mastip
hot runner solutions

MVG55 Valve Gate

Assembly Overview

IMPORTANT!!

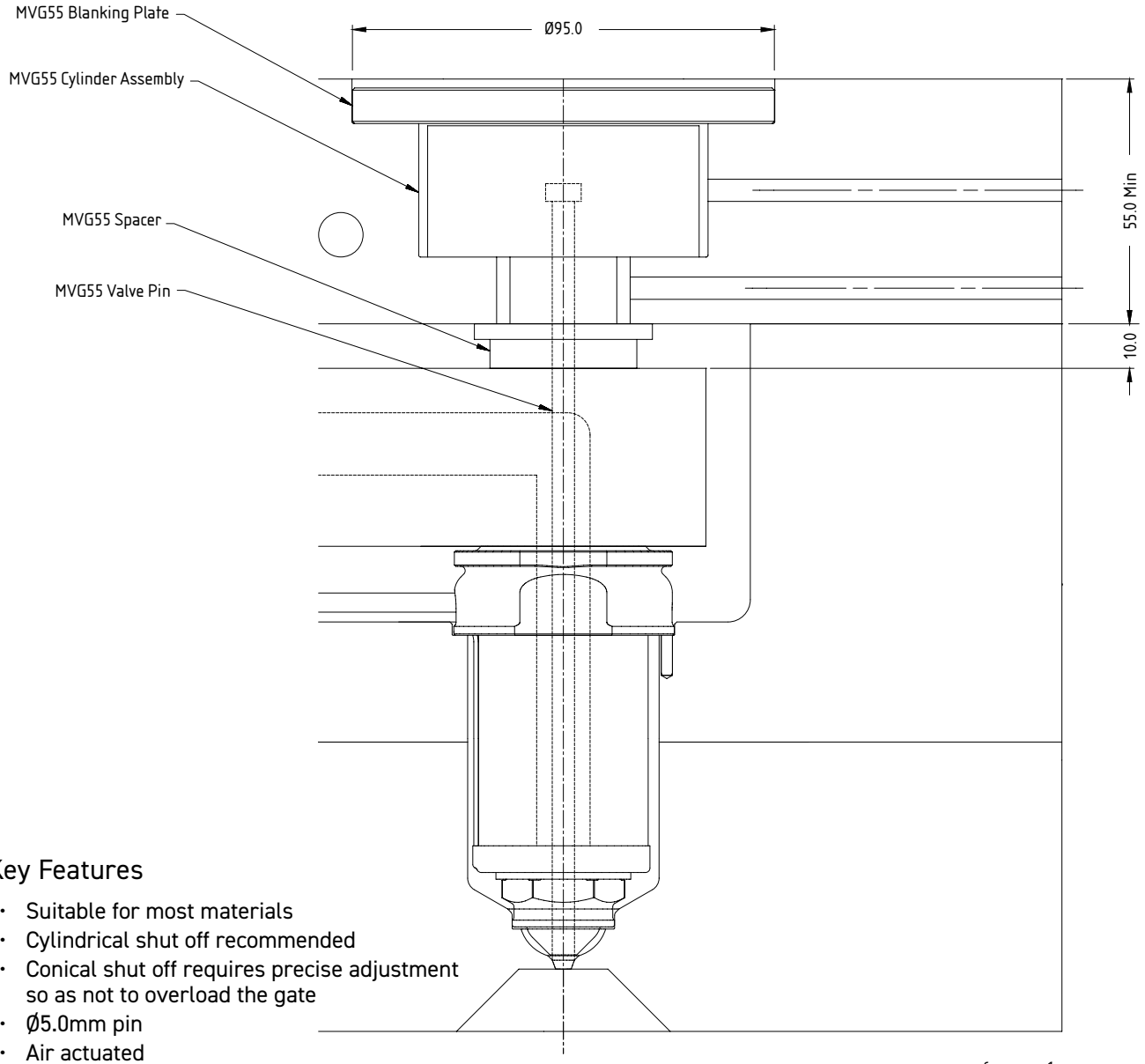
The back plate must be cooled and must not exceed 100˚C.

