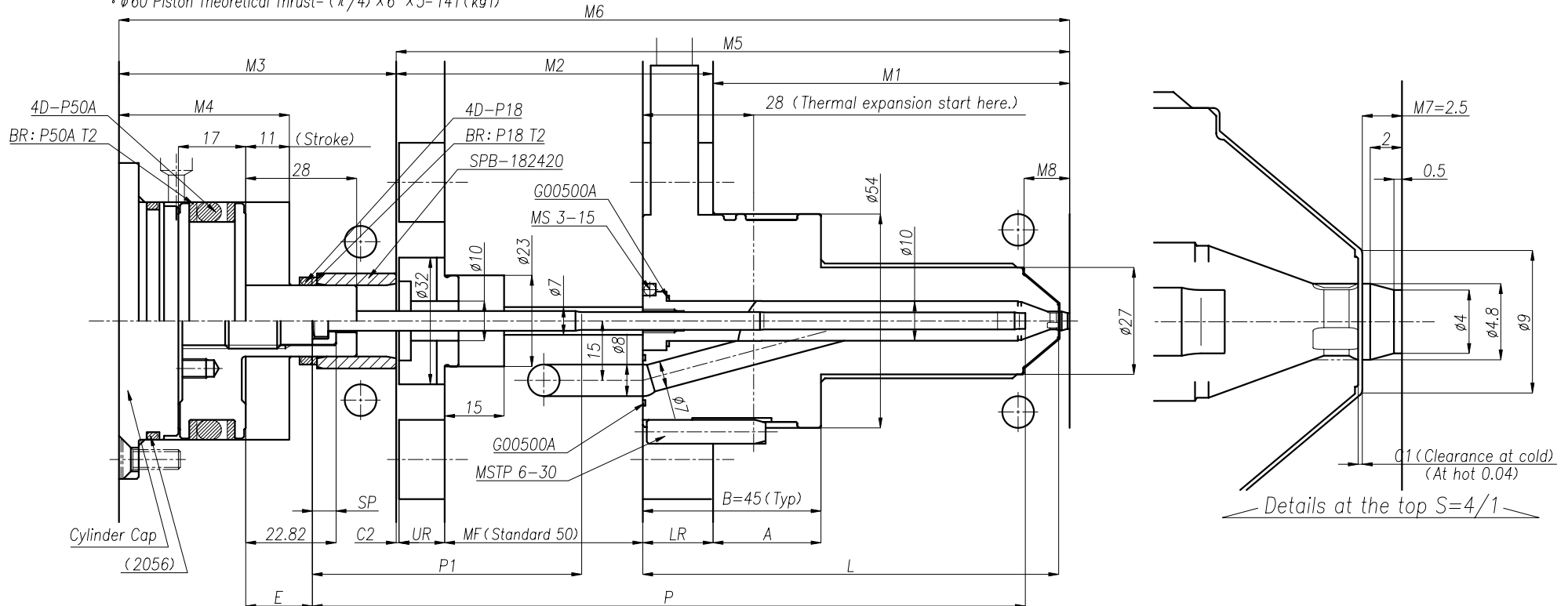


11 SVP4F Assembly drawing (φ 4.0)

SVP4F Base dimension

Standard	L Dimension	P Dimension (P1 Dimension)	E	SP	M1	M2	M3	M6
For SVP4F-85	85	160 (68)	16.82	6.0	70	80	70	220
For SVP4F-105	105	180 (68)			90			240
For SVP4F-125	125	200 (68)			110			260

- Cylinder caps and O-ring 2056 are to be arranged by customer.
- φ60 Piston Theoretical Thrust= (π/4) × 6² × 5= 141 (kgf)



<Formula for C1 Clearance> (D=28: Thermal expansion start here.)

Thermal expansion=(Body L Dimension-D) × (Body Temp.-Mold Temp.) × 1.2÷ 100000

C1 (Clearance) = Thermal expansion+0.04 (Clearance at hot)

<Formula for A (depth)> (M7=2.5: Gate land, B=45)

Lower Riserpad height=Body Length+C1+M7-M1

Formula for A (depth)= B-LR

<Formula for C2 Clearance>

Thermal expansion=(M2-LR+D) × (Manifold Temp. - Mold Temp.) × 1.2÷ 100000

* Compression=(M2+A) × 10÷ (2.1× 10000)

C2 (Clearance) = Thermal expansion-Compression

UR (upper riser height)= M2-LR-MF-C2

<Formula for M4 (Cylinder depth)>

Thermal expansion of Valve Pin= ((L-D) × 0.95 × (Body Temp.-Mold Temp.) + (MF+D) × 0.6 × (Manifold Temp.-Mold Temp.)) × 1.0÷ 100000

M4 (Cylinder depth) = M6+0.1 (Pin stick out) - (P+Thermal expansion of Valve Pin+E)

M8=M7+9.0 (When Gate land 2.5mm, M8=11.5mm)

Manifold temp. = Melt temp. , Body temp.=Melt temperature+20℃

Ratio 0.95 and 0.6 in the formula of valve pin thermal expansion is based on experimental value.

10Kgf/mm² is set value by Seiki. 2.1× 10⁴ Kgf/mm² : Yong's modulus of elasticity

Select valve pin and spacer

1. Select valve pin

1) Round off decimals of M5 dim to 0. ... (M5A)

2) M5A+10=M5B

3) Round off the number of units of the calculated M5 B value dim to 1.-Valve pin length (P)

2. Select spacer

1) E=M5A-P+26.82 26.82 is fixed number

2) The spacer dimension to be selected accordingly to E dimension.