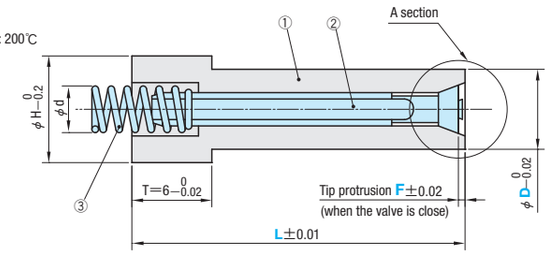
SPACERS FOR GAS VENT UNIT

Non JIS material definition is listed on P.1351 - 1352

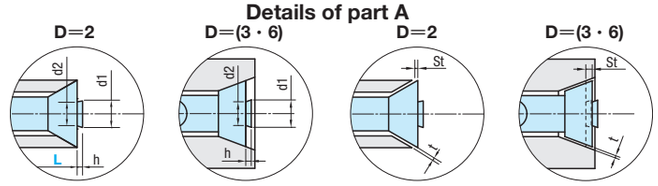
MSTV

M ①Sleeve (body): SUS303
②Valve: SUS303
③Spring: SUS type
Operating temperature limit: 200℃

Cross-sectional view



Details of part A



Head diameter H	Tip d1	Tip d2	Tip h	Stroke st	Gas exhaust clearance t	Spring dia. d	(Spring load) N	Part Number Type	Part Number D	L	F	U/Price 1～6
4	1.0	0.9	0.3	0.05～0.1	0.03～0.06	2.9	0.68	MSTV	2	20	—	Quotation
5	1.0	0.9		0.2 ～0.3	0.1 ～0.15	2.9	0.68		3	20	0.3	
8	1.5	1.3		0.3 ～0.4	0.15～0.2	3.8	1.96		6	25	0.5	

Order: Part Number — L — F
MSTV2 — 20
MSTV3 — 20 — 0.3

Price: Quotation

Days to Ship: Quotation

■Characteristics

1. Effective gas exhaust
   - reduces molding defects.
     (reduction of burns, shrink, poor potting, weld lines, etc.)
   - can shorten a molding cycle.
2. Being made of stainless steel, it is resistant to corrosion.

■Notes on handling

- Resin leak from the valve and burrs may occur depending on the molding condition and the type of resin.
- Select a mounting location carefully because the shape of the gas vent unit will be transferred on the surface of mold products.
- Cleanse the resin gas exhaust passage and the gas vent unit periodically.
- For the shape of a gas exhaust passage, refer to the right diagram.
- Take the tip protrusion (value F) into account for a residence area of resin gas to specify L1.

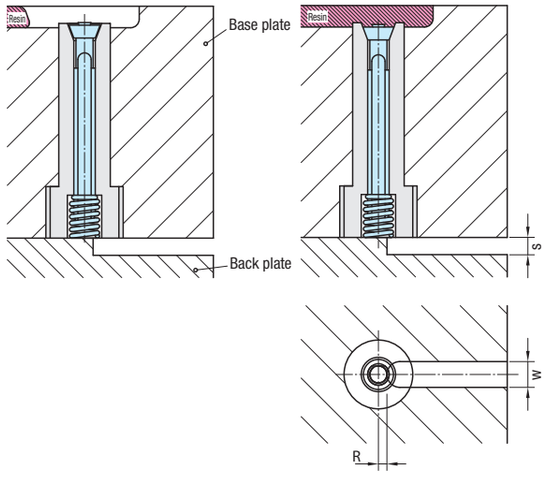
■Processing example of dimensions for gas exhaust passage

Part Number Type	Part Number D	s×w Cross-sectional area of the gas exhaust passage	ℓ
MSTV	2	s=0.5 or longer 0.85mm² or larger	Specify the spring seating surface that is 3/4 or longer of the entire perimeter.
	3	s=0.5 or longer 0.85mm² or larger	
	6	s=0.5 or longer 2.30mm² or larger	

■Operation principle

The spring opens the valve and gas that resins produce and air in the mold is exhausted.

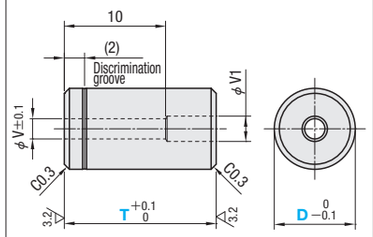
When resins reach the valve, the valve closes by resin pressure and exhaust finishes.



A gas exhaust passage that leads outside the mold is required. The exhaust should be air emission or forced exhaust (vacuuming) by a vacuum pump, a vacuum generator, etc. Note that the valve may close if exhaust pressure is high.

MSTVS

When T dimension is 15 or smaller, V1=V No discrimination groove



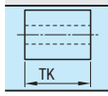
M SUS303

V	V1	Part Number Type	Part Number D	T 0.1mm increments	U/Price 1～6 T5.0～25.0	U/Price 1～6 T25.1～50.0
1.5	2	MSTVS	5	5.0～50.0	Quotation	
2	2.5		8			

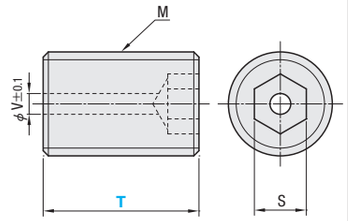
Order: Part Number — T
MSTVS5 — 19.5

Days to Ship: Quotation

Alterations: Part Number — T — (TK)
MSTVS5 — 18.95 — TK

Alteration	Code	Spec.	1Code
	TK	Changes T dimension tolerance. $T_{0}^{+0.1}$ ···› $T_{-0.02}^{0}$ When TK is used, T dimension alteration in 0.01mm increments possible	Quotation

MSTVM



M SUS304 equivalent

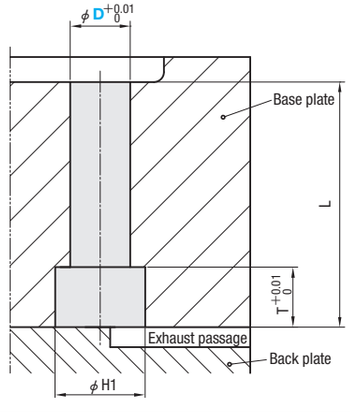
φD	Hex (S)	V	M (Coarse thread)	Part Number Type	Part Number No.	T	U/Price 1～6
3	4	1.5	8 (P1.25)	MSTVM	3	12	Quotation
6	5	2	10 (P1.5)		6	15	

Order: Part Number — T
MSTVM6 — 15

Days to Ship: Quotation

Price: Quotation

■Example of dimensions for molding holes (for MSTV)



Part Number Type	Part Number D	L	Tip protrusion F	T	H1
MSTV	2	20	—	6	5 ※
	3	20	0.3		6
	6	25	0.5		8.5

※If you use the spacer for gas vent unit MSTVS or MSTVM for the gas vent unit MSTV2—20, H1=6 and use MSTVS5/MSTVM5.

Example

- If the base plate is thick for L dimension, use spacer (MSTVS・MSTVM), etc.
- If you use MSTVM and you are concerned about the case it loosens, take measures against loosening such as double lock.