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



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

figure. 1

Spacing Layout

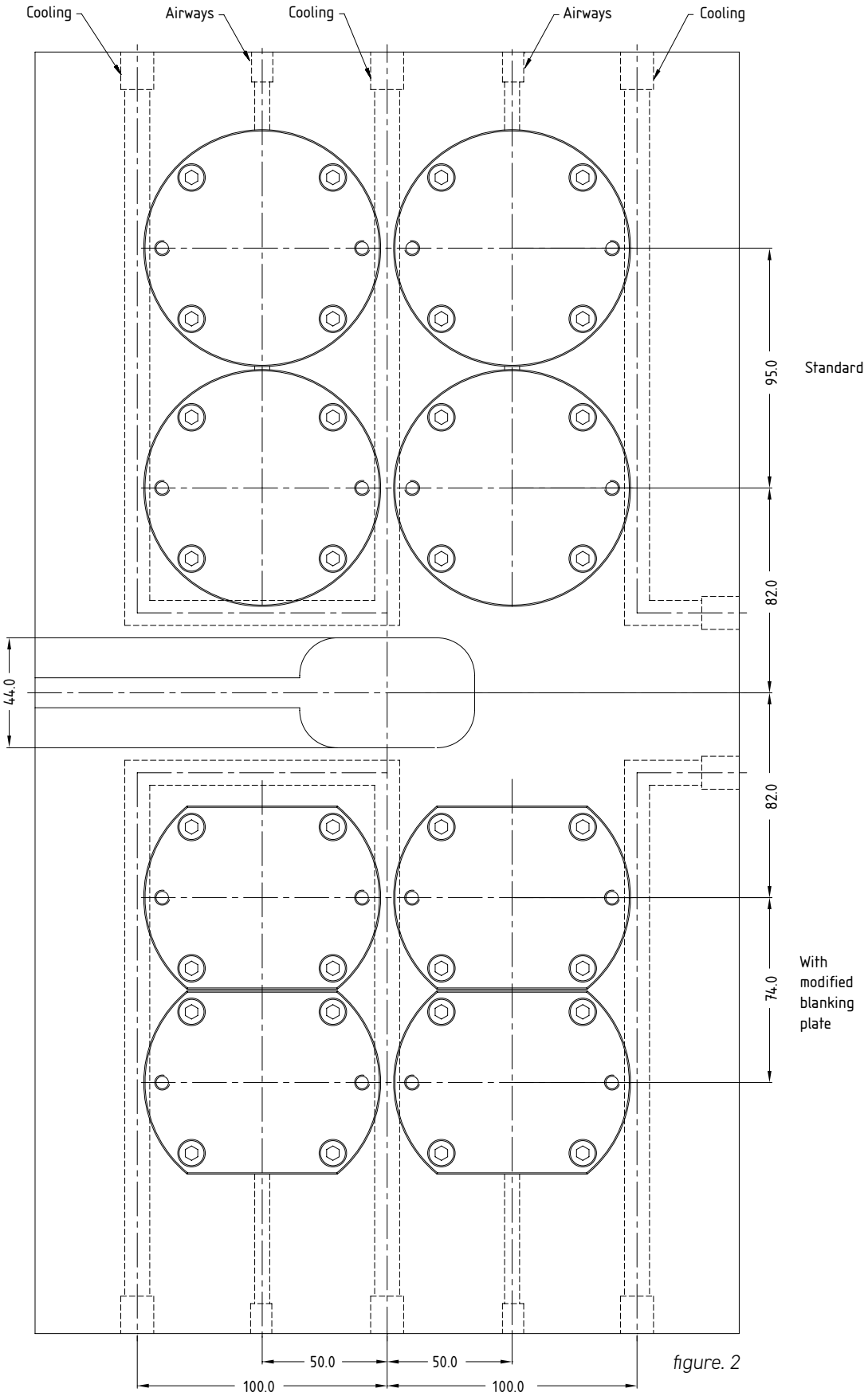


figure. 2

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

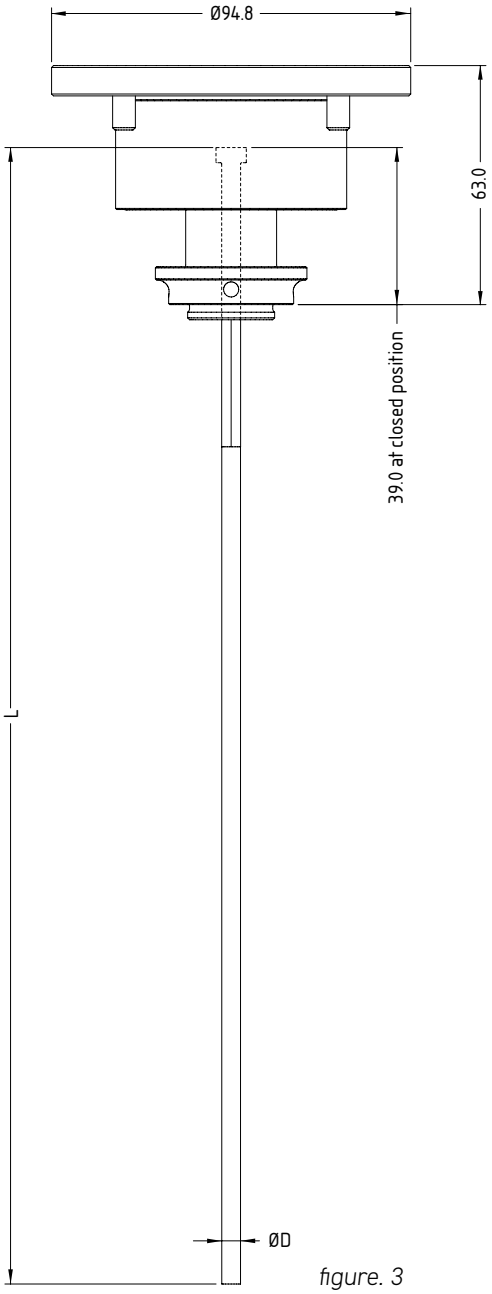


figure. 3

Nozzle Compatibility				
Description	Nozzle	Tip	Nozzle Length	Supplied Pin Size
MVG55-P1 Headed Pin	BX27	OV/TV	75 - 450	Ø5.0

