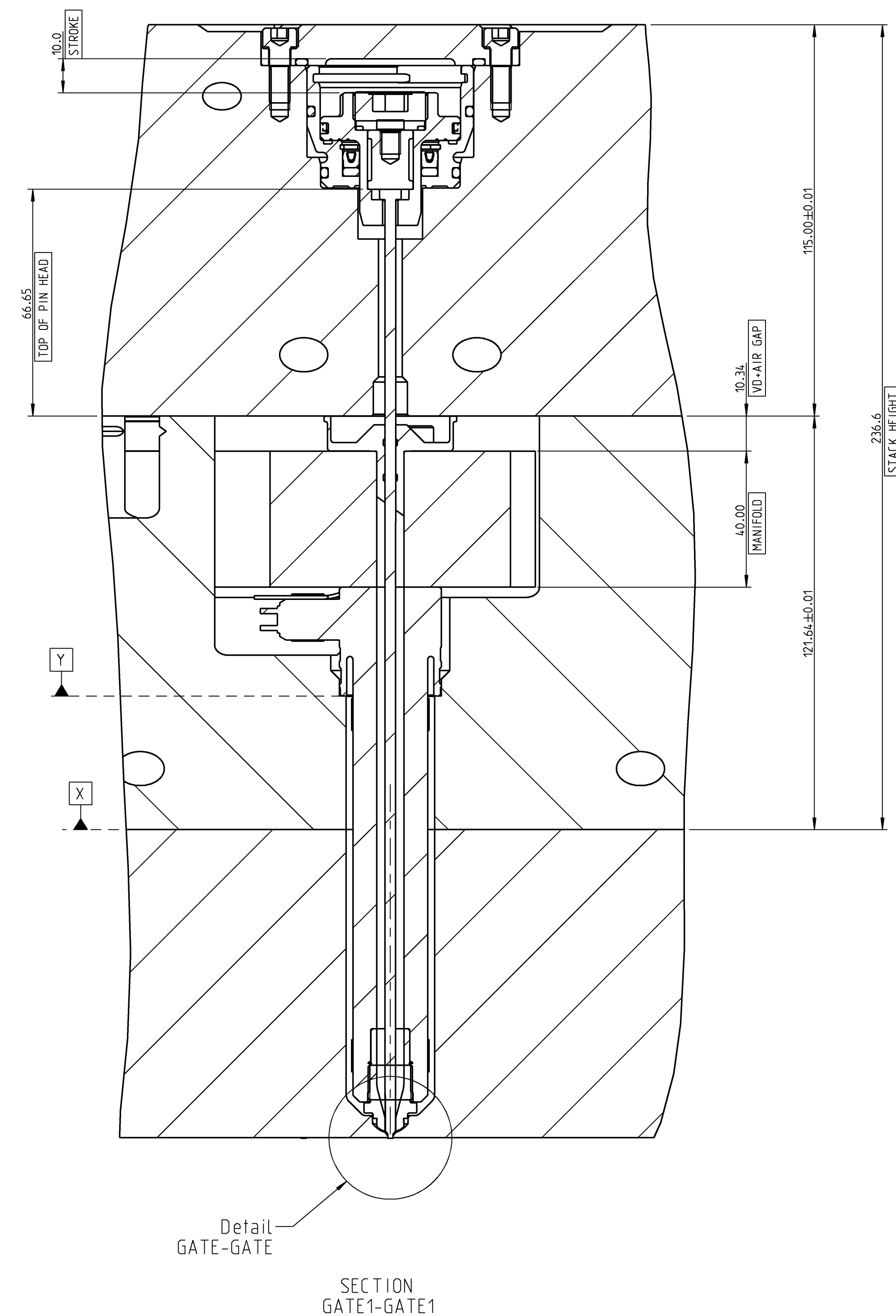


14 SEAL TORQUE  
20-22 ft-lbs  
(27-30 Nm)  
REFER TO USER MANUAL  
FOR CORRECT TORQUING  
PROCEDURE - CONT

**IMPORTANT NOTICE:**  
CLOSE PROXIMITY OF GATE COOLING CHANNELS WITH  
TURBULENT FLOW ARE A KEY FACTOR IN OPTIMIZING  
GATE QUALITY, VESTIGE AND CYCLE TIME.


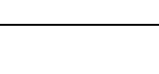

**NOTES:**

- IT IS RECOMMENDED TO STRESS RELIEVE NOZZLE GATE WELL AREA AFTER MACHINING TO ENHANCE GATE LONGEVITY.
- IT IS RECOMMENDED TO HAVE THE CAVITY GATE AREA FOLLOWING BELOW HARDNESS FOR
  - CYLINDRICAL VALVE GATE: MINIMUM 54HRC
  - TAPERED VALVE GATE: 46-48 HRC
- NOZZLE WELL AREA SHOULD NOT HAVE ANY SHARP CORNERS, UNLESS SPECIFIED ON THE GA.
- DO NOT NITRIDE OR CHROME THE AREA.
- GATE AND LAND TOLERANCES ARE GENERALLY VERY TIGHT.
- THE PRESENCE OF A LARGE DIMENSIONED GATE AND TOLERANCES IS USED FOR UNIFORMITY. GATE AREA DIMENSIONS WHICH ARE NOT IDENTICAL TO EACH OTHER WILL LEAD TO AN UNBALANCED CHARGING OF MOLD AND CAVITY.



PROCESS TEMP: 225°C  
MOLD TEMP : 25°C  
DELTA TEMP : 200°C

DETAIL GATE1-GATE1  
SCALE 10:1

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REV.	DATE	E.C.R.	Revision Description				DR'N	CH'D	APP'D
 Mold-Masters (2007) Limited			Order Number: 5461625 - 10  Mold Number: 6169-01	Customer Name: Weener Plastik GmbH End User: Weener Plastik GmbH Customer Reference Number: N/A					
General Tolerances DIN ISO2768-m			General Assembly Drawing						
No: 5461625-010-SYGD-00			Scale: 1:1		Title: GATE DETAIL 16 DROP MSC RLL VR				
	Date:	By:	 First Angle Projection		Drw No: 5461625EGD1E0-10 SAP Mat: CMA				
DR'N	2021-06-14	VKV / RSCH							
CH'D	2021-06-14	ACH							
APP'D	2021-06-14				Paper Size: Sheet: 1 of 1 Revision: 0				