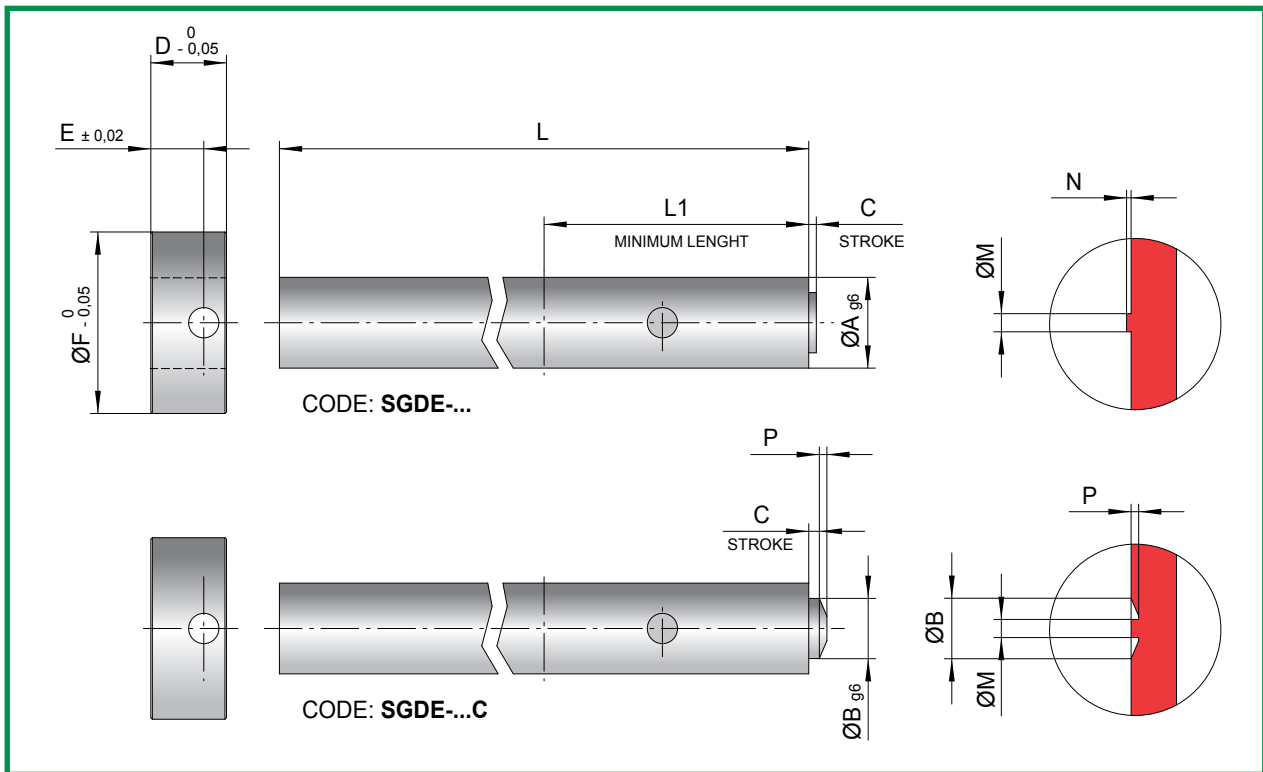


# DYNAMIC GAS VENTING EJECTOR PIN



CODE	A	B	C	D	E	F	M	N	P	L1	L	
SGDE-605	6	4	0,5	5	3,5	12	1,2	0,3	/	35	300	400
SGDE-607C	6	4	0,7	5	3,5	12	1,2	/	0,5	35	300	400
*SGDE-608	6	4	0,8	5	3,5	12	/	/	/	35	300	400
SGDE-805	8	4	0,5	5	3,5	14	1,2	0,3	/	35	300	400
SGDE-807C	8	4	0,7	5	3,5	14	1,2	/	0,5	35	300	400
*SGDE-808	8	4	0,8	5	3,5	14	/	/	/	35	300	400
SGDE-1005	10	4	0,5	5	3,5	16	1,2	0,3	/	35	300	400
SGDE-1007C	10	4	0,7	5	3,5	16	1,2	/	0,5	35	300	400
*SGDE-1008	10	4	0,8	5	3,5	16	/	/	/	35	300	400
SGDE-1205	12	4	0,5	7	4	18	1,2	0,3	/	35	600	
SGDE-1207C	12	4	0,7	7	4	18	1,2	/	0,5	35	600	
*SGDE-1208	12	4	0,8	7	4	18	/	/	/	35	600	
SGDE-1405	14	4	0,5	7	4	22	1,2	0,3	/	35	600	
SGDE-1407C	14	4	0,7	7	4	22	1,2	/	0,5	35	600	
*SGDE-1408	14	4	0,8	7	4	22	/	/	/	35	600	

