ONLY FOR HIGH VISCOSITY MATERIALS

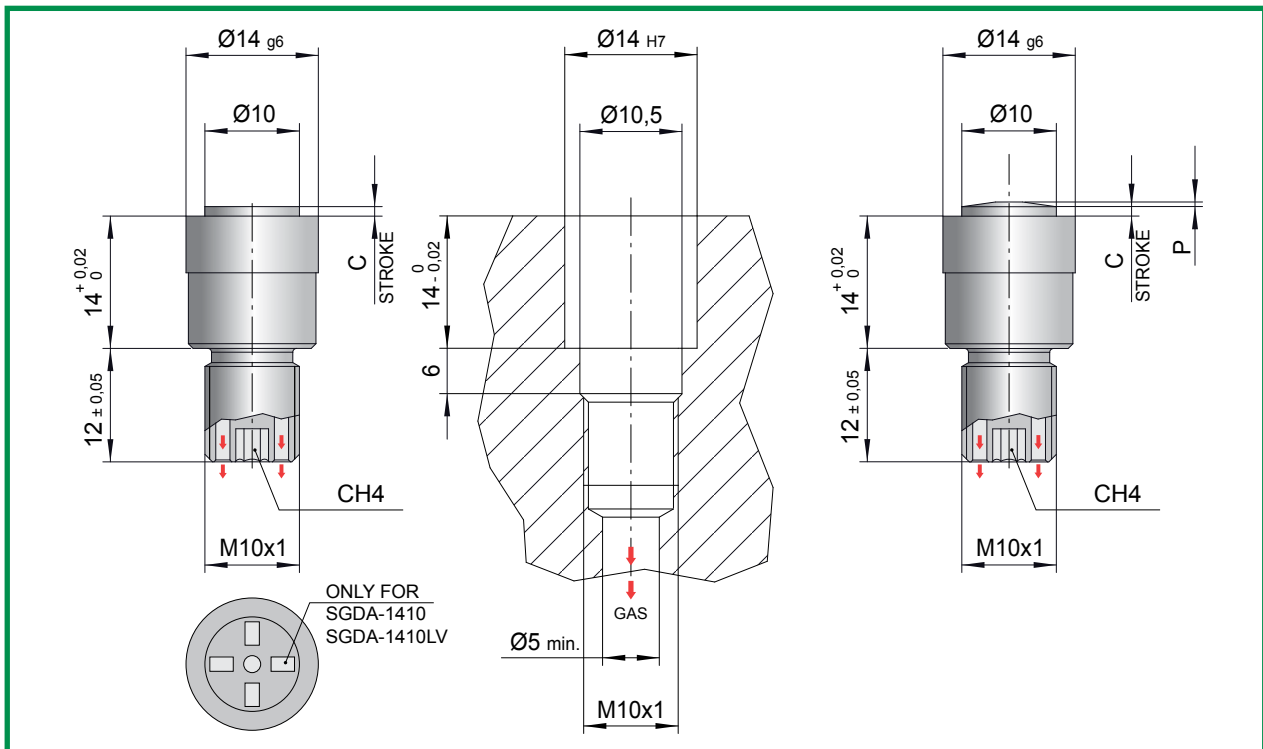| CODE	C	M	N	P
SGD-1410	1	2	0,5	/
SGDA-1410	1	2	0,5	/
SGD-1410C	1	2	/	0,5
SGD-1415	1,5	/	/	/

Mat.: AISI 420B   Hardness: 50÷52 HRC
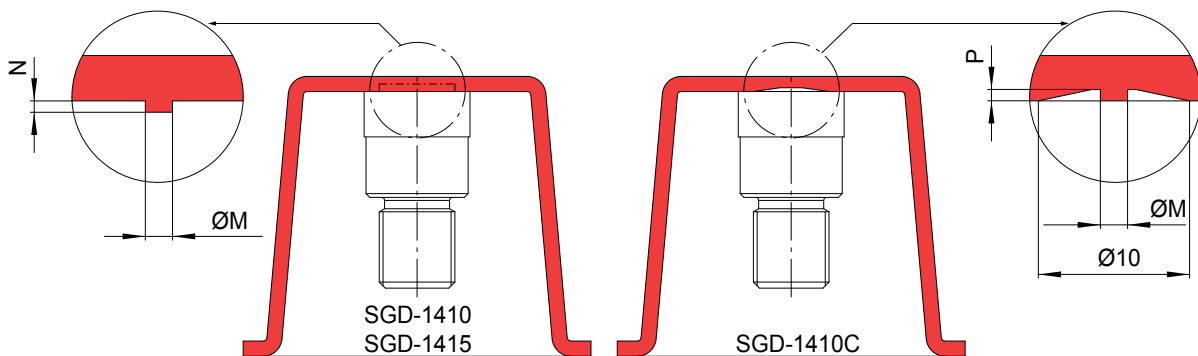
CHARACTERISTICS

1. HIGH VENTING CAPACITY;
2. VENTING SURFACE NOT AFFECTED BY MOLD DEPOSITS;
3. IN CAVITY AIR BACK PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF AESTHETIC CHARACTERISTICS OF THE INJECTED PART;
5. POSSIBILITY OF FRONT DISASSEMBLY.

