

MP PIN ADJUSTMENT (CLICK) CY2/CB2/CB3



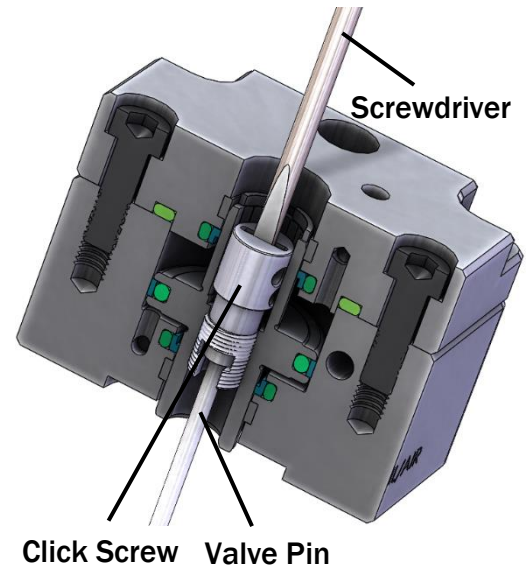
 **MasterFlow**®

LEADER IN HOT RUNNER TECHNOLOGY

Pin Adjustment Instruction CY2/CB2/CB3 Click

1. Divide the mould in fixed and movable half.
2. Correct dimensions can only be maintained with production temperatures on hot runner and mould. Connect the water cooling to cylinders/clamping plate to prevent damage on seals. Heat up the hot runner system and the fixed mould half (mould temperature) to production temperatures.

3. Put the piston in the “closed” position (forward). Look if the pin is far away from the gate (>2mm), move on to step 5.
4. If it is close to the gate (<2mm), put the piston in the “open” position (backward) and click the screw back 5 clicks (counterclockwise) with a screwdriver. Every click means the pin is moved 0,05 mm for CY2/CB2 and 0,0625 mm for CB3. If the piston is rotating, you have either reached the bottom of the thread, or you need MasterFlow “Pin Adjustment Tool”. Put the piston in the “closed” position (forward). Repeat from step 3.



5. Keep pressure on the piston in the “closed” position (forward). Click the pin forward until the pin is levelling (flush) with the gate. This is your calibration position. **Important:** If it feels like the screw get stuck and hard to click, this is an indication that the boring dimension at the gate is incorrect so the pin can't get forward. Please check mould boring details.
6. For **Tapered Gate** (15° conical on each side): put the piston in the “open” position (backward) and keep the pressure, then “click” another 4 or 3 “click” forward (4 clicks for CY2/CB2 and 3 clicks for CB3). This is to secure that the tapered gate is sealing.

Cylinder stroke and maximum pressure

Series	Cylinder	Max cylinder pressure (bar) Pneumatic	Max cylinder pressure (bar) Hydraulic	Cylinder stroke (mm)
20	CY2 / CB2	6	8	8,5
30	CY2 / CB2	10	15	8,5
40	CY2 / CB2	-	40	8,5
40	CB3	15	20	15
50	CB3	-	50	15

7. At production, adjust the air/oil pressure to required level for the specific application. Do not use more air/oil pressure than required. See chart maximum pressure for the different series. When using oil pressure from injection moulding machine, set the pressure limit valve (mechanical) at maximum required pressure. **Important:** Pressure peaks/spikes above maximum pressure may damage seals, pins and the mould.