Order example: SGDE-605x300

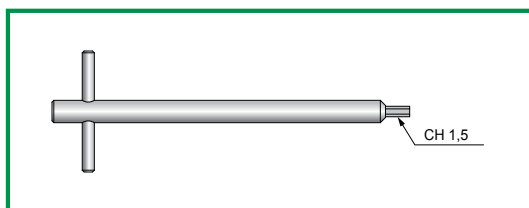
Mat. valve: AISI 420B

Hardness: 50÷52 HRC

Mat. ejector pin: 1.2344

Hardness: 950 HV

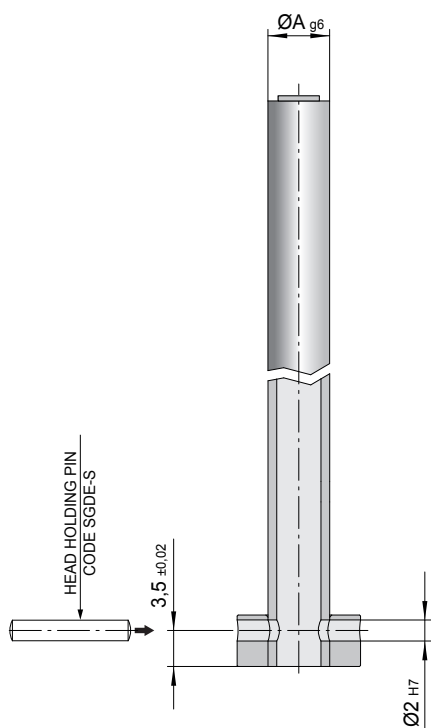
\* It is necessary to inject an air blast after ejection of plastic part. (See technical notes)



CODE: **SGDE-CH**

## ASSEMBLY

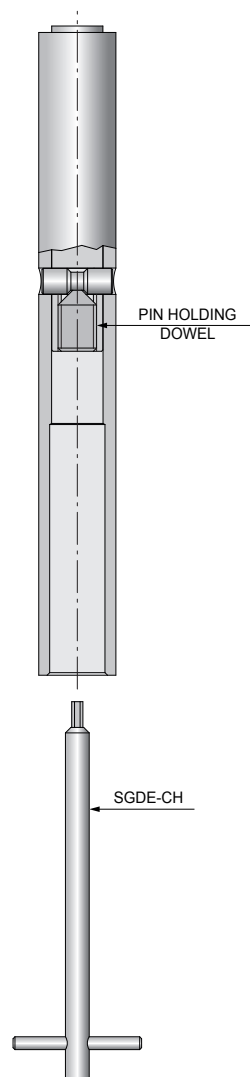
- Cut the ejector rod to the desired length.
- Machine on the ejector rod the hole to fit the head-holding pin.
- Insert the ejector head and fix it with the pin code SGDE-S.



