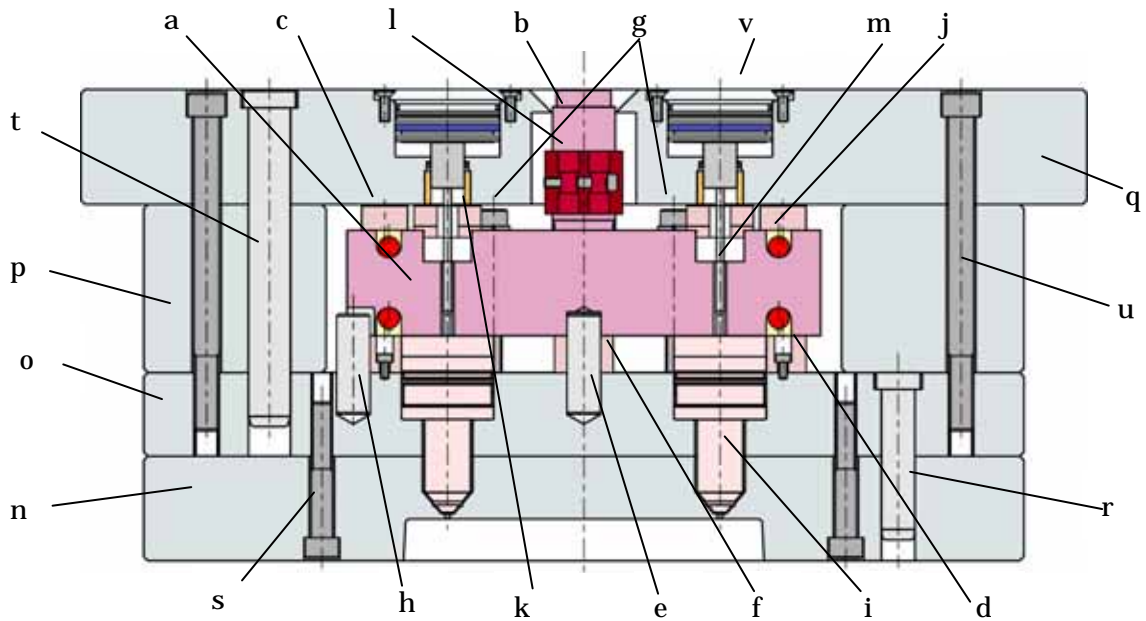


[Valve SVP (F) Mold Structure]



[Names of Parts]

a.	Manifold	b.	Sprue Bushing	c.	Upper Riser Pat
d.	Lower Riser Pat	e.	Center Pin	f.	Center Ring
g.	Manifold locking bolt	h.	Dowel Pin	i.	Probe
j.	Manifold Heater	k.	Support	l.	Band Heater
m.	Valve Pin	n.	Cavity Plate	o.	Back Plate
p.	Spacer Block	q.	Clamping Plate	r.	Guide Pin A
s.	Mold Plate Locking Bolt A	t.	Guide Pin B	u.	Mold Plate Locking Bolt B
v.	Cylinder Head				



WARNING

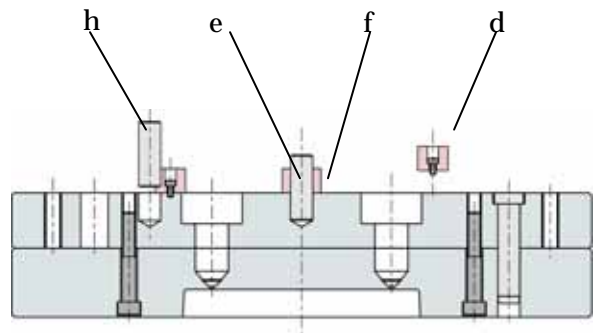
Check each dimension before assembly.
 These processes are based on the standard Seiki system. Please check your system carefully before start these process.

[Preparation for assembly]

1. Insert the greased guide pin A [r] between the cavity plate [n] and the back plate [o].
2. Bolt on the cavity plate [n] to the back plate [o] with the mold plate locking bolt A [s].

[Assembly]

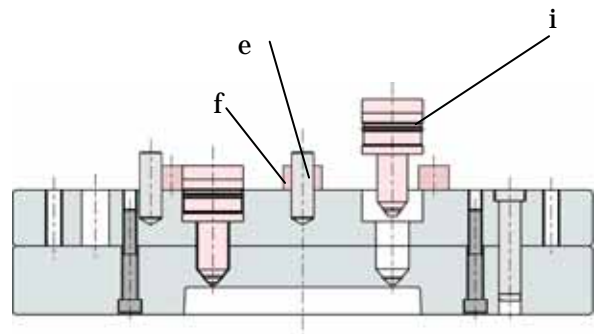
1. Insert the center pin [e] and the dowel Pin [h].
2. Insert the center ring [f] to the center pin [e].
3. Secure the lower riser [d] with M4 (C.S. S.).



