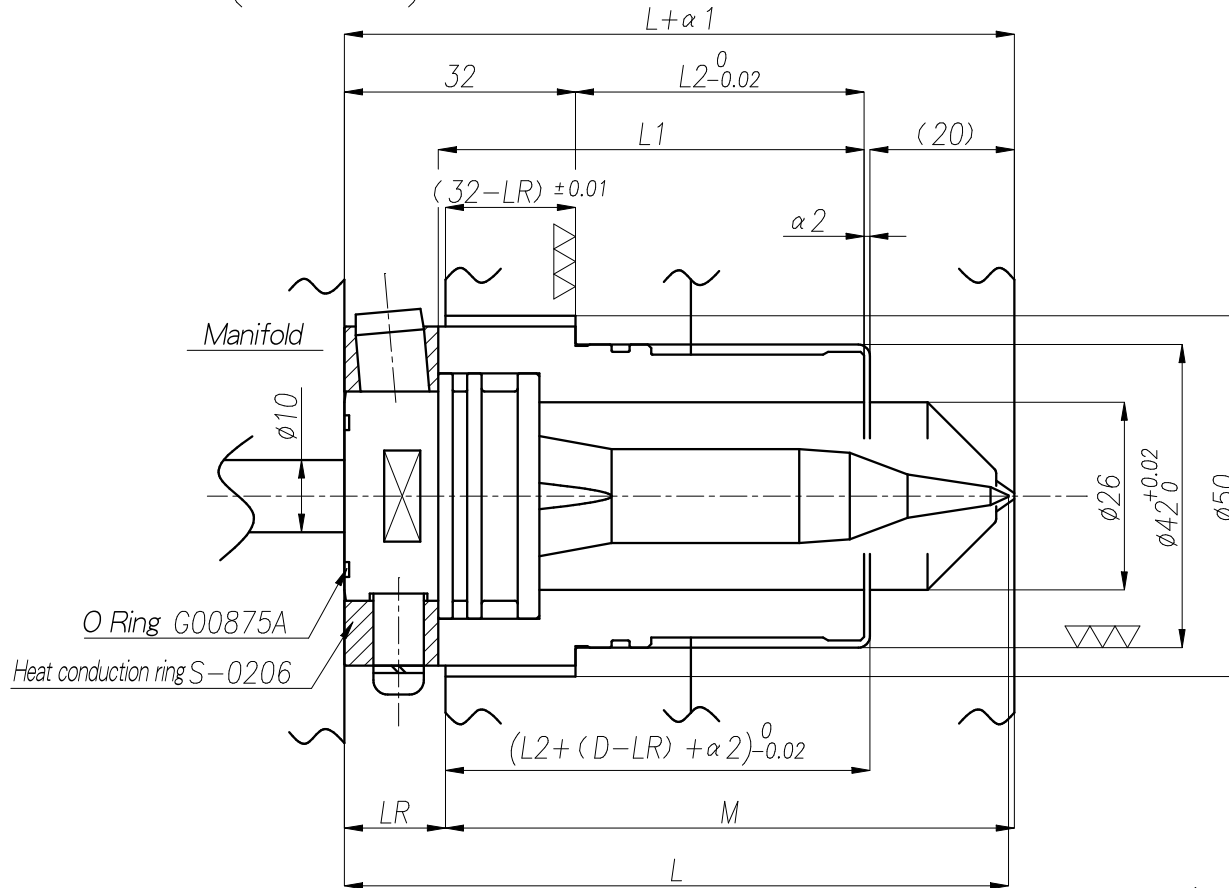
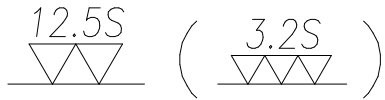
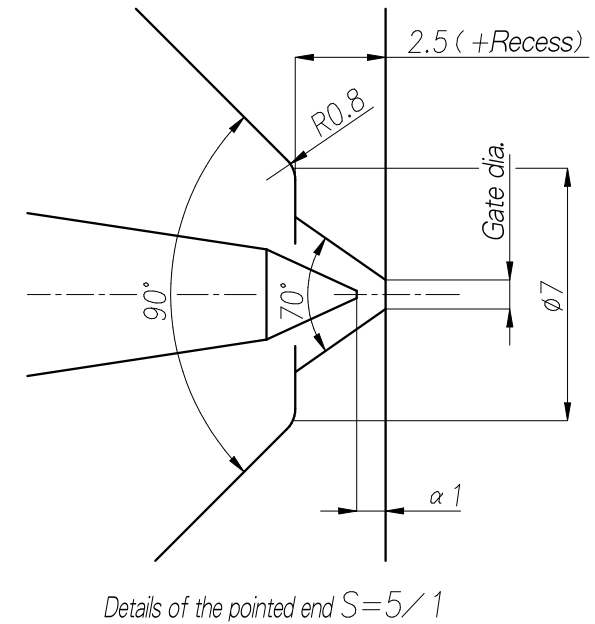


# STT-13DBX(F II) Assembly Drawing



Standard	L	L1	L2	Runner bushing standard
STT-13DBX(F II)-92	92	59	40	RB-014
STT-13DBX(F II)-102	102	69	50	RB-015
STT-13DBX(F II)-112	112	79	60	RB-016
STT-13DBX(F II)-122	122	89	70	RB-017
STT-13DBX(F II)-132	132	99	80	RB-018



Tolerance unless specified

Dimension	angle
$\pm 0.1$	$\pm 0.5^\circ$

<  $\alpha 1$  (Tip clearance) Formula > ( $D=32$ : Thermal expansion start here.)  
 $\alpha 1 = (L-D) \times (\text{Body temp.} - \text{Mold temp.}) \times 1.2 \div 100000$   
 $\therefore \text{Body temp.} = \text{Melt temp} + 40^\circ\text{C}$ .  $\text{Manifold temp.} = \text{Melt temp.}$   
 $\therefore LR \geq 12$

<  $\alpha 2$  (Runner Bushing Clearance) Formula >  
 $\alpha 2 = 1.2 \div 100000 \times T1 \times L2$   
 $T1$  (Average temp. of runner bushing) = ( $\text{Manifold temp.} - \text{Melt temp.}$ )  $\times 0.5$