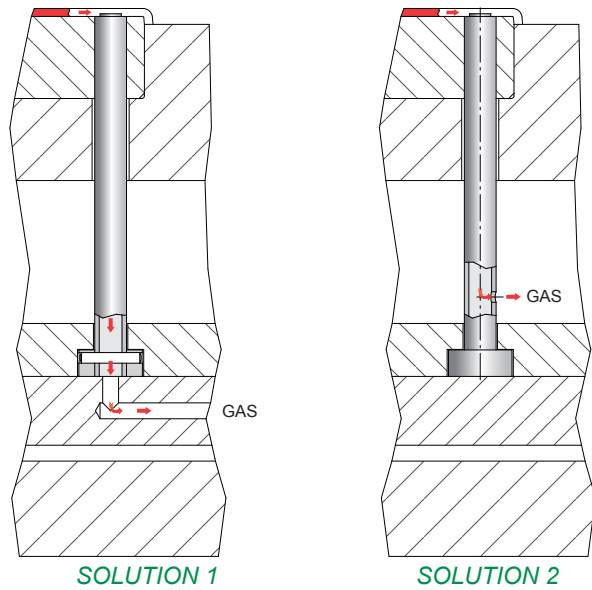
## CLEANING AND MAINTENANCE

It is possible to disassemble the dynamic venting valve with the following procedure:

- Remove the head holding pin and the ejector head.
- Unscrew the internal dowel with the key SGDE-CH, remove the valve holding pin and extract the venting valve from ejector front side.



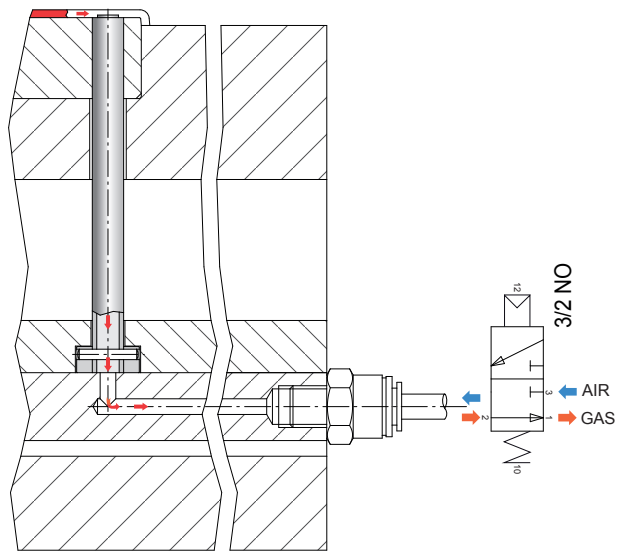
- The gas can flow out of the ejector pin through a hole machined in the ejector plate or in the ejector rod.



## TECHNICAL INSTRUCTIONS FOR THE APPLICATION OF CODE SGDE-608/808/1008

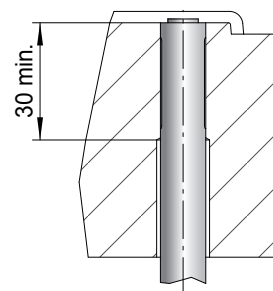
For a correct application of the venting valve code: SGDE-608/808/1008 it is necessary to inject an air blast after ejection of plastic part, the air will guarantee the valve to open every shot.

With a normally open 3/2 valve it is possible to use the gas venting channel also to inject the air blast.

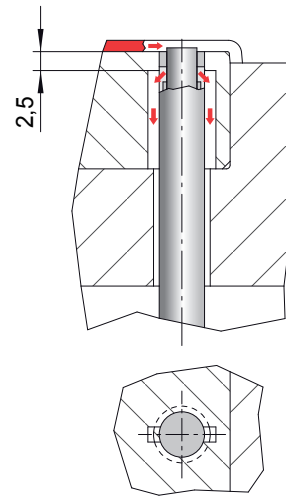


## TECHNICAL INSTRUCTIONS FOR THE APPLICATION OF CODE SGDE-608/808/1008

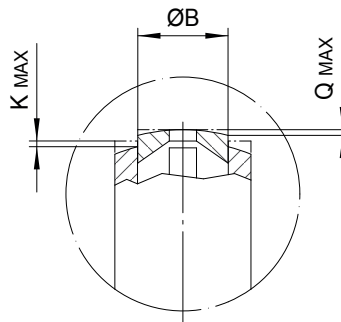
- It is necessary to guide the ejector pin for at least 30mm.



Some polymeric materials produce remarkable gas volume during melting process. Oily gas deposits can pile up and obstruct the gas venting channels. It is possible to machine extra gas venting channel in the mold as shown in the picture to improve valve performance.

