MVG55 Valve Gate
The back plate must be cooled and must not exceed 100°C.
The cylinder should be in the closed position at all times except during injection and packing.

**Air quality:** Filtered to 40 μM and lubricated

**Minimum air:** pressure 4 Bar

**Maximum air:** pressure 10 Bar

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**Key Features**

- Suitable for most materials
- Cylindrical shut off recommended
- Conical shut off requires precise adjustment so as not to overload the gate
- Ø5.0mm pin
- Air actuated

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**figure. 1**
MVG55 Overall Dimensions

Note: Pins are supplied in standard length and must be cut to required length before installation.

Pins can be supplied finished ready to use by Mastip

Refer to page MVG55-6 Pin Calculations section to calculate required final pin lengths

<table>
<thead>
<tr>
<th>Description</th>
<th>Nozzle</th>
<th>Tip</th>
<th>Nozzle Length</th>
<th>Supplied Pin Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>MVG55-P1 Headed Pin</td>
<td>BX27</td>
<td>OV/TV</td>
<td>75 - 450</td>
<td>Ø5.0</td>
</tr>
</tbody>
</table>
Pin Details

**Caution:** The gap between the gate and the pin in a hot state is critical. If the gap is too large there will be a poor gate vestige and drooling from the nozzle may occur. If the gap is too small, the pin can strike the gate and may decrease the gate life.

To calculate final pin length use the following equation:

$$\text{Pin Length} = 29.0 + 10.0 + X + L4 + L + 0.05$$

*figure. 6*
Conical and Cylindrical Valve Gate Recommendations

<table>
<thead>
<tr>
<th>Description</th>
<th>D</th>
<th>d1</th>
<th>d2</th>
<th>AT</th>
<th>GT</th>
<th>qT</th>
<th>HT</th>
</tr>
</thead>
<tbody>
<tr>
<td>MVG55-P1 Headed Pin</td>
<td>5.0</td>
<td>3.5</td>
<td>3.45</td>
<td>3.5</td>
<td>3.5</td>
<td>2.0</td>
<td>3.0</td>
</tr>
</tbody>
</table>

Conical Valve Gate

Conical Valve Gates by arrangement with Mastip Engineering and Applications Teams

The pin will form a 0.1mm deep dimple on the part.
Pin and gate to be lapped to ensure clean shutoff.
Recommended for amorphous polymers.

Cylindrical Valve Gate

The pin will form a 0.1mm deep dimple on the part.
Recommended for semi-crystalline and filled polymers.

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**Exploded Diagram**

**MVG55 Valve Gate**

**System Overview**

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### As Supplied

**A** MVG55 CYLINDER ASSEMBLY

- Blanking Plate Screw
- Blank Plate
- Blank Plate Seal
- Pin Locking Screw
- Valve Pin Adjustment Packers
- Valve Pin
- Valve Pin Adjustment Packers
- Piston Main Seal
- Piston
- Piston Rod Seal
- Circlip
- Cylinder
- Cylinder End Seal
- Locating Spacer
- Valve Pin Seal

**B** MVG55 VALVE PIN + SEAL

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PRE INSTALLATION
1. Verify the actuator pockets and air circuits are machined in the back plate as shown in figure 5.
2. Ensure there are no sharp edges or burrs in the actuator pockets.
3. Ensure the actuator pocket and air circuits are clean.
4. Cut pins to length and profile end to conical or cylindrical form (refer nozzle approval drawing)
5. Assemble the fixed half of the mould including hot runner nozzles and manifold excluding backplate.
   → Refer to the Technical Specifications section in the Technical Guide
   Pin and seal are a matched set and must remain paired.

INSTALLATION

ONE
Ensure all components are clean

TWO

Fit the Cylinder End Seal 12 to the Cylinder 11
Apply grease* to Cylinder End Seal 12

THREE

Fit the Cylinder 11 and Locating Spacer 13 to the mould backplate and retain using the Circlip 10
Ensure Cylinder 11 is compressing Cylinder End Seal 12 to fit Circlip 10 securely in groove on Locating Spacer 13

FOUR

Apply grease* to the sealing bores of the Locating Spacer 13 and Cylinder 11 and to the pre fitted Piston Seals 7 & 9
Fit Piston 8 to the Cylinder 11

* Mastip recommends using high temperature silicon grease
Clean any residual material from the pin seal pocket and thread in the manifold.

Apply heat resistant nickel based anti-seize to the thread of the new pin seal and screw into the manifold and tighten to 20Nm.

Ensure pins slide smoothly through the pin seal after tightening.

Centralise Cylinder Assembly A to the Actuator pocket.
Fit mould backplate to mould and fasten.

**Note:** If backplate location guides start to locate first, then the cylinder assembly should self locate to the manifold. However in some case’s it may be necessary to move the cylinder assemblies in the actuator pocket to locate them with the manifold.
INSTALLATION CONT.....

**EIGHT**

Insert the Valve Pin Adjustment Packers 5b, 5c & 5d onto the Valve Pin 6.
Ensure the correct packer thickness is in the correct position. (Recommend starting with the thinnest packer above the pin head, then adjust to suit if necessary).
Fit the Valve Pin 6 to Piston 8.
Fit the remaining Valve Pin Adjustment Packer 5a above the pin head.
Fit the Pin Locking Screw 4 to the Piston 9 and tighten to 40Nm.

**NINE**

Fit Blanking Plate Seal 3 to Blanking Plate 2a or 2b.
INSTALLATION CONT.....

Fit **Blanking Plate 2a** or **2b** to the mould backplate and fasten using **Blanking Plate Screws 1**.
PIN HEIGHT ADJUSTMENT

ONE

Remove Blanking Plate or

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PIN HEIGHT ADJUSTMENT CONT.....

Remove the Pin Locking Screw 4
Remove the Valve Pin Adjustment Packer 5b
Remove the Valve Pin 6
Remove the remaining Valve Pin Adjustment Packers 5a, 5c & 5d
PIN HEIGHT ADJUSTMENT CONT.....

Minor Adjustment

Swap Valve Pin Adjustment Packers

+0.1
+0.2
+0.3

Swap Valve Pin Adjustment Packers

(2) , (3) , (4) & (5) to achieve small pin adjustments
(different packer = different height)

Major Adjustment

Move one or more Valve Pin Adjustment Packers

(2) , (3) , (4) & (5) from below the pin head to above the pin head to achieve large pin adjustment
Assemble Valve Pin 6, (ensure pins are matched to seals), Valve Pin Adjustment Packers 5a, 5b, 5c & 5d and the Pin Locking Screw 4 and tighten to 40Nm
PIN HEIGHT ADJUSTMENT CONT.....

Fit Blanking Plate 2a or 2b to the mould backplate and fasten using Blanking Plate Screws 1.
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