ERMANNO BALZI

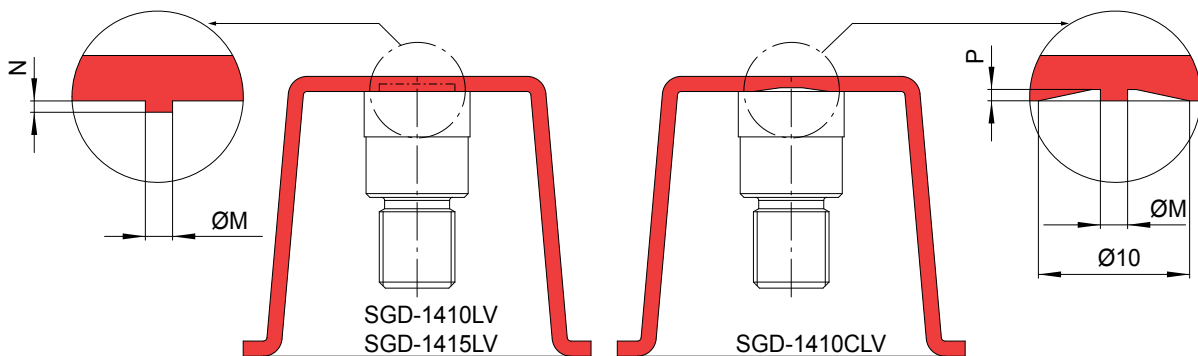| SUITABLE ALSO FOR LOW VISCOSITY MATERIALS				
CODE	C	M	N	P
SGD-1410LV	1	1,2	0,5	/
SGDA-1410LV	1	1,2	0,5	/
SGD-1410CLV	1	1,2	/	0,5
SGD-1415LV	1,5	/	/	/

Mat.: AISI 420B   Hardness: 50÷52 HRC

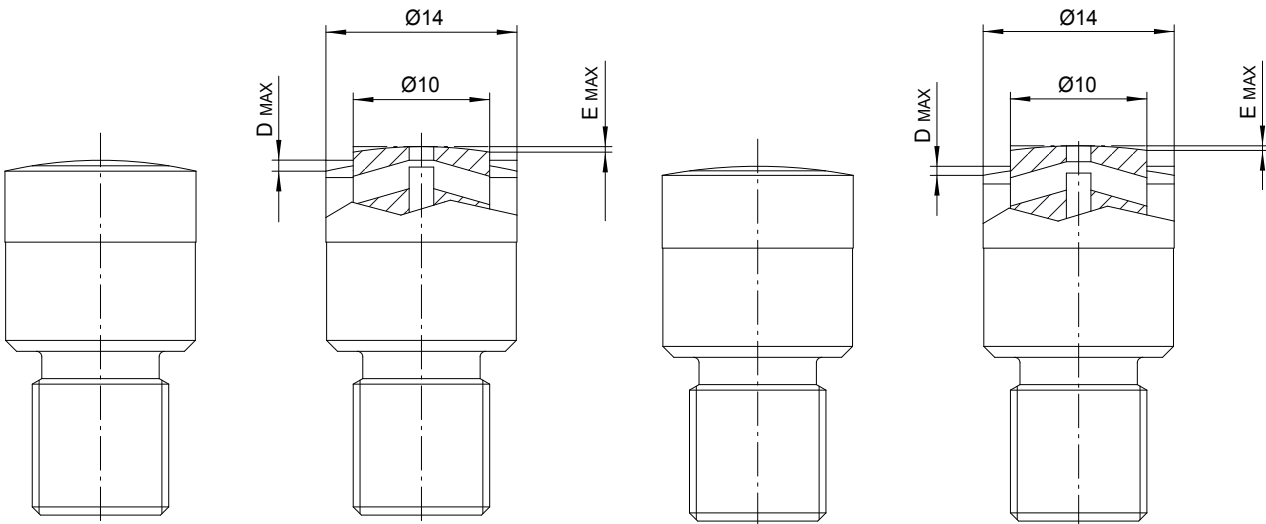SGD-1410LV
SGD-1415LV

SGD-1410CLV

CHARACTERISTICS

1. HIGH VENTING CAPACITY;
2. VENTING SURFACE NOT AFFECTED BY MOLD DEPOSITS;
3. IN CAVITY AIR BACK PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF AESTHETIC CHARACTERISTICS OF THE INJECTED PART;
5. POSSIBILITY OF FRONT DISASSEMBLY.

