

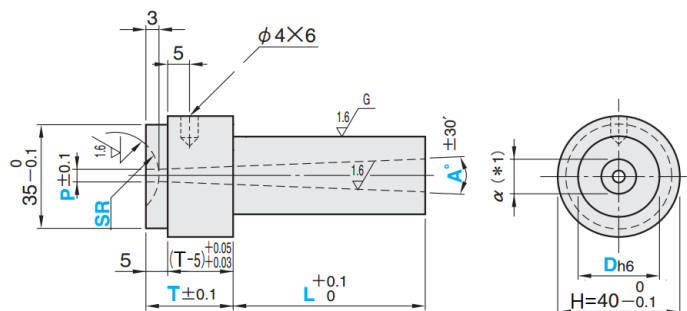
## Sprue Bushings-B Type

### 澆口套 - B 型

#### Straight type



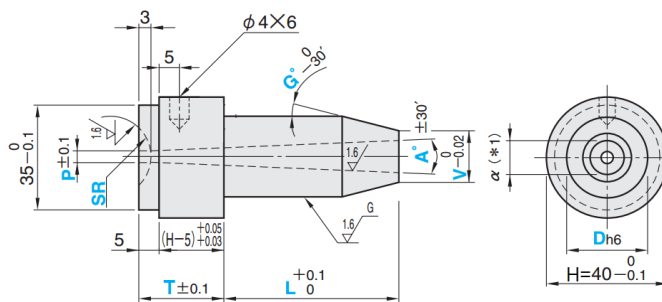
Type		M	H
Normal 一般型	String eliminator type 防拉絲型		
SJBC	SJBCH	S45C	-
SJBD	SJBDH	SKD61	48-52HRC



#### Tapered Type



Type		M	H
Normal 一般型	String eliminator type 防拉絲型		
SJTC	SJTCH	S45C	-
SJTD	SJTDH	SKD61	48-52HRC



Dh6		Type	D	T	L 0.1mm increments s	SR	P	A°		
								0.5° increments	V 0.1mm increments	G° 1° increments
10	0 -0.009	Straight type SJBC SJBD SJBCH SJBDH	10	25	0~120.0	0 10.5 11 12 13 16 20 21	2 2.5 3 3.5 4 4.5 5	1~4	D>V≥α+2  Available for tapered type only	1~10  Available for tapered type only
12	0 -0.011			25						
13			25							
16	25									
20	0 -0.013	Tapered Type SJTC SJTD SJTCH SJTDH	16	25	0~200.0	20 21	4 4.5 5	1~4	D>V≥α+2  Available for tapered type only	1~10  Available for tapered type only
				20						
			20	25						
			20	30						

(\*1) The value of α is set in accordance with L dimension.

(\*2) L dimension is restricted by P, V and A.

(\*3) L dimension limits

P	2	2.5	3	3.5~4.5
A	1	1.5~4.0	1	1.5~4.0
L dimension limits	50	85	50	85

(\*4) Working limits

•Straight type

$$D - \alpha \geq 2 \quad (\text{Calculation of } \alpha \text{ value}) \alpha = P + 2\{L + (U) + H - 3\} \tan A / 2$$

•Tapered type

$$V - \alpha \geq 2$$

$$L - l \geq 3 \quad (\text{Calculation of } l \text{ value}) l = (D - V) / 2 \tan(G - 0.25)$$

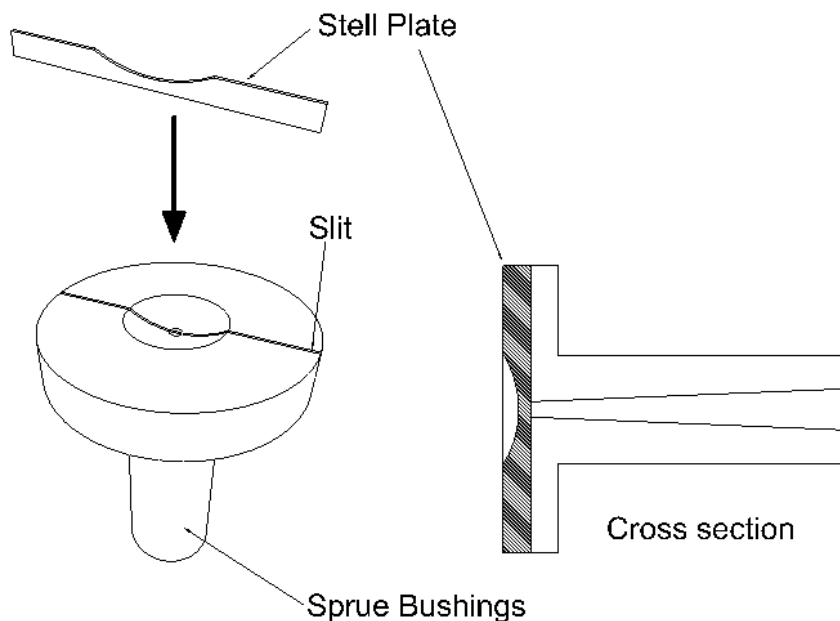
 **Order:** Type - D - T - L - SR - P - A - V - G - KC,WKC...etc

**Example:** SJBD - D13 - T30 - L125 - SR16 - P3 2

SJTD - D16 - T30 - L135 - SR20 - P2.5 3 - V14 - G2

**Features of sprue bushings with string eliminator type :**

防拉絲型說明



**Alterations 追加加工:**

Alterations	Code	Spec.
	<b>KC</b>	<p>Adds a key flat on the head</p>
	<b>WKC</b>	<p>Adds two parallel flats on the head</p>
	<b>ZC</b>	<p>Undercut machining S, T, U = 0.1mm increments  <math>S \geq \alpha + 2</math>  <math>\alpha + 2 \leq T \leq D / (V - 2U \tan \alpha)</math>  <math>1.5 \leq U \leq 5</math>                      Specification Lmax. <math>\geq L + U</math>                      Designation method ZC-S3.5-T4.0-U2.0</p>

Alterations	Code	Spec.		
	<b>GKC</b>	<p>Changes the G tolerance  <math>G_{-30}^0 \rightarrow G_{-15}^0</math>                      Available for tapered type when <math>\ell \leq 15</math> and <math>(L - \ell) \geq 10</math>                      Combination with ZC not available</p>		
	<b>LKC</b>	<p>Changes L dimension tolerance  <math>L_{+0.1}^0 \rightarrow L_{-0.02}^0</math>                      L dimension: 0.01mm increments when LKC is used                      Combination with ZC not available</p>		
	<b>RC</b>	<p>The step radius R is processed in the tip bore to prevent the connection between the sprue and the runner from breaking when releasing from the mold.</p> <p>Dimension selection of step radius R</p> <table border="1"> <tr> <td>1</td> <td>2</td> </tr> </table> <p>Available for <math>\alpha \geq 5</math>                      Straight type <math>D - \alpha - (2 \times RC) &gt; 2</math>                      Tapered type <math>V - \alpha - (2 \times RC) &gt; 2</math>                      Combination with shapes A, B, C not available                      Combination with ZC not available</p> <p>The step radius R is cut with an inner R cutter.                      Surface roughness and position precision are not provided.</p>	1	2
1	2			