Fitment

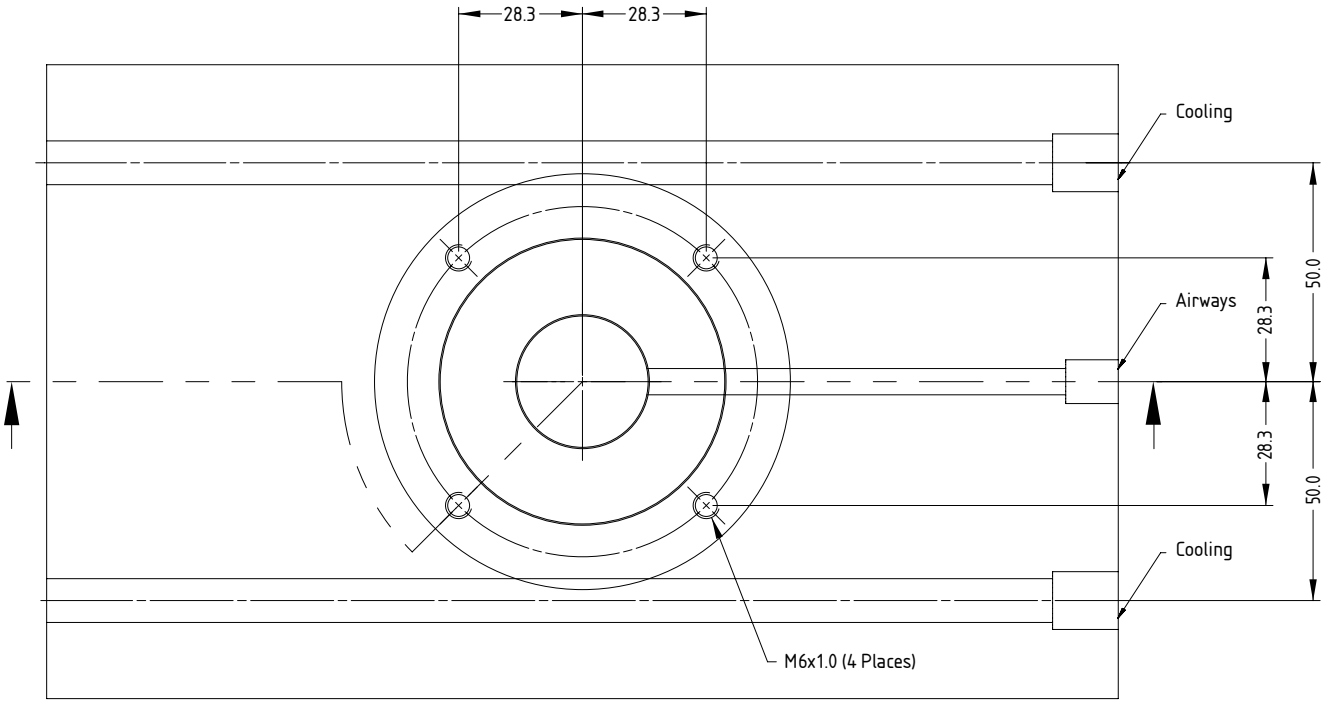


figure. 4

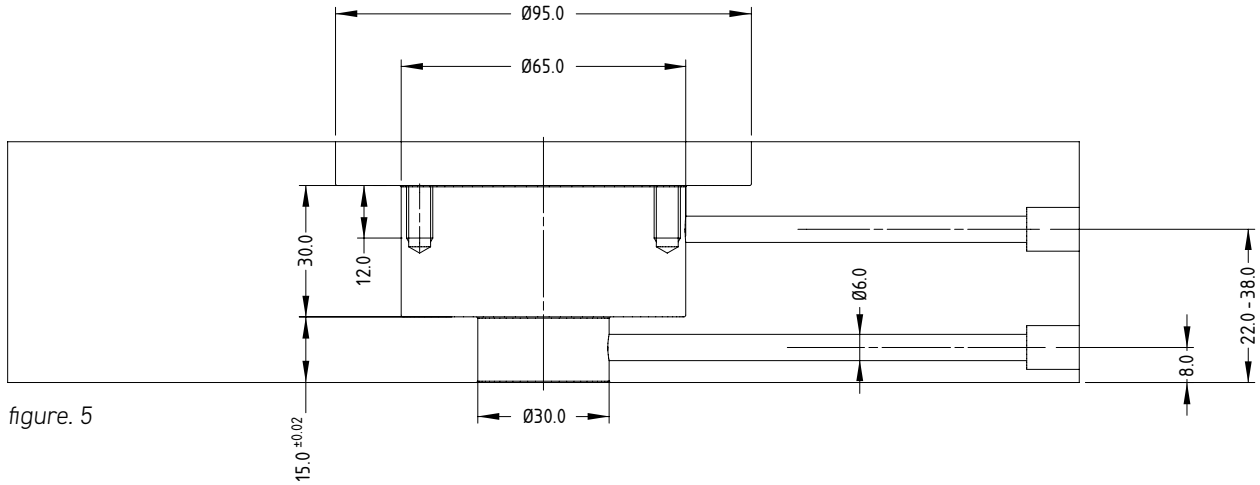


figure. 5

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:
Pin Length = 29.0 + 10.0 + X + L4 + L + 0.05

