

Valve Pin Assembly

ONE

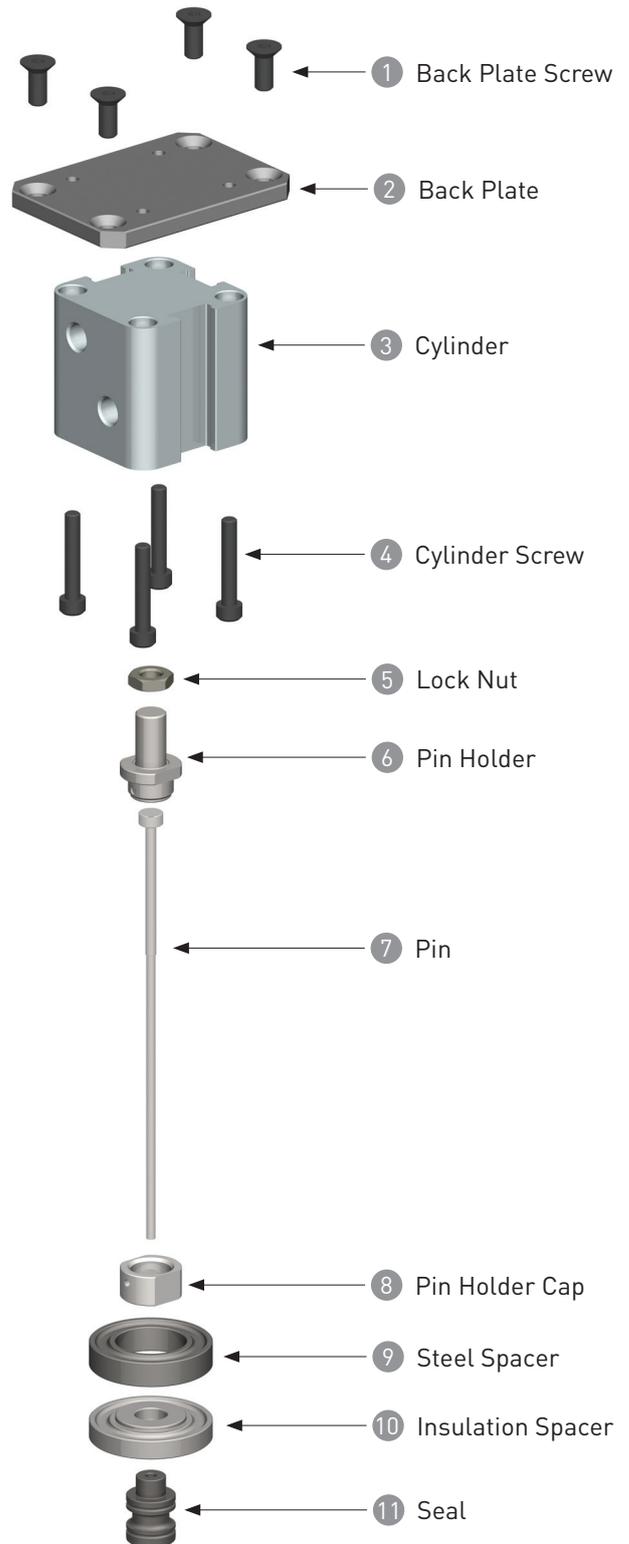
Fit the hydraulic piping and fittings to the cylinder. Quick connect fittings with shut-off are recommended. These fittings prevent hydraulic fluid loss when the mould is disconnected from the hydraulic power source. Always use solid piping and keep the hydraulic cylinder pressure below 50 bar.

TWO

Install the nozzles as per the relevant nozzle installation instructions.

THREE

Fit the valve pin seal in the manifold bush hole. The top face of the seal should be 0.01-0.05 proud of the manifold top face to seal. (Ensure that the pins and seals are matched as a set).

