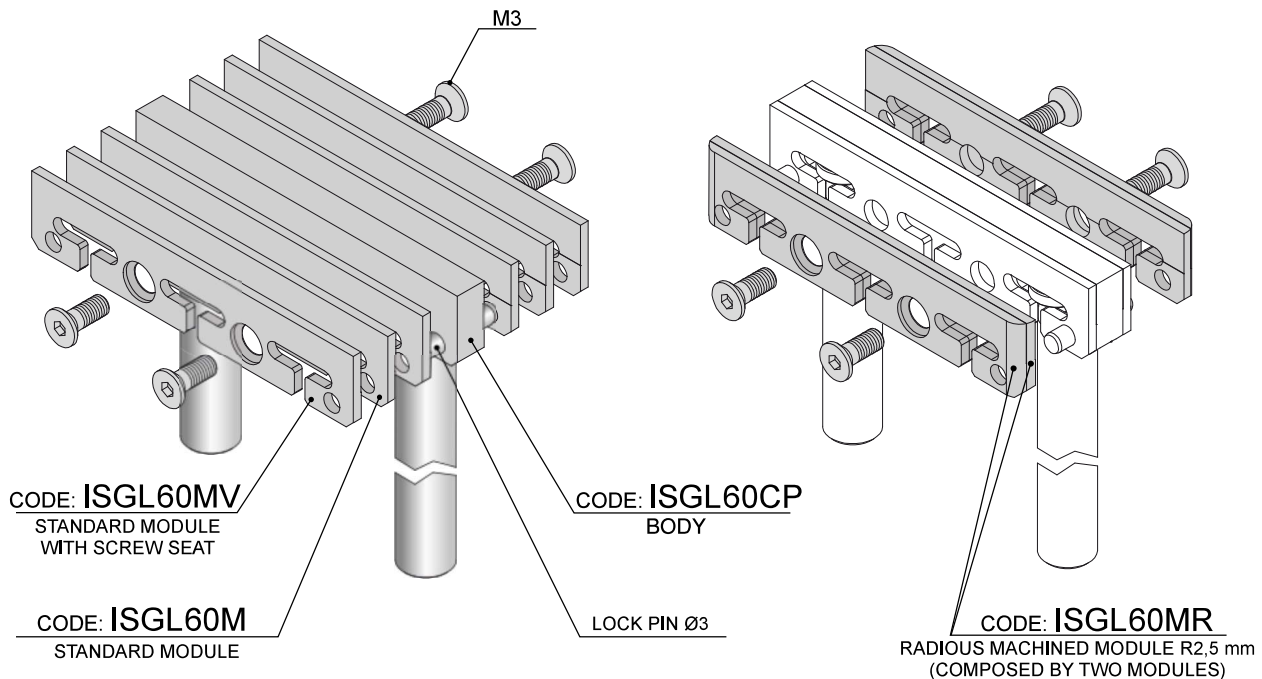
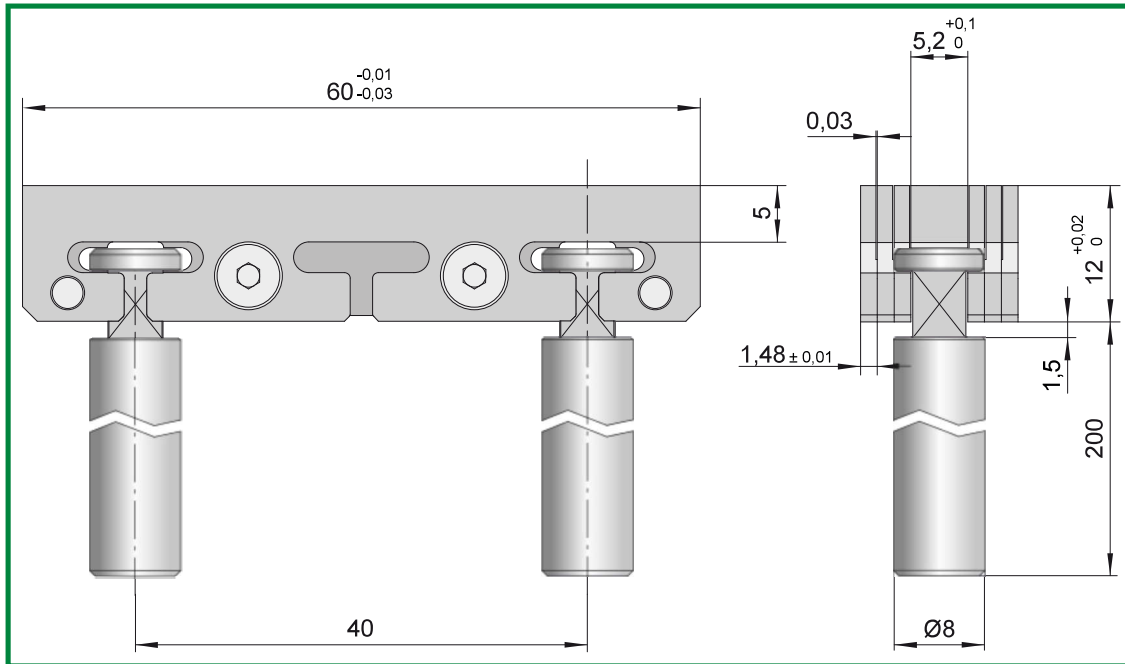
CODE: **ISGL20MR**
RADIOUS MACHINED MODULE R2,5 mm
(COMPOSED BY TWO MODULES)

CHARACTERISTICS

- 1) MODULAR SYSTEM (to be fitted in any given space);
- 2) POSSIBILITY OF BACK OR SIDE ASSEMBLY AND DISASSEMBLY ;
- 3) EASE OF MAINTENANCE (thanks to the fully dismantable set up);
- 4) POSSIBILITY TO SHAPE THE INSERT;
- 5) STAINLESS STEEL;
- 6) RADIOUS MACHINED TERMINAL MODULES AVAILABLE.

LAMELLAR GAS VENT DEVICE

BACK FIXING

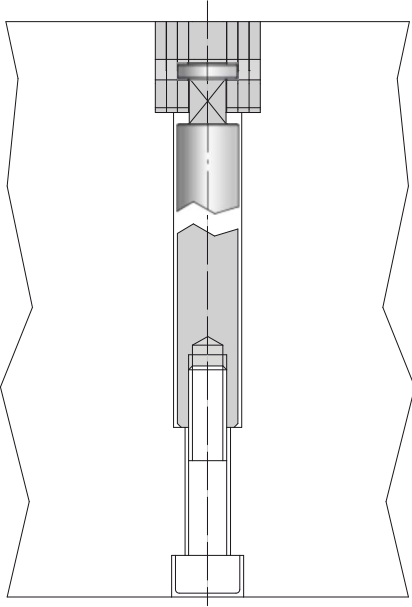


CHARACTERISTICS

- 1) MODULAR SYSTEM (to be fitted in any given space);
- 2) POSSIBILITY OF BACK OR SIDE ASSEMBLY AND DISASSEMBLY ;
- 3) EASE OF MAINTENANCE (thanks to the fully dismountable set up);
- 4) POSSIBILITY TO SHAPE THE INSERT;
- 5) STAINLESS STEEL;
- 6) RADIOUS MACHINED TERMINAL MODULES AVAILABLE.

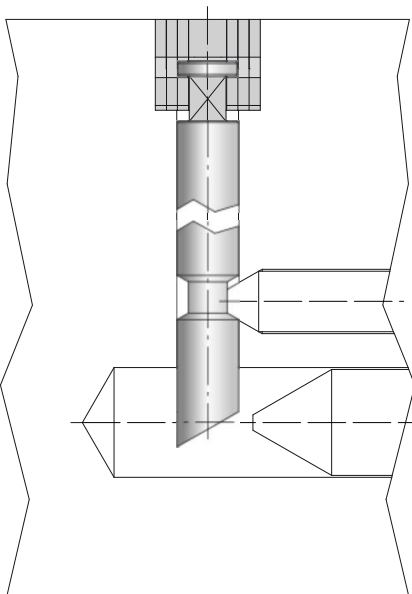
APPLICATION 1:

Back fixing

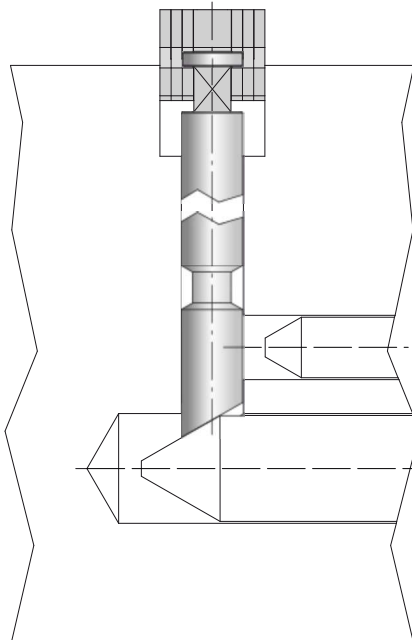


APPLICATION 2:

Side fixing and ejection system

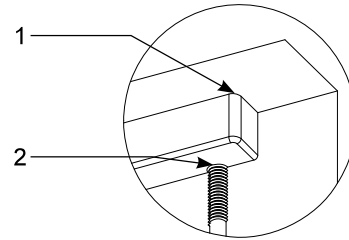


FIXING PHASE

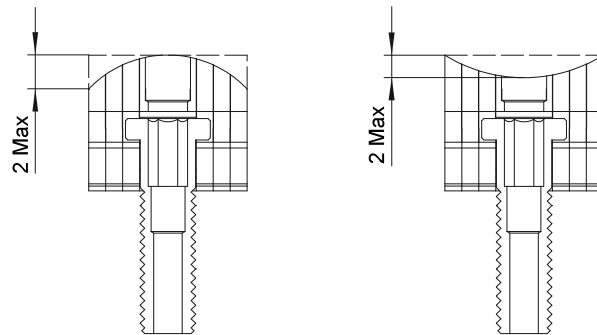


EJECTION PHASE

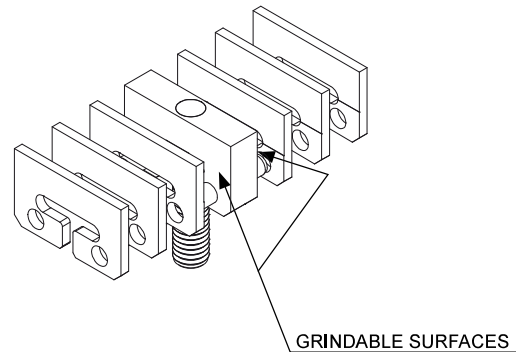
1. In order to avoid intrusions with the gas vent's lockpins the seat edges radius should not exceed 2.5mm.
2. The χ ing screws also work as ejecting devices.