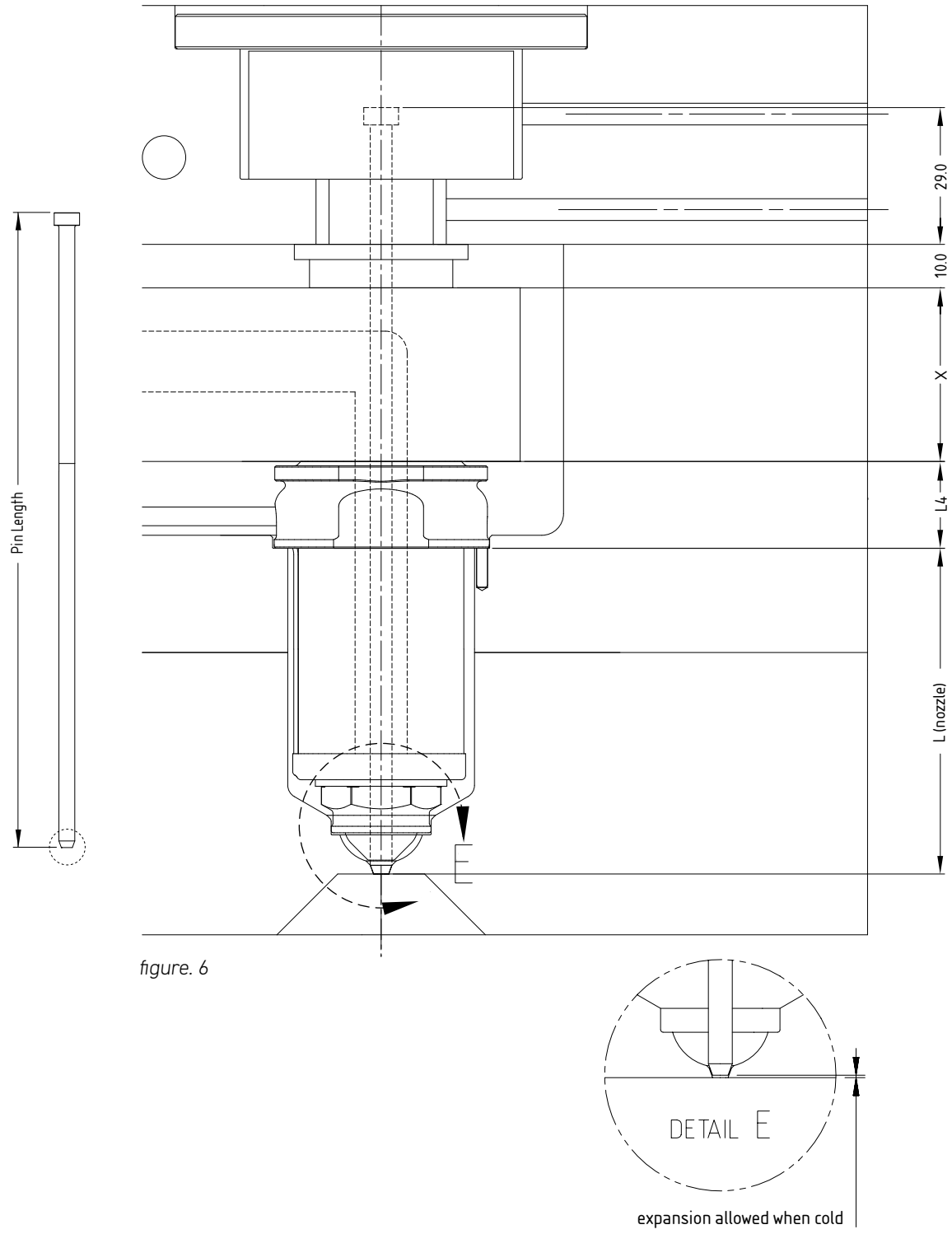


figure. 6

Conical and Cylindrical Valve Gate Recommendations

	Conical Valve Gate[1]	Cylindrical Valve Gate
Gate Quality	***	***
Pin Cooling	***	*
Filled Materials	*	***
Material with Small Moulding Window	*	***
Ease of Pin Setup	*	***
Ease of Gate Manufacture	***	**
Gate Life	***	*

Key	Value
*	Lowest Rating
***	Highest Rating

[1] **Conical Valve Gates by arrangement with Mastip Engineering and Applications Teams**

Conical Valve Gate

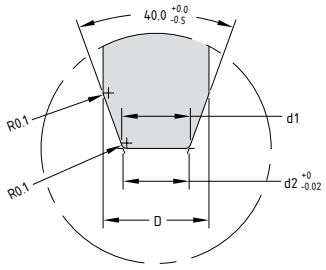
Description	D	d1	d2	AT	GT	qT	HT
MVG55-P1 Headed Pin	5.0	3.5	3.45	3.5	3.5	2.0	3.0

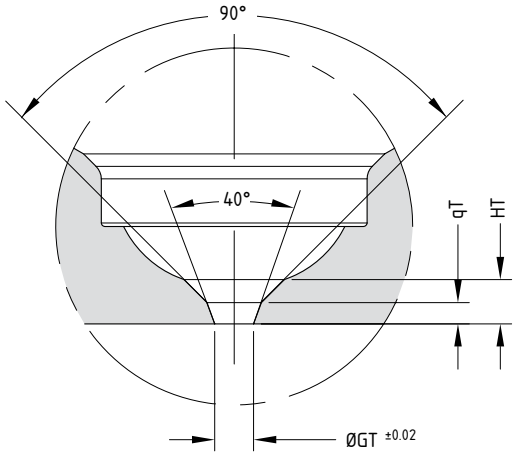
Conical Valve Gates by arrangement with Mastip Engineering and Applications Teams

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.



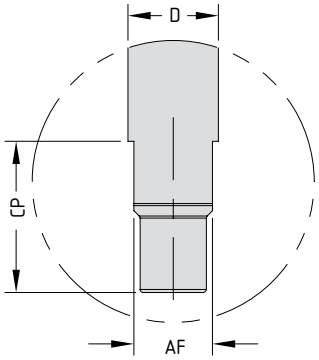


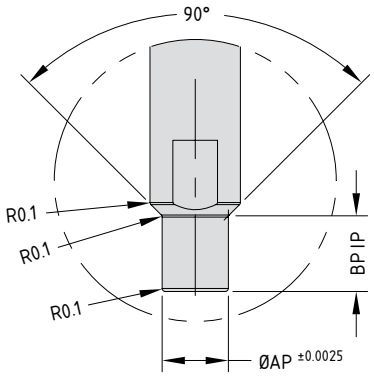
Cylindrical Valve Gate

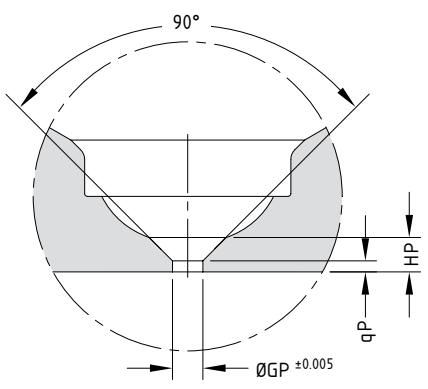
Description	D	AP	BP	AF	CP	GP	qP	HP
MVG55-P1 Headed Pin	5.0	3.492	2.5	4.4	8.0	3.505	1.3	3.0

The pin will form a 0.1mm deep dimple on the part.

Recommended for semi-crystalline and filled polymers.