ERMANNO BALZI

WORKING SYSTEM
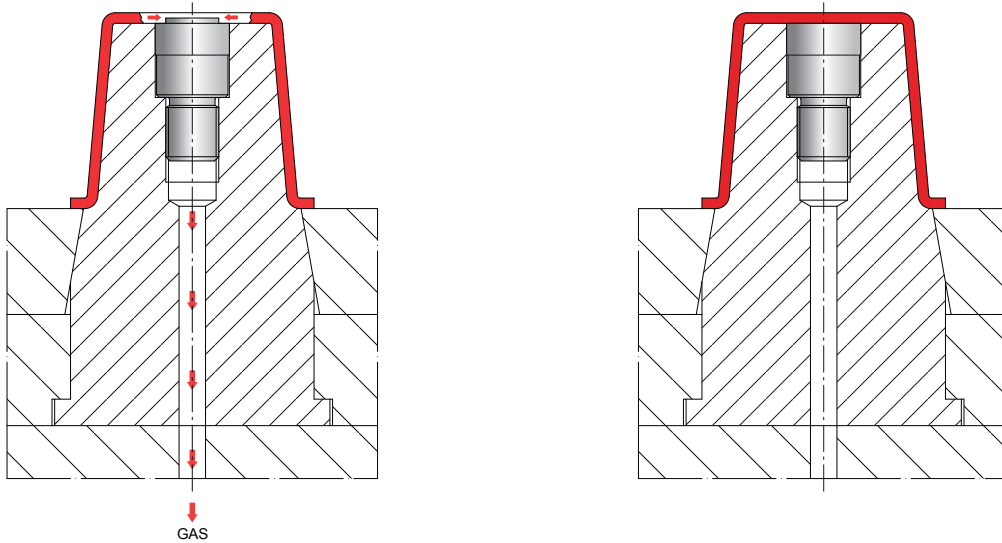
During the injection process the spring keeps the sliding insert in "open position" allowing the gases to pour out through the hole on the top of the valve. When the flow front reaches SGD the sliding insert moves back under plastic pressure to "close position" and closes the gas venting hole.

SHAPING MACHINING

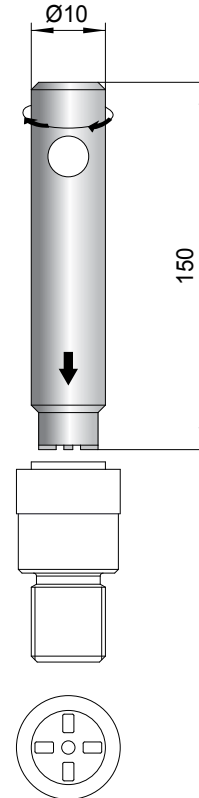*MODEL: SGD-1410*   *MODEL: SGD-1415*

CODE	D	E
SGD-1410	0,8	0,4
SGD-1415	0,5	0,25

The SGD valve can be shaped within the maximum limit shown in the above picture.
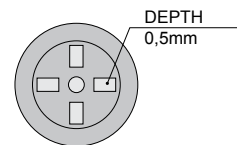
ERMANNO BALZI

