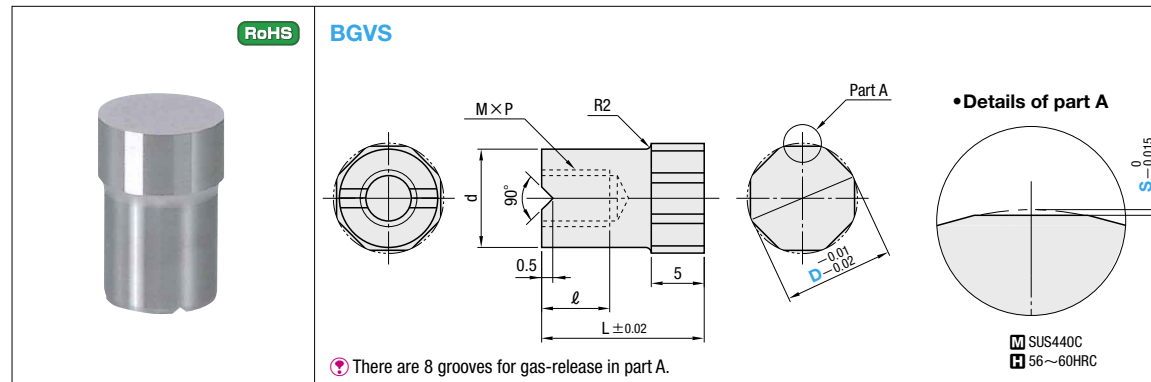


CAVITY INSERTS FOR GAS RELEASE

—ROUND TYPE—



| d | L | l | M×P | Part Number | | S | U/Price |
|-----|----|-----|--------|-------------|----|--------------|-----------|
| | | | | Type | D | | |
| 5.5 | 10 | 4.5 | M3×0.5 | BGVS | 6 | 0.03 0.05 | Quotation |
| 7.5 | 12 | 6 | M4×0.7 | | 8 | | |
| 9.5 | 15 | 7.5 | M5×0.8 | | 10 | | |

Order Part Number — S
BGVS 8 — 0.03

Price Quotation

Days to Ship Quotation

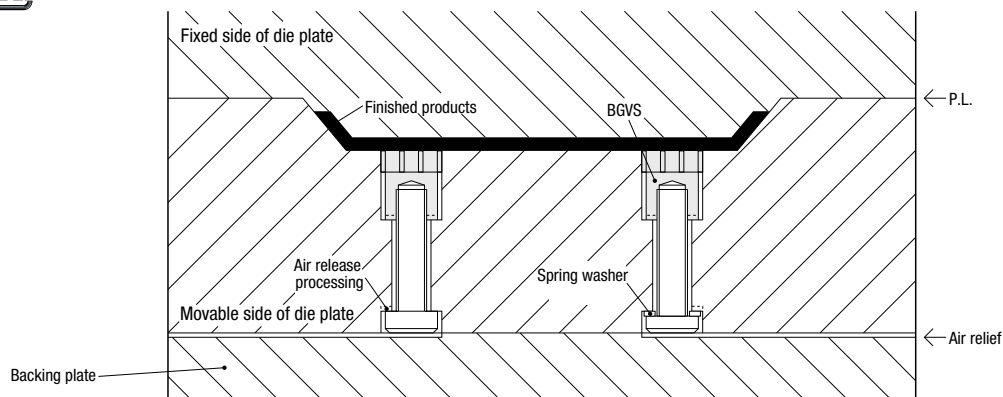
■Features

- It can release gas as well as air efficiently out of cavity from a groove (S).
- Even when resin tar plugs the gas-release groove in part A of above drawing, it can be removed easily by taking out the cavity insert from metal mold.
- Being made of stainless steel, it is resistant to corrosion.

■Notes

1. Insert into a part where gas is apt to collect, such as the last filler.
2. Select an appropriate groove width (S) by resin liquidity and mold conditions.
3. Please be careful about mounting position since shape of the groove may appear on the finished product depending on the groove width and resin.