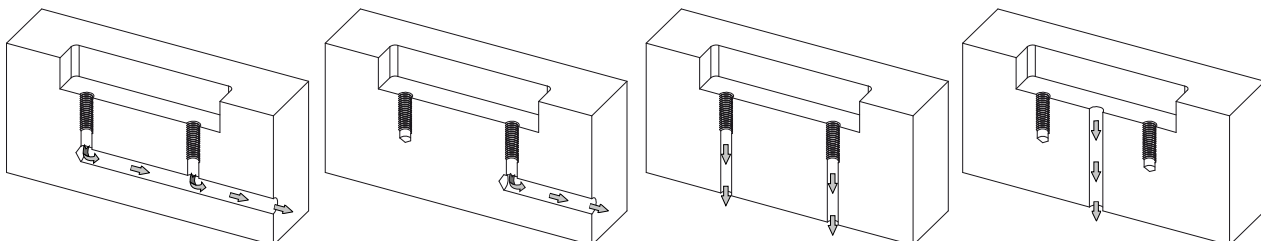
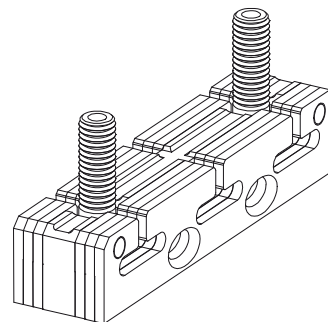
It is possible to machine the insert according to the mould surface. After, it will be necessary to disassembly the device in order to clean it. To ensure the free passage of the gas.

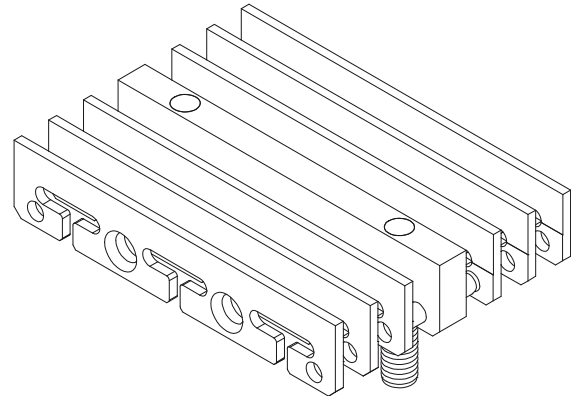
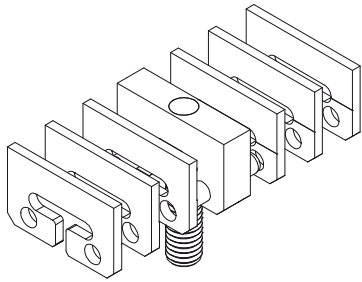


The assembled insert χ nal size amounts to the summation of several dimensions subjected to tolerance, thanks to the use of lamellar elements in the χ nal set up. In order to ensure the correct placing into the mould cavity, we recommend to measure empirically the size of the insert and, if required, to modify it by grinding both inner sides of the central body.

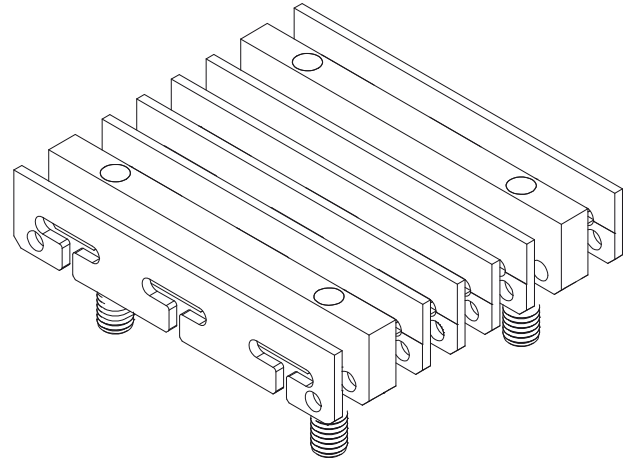
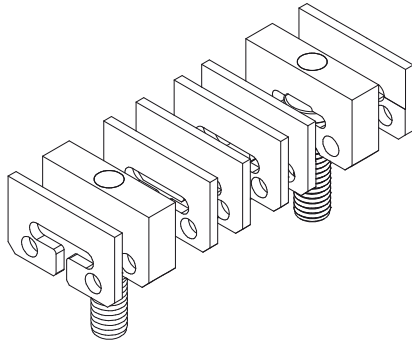


Ermanno Balzi's modular system geometry grants gas evacuation through a full communicating system where gasses are conveyed towards one only exit aperture. Such exit hole can always be placed in the best available position, ensuring maximum flexibility (see examples).

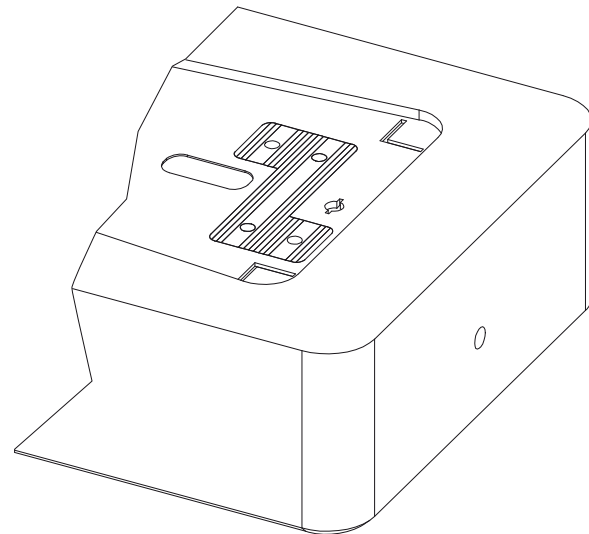
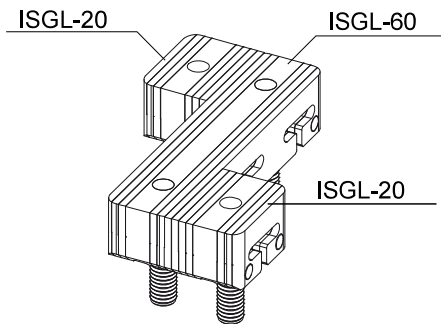


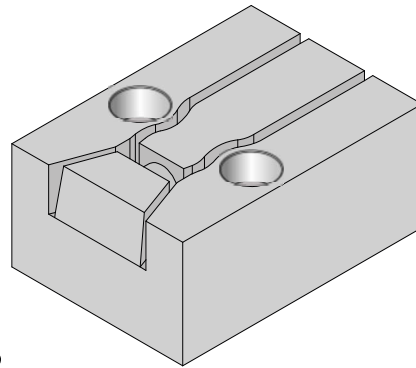


In case of central body application we recommend a maximum number of 10 modular elements.
It is necessary to apply at least the body and one modular element on both sides.

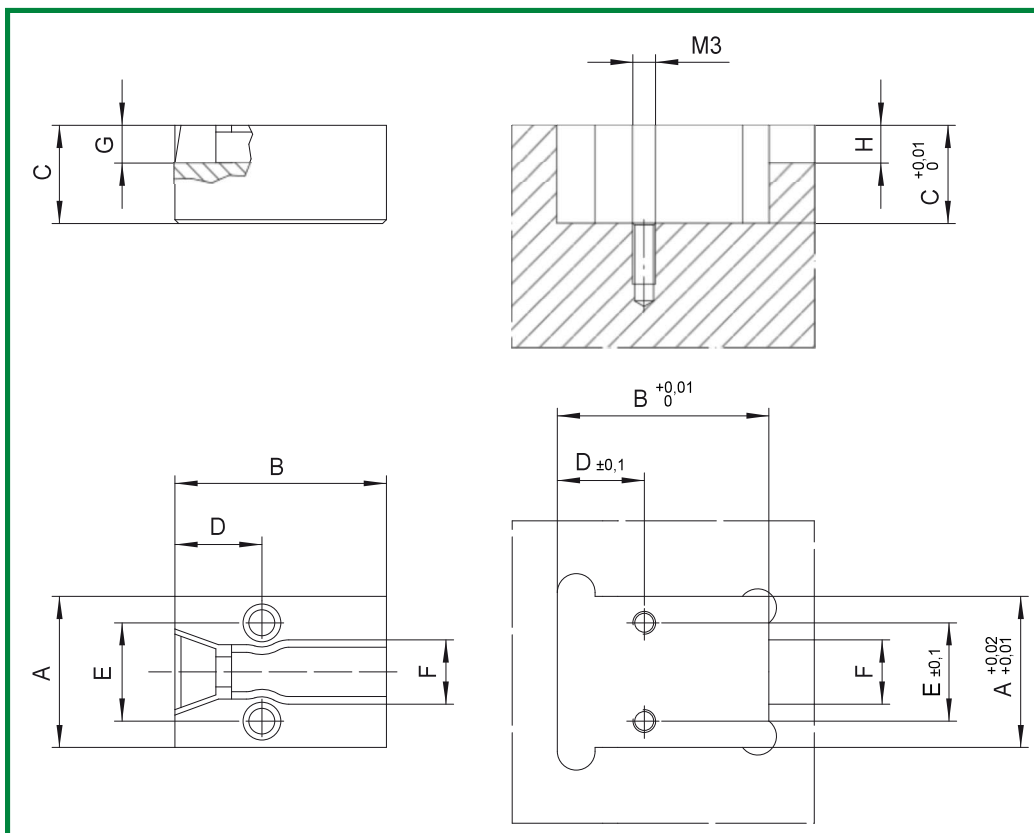


In case of double body application we recommend to insert a maximum number of 30 modular elements.
It is also necessary to insert one modular element on both ends of the bodies.





