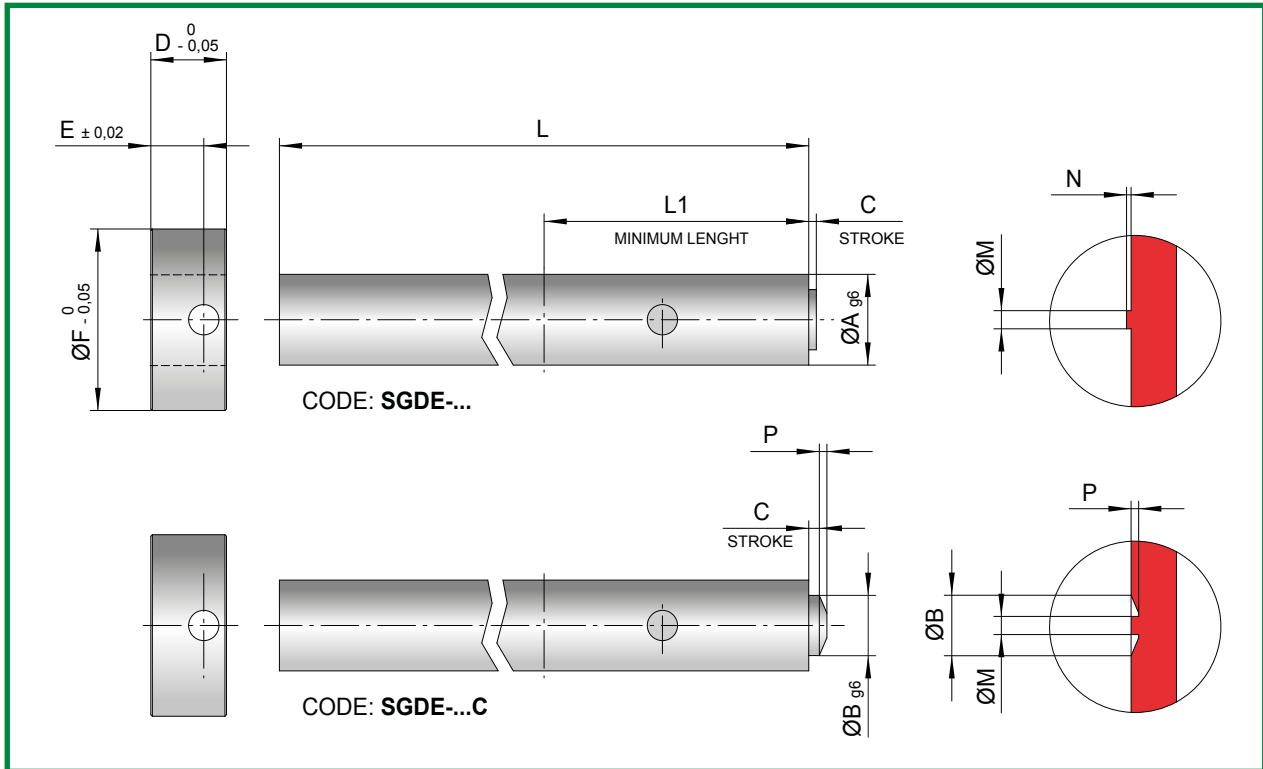


# DYNAMIC GAS VENTING EJECTOR PIN



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

Order example: SGDE-605x300

Mat. valve: AISI 420B

Hardness: 50÷52 HRC

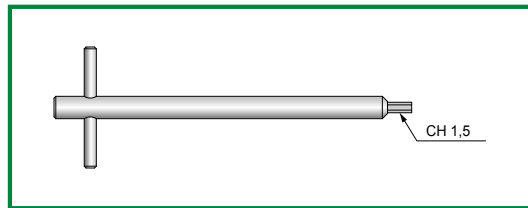
Mat. ejector pin: 1.2344

Hardness: 950 HV

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

## CHARACTERISTICS

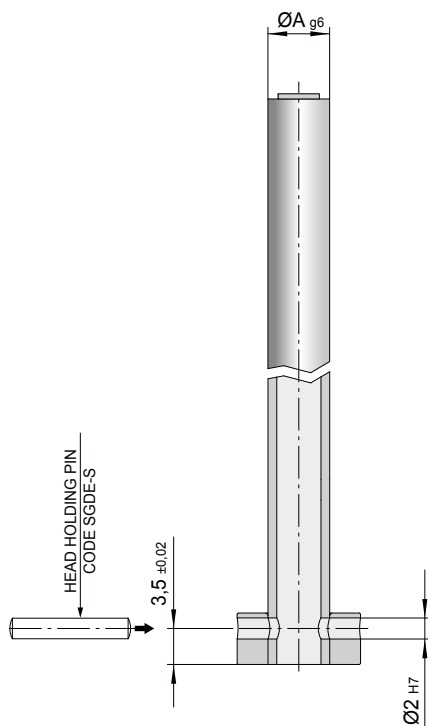
1. HIGH VENTING CAPACITY;
2. MOLD DEPOSITS CANNOT PLUG UP THE VENTING SURFACE;
3. CAVITY AIR COUNTER PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF PART'S AESTHETIC CHARACTERISTICS;
5. INTERCHANGEABLE WITH STANDARDIZED DIN EJECTOR PINS;
6. ADJUSTABLE LENGTH;
7. CUSTOM SIZES AVAILABLE.



