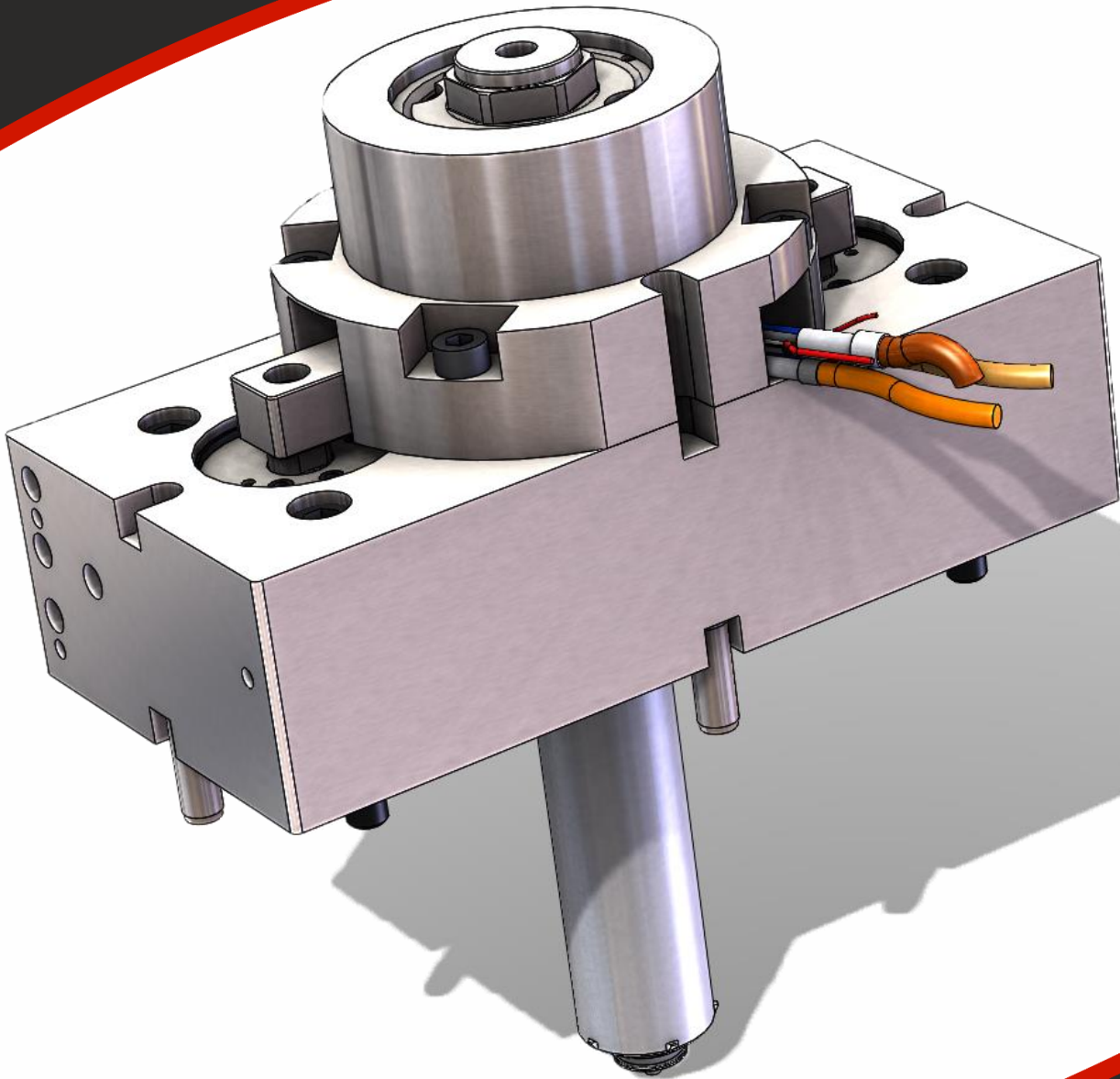


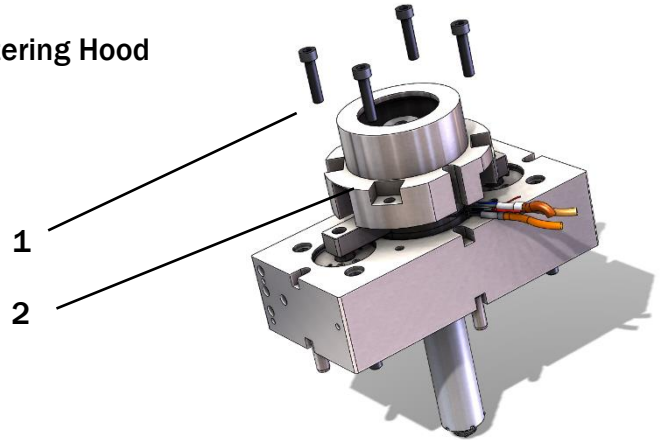
# MP SEAL KIT SINGLE VALVE GATE (SMP)



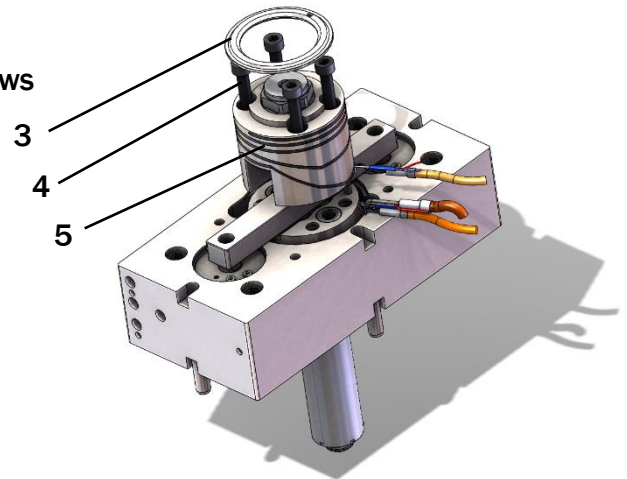
 **MasterFlow**®

LEADER IN HOT RUNNER TECHNOLOGY