4. Insert probes [i].
5. Insert the probe-dowel pin.
6. Set Sleeve O-ring on the sleeve and insert the sleeve.

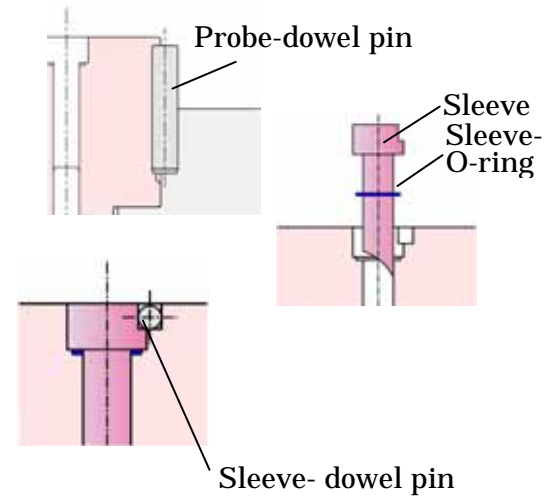
Attention : Do not install Sleeve O-ring in case of SV25F, SV32F, SVP2F, SVPL2F

7. Insert sleeve-dowel pin



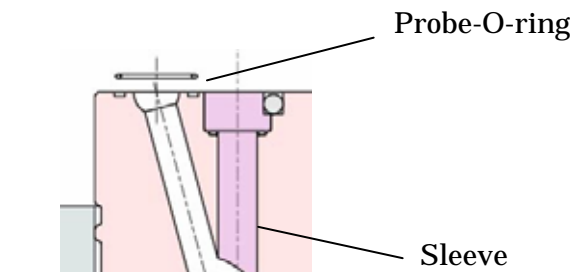
CAUTION

Sleeve and valve pin are paired before shipping. Use them as a pair.



8. Install Probe O-rings.

We recommend greasing Probe O-ring in order to install them in place. Refer to **O-Rings Installation Guide** for further information.



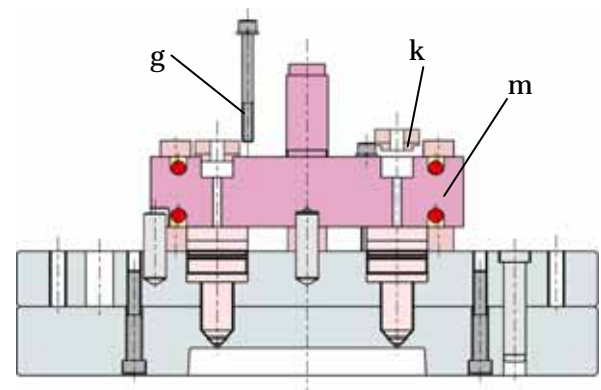
9. Set the manifold [a].

10. Bolt down the manifold with the manifold locking bolt [g].

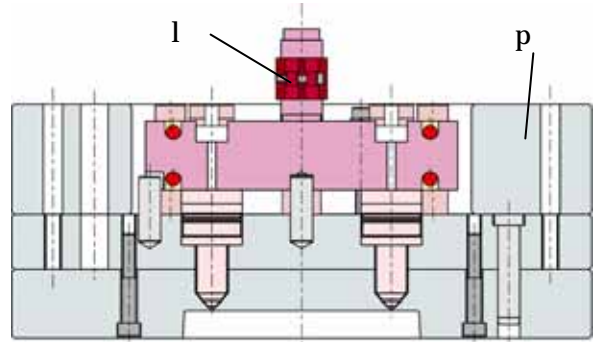
11. Insert support [k].

CAUTION

To prevent over tightening, place a spring washer between bolt and the manifold. Tighten bolt then back off 1/4 to 1/2 turn.



12. Set thermocouple.
13. Connect the lead wire to the tubular heater.
Refer to the [Instruction for Connecting a Tubular Heater].
14. Set the band heater [l] around the sprue bushing tightly.
15. Set spacer blocks.

