

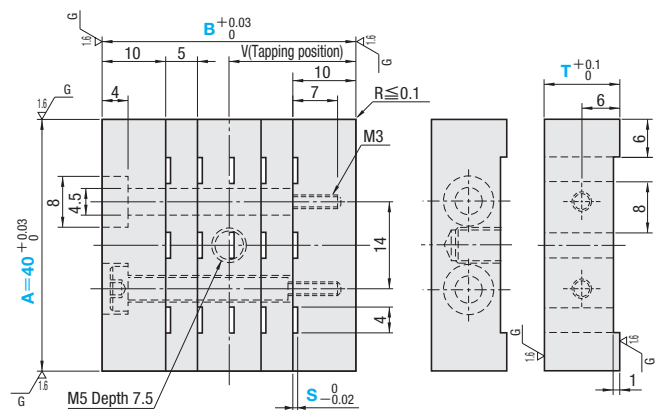
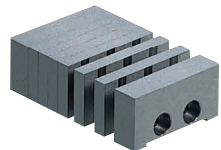
CAVITY INSERTS FOR GAS RELEASE

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

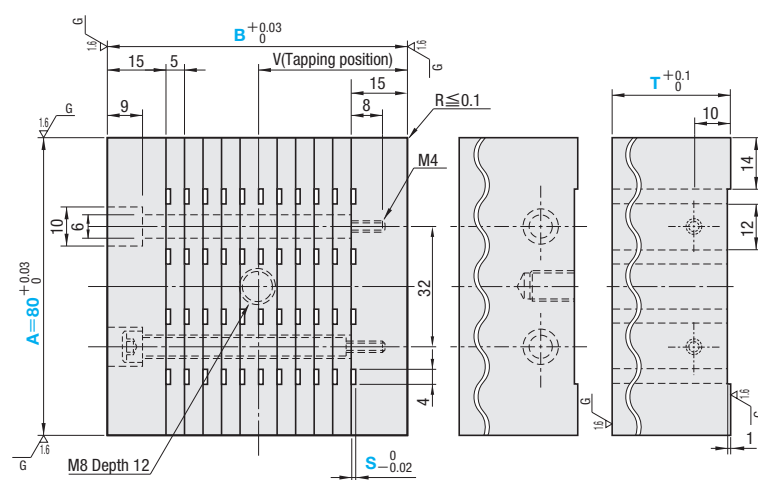
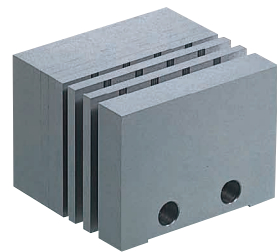
BGV

RoHS

A=40



A=80



Precision Standard

- Squariness for A · B surfaces 0.02mm or less for 100mm
- Parallel accuracy of upper and lower surfaces 0.02mm or less for 100mm

M S50C

A 2 Shoulder bolts (MSB)

V	Number of plates	No. of grooves	Supplied bolts	Part Number			T	S	
				Type	A	B			
20	6	15	MSB4.5-25	BGV	40	40	12	0.03	
25	8	21	MSB4.5-35		40	50	20		
30	10	27	MSB4.5-45		40	60	40		
30	8	28	MSB6-35		80	60	60		0.05
35	10	36	MSB6-45			70	80		
40	12	44	MSB6-55			80	80		



Order

Part Number — T — S
BGV8070 — 60 — S0.05



Price

Quotation



Days to Ship

Quotation



Alterations



Part Number — T — S — (RC · MC · CMK)
BGV8070 — 60 — S0.05 — RC10-MC-CMK



Quotation

Alterations	Code	Spec.	1Code
	RC	Machines R-chamfering at 4 corners on A · B surfaces whose R<=0.1. A RC (Selection) 40 3 5 80 5 10	Quotation
	MC	Makes the number of tap hole 3. A V1 M 40 10 M5 Depth 7.5 80 7.5 M8 Depth 12	
	CMK	Changes the tolerance of A dimension and B dimension. A+0.03/0 ... A-0.03/0 B+0.03/0 ... B-0.03/0	