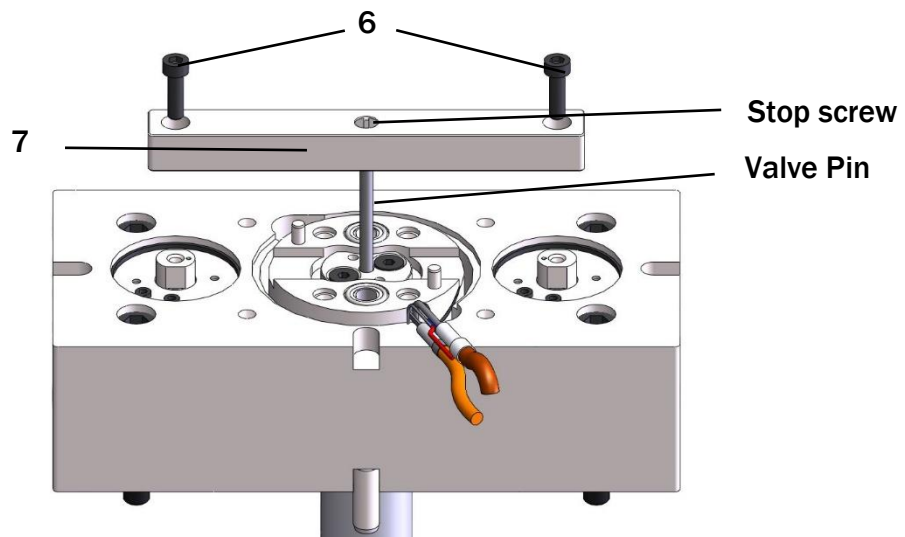
1. Make sure that the hot runner is clean (Valve Pin, End Cap, Pin Guide(s), Shank, Manifold Seal, Bushing Block and Injection Block).
2. Loosen the screws (1) and remove the Centering Hood (2).