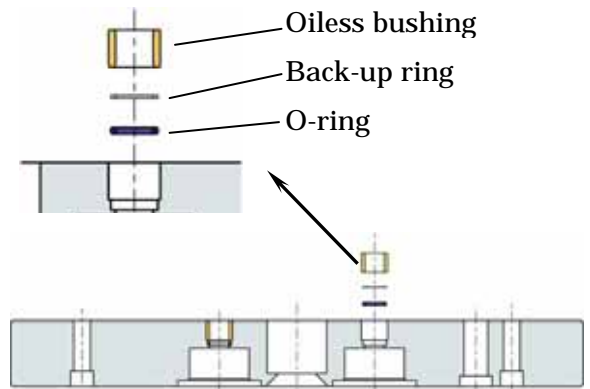


CAUTION
Do not pinch the lead wire when you set spacer blocks.

16. Insert O-ring, back-up ring, and oilless bushing into the clamping plate [q] and grease them.

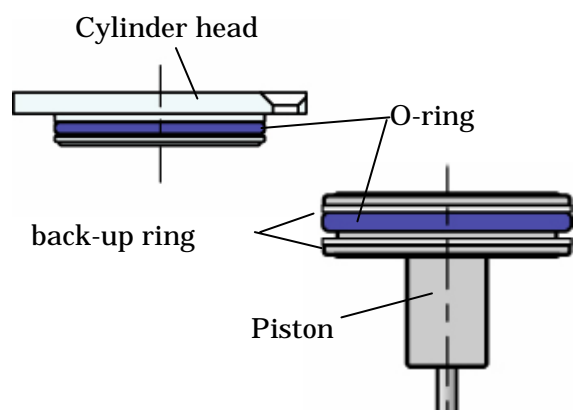
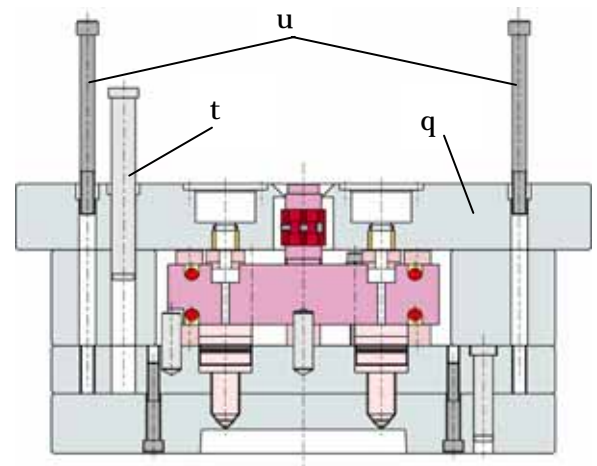
Seiki recommendation

Silicon grease: G-40L (Shinetsu Silicon)
(Please consult our office nearest you for any substitute products.)



CAUTION
Handle with care when you work with an oilless bushing. They are easily distortable.
Use soft tools such as a plastic hammer.

17. Set a clamping plate [q]
18. Insert greased guide pin B [t] and fasten the mold with mold plate locking bolt.
19. Grease piston holes on the clamping plate [q].
Seiki recommendation
Silicon grease: G-40L (Shinetsu Silicon)
(Please consult our office nearest you for any substitute products.)
20. Set an O-ring and back-up rings on a piston and put the grease all over.



**CAUTION**

Put grease on entire piston including O-ring, back-up ring, and piston rod. **Do not over grease!**

21. Insert valve pin (piston) [m].

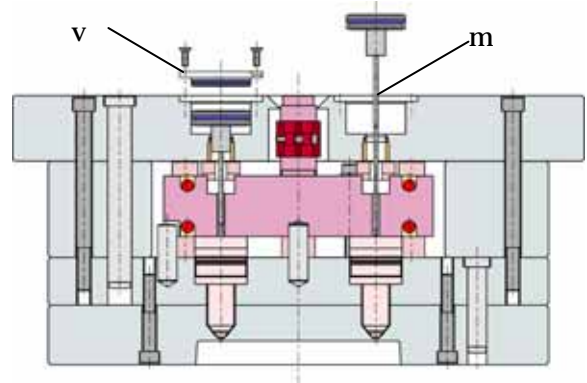
22. Set the O-ring to the cylinder head [v] and grease it.

Seiki recommendation

Silicon grease: G-40L (Shinetsu Silicon)
(Please consult our office nearest you for any substitute products.)

23. Insert cylinder head [v] and bolt it down.

*Cylinder caps and O-rings are to be arranged by customer. *



[Assembly is completed.]

Make sure there is no conduction between each heater and mold before wiring. (There is conduction between the probe sensor and the mold due to the earthen style sensor.)