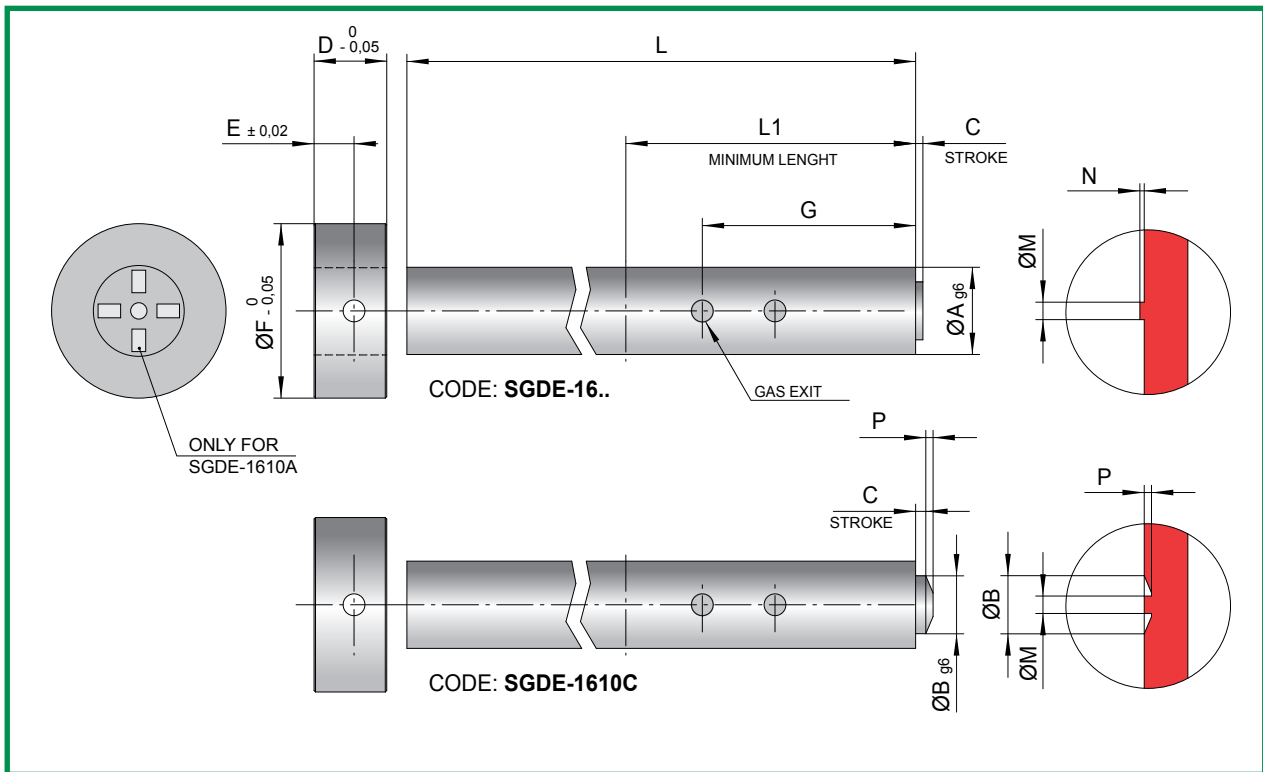


SHAPING MACHINING



CODE	B	K	Q
SGDE-605/805/1005	4	0,5	0,25
SGDE-608/808/1008	4	0,25	0,25

# DYNAMIC GAS VENTING EJECTOR PIN



CODE: **SGDE-16..**

## ONLY FOR HIGH VISCOSITY MATERIALS

CODE	A	B	C	D	E	F	G	M	N	P	L1	L
SGDE-1610	16	10	1	7	4	22	80	2	0,5	/	100	780
SGDE-1610A	16	10	1	7	4	22	80	2	0,5	/	100	780
SGDE-1610C	16	10	1	7	4	22	80	2	/	0,5	100	780
SGDE-1615	16	10	1,5	7	4	22	80	/	/	/	100	780