CODE: EB



SAITO MOLD Mfg.co.ltd
Patented system

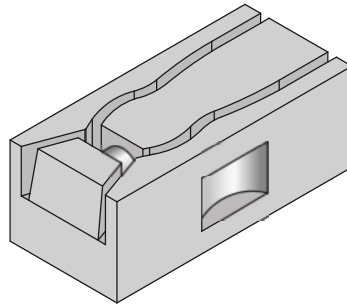


CODE	A	B	C	D	E	F	G	H
EB	20	28,0	13,0	11,5	13	8,5	5	5

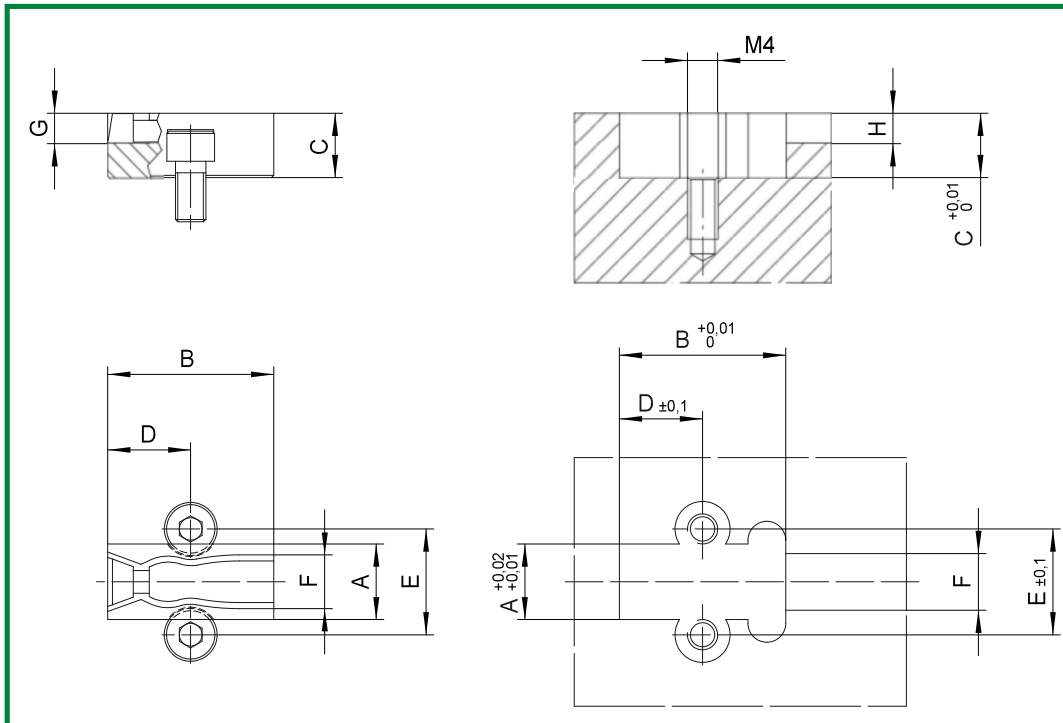
Mat.: AISI 420B
Hardness: 50+52 HRC

CHARACTERISTICS

- 1) COMPLETE GAS RELEASE;
- 2) IMPROVEMENT OF THE AESTHETIC CHARACTERISTICS OF THE PART;
- 3) INJECTION PRESSURE DRAMATICALLY REDUCED;
- 4) EASY TO REMOVE AND EASY MAINTENANCE.



CODE: EB-MINI



SAITO MOLD Mfg.co.ltd
Patented system



CODE	A	B	C	D	E	F	G	H
EB-MINI	10	22,0	8,5	11	14	7,5	4	4

Mat.: AISI 420B
Hardness: 50+52 HRC

CHARACTERISTICS

- 1) COMPLETE GAS RELEASE;
- 2) IMPROVEMENT OF THE AESTHETIC CHARACTERISTICS OF THE PART;
- 3) INJECTION PRESSURE DRAMATICALLY REDUCED;
- 4) EASY TO REMOVE AND EASY MAINTENANCE.

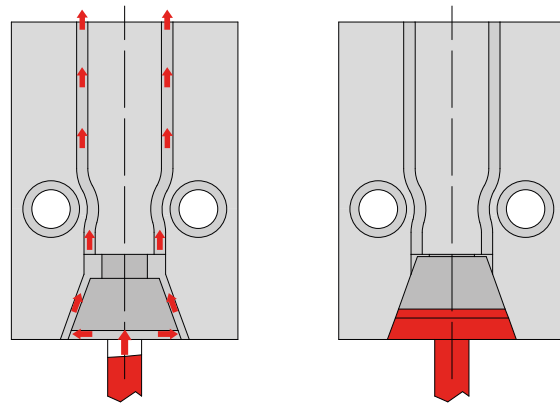
Venting issues produce bad quality parts and can also put the mould itself at risk. Voids, bubbles, short shots and surface defects such as blemishes or burn marks produce rejected parts and dramatically reduce the mould profitability .

ECOVENT is an innovative solution able to solve the most familiar effects of poor venting and to reduce the maintenance of venting grooves and channels.

ECOVENT is based on a simple mechanical system that allows the gas to escape from a venting window a few square millimeter wide that automatically closes down under plastic flow front pressure. As a consequence the pressure inside the cavity decreases significantly allowing to modify the injection parameters and optimize the filling pattern. ECOVENT can be applied at last filling point or at runner side according to part design and aesthetic demands. Application on runner allows anyway a pressure decrease: according to Bernoulli's principle an increase in the speed of the fluid occurs simultaneously with a decrease in pressure. With the application of ECOVENT the speed of gas flowing into the runner increases causing a pressure drop, the pressure gradient between runner and cavity intakes the gas from the cavity into the runner and outside of the mould through ECOVENT.

WORKING SYSTEM

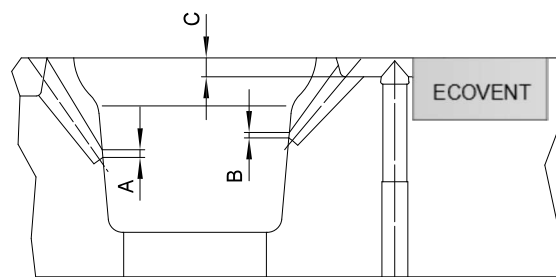
During the injection process the spring keeps the slider in "OPEN POSITION" allowing the gas to pour out through the proper channels. When the flow front reaches ECOVENT the slider moves back under plastic pressure and closes the gas venting channels. ECOVENT working system is not based on the over flow concept, the small mark called "TAB" is a kind of certification that the gas has been completely released.



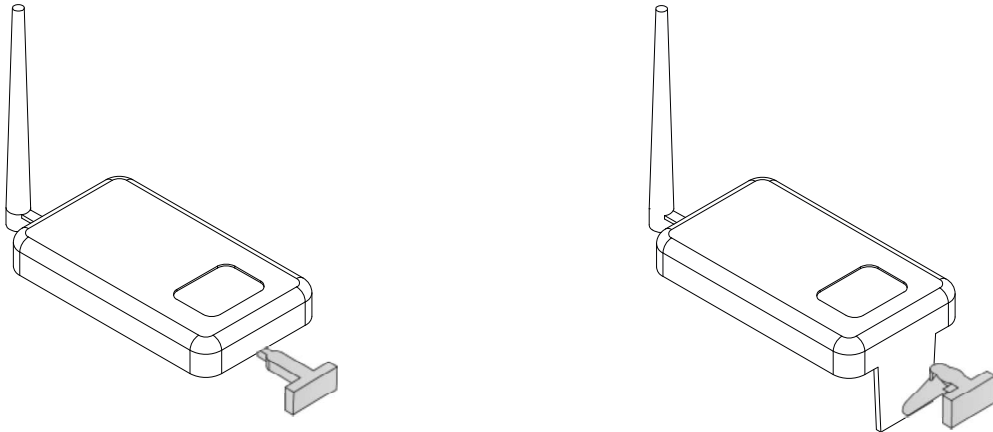
APPLICATION EXAMPLE

ECOVENT can be connected to last filling point of the cavity with a "submarine" channel. With such a design it is possible to automatically cut the connecting channel during the ejection of the injected part.

The dimension of the venting hole "B" has to be as big as possible in order to help the gas venting.



APPLICATION AT LAST FILLING POINT

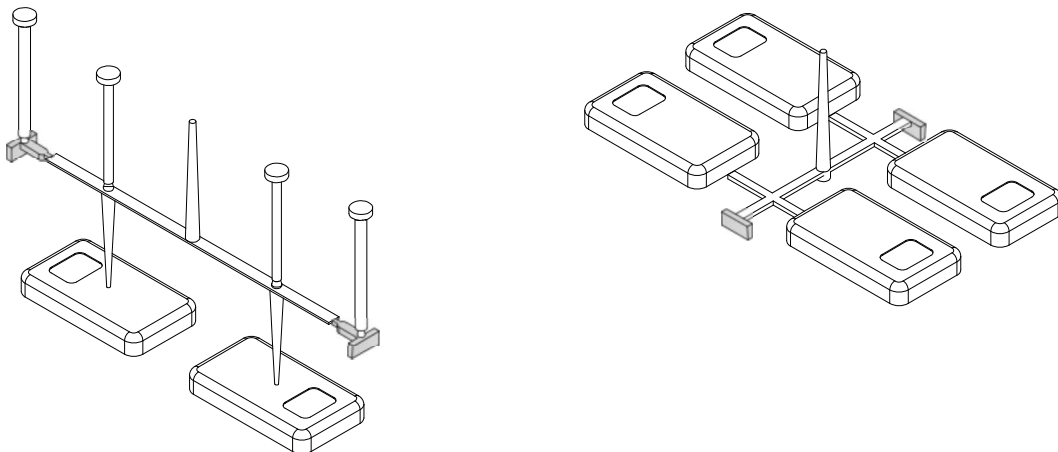


During the filling phase the plastic flow front pushes air and gases contained in the cavity trough ECOVENT where a big gas vent channel is open. In such a condition the plastic feels the cavity with a very low backpressure and the injection pressure decreases accordingly.

