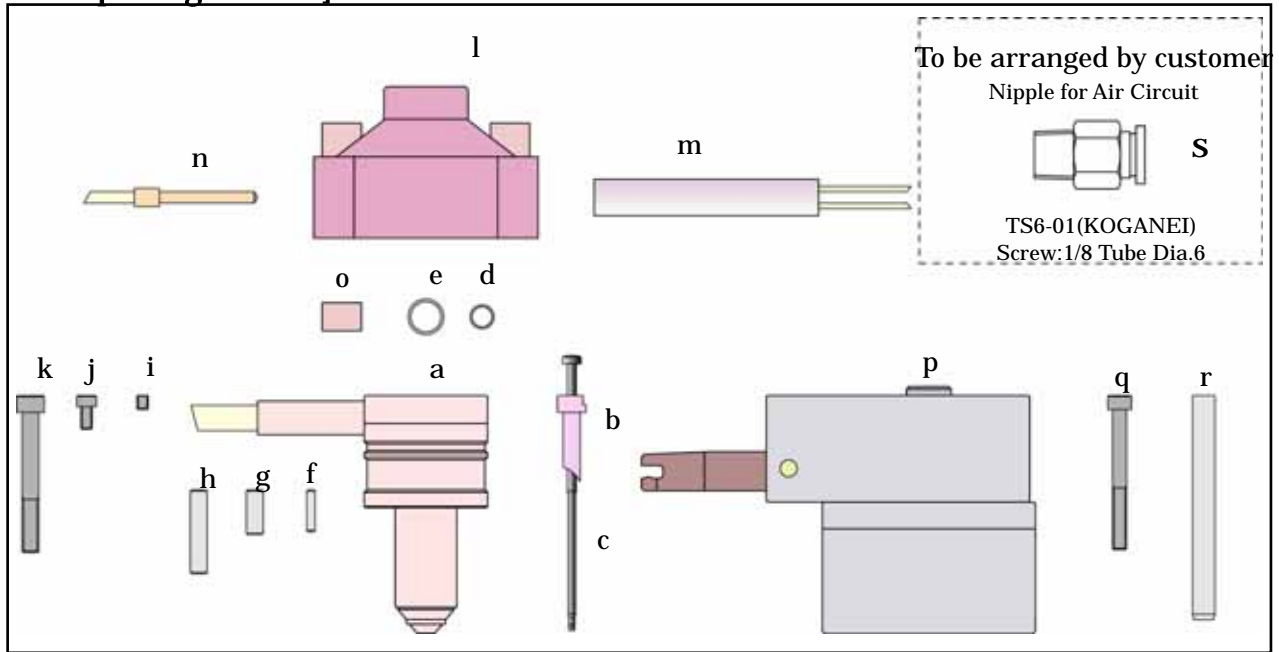


**[ List of packaged item ]**

**[ Names of Parts ]**

#	Name	Series Part	SVPL2(F)		SVPL3(F)		SVPL5	
			Standard	Qty.	Standard	Qty.	Standard	Qty.
a	Probe			1		1		1
b	Sleeve			1		1		1
c	Valve pin			1		1		1
d	Stainless steel O-ring (for sleeve)				G00406A	1	G00625A	1
e	Stainless steel O-ring (for probe)	G00500A		1	G00500A		13Btype	1
f	Dowel pin (for sleeve)	Dia.3 × 15		1	Dia.3 × 15	1	Dia.3 × 15	1
g	Dowel pin (for upper plate)	Dia.6 × 15		2	Dia.6 × 15	2	Dia.6 × 15	2
h	Dowel pin (for body)	Dia.6 × 30		1	Dia.6 × 30	1	Dia.6 × 30	1
i	Plug bolt (for thermocouple and cartridge heater)	M4 × 5		3	M4 × 5	3	M4 × 5	3
j	Cap screw bolt (for lower riser)	M4 × 8		4	M4 × 8	4	M4 × 8	4
k	Cap screw bolt (for upper plate)	M6 × 50		2	M6 × 50	2	M6 × 50	2
l	Upper plate			1		1		1
m	Cartridge heater	Dia.13 × 80 240V480W		2	Dia.13 × 80 240V480W	2	Dia.13 × 80 240V480W	2
n	Thermocouple	Made in Seiki		1	Made in Seiki	1	Made in Seiki	1
o	Lower riser Pat			4		4		4
p	Cylinder unit			1		1		1
q	Cap screw bolt (for cylinder unit) Note 1	M5 × 50 (M5 × 70)		4	M5 × 55 (M5 × 75)	4	M6 × 60 (M5 × 85)	4
r	Dowel pin (for cylinder unit)	Dia.8 × 80		2	Dia.8 × 80	2	Dia.10 × 120	2