Order example: SGDE-1610x780

Mat. valve: AISI 420B

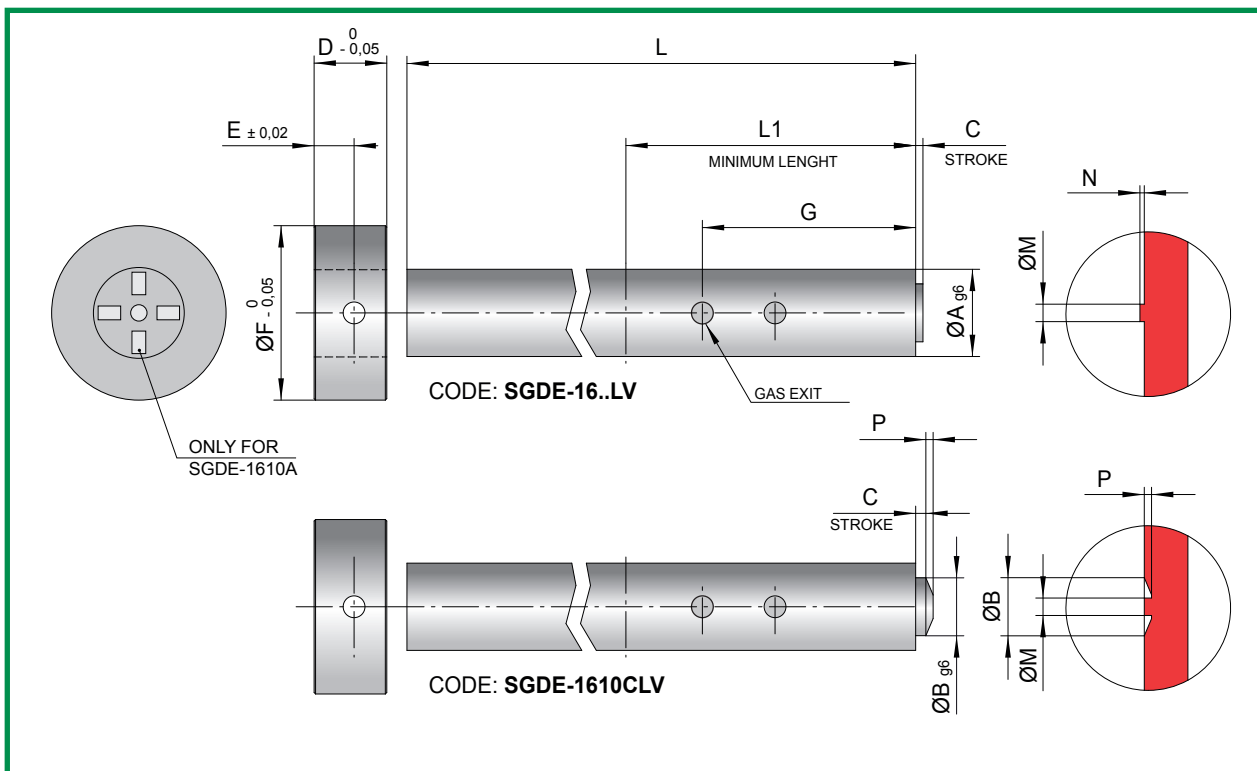
Hardness: 50±52 HRC

Mat. ejector: 1.2344

Hardness: 1000/1100 HV

## CHARACTERISTICS

1. HIGH VENTING CAPACITY;
2. MOLD DEPOSITS CANNOT PLUG UP THE VENTING SURFACE;
3. CAVITY AIR COUNTER PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF PART'S AESTHETIC CHARACTERISTICS;
5. INTERCHANGEABLE WITH STANDARDIZED DIN EJECTOR PINS;
6. ADJUSTABLE LENGTH;



## CODE: **SGDE-16..LV**

### SUITABLE ALSO FOR LOW VISCOSITY MATERIALS

CODE	A	B	C	D	E	F	G	M	N	P	L1	L
SGDE-1610LV	16	10	1	7	4	22	80	1,2	0,5	/	100	780
SGDE-1610ALV	16	10	1	7	4	22	80	1,2	0,5	/	100	780
SGDE-1610CLV	16	10	1	7	4	22	80	1,2	/	0,5	100	780
SGDE-1615LV	16	10	1,5	7	4	22	80	/	/	/	100	780