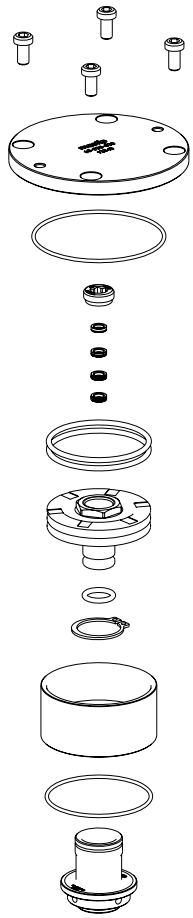






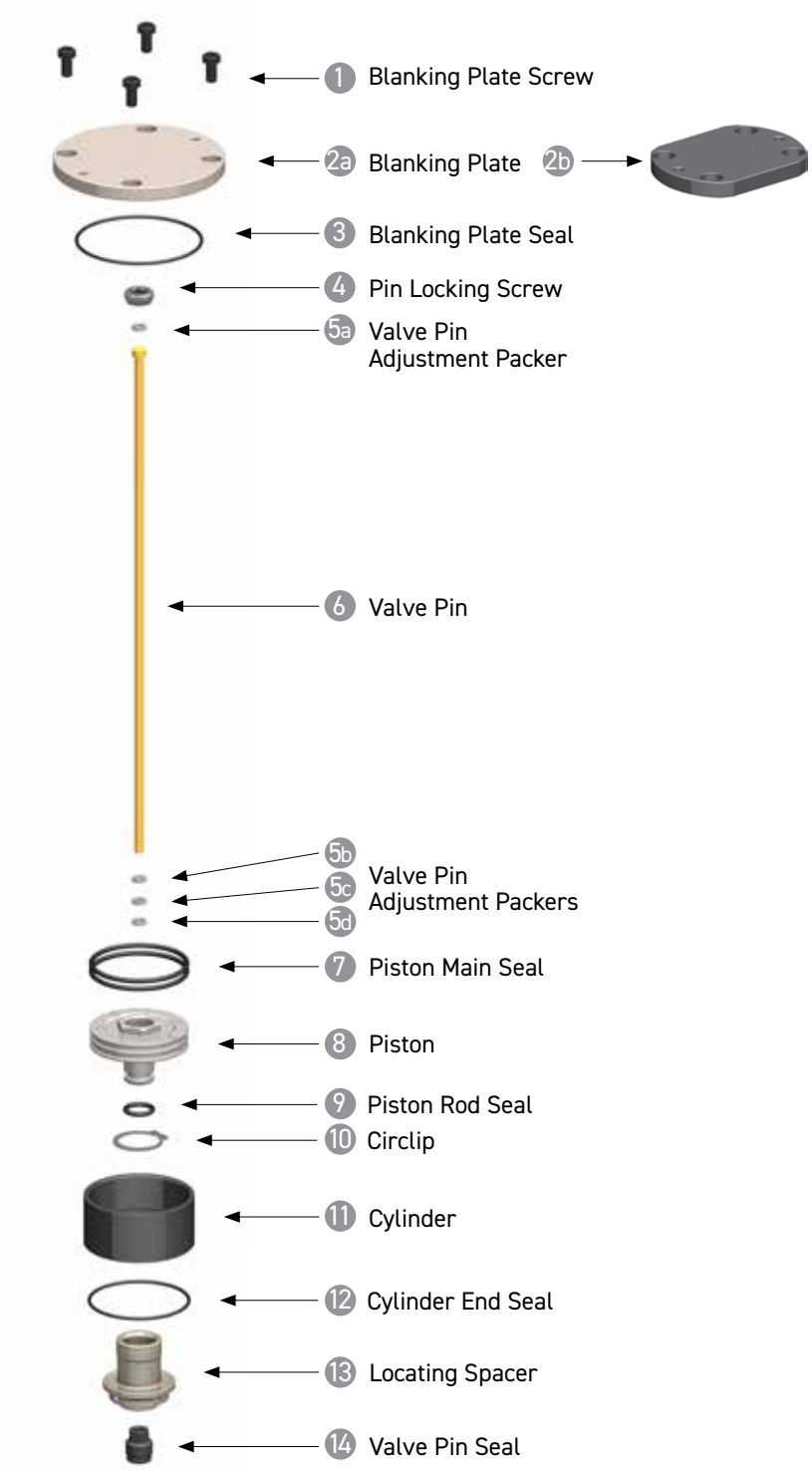
As Supplied

A MVG55 CYLINDER ASSEMBLY



B MVG55 VALVE PIN + SEAL

Exploded Diagram



Installation and Pin Adjustment Guide

PRE INSTALLATION

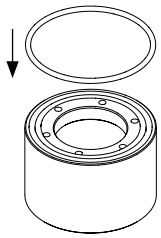
1. Verify the actuator pockets and air circuits are machined in the back plate as shown in figure 5.
2. Ensure there are no sharp edges or burrs in the actuator pockets.
3. Ensure the actuator pocket and air circuits are clean.
4. Cut pins to length and profile end to conical or cylindrical form (refer 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

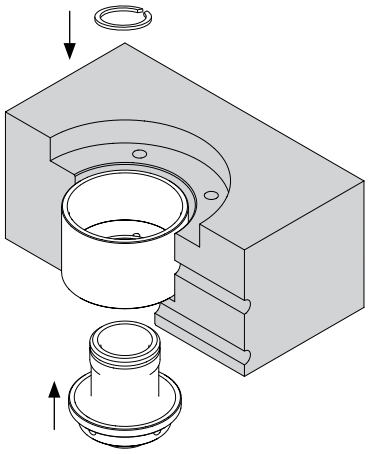
Ensure all components are clean

TWO



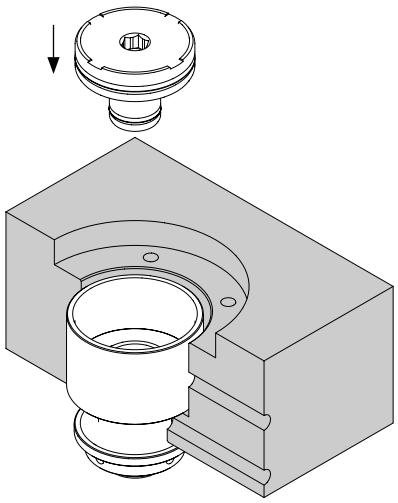
Fit the **Cylinder End Seal** 12 to the **Cylinder** 11
Apply grease* to **Cylinder End Seal** 12

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

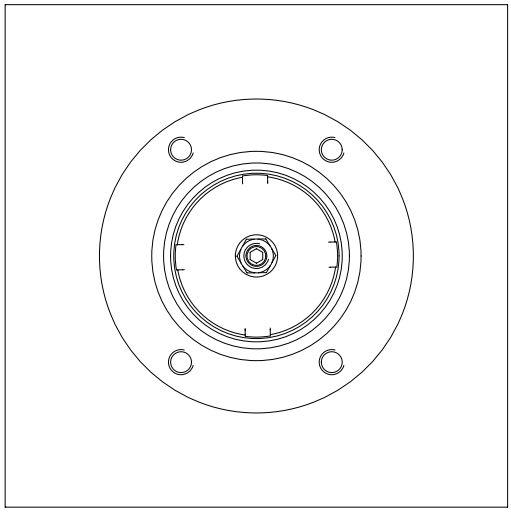


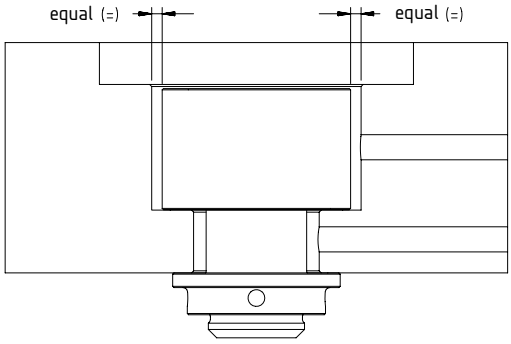
Apply grease* to the sealing bores of the **Locating Spacer** 13 and **Cylinder** 11 and to the pre fitted **Piston Seals** 7 & 9
Fit **Piston** 8 to the **Cylinder** 11

* Mastip recommends using high temperature silicon grease

INSTALLATION CONT.....