The main positive outcomes are:

- In cavity pressure dramatically reduced
- Part quality improvement
- Extended mold maintenance frequency

APPLICATION AT RUNNER SIDE



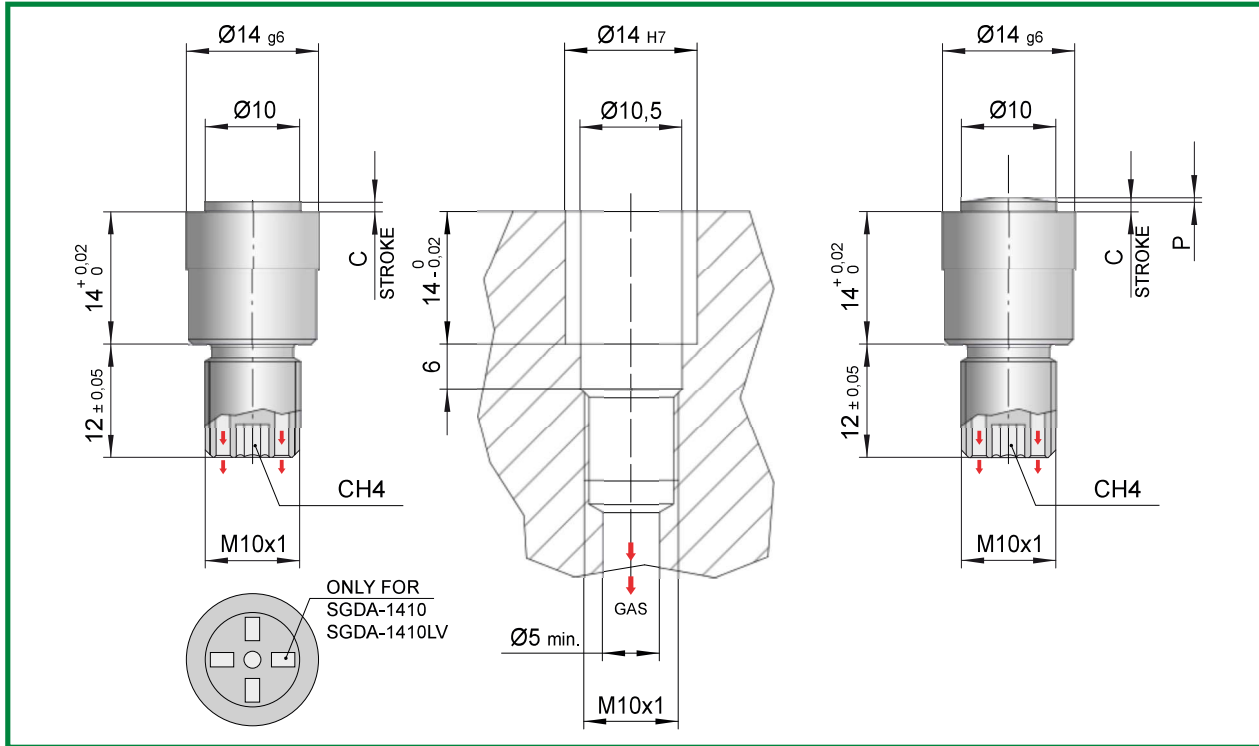
With ECOVENT application a big gas venting area is set up at the end of the runner that allows the gases produced during the melting process to flow through the system instead of flowing into the cavity.

Moreover it avoids to compress the air contained into the sprue and runner into the cavity and, according to Bernoulli's principle, it is possible to extract air from the cavity itself

The main positive outcomes are:

- Extended mold maintenance frequency
- Part quality improvement
- Reduced in cavity pressure

DYNAMIC GAS VENTING SYSTEM

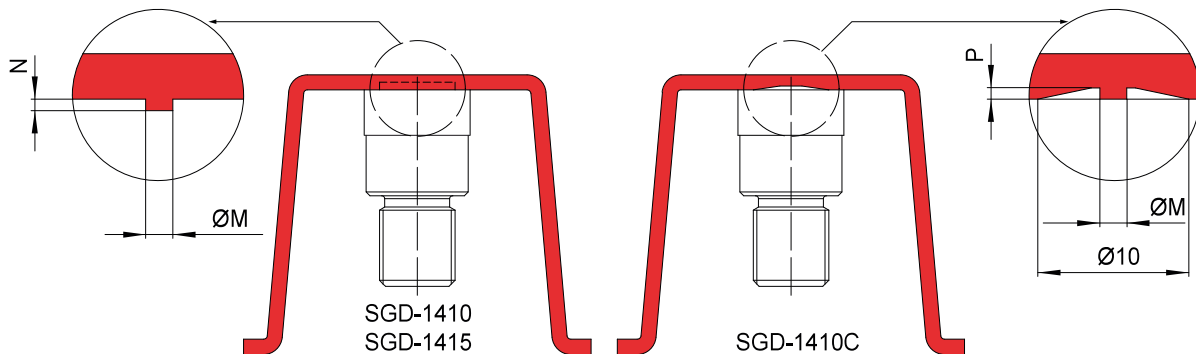


ONLY FOR HIGH VISCOSITY MATERIALS

CODE	C	M	N	P
SGD-1410	1	2	0,5	/
SGDA-1410	1	2	0,5	/
SGD-1410C	1	2	/	0,5
SGD-1415	1,5	/	/	/

Mat.: AISI 420B

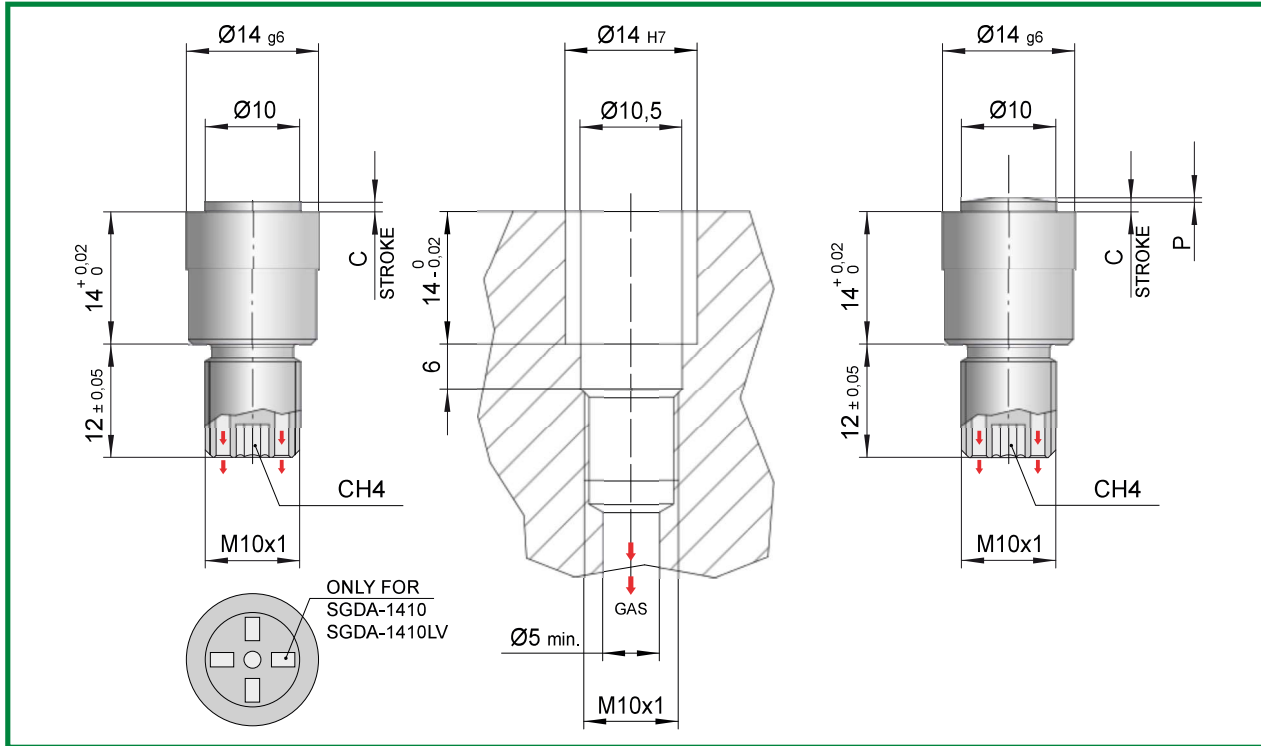
Hardness: 50+52 HRC



CHARACTERISTICS

1. HIGH VENTING CAPACITY;
2. VENTING SURFACE NOT AFFECTED BY MOLD DEPOSITS;
3. IN CAVITY AIR BACK PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF AESTHETIC CHARACTERISTICS OF THE INJECTED PART;
5. POSSIBILITY OF FRONT DISASSEMBLY.