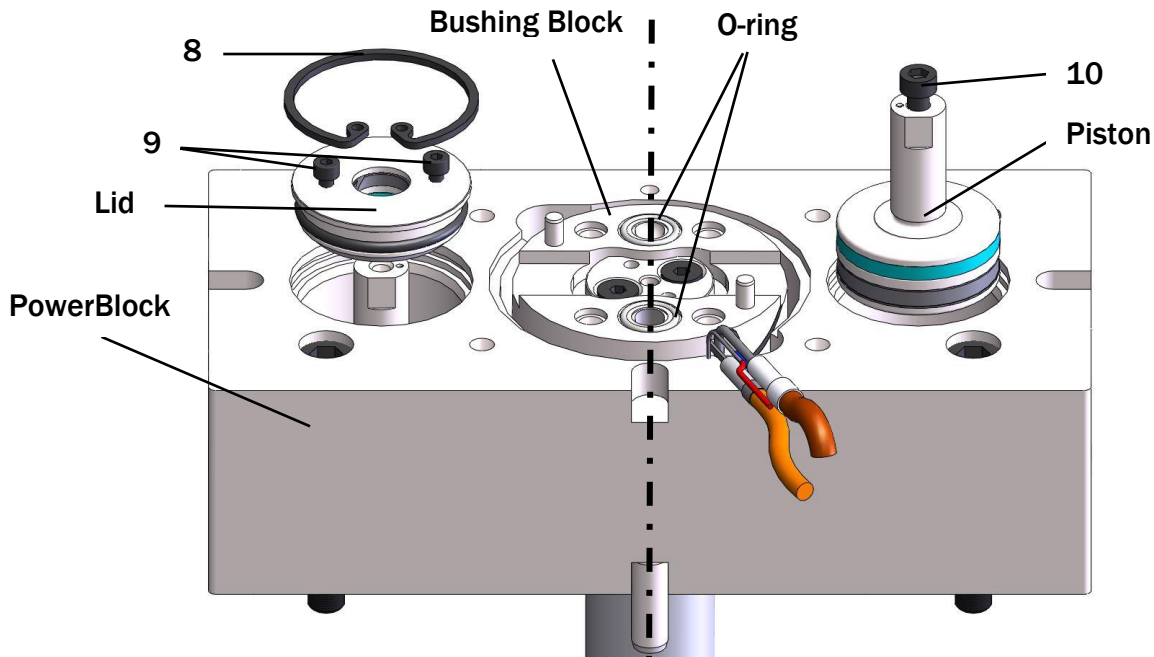
3. Take off the isolation ring (3), loosen the screws (4) and remove the Injection Block (5).



4. Loosen the screws (6) and remove the Pin Lever (7) with valve pin and stop screw in one piece. Be careful not to bend the valve pin.



5. Remove the circlip (8) and put two screws (9) in the lid. Use these screws to pull out the lid from the PowerBlock. Put a screw (10) in the piston and pull the piston out of the PowerBlock.