FRONT UNSCREWING

The valve code SGDA-1410 can be screwed and unscrewed thanks to the special key code CS-SGDA. This application makes faster and simplier the valve maintenance procedure.
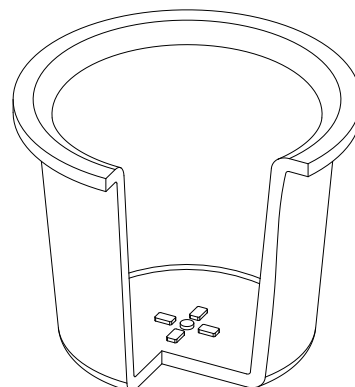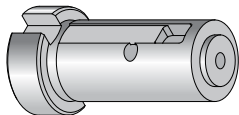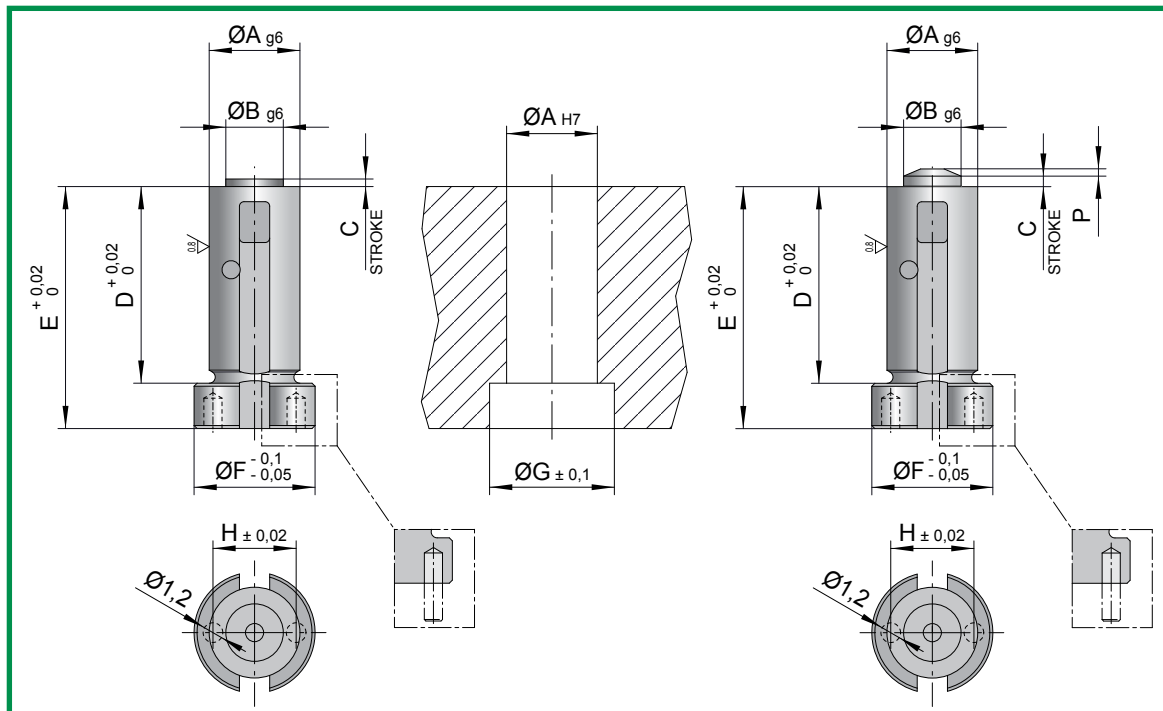
Ø10

150

CODE: **CS-SGDA**

The top surface of the valve type SGDA-1410 is machined to fit the key code CS-SGDA.
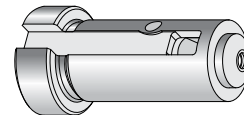
DEPTH 0,5mm

Such special machining creates four protrusions thickness 0,5 mm on the injected part.
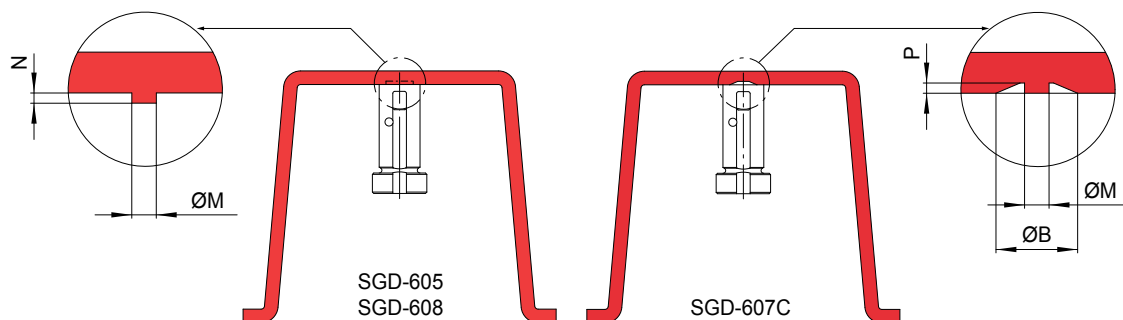
CODE: **SGD-605 / SGD-608**   CODE: **SGD-607C**

CODE	A	B	C	D	E	F	G	H	M	N	P
SGD-605	6	4	0,5	13	16	8	8,5	5,5	1,2	0,3	/
*SGD-608	6	4	0,8	13	16	8	8,5	5,5	/	/	/
SGD-607C	6	4	0,7	13	16	8	8,5	5,5	1,2	/	0,5

Mat.: AISI 420B   Hardness: 50÷52 HRC

* It is necessary to inject an air blast after ejection of plastic part. (See technical notes)
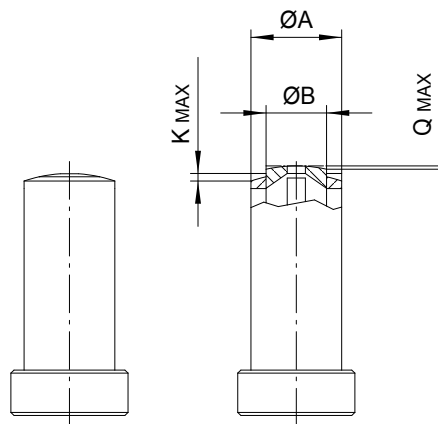
SGD-605
SGD-608

SGD-607C

CHARACTERISTICS

1. HIGH VENTING CAPACITY;

2. VENTING SURFACE NOT AFFECTED BY MOLD DEPOSITS;

3. IN CAVITY AIR BACK PRESSURE DRAMATICALLY REDUCED;

4. IMPROVEMENT OF AESTHETIC CHARACTERISTICS OF THE INJECTED PART.

ERMANNO BALZI

SHAPING MACHINING

The SGD-6.. valves can be shaped within the maximum limit shown in the above picture.