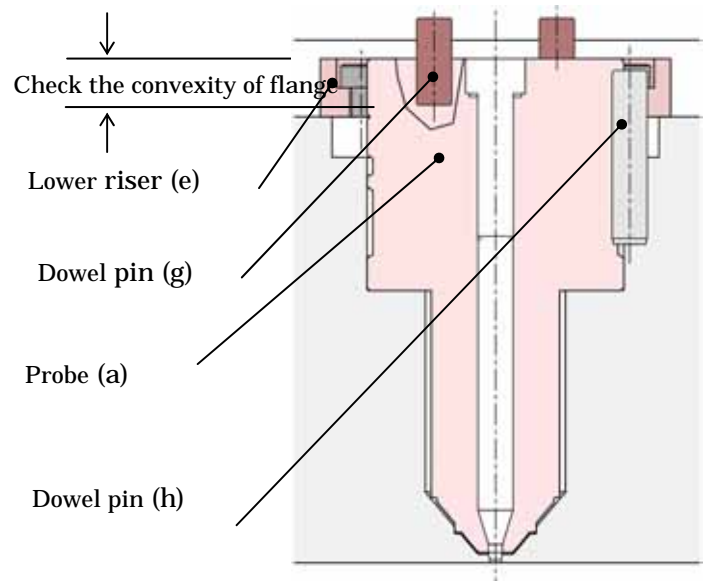
\* Customer will arrange air circuit nipples [ s ] (needs 2).\*

- ❖ Plug bolts [ i ] will be indicated as "S.S.B."
- ❖ Cap screw bolts [ j,k,q ] will be indicated as "S.H.C.S."
- ❖ Standard size for [ q ] is for the erecting system specification. The size in ( ) is for the inverted system specification.

### SVPL assembly

#### 1. Set the probe

- Secure lower riser pad[e] with S.H.C.S. [ j ] (M4×8 needs 4).
- Insert probe [a].
- Insert a probe dwell pin [h] (Dia.6×30).
- Insert an upper plate dowel pin [g] (Dia.6×15 needs 2).



#### 2. Set the valve pin

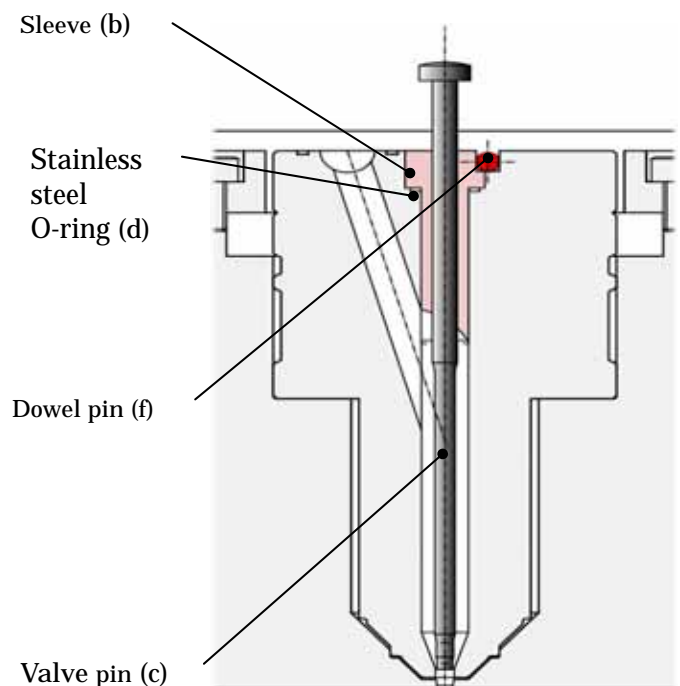
- Insert a stainless steel O-ring [d].
- Insert a sleeve [b]. Pay attention to the O-ring when you insert a sleeve.
- Insert a sleeve Dowel pin [f](Dia.3×15).
- Insert a valve pin [c].
- 

< Standard for stainless steel O-ring for sleeve [ d ] >

Type	Standard	Outer dia.
SVPL3(F)	G00406A	Dia. 10.31
SVPL5(F)	G00625A	Dia. 15.88

**Attention : Do not install a stainless O-ring [d] in case of SVPL2 and SVPL2F series.**

\* Make sure that the O-ring is in place when you insert a sleeve.