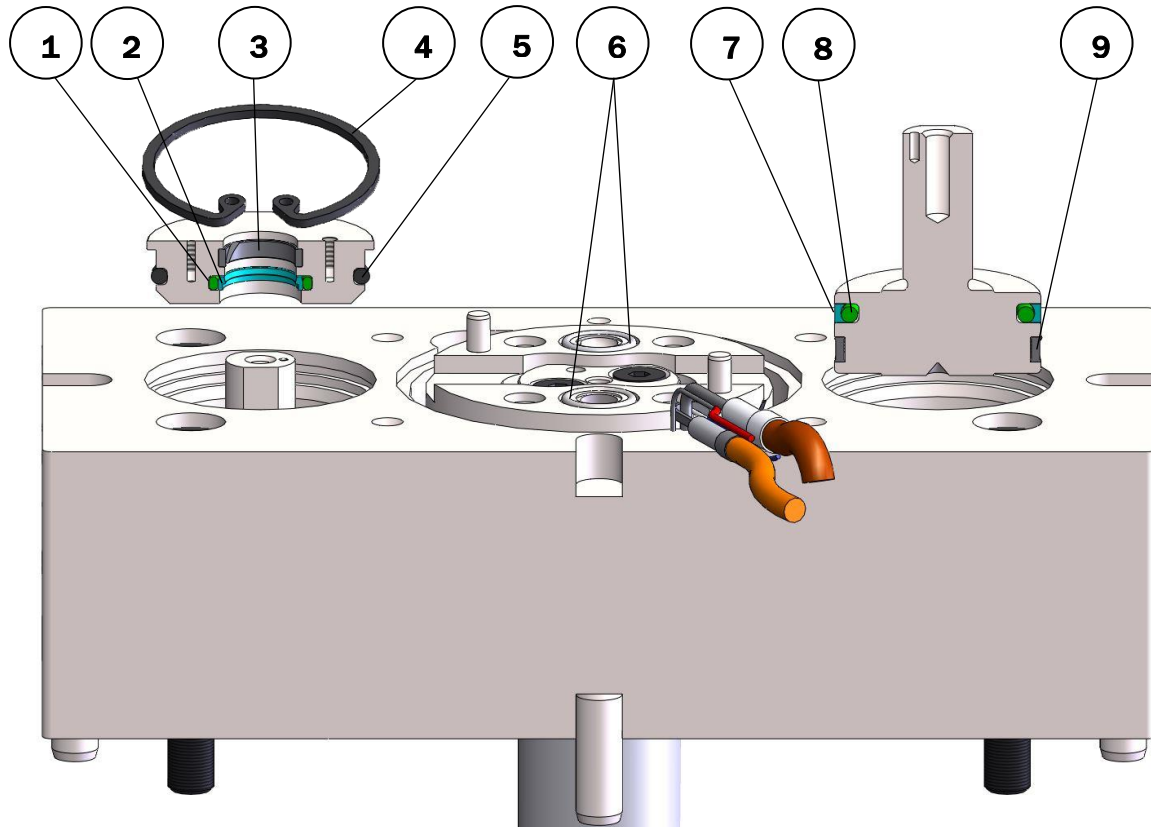


6. Use a pointed tool (preferably non-metallic) to carefully remove all the old seals. Clean the PowerBlock, Bushing Block, Piston and Lid. Very important to clean all the O-ring seats.
7. Replace all seals in their respective place. Recommended to use the MasterFlow seal replace tool (for number 2 – see BOM on the next page).
8. Place the piston in the cylinder house. Press firmly until you feel that the piston is in the right place. Align the lid vertically and press firmly. Secure the lid with the circlip.
9. Reassemble according to above backwards (step 4 – step 2). Please note that correct torque is needed.  
Cylinder stroke and maximum pressure.

- **Step 4-2 – Screws (class 12.9)**
- M6: 17 Nm
  - M8: 40 Nm
  - M10: 79 Nm (Series 50)

Series	Max cylinder pressure (bar) Pneumatic	Max cylinder pressure (bar) Hydraulic	Cylinder stroke (mm)
30	15	15	8,5
40	15	15	11
50	15	15	14

10. 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, pin and the mould.**



### INCLUDED IN DELIVERY

9	1	2	PISTON GUIDE BAND
8	1	2	PISTON SEAL O-RING VITON
7	1	2	PISTON SEAL
6	-	1 or 2 <sup>2</sup>	MP O-RING (Steel)
5	1	2	PISTON LID SEAL VITON
4	-	2	CIRCLIP
3	1	2	PISTON ROD GUIDE BAND
2	1	2	PISTON ROD SEAL
1	1	2	PISTON ROD SEAL O-RING VITON
Item	QTY. <sup>1</sup>	QTY IN TOTAL / SMP	Description

1. Quantity per seal kit (1 cylinder).

2. 1 for Single Valve Gate with Single flow, and 2 for Dual flow.

#### MasterFlow AB

Hultmansgatan 1  
Box 501, SE-593 25 Västervik  
Sweden

Telefon/ Telephone  
Nat. 0490-822 60  
Int. +46-490-822 60

E-post/ E-mail  
info@masterflow.se  
Hemsida/ Website  
www.masterflow.se

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