CODE	A	B	K	Q
SGD-605	6	4	0,5	0,25
SGD-608	6	4	0,5	0,25

APPLICATION EXAMPLE

The valve type SGD-6.. has to be fixed into the mold insert from the back side. The spacer code D-SGD and the dowel code G-SGD can make this application easier.

The spacer is specially designed to collect the gases from the valve toward a central hole that communicates with the open atmosphere. It is possible to machine the spacer in order to reach the desired length.

The dowel allows to fix the spacer and the valve and collects the gases into the central hole.

Code:D-SGD

GAS

Code:G-SGD

GAS

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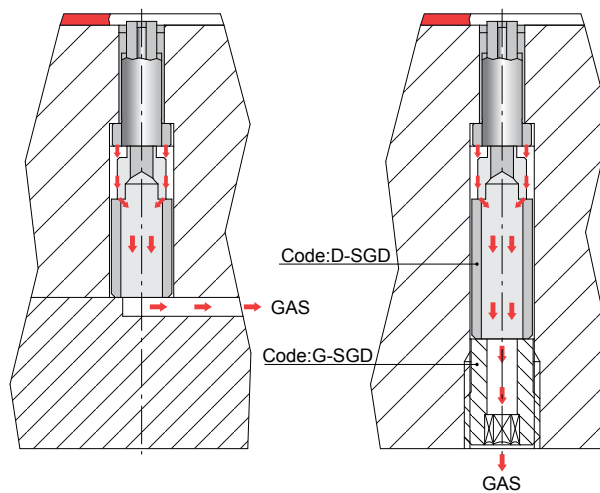
For a correct application of the venting valve code: SGD-608 it is necessary to inject an air blast after ejection of plastic part, the air will guarantee the valve to open every shot.

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

3/2 NO

AIR

GAS
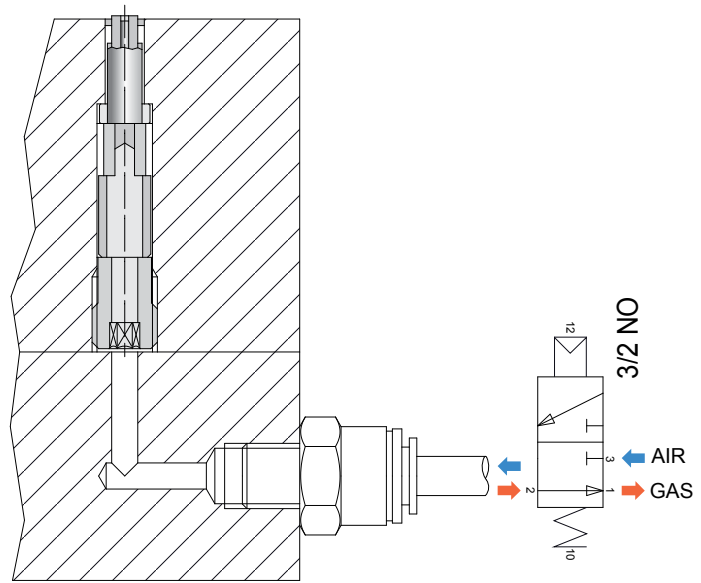
Some polymeric materials produce remarkable gas volume during melting process. Oily gas deposits can pile up and obstruct the gas venting channels. It is possible to machine extra gas venting channel in the mold as shown in the picture to improve valve performance.
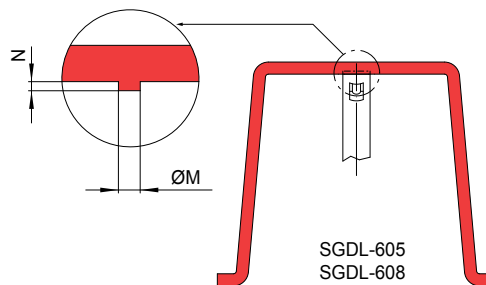
2,3