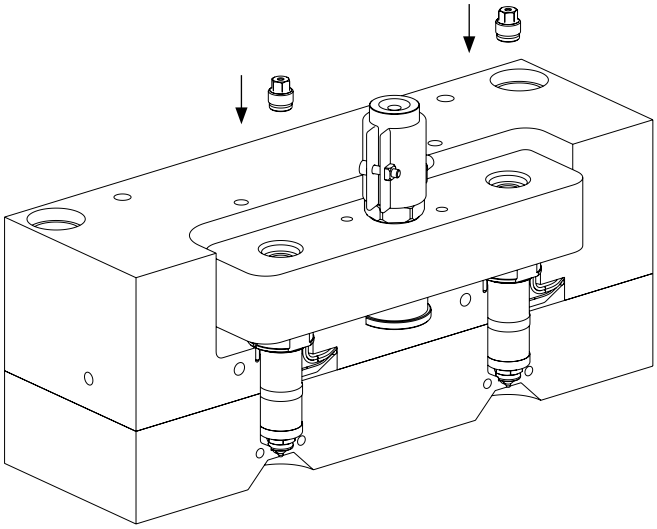
FIVE





Centralise **Cylinder Assembly** A to the Actuator pocket.

SIX



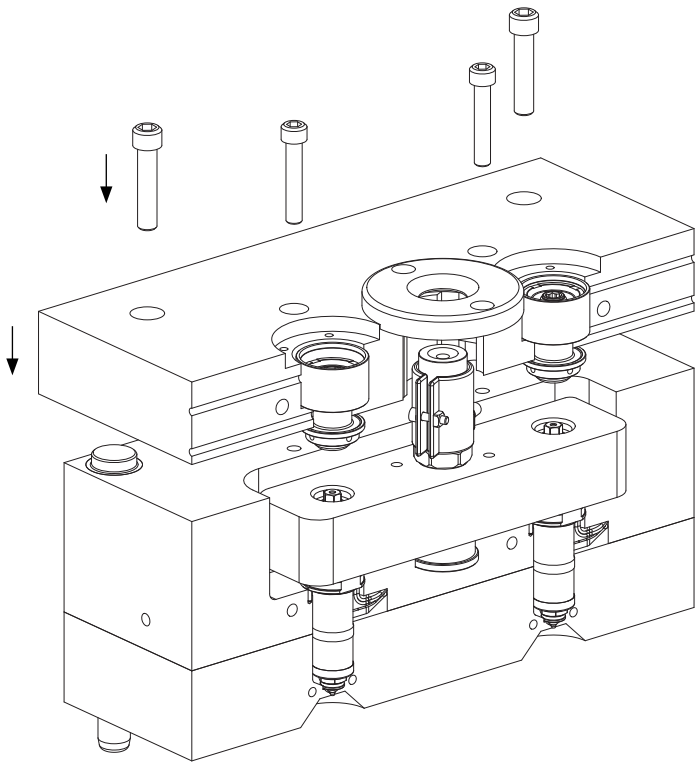
Clean any residual material from the pin seal pocket and thread in the manifold.

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.

INSTALLATION CONT.....

SEVEN

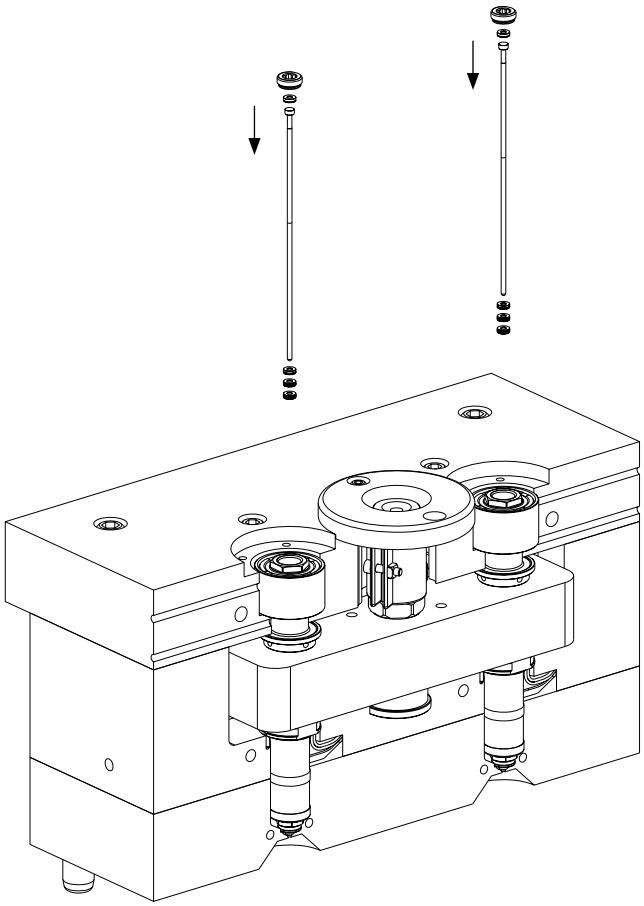


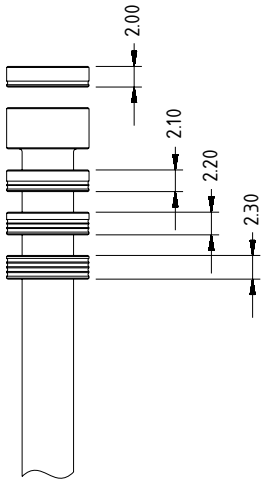
Fit mould backplate to mould and fasten.

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.....

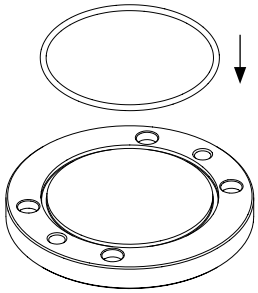
EIGHT





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.