DYNAMIC GAS VENTING SYSTEM

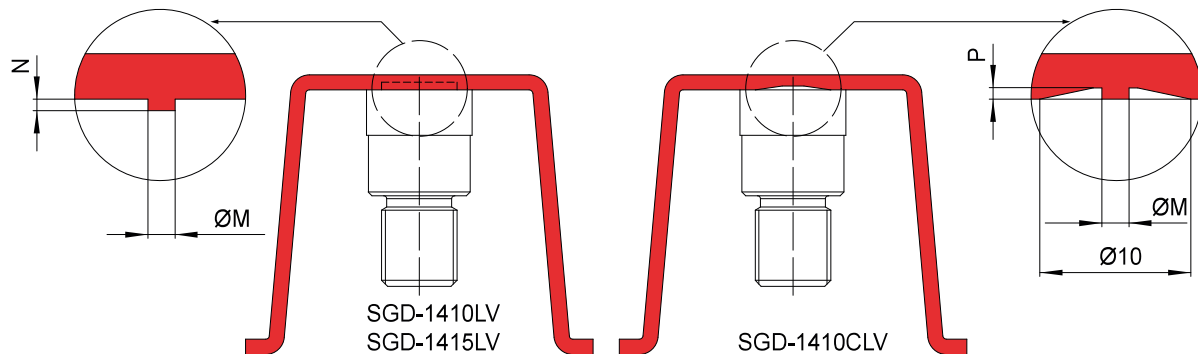


SUITABLE ALSO FOR LOW VISCOSITY MATERIALS

CODE	C	M	N	P
SGD-1410LV	1	1,2	0,5	/
SGDA-1410LV	1	1,2	0,5	/
SGD-1410CLV	1	1,2	/	0,5
SGD-1415LV	1,5	/	/	/

Mat.: AISI 420B

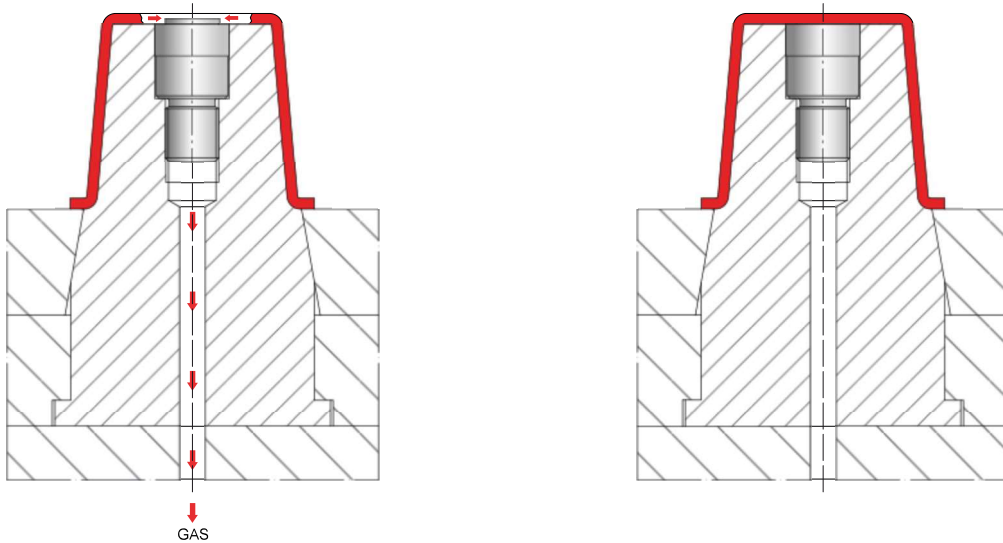
Hardness: 50+52 HRC



CHARACTERISTICS

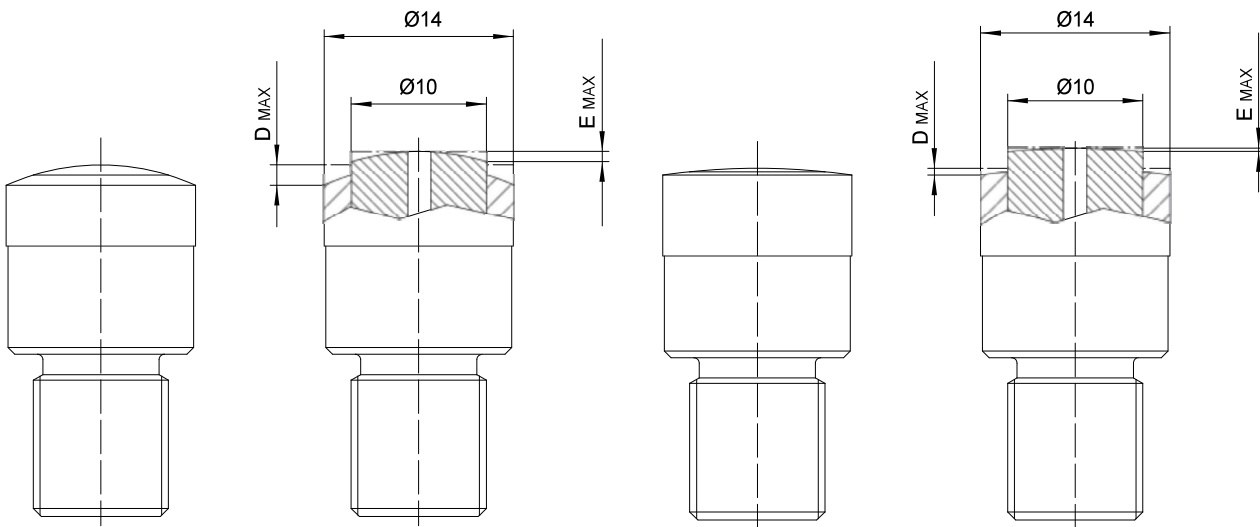
1. HIGH VENTING CAPACITY;
2. VENTING SURFACE NOT AFFECTED BY MOLD DEPOSITS;
3. IN CAVITY AIR BACK PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF AESTHETIC CHARACTERISTICS OF THE INJECTED PART;
5. POSSIBILITY OF FRONT DISASSEMBLY.

WORKING SYSTEM



During the injection process the spring keeps the sliding insert in “open position” allowing the gases to pour out through the hole on the top of the valve. When the flow front reaches SGD the sliding insert moves back under plastic pressure to “close position” and closes the gas venting hole.

SHAPING MACHINING



MODEL: SGD-1410

MODEL: SGD-1415

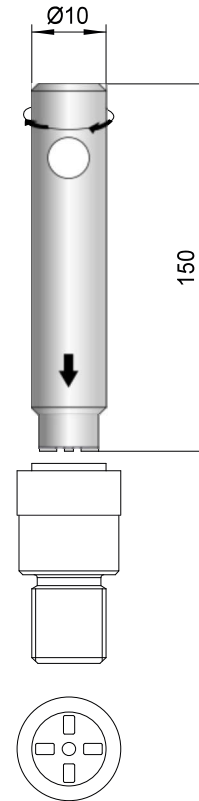
CODE	D	E
SGD-1410	1,5	0,75
SGD-1415	0,5	0,25

The SGD valve can be shaped within the maximum limit shown in the above picture.

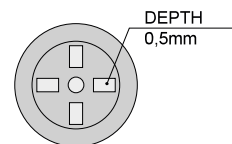
FRONT UNSCREWING

The valve code SGDA-1410 can be screwed and unscrewed thanks to the special key code CS-SGDA. This application makes faster and simpler the valve maintenance procedure.

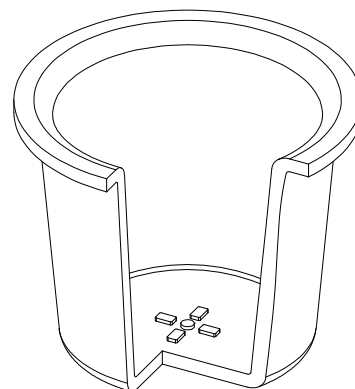
CODE: CS-SGDA



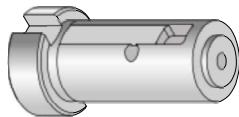
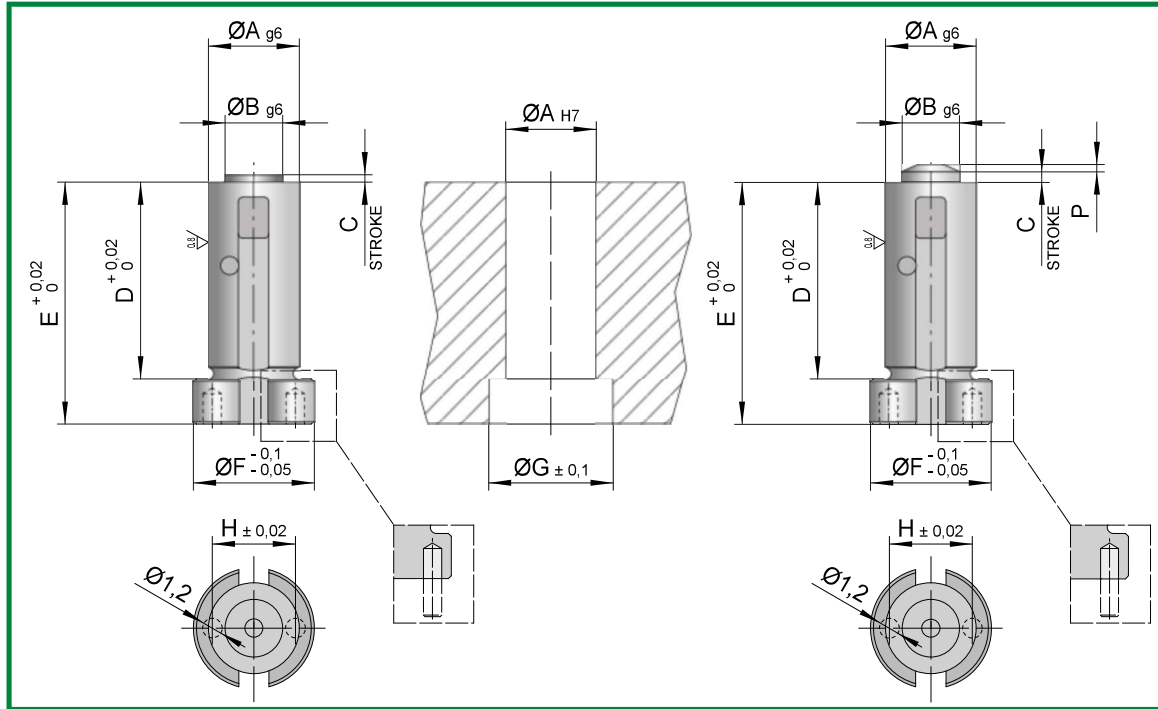
The top surface of the valve type SGDA-1410 is machined to fit the key code CS-SGDA.



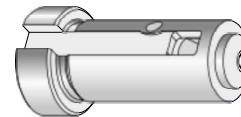
Such special machining creates four protrusions thickness 0,5 mm on the injected part.