GAS

ERMANNO BALZI
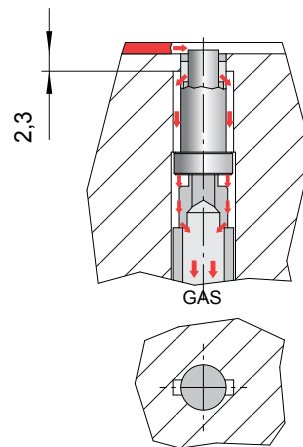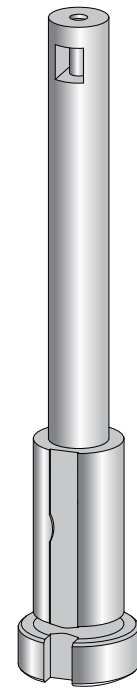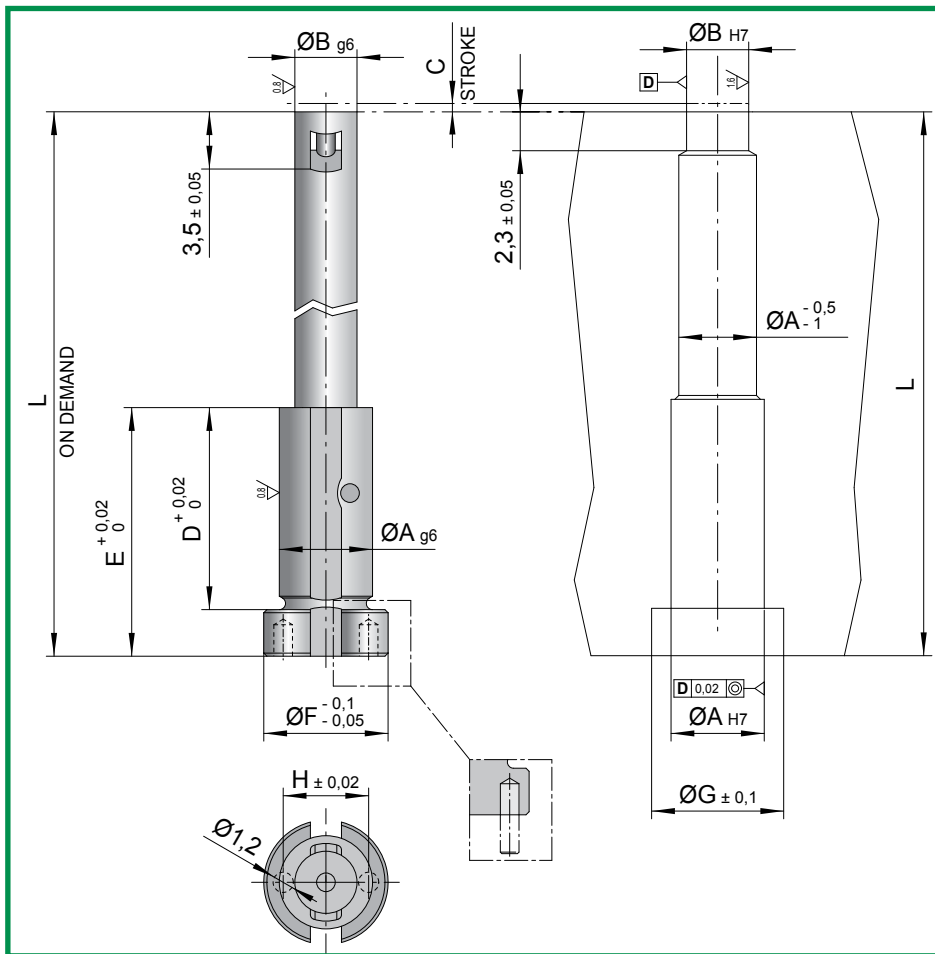
CODE: **SGDL-...**

CODE	A	B	C	D	E	F	G	H	L (min)	L (max)	M	N
SGDL-605	6	4	0,5	13	16	8	8,5	5,5	20	105	1,2	0,3
*SGDL-608	6	4	0,8	13	16	8	8,5	5,5	20	105	/	/