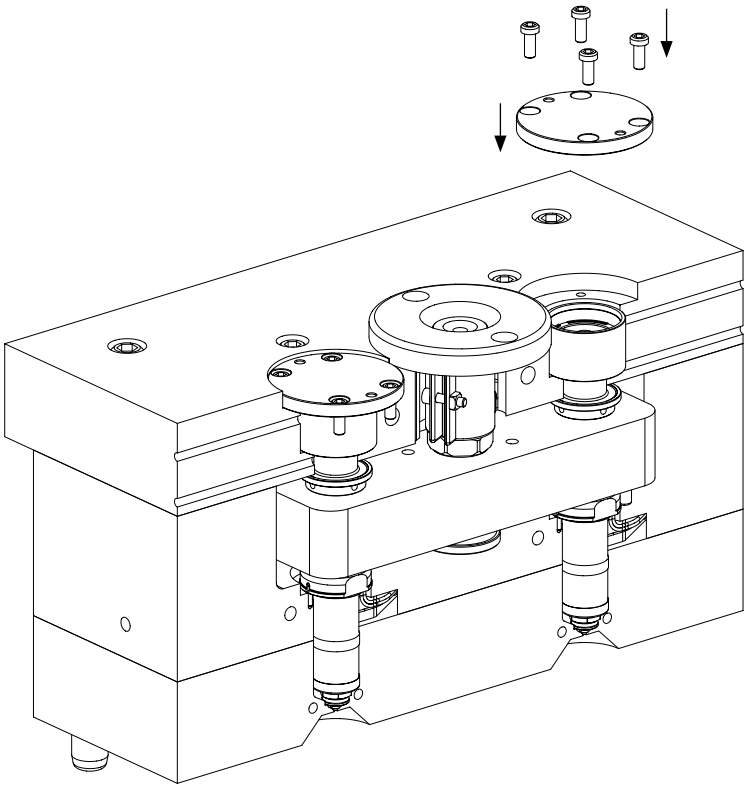
NINE



Fit **Blanking Plate Seal** 3 to **Blanking Plate** 2a or 2b

INSTALLATION CONT.....

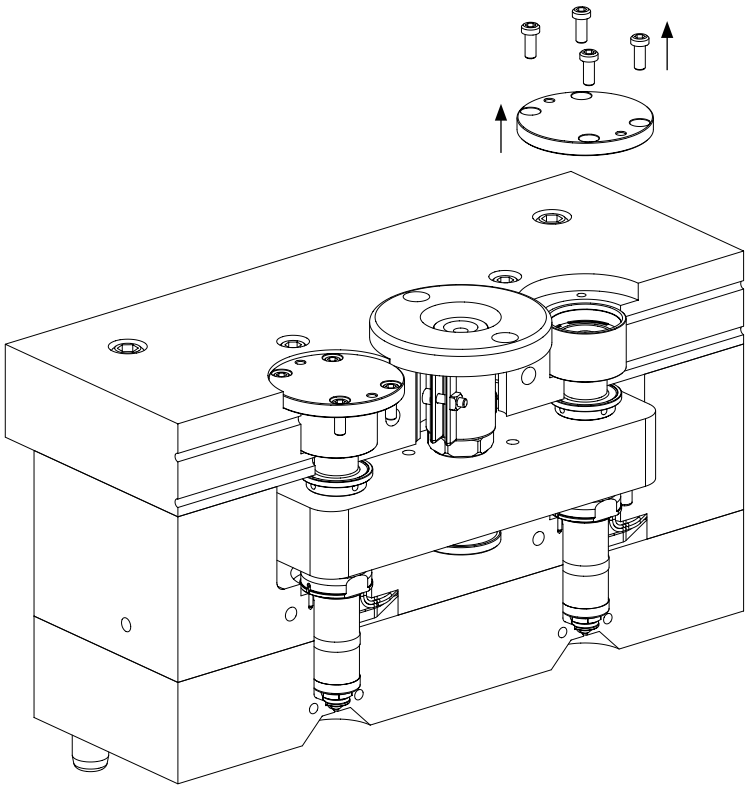
TEN



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

PIN HEIGHT ADJUSTMENT

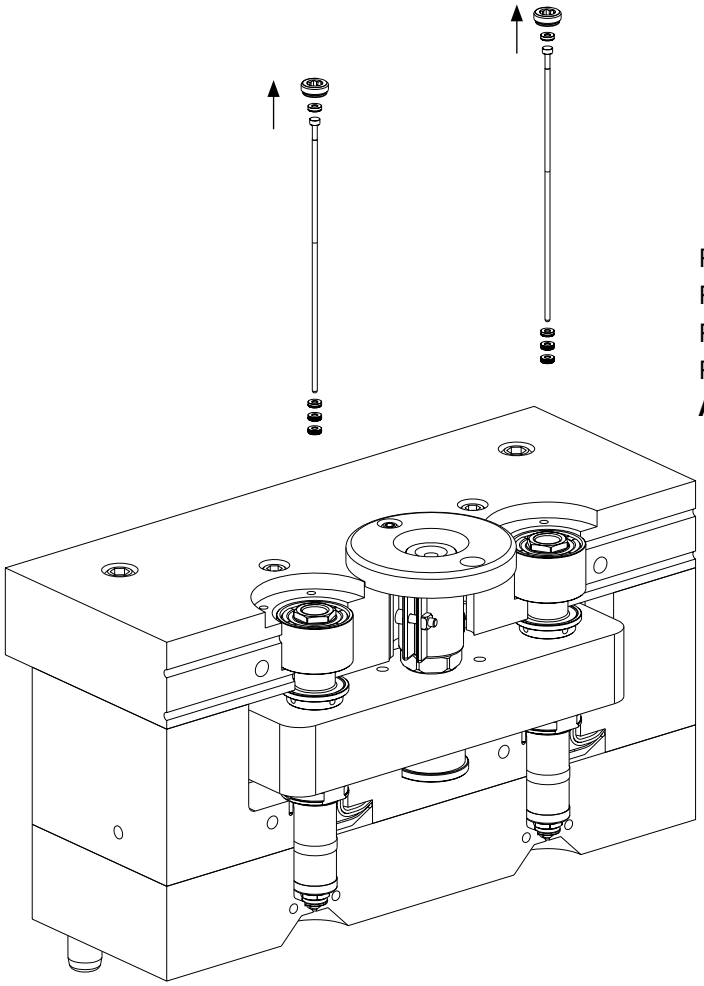
ONE



Remove **Blanking Plate** 2a or 2b

PIN HEIGHT ADJUSTMENT CONT.....