DYNAMIC GAS VENTING SYSTEM



CODE: SGD-605 / SGD-608



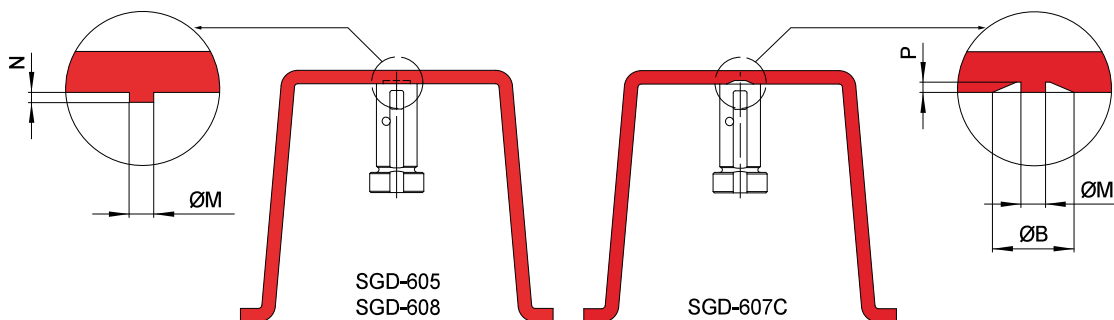
CODE: SGD-607C

CODE	A	B	C	D	E	F	G	H	M	N	P
SGD-605	6	4	0,5	13	16	8	8,5	5,5	1,2	0,3	/
*SGD-608	6	4	0,8	13	16	8	8,5	5,5	/	/	/
SGD-607C	6	4	0,7	13	16	8	8,5	5,5	1,2	/	0,5

Mat.: AISI 420B

Hardness: 50+52 HRC

* It is necessary to inject an air blast after ejection of plastic part. (See technical notes)

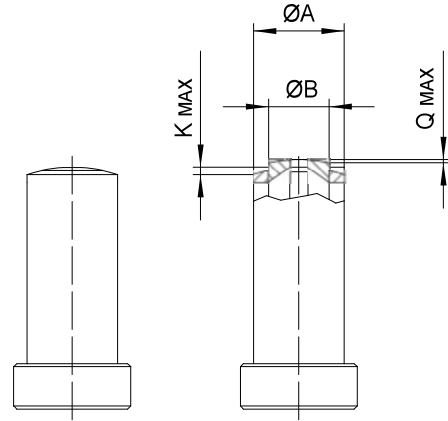


CHARACTERISTICS

1. HIGH VENTING CAPACITY;
2. VENTING SURFACE NOT AFFECTED BY MOLD DEPOSITS;
3. IN CAVITY AIR BACK PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF AESTHETIC CHARACTERISTICS OF THE INJECTED PART.

SHAPING MACHINING

The SGD-6.. valves can be shaped within the maximum limit shown in the above picture.



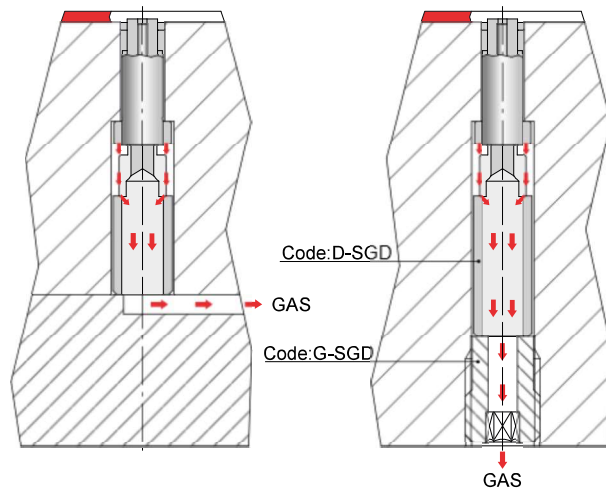
CODE	A	B	K	Q
SGD-605	6	4	0,5	0,25
SGD-608	6	4	0,5	0,25

APPLICATION EXAMPLE

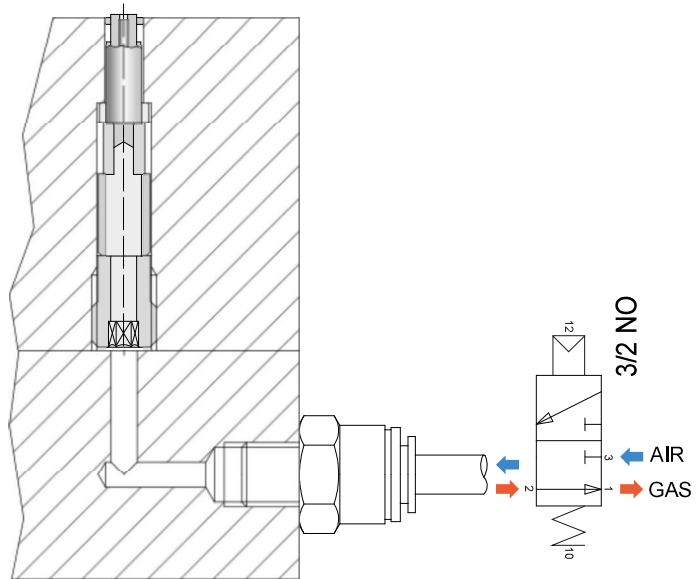
The valve type SGD-6.. has to be fixed into the mold insert from the back side. The spacer code D-SGD and the dowel code G-SGD can make this application easier.

The spacer is specially designed to collect the gases from the valve toward a central hole that communicates with the open atmosphere. It is possible to machine the spacer in order to reach the desired length.

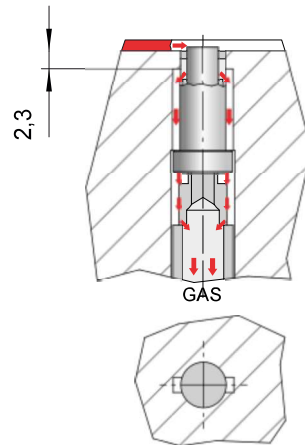
The dowel allows to fix the spacer and the valve and collects the gases into the central hole.



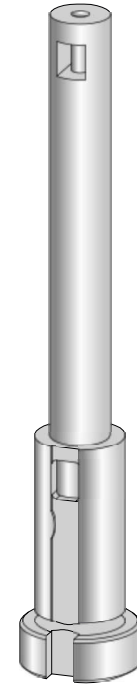
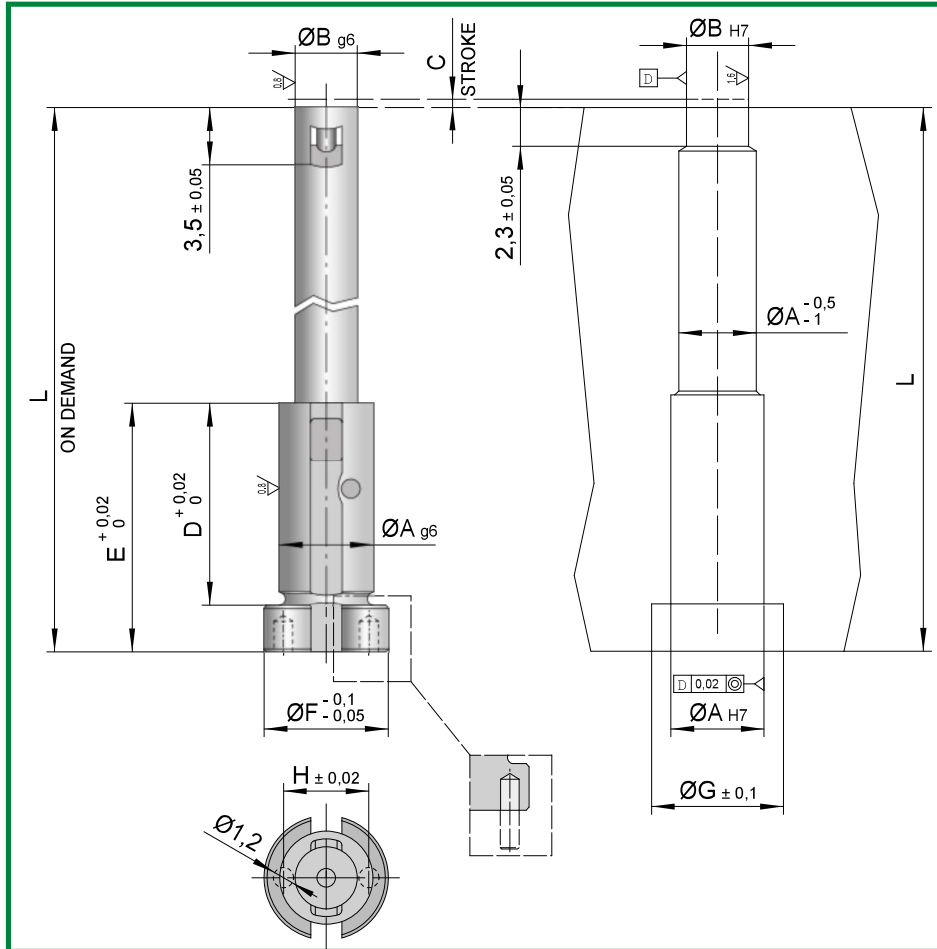
For a correct application of the venting valve code: SGD-608 it is necessary to inject an air blast after ejection of plastic part, the air will guarantee the valve to open every shot. With a normally open 3/2 valve it is possible to use the gas venting channel also to inject the air blast.



Some polymeric materials produce remarkable gas volume during melting process. Oily gas deposits can pile up and obstruct the gas venting channels. It is possible to machine extra gas venting channel in the mold as shown in the picture to improve valve performance.



DYNAMIC GAS VENTING SYSTEM

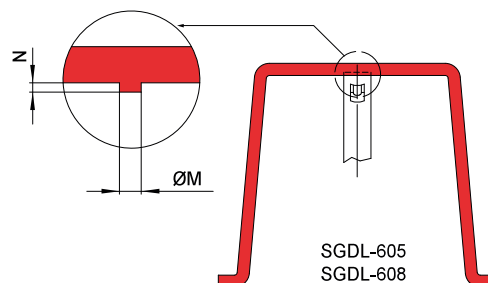


CODE: SGDL-...