Mat.: AISI 420B   Hardness: 50÷52 HRC

* It is necessary to inject an air blast after ejection of plastic part. (See technical notes)
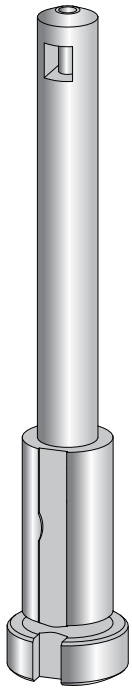
SGDL-605
SGDL-608
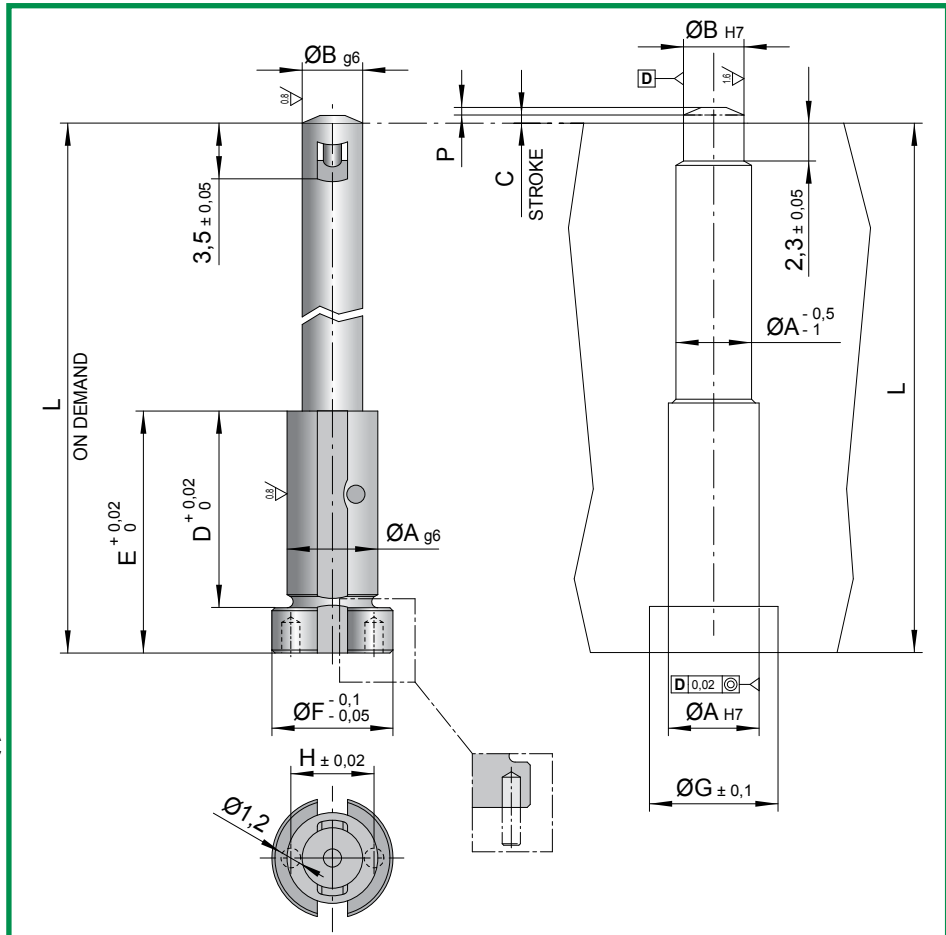
CHARACTERISTICS

1.   HIGH VENTING CAPACITY;
2.   VENTING SURFACE NOT AFFECTED BY MOLD DEPOSITS;
3.   IN CAVITY AIR BACK PRESSURE DRAMATICALLY REDUCED;
4.   IMPROVEMENT OF AESTHETIC CHARACTERISTICS OF THE INJECTED PART;
5.   LIMITED DIMENSONS;
6.   MAXIMUM AVAILABLE LENGHT 105mm.

ERMANNO BALZI

CODE: **SGDL-607C**

CODE	A	B	C	D	E	F	G	H	L (min)	L (max)	M	N	P
SGDL-607C	6	4	0,7	13	16	8	8,5	5,5	20	105	1,2	/	0,5

Mat.: AISI 420B
Hardness: 50÷52 HRC

SGDL-607C

CHARACTERISTICS

1. HIGH VENTING CAPACITY;
2. VENTING SURFACE NOT AFFECTED BY MOLD DEPOSITS;
3. IN CAVITY AIR BACK PRESSURE DRAMATICALLY REDUCED;
4. IMPROVEMENT OF AESTHETIC CHARACTERISTICS OF THE INJECTED PART;
5. LIMITED DIMENSONS;
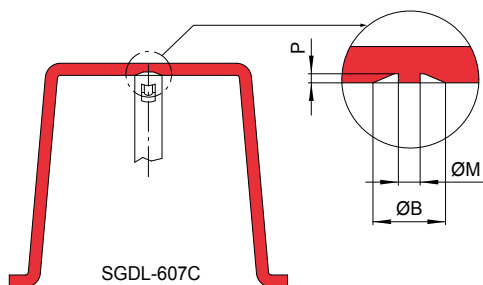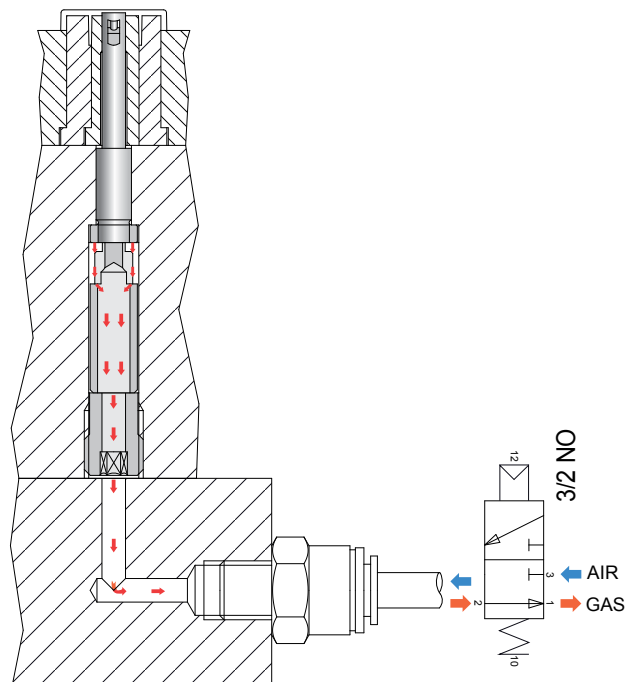6. MAXIMUM AVAILABLE LENGHT 105mm.