**CAUTION**

When inserting the sleeve, pay attention not to crush the metal O ring.

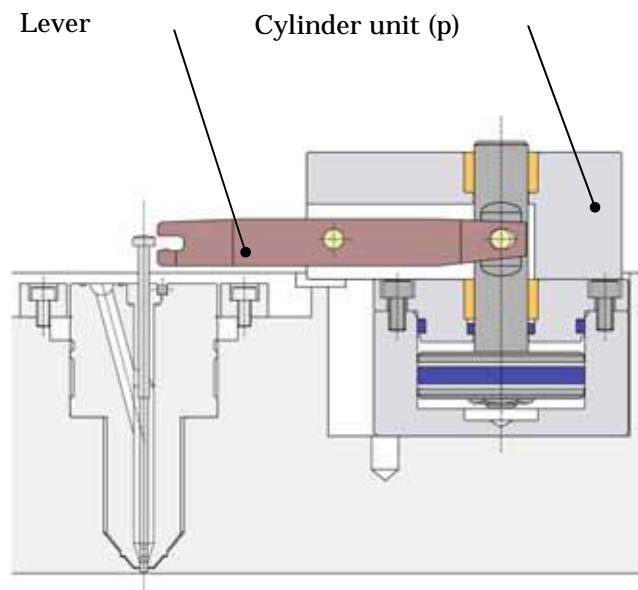
### 3. Set the cylinder unit

- Pre-set air circuit nipples on the cylinder unit [p].
- Set the cylinder unit [p] and adjust the unit position where a lever meets a valve pin [c].

\*Two of the dowel pin holes on the cylinder unit provide an indication of the adjustment. Slide the unit until these holes are visible.

<Standard hole size for dowel pin (Mold)>

Type	Inner diameter
SVPL2(F)	Dia. 8
SVPL3(F)	Dia.8
SVPL5	Dia.10



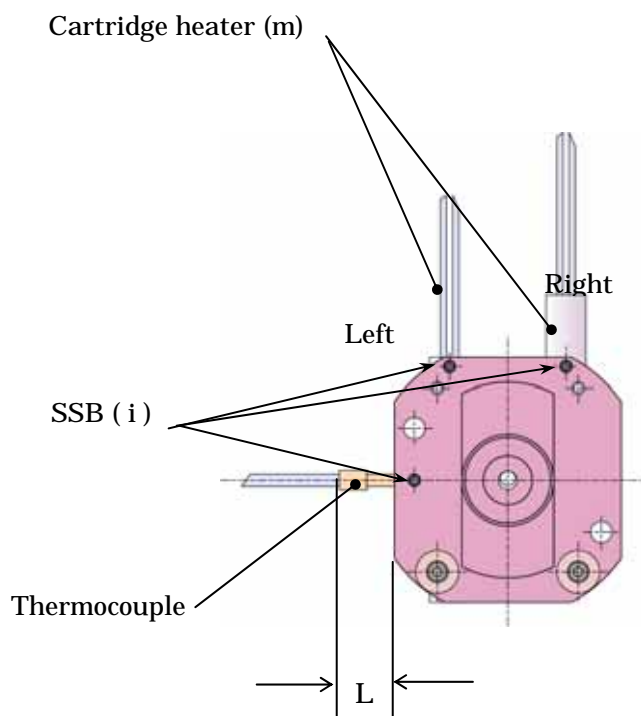
\* Cylinder unit is shipped pre-greased. Therefore a greasing is not necessary before assembly. Grease each sliding part regularly for maintenance.