CODE	A	B	C	D	E	F	G	H	L (min)	L (max)	M	N
SGDL-605	6	4	0,5	13	16	8	8,5	5,5	20	105	1,2	0,3
*SGDL-608	6	4	0,8	13	16	8	8,5	5,5	20	105	/	/

Mat.: AISI 420B Hardness: 50+52 HRC

* It is necessary to inject an air blast after ejection of plastic part. (See technical notes)

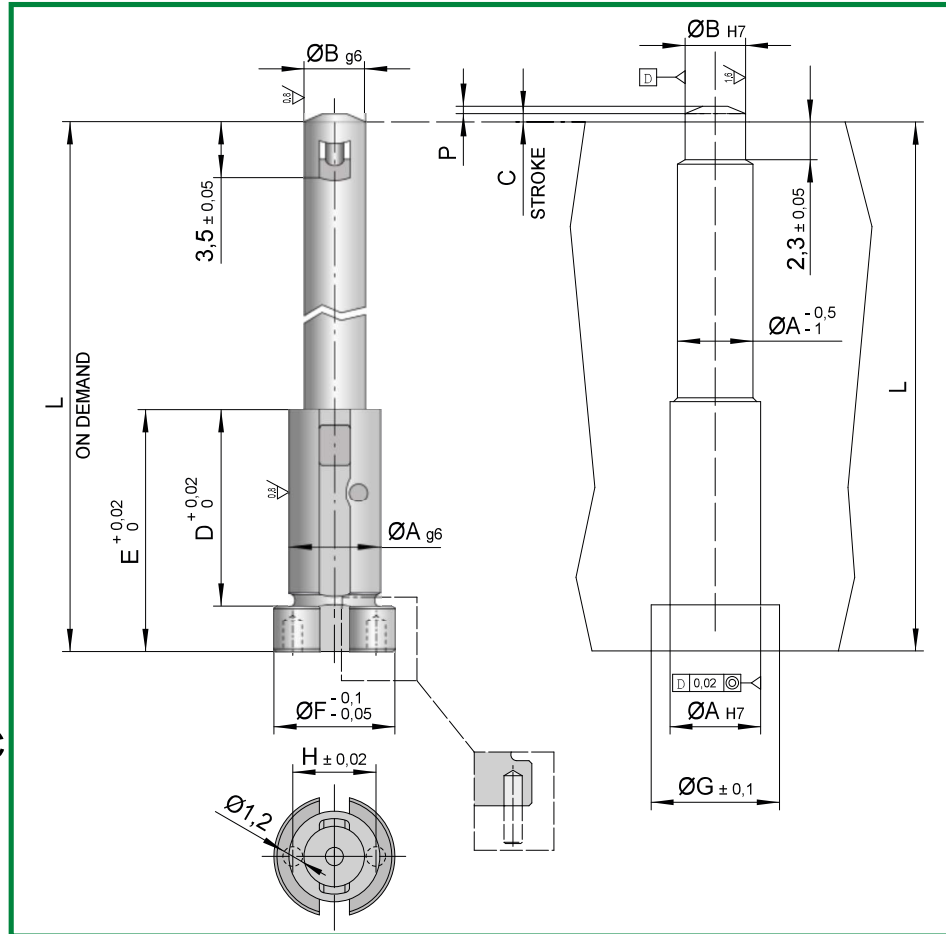


CHARACTERISTICS

1. HIGH VENTING CAPACITY;
2. VENTING SURFACE NOT AFFECTED BY MOLD DEPOSITS;
3. IN CAVITY AIR BACK PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF AESTHETIC CHARACTERISTICS OF THE INJECTED PART;
5. LIMITED DIMENSIONS;
6. MAXIMUM AVAILABLE LENGTH 105mm.



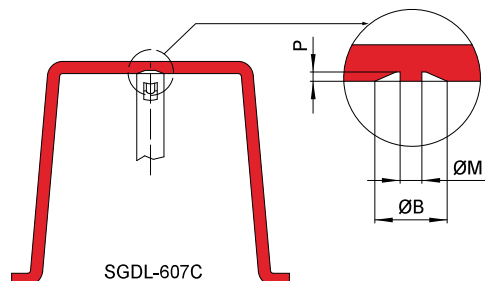
CODE: SGDL-607C



CODE	A	B	C	D	E	F	G	H	L (min)	L (max)	M	N	P
SGDL-607C	6	4	0,7	13	16	8	8,5	5,5	20	105	1,2	/	0,5

Mat.: AISI 420B

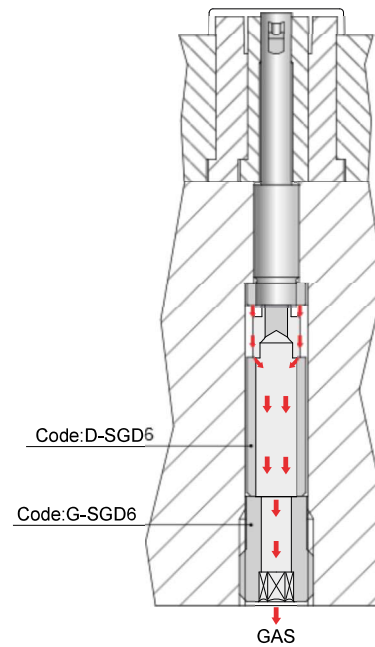
Hardness: 50+52 HRC



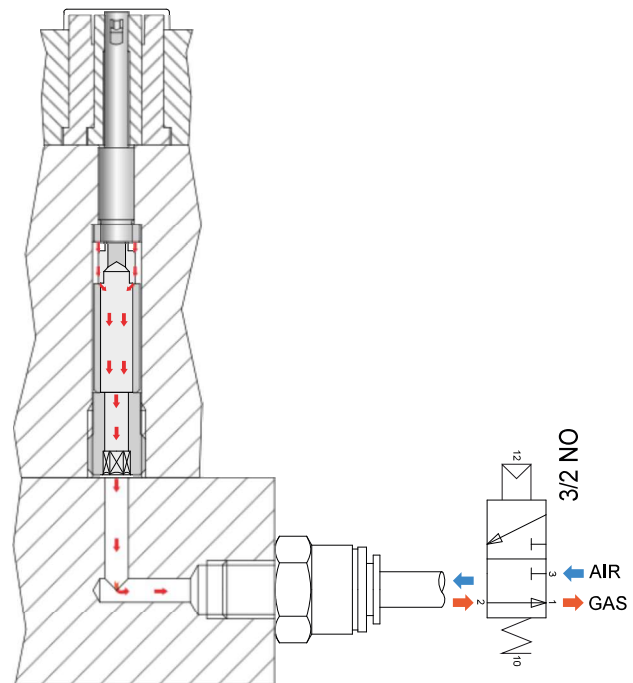
CHARACTERISTICS

1. HIGH VENTING CAPACITY;
2. VENTING SURFACE NOT AFFECTED BY MOLD DEPOSITS;
3. IN CAVITY AIR BACK PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF AESTHETIC CHARACTERISTICS OF THE INJECTED PART;
5. LIMITED DIMENSIONS;
6. MAXIMUM AVAILABLE LENGTH 105mm.

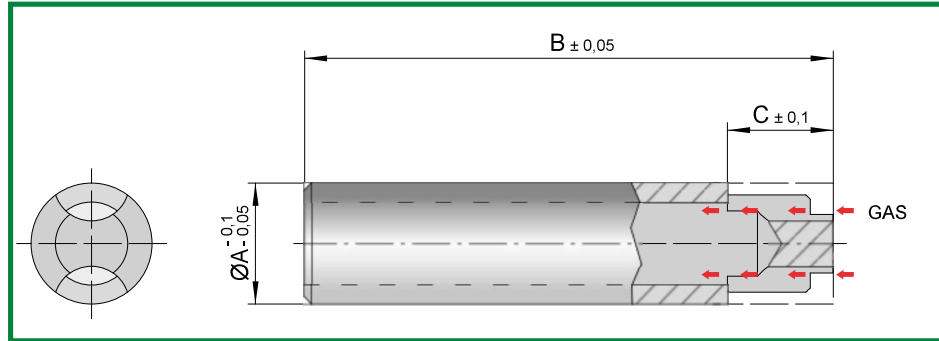
The valve type SGDL has to be fixed into the mold insert from the back side and the valve needle has to stick out from the mold surface for a dimension equal to the stroke "C". The spacer code D-SGD.. and the dowel code G-SGD.. can make this application easier. The spacer is specially designed to collect the gases from the valve toward a central hole that communicates with the open atmosphere. It is possible to machine the spacer in order to reach the desired length. The dowel allows to fix the spacer and the valve and collects the gases into the central hole.



For a correct application of the venting valve Code: SGDL-608 it is necessary to inject an air blast after ejection of plastic part, the air will guarantee the valve to open every shot. With a normally open 3/2 valve it is possible to use the gas venting channel also to inject the air blast.



SPACER FOR GAS VENTING VALVE

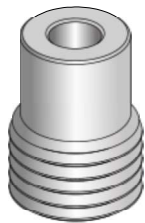


CODE: D-SGD..

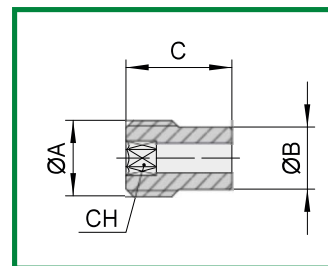
CODE	A	B	C
D-SGD6	8	50	7

Mat.: carbon steel. Hardness: 750 N/mm² (220 HB)
Nitred depth 0,1mm

DOWEL FOR GAS VENTING VALVE



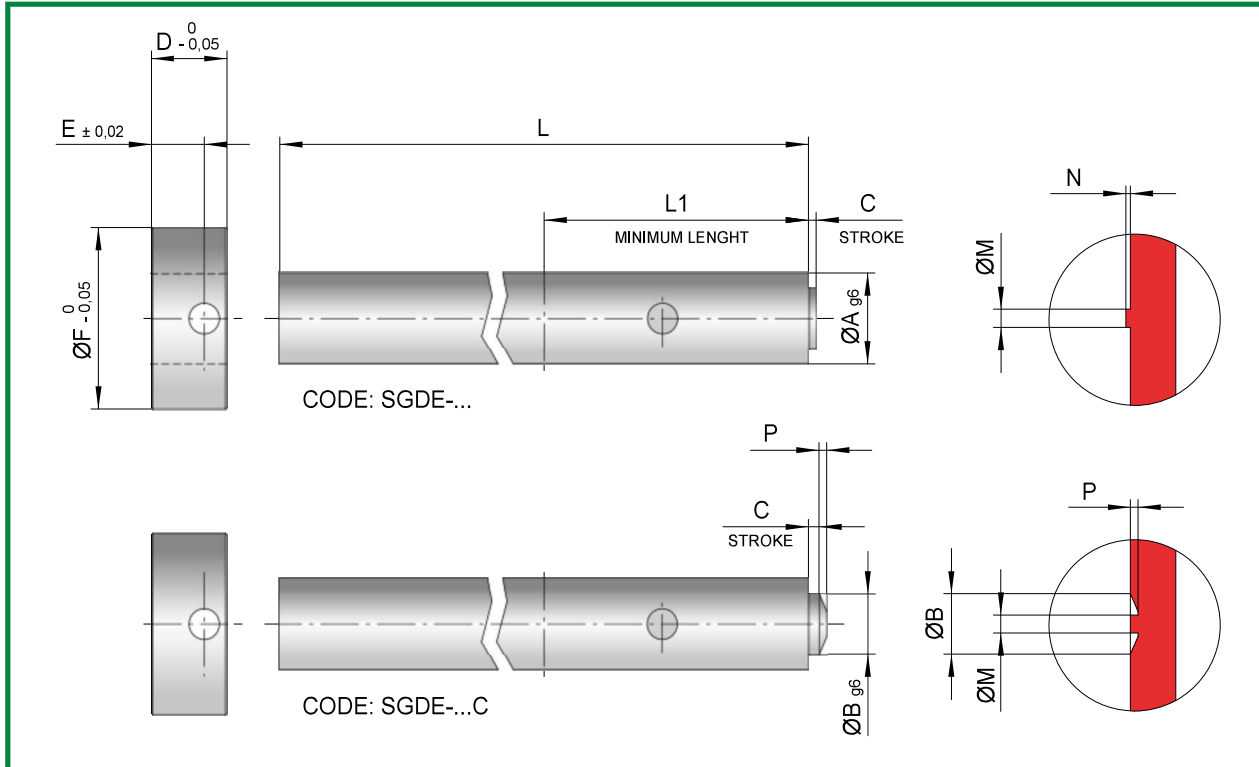
CODE: G-SGD..