TWO

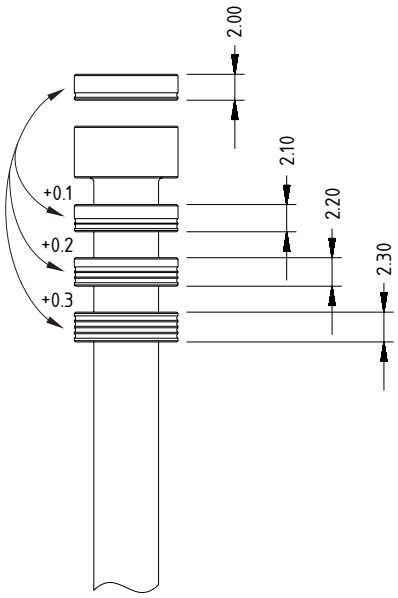


Remove the **Pin Locking Screw** 4
Remove the **Valve Pin Adjustment Packer** 5a
Remove the **Valve Pin** 6
Remove the remaining **Valve Pin Adjustment Packers** 5b, 5c & 5d

PIN HEIGHT ADJUSTMENT CONT.....

THREE

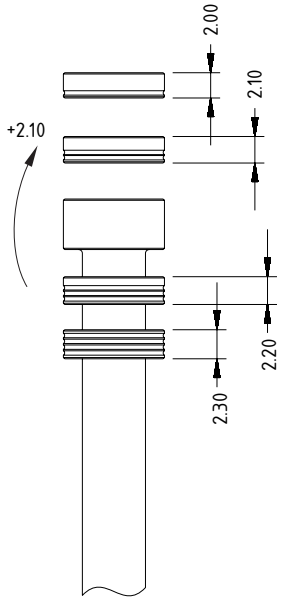
Minor Adjustment



Swap **Valve Pin Adjustment Packers** 5a, 5b, 5c & 5d to achieve small pin adjustments (different packer = different height)

FOUR

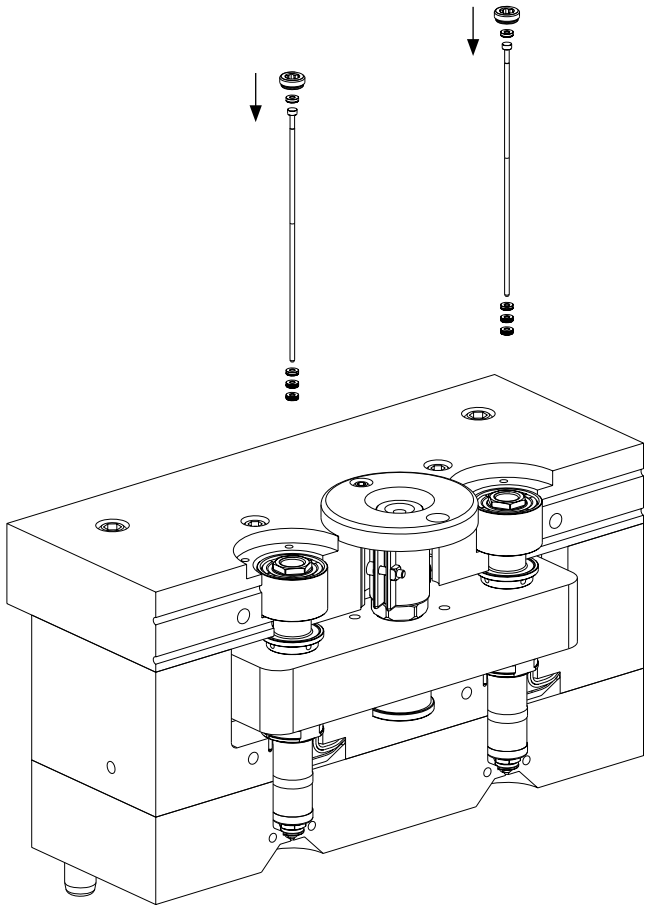
Major Adjustment



Move one or more **Valve Pin Adjustment Packers** 5a, 5b, 5c & 5d from below the pin head to above the pin head to achieve large pin adjustment

PIN HEIGHT ADJUSTMENT CONT.....

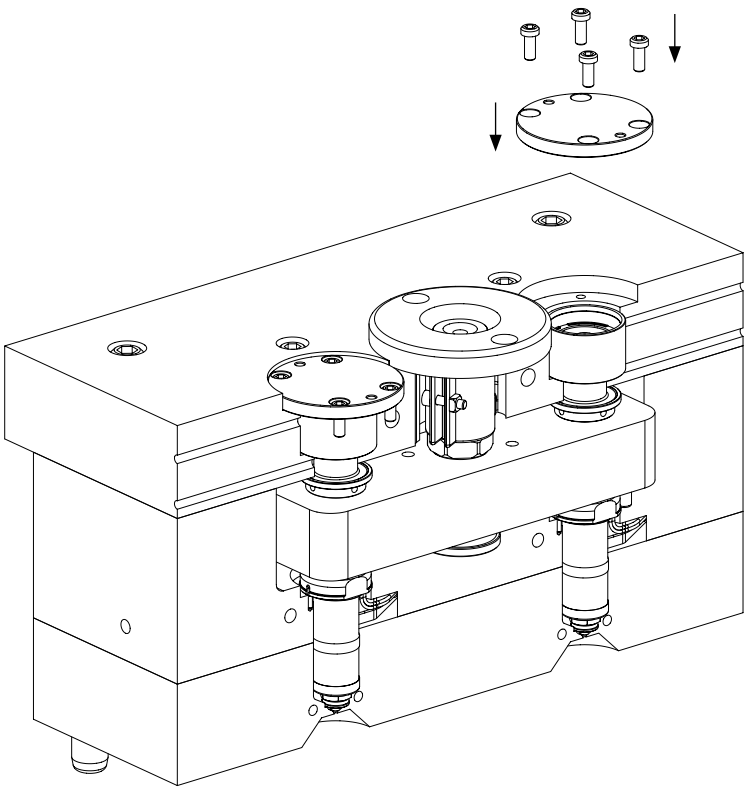
FIVE



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.....

SIX



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

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