Order example: SGDE-1610LVx780

Mat. valve: AISI 420B

Hardness: 50÷52 HRC

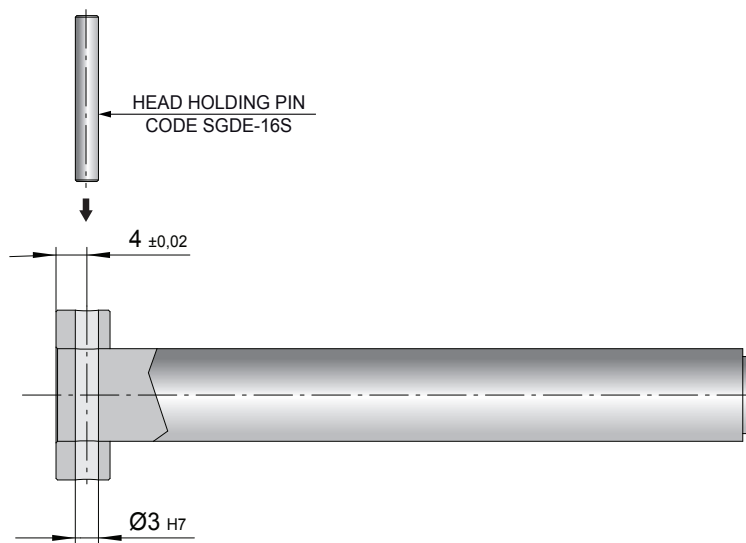
Mat. ejector: 1.2344

Hardness: 1000/1100 HV

## CHARACTERISTICS

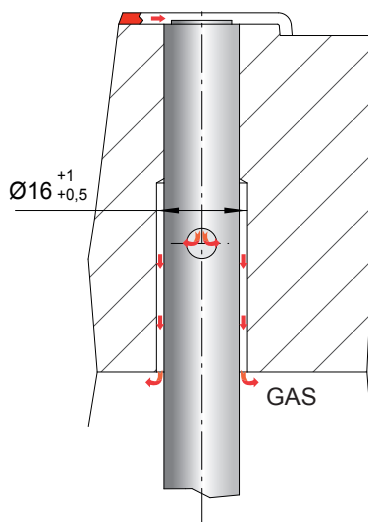
1. HIGH VENTING CAPACITY;
2. MOLD DEPOSITS CANNOT PLUG UP THE VENTING SURFACE;
3. CAVITY AIR COUNTER PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF PART'S AESTHETIC CHARACTERISTICS;
5. INTERCHANGEABLE WITH STANDARDIZED DIN EJECTOR PINS;
6. ADJUSTABLE LENGTH;

### EJECTOR'S HEAD ASSEMBLY



- Cut the ejector rod to the desired length.
- Machine on the ejector rod the hole  $\text{Ø}3$  to fit the head-holding pin.
- Insert the ejector head and fix it with the pin code SGDE-16S.

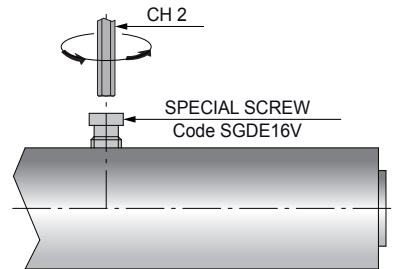
### VENTING HOLE POSITION



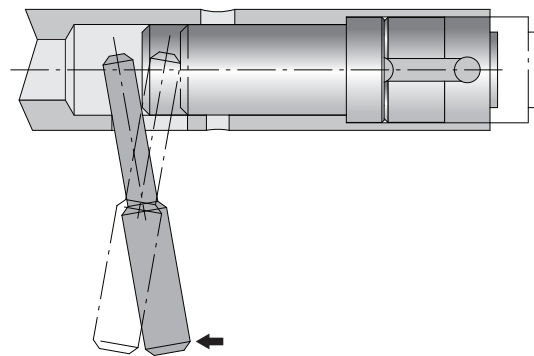
- Make sure the venting hole is located in the non-guided area of the ejector's seat

CLEANING AND MAINTENANCE

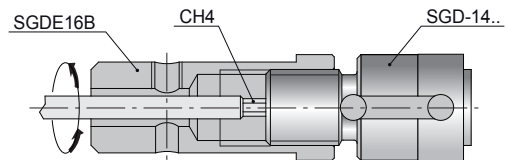
- Remove the special screw code SGDE-16V using a hexagonal key CH 2.