### 4. Install parts on the upper plate

- Insert cartridge heater [m] straight and evenly and bolt on to an upper plate [i] with S.S.B. [i].
- \* Remove an upper riser and bolt on with S.S.B..
- Insert a thermocouple [n] and bolt on to the upper plate with SSB [i].

<Thermocouple protrusion dimension>

Type	L dimension (mm)
SVPL2(F)	18
SVPL3(F)	14
SVPL5	14



### 5. Secure the cylinder unit

- Set probe O-rings [e] (1 place) in the probe [a] and set the upper plate [l] on.

< Standard for stainless O-rings for probes [ e ] >

Type	Standard	Outer dia.
SVPL2(F) SVPL3(F)	G00500A	Dia.12.7
SVPL5	For 13B	Dia.17.0

\* Make sure that the O-rings are in place when you insert a sleeve.

- Insert Dowel pins [r] (2places) in the cylinder unit [p].

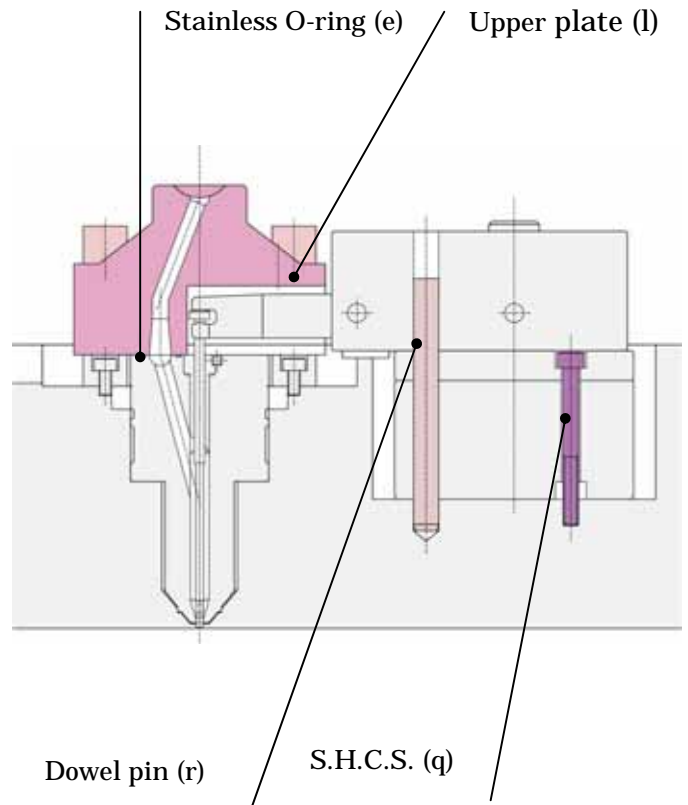
< Standard for Dowel pin [ r ] for a cylinder unit >

Type	D.P. Standard
SVPL2(F) SVPL3(F)	Dia. 8×80
SVPL5	Dia. 10×120

Bolt down the cylinder unit [p] with S.H.C.S. [q] (4 places).

< Standard for S.H.C.S.[q] for a cylinder unit >

Type	Bolt Standard
SVPL2(F)	M5×50
SVPL3(F)	M5×55
SVPL5	M6×60

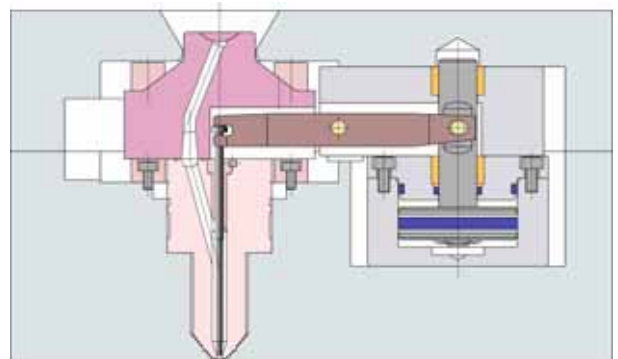


When putting the upper plate, make sure the valve O ring is in the position.

### 6. Anchor the anchor plate

- Do not pinch the lead wire when you set the anchor plate.
- Make sure there is no conduction between each lead wire and mold after setting the anchor plate.

\* There is conduction between a tip heater / body sensor and the mold. (No conduction between probe heater / cartridge heater / thermocouple and the mold.)



< Completion >