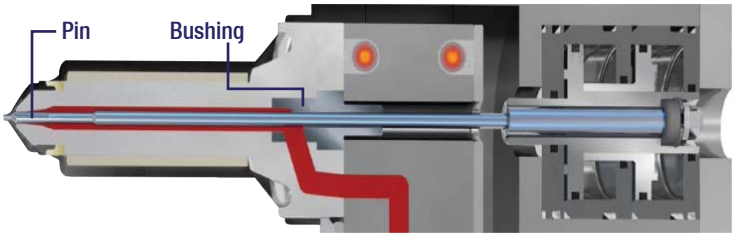
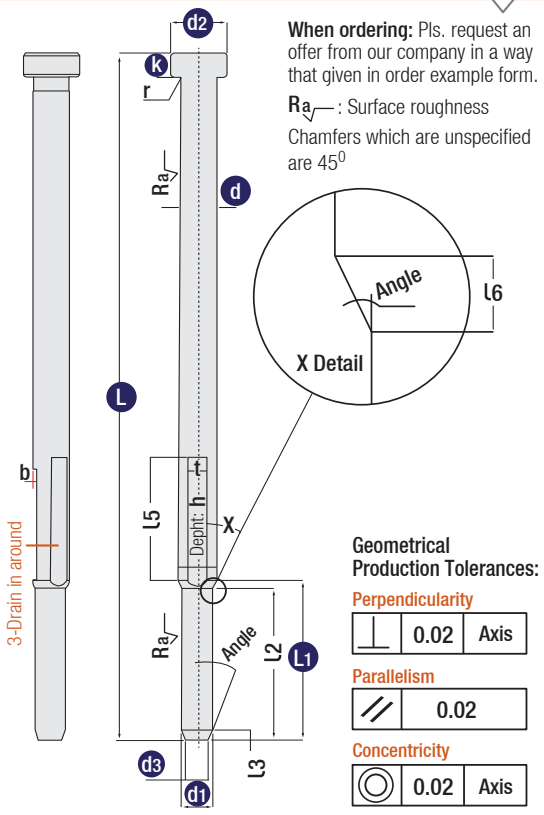


Valve Gate Pin & Bushing (custom-made production) Code: VGP

Valve Gate Pin: Mounting and demounting of Valve Gate Pin are such as the sectional view, they will be produced in desired material and dimensions.
Valve Gate Pin Bushing: The seconds Bushing in nozzle is to avoid expansion and bending of movable pin under load and heat. It can be change by demounting. As per request in order, technical drawing or sample is required.
The products will be produced in precision and faithfully.

Valve Gate Pin - Order Example:



When ordering: Pls. request an offer from our company in a way that given in order example form.
Ra: Surface roughness
Chamfers which are unspecified are 45^0

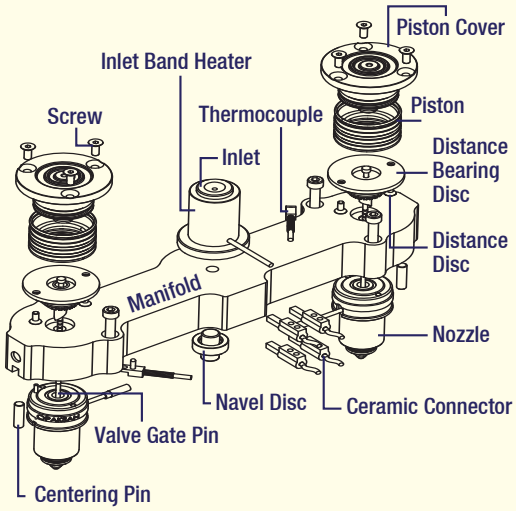
Geometrical Production Tolerances:

Perpendicularity	0.02	Axis
Parallelism	0.02	
Concentricity	0.02	Axis

Tolerance before TiN coating can be; -0.008 / After coating it can be; +0.01
Step chamfer dimensions:
Groove slotted machining dimensions:
TiN coating area & its length:
Full length & tolerance:
Material / Hardness: 1.2344 or HSS
Quantity:
General tolerance values ±:

Important: For precision production of Valve Gate Pin, sending the previous existing pin or bushing sample offers good production.

Assembly Process of Valve Gate Systems



Assembly Steps

Holding Plate:

* Insert the hot runner nozzles to the cavities / housings same axis with centering pin. Put the copper sealing plugs.
* Put the manifold with centering pins secondly, tight manifold screws well-balancedly.
* Insert the pin housing and distance disc into the manifold from upper side.

Top / Mould Cover Plate:

* Tighten the distance bearing disc.
* Put the manifold bridge plate (cavity plate) with taking care of hot runner systems heater and thermocouple wires.
* Center the cover plate with pins, put on to bridge plate and tighten the screws.
* Insert piston housing parts.
* Insert piston-pin group into housing.
* Close the piston with cover part, tighten the screws.
* Check the movement of valve pins by air pressure before starting production.
* Lay the mould in a way that nozzle tips can be seen, insert thermocouples and heaters in to their place and secure with retaining ring that given.
* While making plug connection, external thermocouple wires in hot runner nozzles will be used, their own thermocouple wires of heater will be left idle.