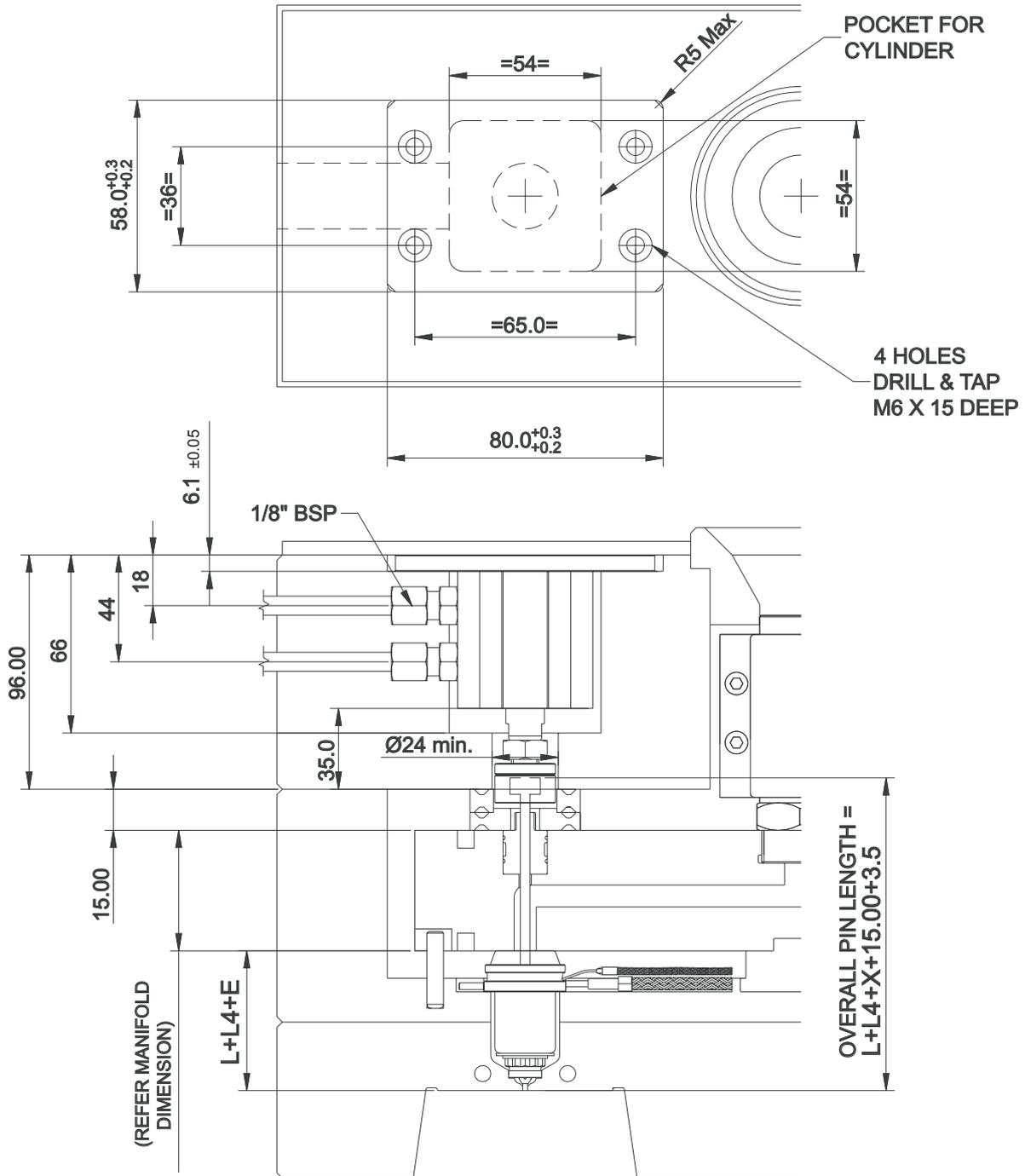


Pin Adjustment

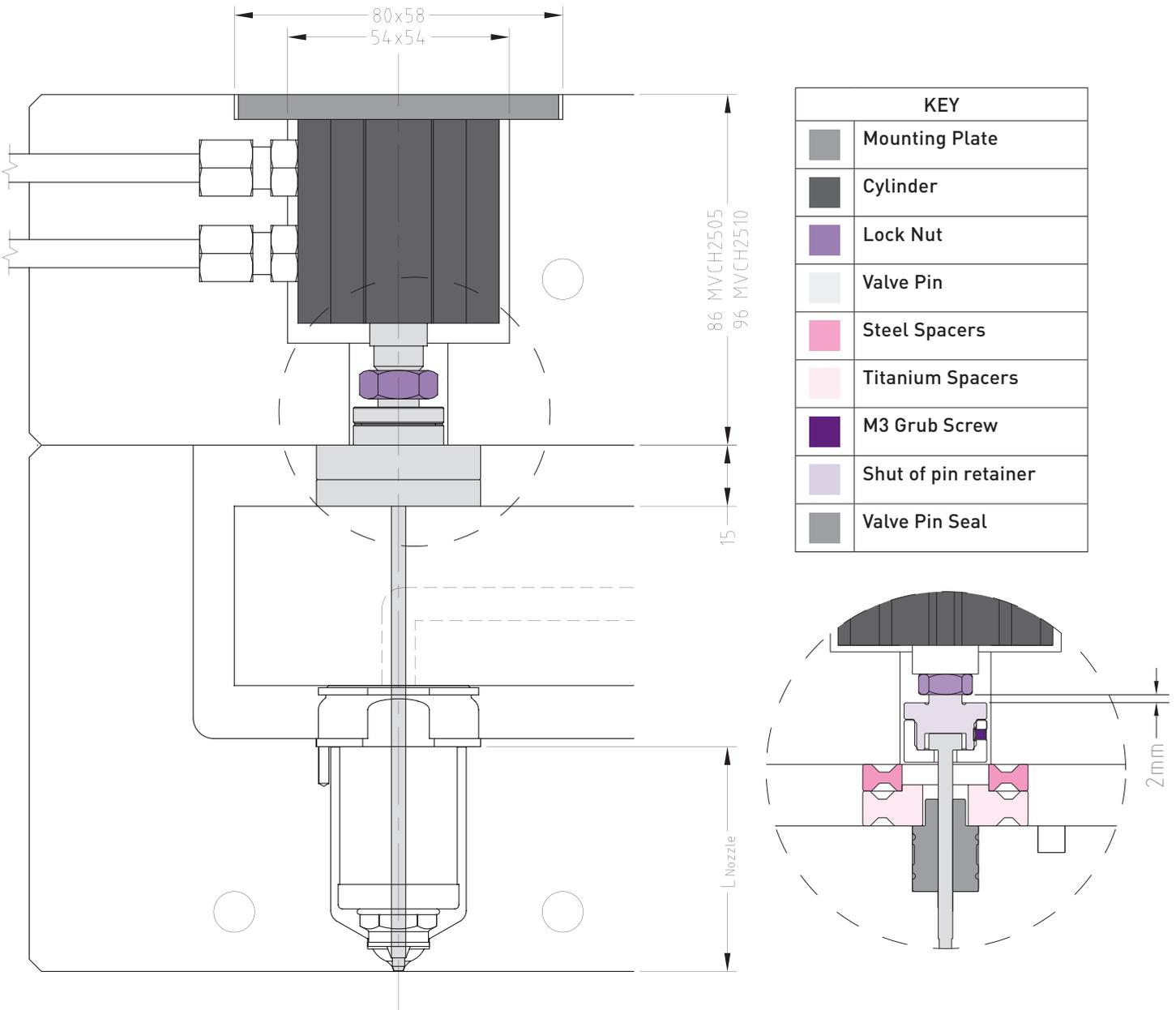
FOUR

Determine the correct pin length. **Pin Length = 3.5 + 15 + X + L4 + L**

Insert the shortened pin into the pin holder. Recheck pin length.



Cylinder Assembly



FIVE

Assemble the valve gate cylinder assembly which consists of:

	Mounting Plate		Lock Nut
	Valve Pin		Shut of pin retainer
	Cylinder		M3 Grub Screw

Mould Installation

SIX

With the front face of the gate visible feed the valve gate assembly through the back plate taking care not to damage the valve pin.

SEVEN

Set the valve pin length.

- Ensure the cylinder is actuated forward – pin closed position. You can use an airgun to move the piston inside the cylinder.
- Adjust the shutoff pin retainer position so the pin is just touching the gate steel.
- Calculate the pin expansion. $E = \text{pin length} \times 0.0000132 \times (T_{\text{melt}} - T_{\text{mould}})$.
- Adjust the shutoff pin retainer so the pin is sitting away from the gate by the expansion amount.

EIGHT

Screw down the valve cylinder mounting plate.