ex Example



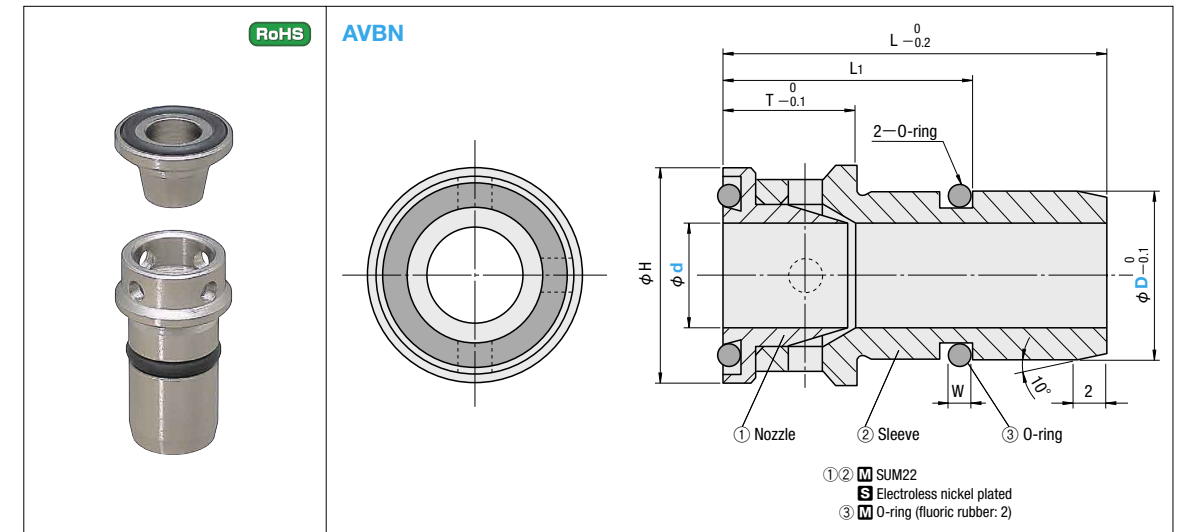
■How to Mount

1. Make a reamer hole of depth L (tolerance of H7) at the parting line (P.L) on the movable side of die plate.
2. Make a counterbore for fixing bolt in the reamer hole. Perform air release processing on the counterbore.
3. Insert BGVS into the mold and fix it with a bolt. Use of spring washer is recommended in order to facilitate prevention of loosening.

VACUUM UNIT

—BLOW TYPE—

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



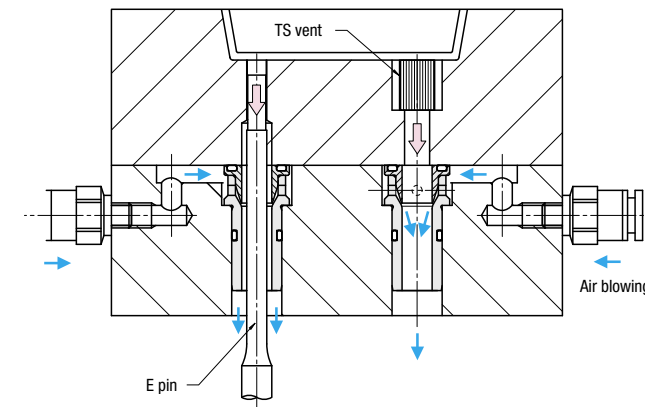
| H | L | L1 | T | O-ring | | Part Number | | d | U/Price |
|----|----|----|---|-------------|----------------|-------------|----|----|-----------|
| | | | | Thickness W | Nominal number | Type | D | | |
| 8 | 18 | 13 | 8 | 1 | 5 | AVBN | 6 | 3 | Quotation |
| 11 | 25 | 15 | 8 | 1.5 | 6 | | 8 | 4 | |
| 13 | 25 | | | | | | 8 | 6 | |
| 16 | 30 | | | | | | 10 | 9 | |
| 19 | 35 | | | | | | 14 | 12 | |

Order Part Number — d
AVBN 10 — 6

Days to Ship Quotation

Price Quotation

ex Example



■Characteristics

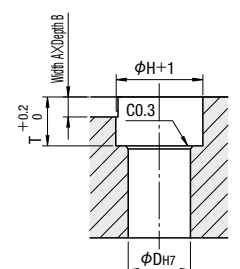
- Vacuum unit (AVBN) prevents molding problem of gas bake, deformation and so on, by air blowing.

■Notes

- Use it under air pressure of 0.3~0.5MPa.
- Set internal diameter d-2mm or less if ejector pin is inserted.
- Perform chamfering to avoid the damage of O-rings when mounting vacuum units.
- Please use tubes of external diameter φ6 or more and internal diameter φ4 or more.
- This unit can be used as a gas countermeasure, but its effectiveness differs depending upon the molding conditions, so it may sometimes be unable to overcome a problem.
- Specifications of unlisted dimensions may change without notice to improve performance.

■Example of recommended machining condition of air passing hole

| Part Number | Groove machining | |
|-------------|------------------|-----|
| | D | B |
| AVBN | 6 | 4 3 |
| | 8 | |
| | 10 | |
| | 13 | |
| 16 | | |



Date Marked Pins
Recycle Marked Pins
Pins with Gas Vent