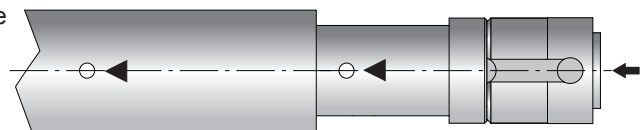
- Insert a pin diameter 3-4mm in the slot and extract the valve.



- Clamp the bush code SGDE-16B and unscrew the valve code SGD-14 with a hexagonal key CH 4.



- During the assembly procedure make sure the reference marks are aligned.

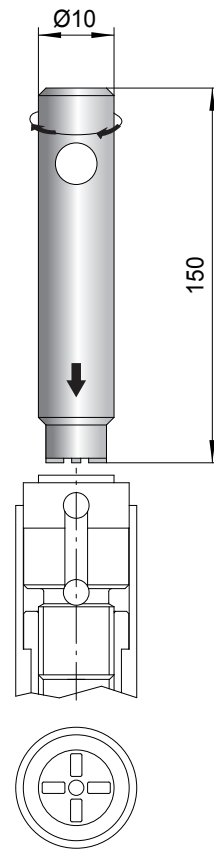




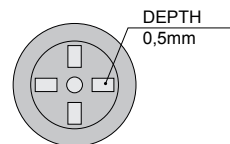
CLEANING AND MAINTENANCE

The valve code SGDE-1610A and SGDE-1610ALV can be screwed and unscrewed thanks to the special key code CS-SGDA.

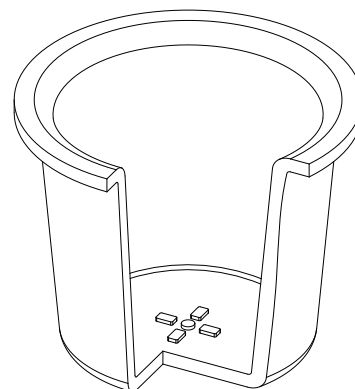
CODE: **CS-SGDA**



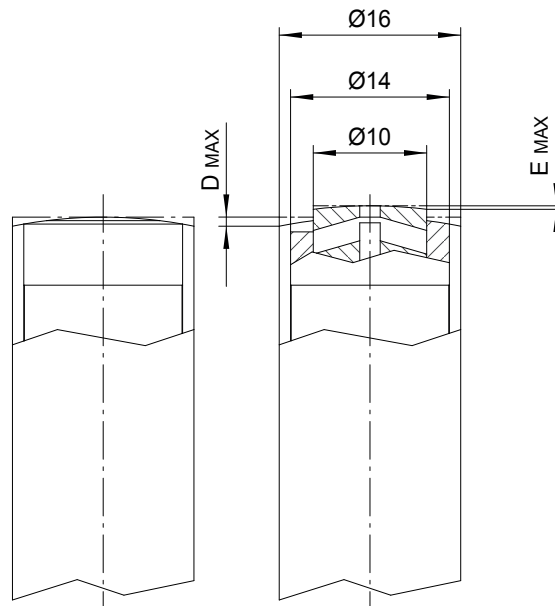
The top surface of the valve type SGDE-1610A and SGDE-1610ALV is machined to fit the key code CS-SGDA.



Such special machining creates four protrusions thickness 0,5 mm on the injected part.



SHAPING MACHINING



CODE	D	E
SGDE-1610	0,8	0,3
SGDE-1615	0,5	0,25

The SGDE-.... valve can be shaped within the maximum limit shown in the above picture.