CODE	A	B	C	CH
G-SGD6	M10	8,3	14	4

Mat.: 7225. Hardness: 750 N/mm² (220 HB)
Nitred depth 0,1mm

DYNAMIC GAS VENTING EJECTOR PIN



CODE	A	B	C	D	E	F	M	N	P	L1	L	
SGDE-605	6	4	0,5	5	3,5	12	1,2	0,3	/	35	300	400
SGDE-607C	6	4	0,7	5	3,5	12	1,2	0,5	0,5	35	300	400
*SGDE-608	6	4	0,8	5	3,5	12	/	/	/	35	300	400
SGDE-805	8	4	0,5	5	3,5	14	1,2	0,3	/	35	300	400
SGDE-807C	8	4	0,7	5	3,5	14	1,2	0,5	0,5	35	300	400
*SGDE-808	8	4	0,8	5	3,5	14	/	/	/	35	300	400
SGDE-1005	10	4	0,5	5	3,5	16	1,2	0,3	/	35	300	400
SGDE-1007C	10	4	0,7	5	3,5	16	1,2	0,5	0,5	35	300	400
*SGDE-1008	10	4	0,8	5	3,5	16	/	/	/	35	300	400

Order example: SGDE-605x300

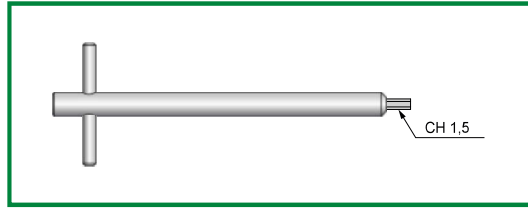
Mat. valve: AISI 420B Hardness: 50±52 HRC

Mat. ejector pin: 1.2344 Hardness: 950 HV

* It is necessary to inject an air blast after ejection of plastic part. (See technical notes)

CHARACTERISTICS

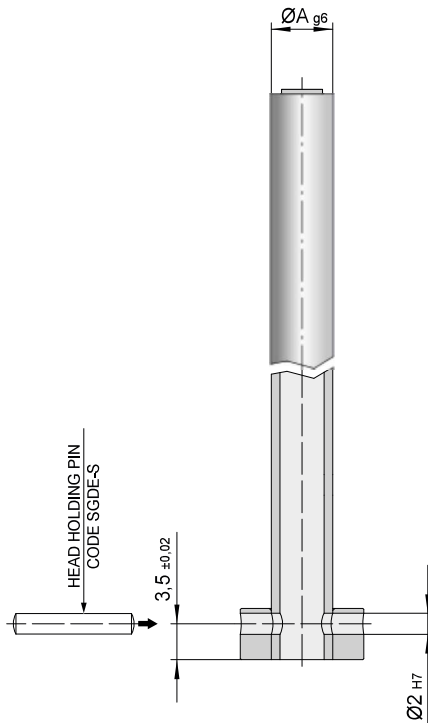
1. HIGH VENTING CAPACITY;
2. MOLD DEPOSITS CANNOT PLUG UP THE VENTING SURFACE;
3. CAVITY AIR COUNTER PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF PART'S AESTHETIC CHARACTERISTICS;
5. INTERCHANGEABLE WITH STANDARDIZED DIN EJECTOR PINS;
6. ADJUSTABLE LENGTH;
7. CUSTOM SIZES AVAILABLE.



CODE: SGDE-CH

ASSEMBLY

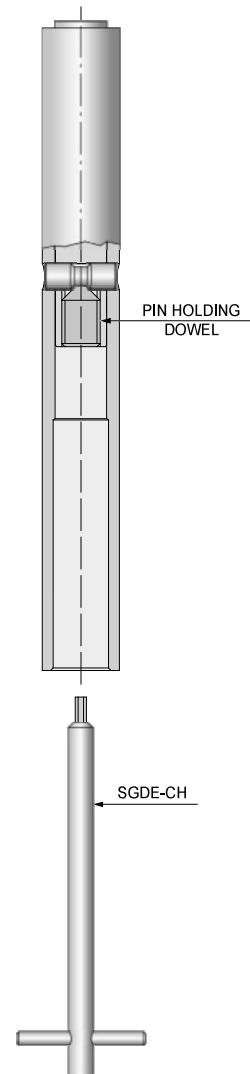
- Cut the ejector rod to the desired length.
- Machine on the ejector rod the hole to fit the head-holding pin.
- Insert the ejector head and fix it with the pin code SGED-S.



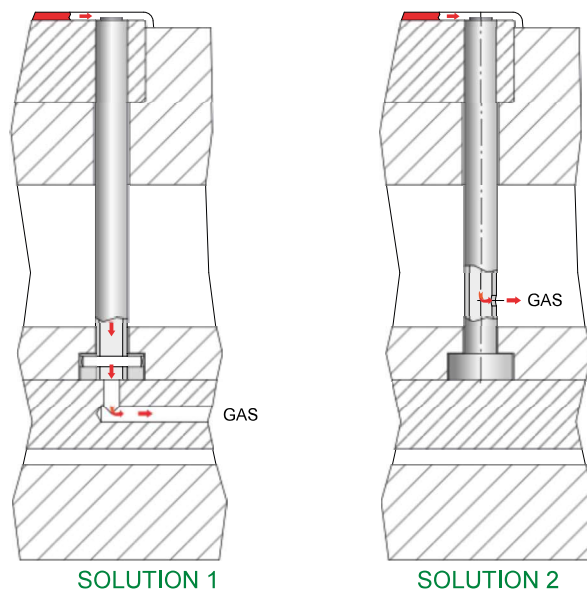
CLEANING AND MAINTENANCE

It is possible to disassembly the dynamic venting valve with the following procedure:

- Remove the head holding pin and the ejector head.
- Unscrew the internal dowel with the key SGDE-CH, remove the valve holding pin and extract the venting valve from ejector front side.



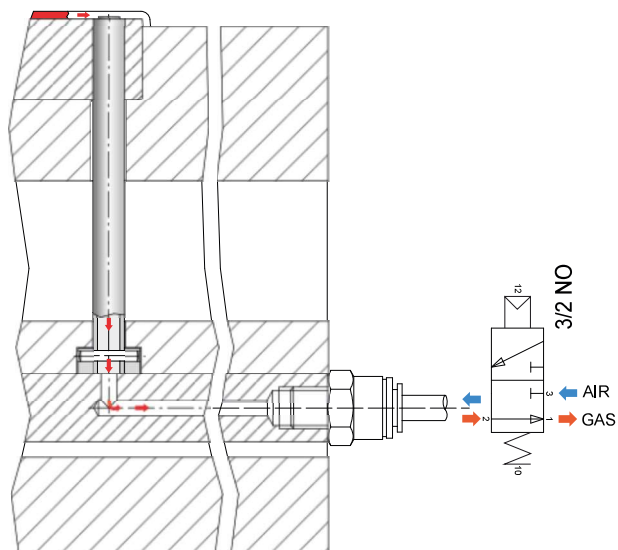
- The gas can flow out of the ejector pin through a hole machined in the ejector plate or in the ejector rod.



TECHNICAL INSTRUCTIONS FOR THE APPLICATION OF CODE SGDE-608/808/1008

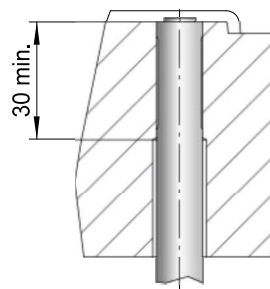
For a correct application of the venting valve code: SGDE-608/808/1008 it is necessary to inject an air blast after ejection of plastic part, the air will guarantee the valve to open every shot.

With a normally open 3/2 valve it is possible to use the gas venting channel also to inject the air blast.

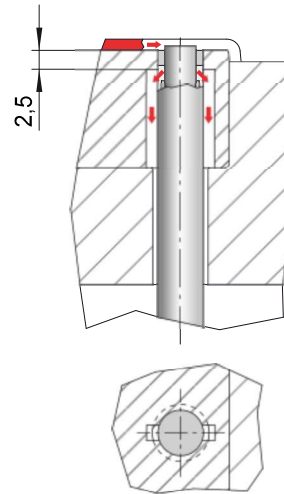


TECHNICAL INSTRUCTIONS FOR THE APPLICATION OF CODE SGDE-608/808/1008

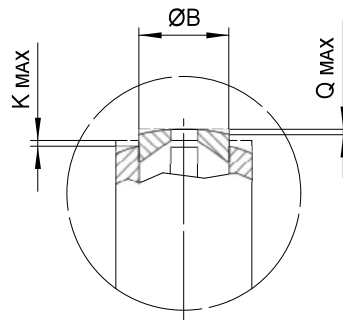
- It is necessary to guide the ejector pin for at least 30mm.



Some polymeric materials produce remarkable gas volume during melting process. Oily gas deposits can pile up and obstruct the gas venting channels. It is possible to machine extra gas venting channel in the mold as shown in the picture to improve valve performance.



SHAPING MACHINING



CODE	B	K	Q
SGDE-605/805/1005	4	0,5	0,25
SGDE-608/808/1008	4	0,25	0,25