CODE: **SGDE-CH**

## ASSEMBLY

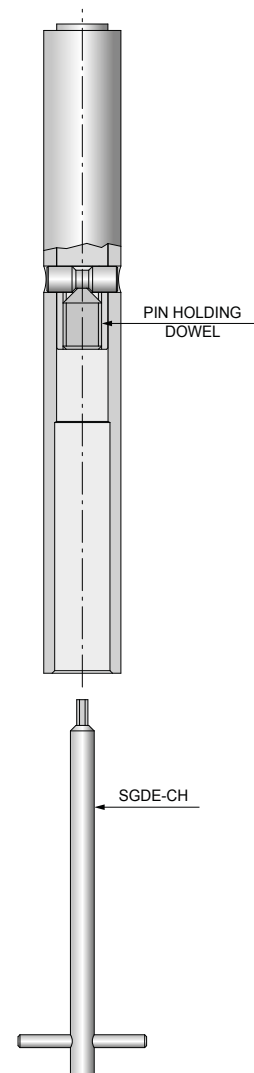
- Cut the ejector rod to the desired length.
- Machine on the ejector rod the hole to fit the head-holding pin.
- Insert the ejector head and fix it with the pin code SGDE-S.



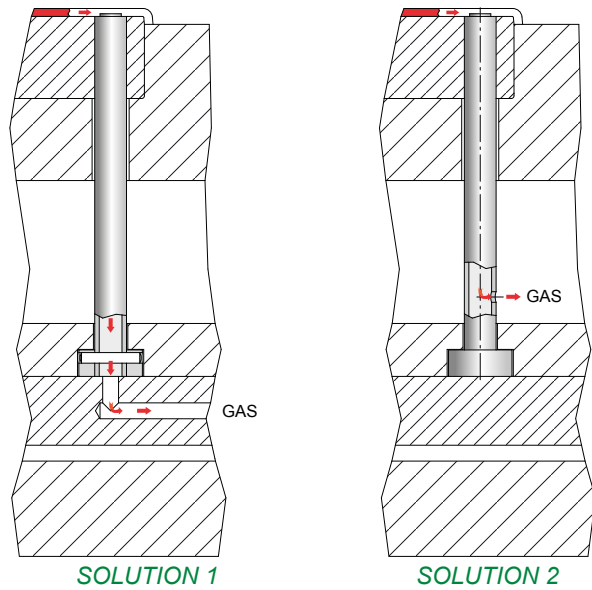
## CLEANING AND MAINTENANCE

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.



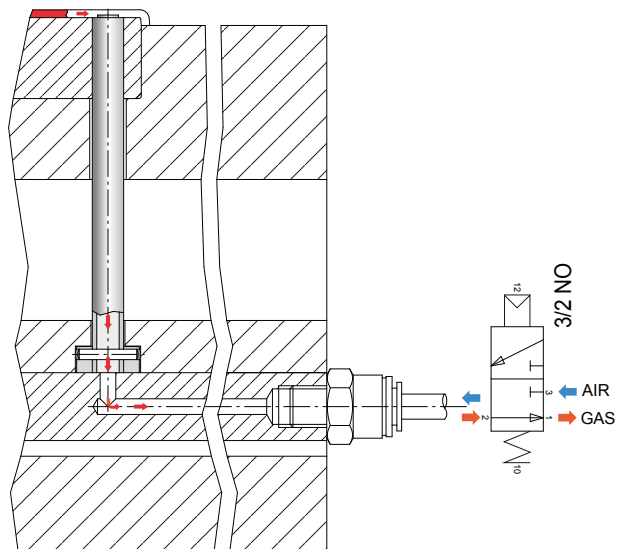
- The gas can flow out of the ejector pin through a hole machined in the ejector plate or in the ejector rod.



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

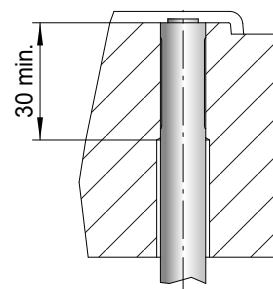
For a correct application of the venting valve code: SGDE-608/808/1008 it is necessary to inject an air blast after ejection of plastic part, the air will guarantee the valve to open every shot.

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

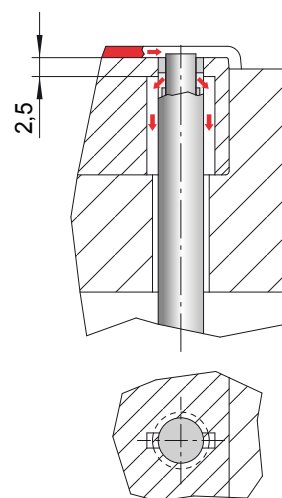


## TECHNICAL INSTRUCTIONS FOR THE APPLICATION OF CODE SGDE-608/808/1008

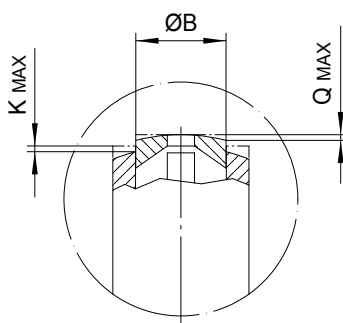
- It is necessary to guide the ejector pin for at least 30mm.



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