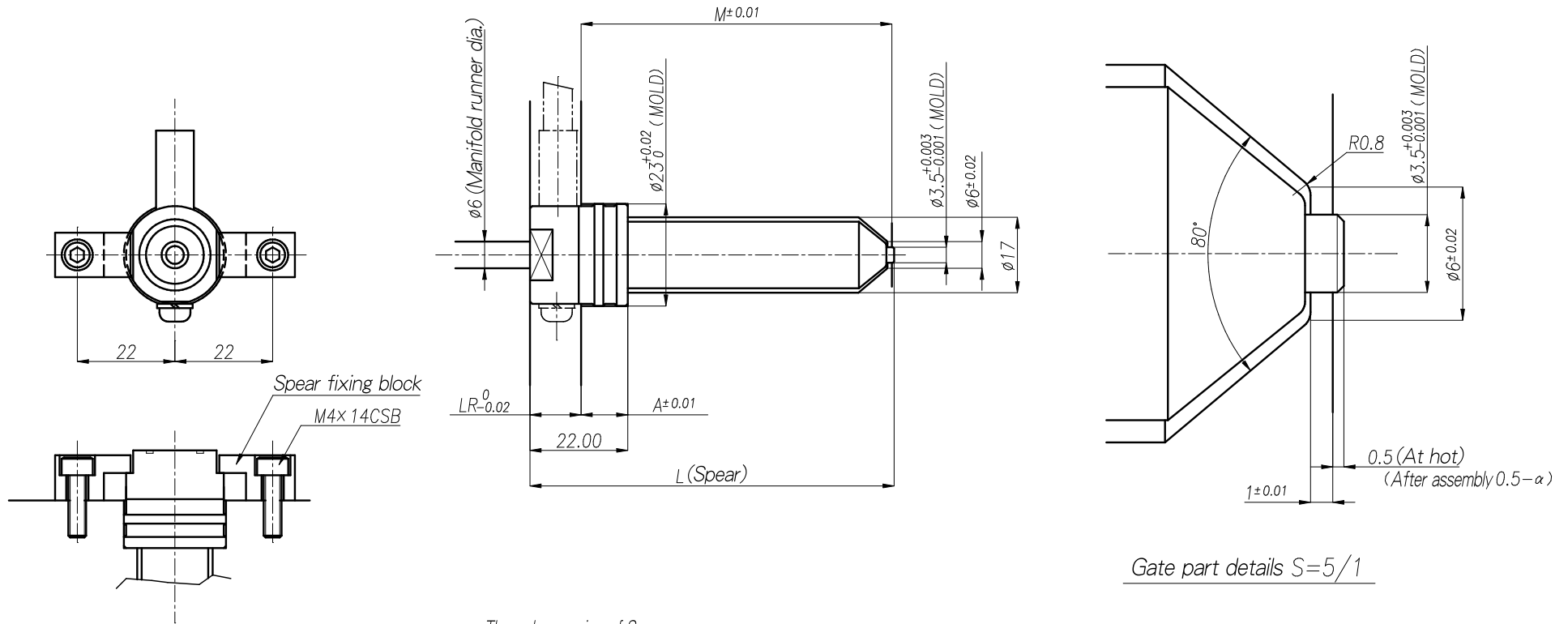


STT-15GF6 Assembly Drawing

Standard	L
STT-15GF6-62	62
STT-15GF6-72	72
STT-15GF6-82	82
STT-15GF6-92	92



Spear fixing block
M4x14CSB

Thermal expansion of Spear : α
 $\alpha = (L - 11) \times (\text{Body temp.} - \text{Mold temp.}) \times 0.000012$
 Lower riser : LR
 $LR = L + \alpha - 0.5 - M$
 Bore depth : A
 $A = 22 - LR$
 $\therefore \text{Body temp.} = \text{Melt temp.}$ $\text{Manifold temp.} = \text{Melt temp.}$
 $\therefore LR \geq 11$

Gate part details S=5/1