Example

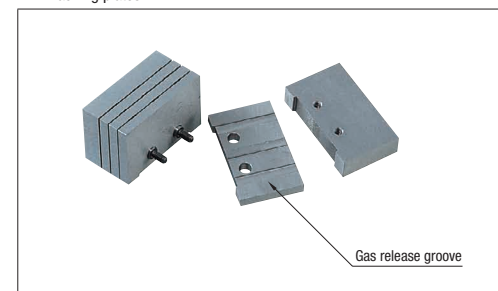
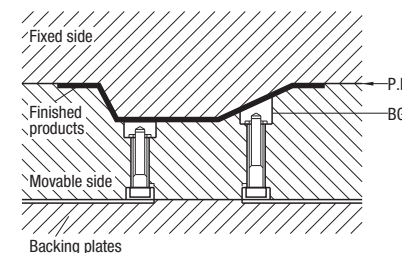


Figure 1

Characteristics

- Gas release groove (S) is processed on each plate. Specific number of each plate is combined to make gas release cavity insert block. (Figure 1)
- Since each plate is fixed only with a shoulder bolt (MSB), plugging by resin or tar can easily be removed by disassembling during maintenance.
- Gas as well as air is released from 0.03 or 0.05mm groove, lowering flow resistance and facilitating molding.
- It can be processed on bent surface to suit the shape of finished product. (See Example)
- Effective in relieving gas at time of mold processing in middle to large size molds.

How to mount

1. Insert where gas is apt to collect such as final filling section.
2. Process bent surface to suit product type as necessary.
3. We recommend addition of relief groove in order to decrease resin plugging in gas release groove. Ideally, a relief groove should be added by alteration of 0.5~1.0mm thickness after leaving approximately 5~12mm of gas release groove section. (Figure 2)
4. A/B dimension tolerance are positive. Insert into mold by actual fitting process.
5. A tap hole is added on the bottom of cavity insert. It is for fixing the insert. (See Example)

Note on handling

1. Select 0.03 for groove depth when resin has a high fluidity, and 0.05 when resin has a low fluidity.
2. Be sure to identify bolt hole and tap hole on the inside of cavity insert in the blueprint when processing bent surface, so that it will not create any problem.
3. Note that tapering process on bent surface enlarges the groove area and may cause plugging.
4. Please be careful about mounting position since shape of the groove may appear on the finished product depending on the groove width and resin.
5. This product achieves dimensional precision by performing the final machining in shape of block which is a combination of each plate with gas release groove. Be sure to reassemble in original order if you happen to disassemble it. You can identify the correct order by the 0.1mm depth V groove in angled direction on the bottom of insert. Slight imbalance may occur by precision error in shoulder bolt and hole. Thus assembly should be done on a flat surface with dimension fitting.
6. Each plate for this product is a raw material. Note that it will be damaged if struck with hard object.

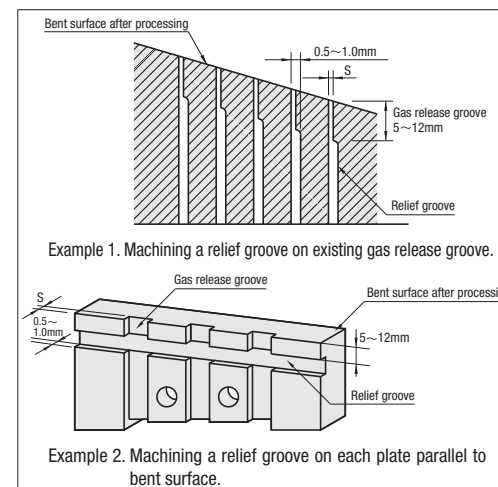


Figure 2: Cavity Inserts for Gas Release Example of relief groove addition