ERMANNO BALZI

The valve type SGDL has to be fixed into the mold insert from the back side and the valve needle has to stick out from the mold surface for a dimension equal to the stroke "C". The spacer code D-SGD.. and the dowel code G-SGD.. can make this application easier. The spacer is specially designed to collect the gases from the valve toward a central hole that communicates with the open atmosphere. It is possible to machine the spacer in order to reach the desired length.

The dowel allows to fix the spacer and the valve and collects the gases into the central hole.
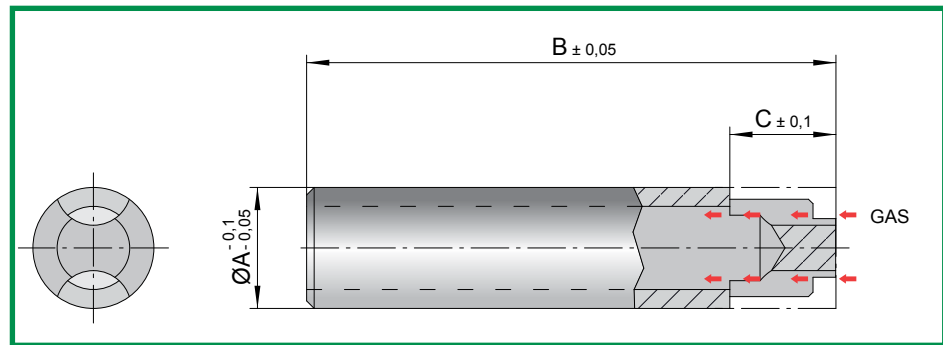
Code:D-SGD6

Code:G-SGD6

GAS
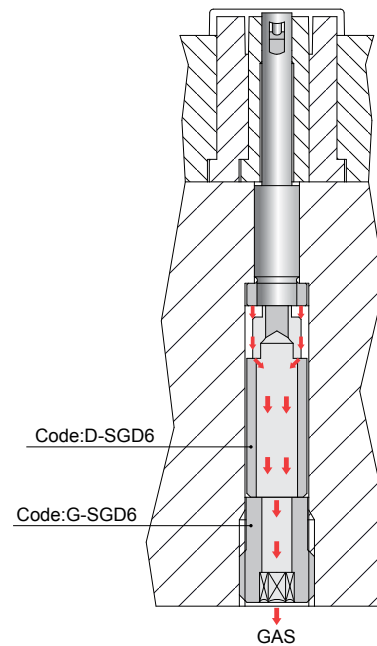
For a correct application of the venting valve Code: SGDL-608 it is necessary to inject an air blast after ejection of plastic part, the air will guarantee the valve to open every shot.

With a normally open 3/2 valve it is possible to use the gas venting channel also to inject the air blast.
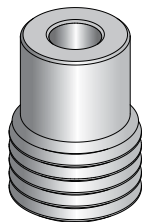
3/2 NO

AIR

GAS

ERMANNO BALZI

CODE: **D-SGD..**

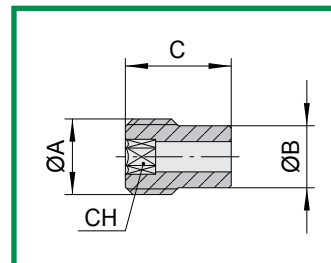| CODE	A	B	C
D-SGD6	8	50	7

Mat.: carbon steel. Hardness: 750 N/mm² (220 HB)
Nitred depth 0,1mm

DOWEL FOR
GAS VENTING VALVE

CODE: **G-SGD..**

CODE	A	B	C	CH
G-SGD6	M10	8,3	14	4

Mat.: 7225. Hardness: 750 N/mm² (220 HB)
Nitred depth 0,1mm

ERMANNO BALZI