

## Precision LV375



With a shot capacity of 2,000 grams Ps, the precision LV375 is available with 4 tip styles and 16 lengths, making it ideally suited for most small-to-medium applications.

### Maximum Shot Weight (Grams)

Sprue Gate	Gating on runners
Pp, Ps	2000
LDPe, PVC-p, SAN	1500
ABS, HDPe, Pa	1000
PET, POM	750
PBT, Pc, PMMA, PPO	500

Gate Insert (Ring)	Gating on parts with Witness Ring
Pp, Ps	2000
LDPe, PVC-p, SAN	1500
ABS, HDPe, Pa	1000
PET, POM	750
PBT, Pc, PMMA, PPO	500

Collar Gate	Gating on parts without Witness Ring
Pp, Ps	2000
LDPe, PVC-p, SAN	1500
ABS, HDPe, Pa	1000
PET, POM	750
PBT, Pc, PMMA, PPO	500

**Note:** Maximum shot weights may be reduced, depending on polymer grade & component dimensions.

**Please note that this updated document contains information on the new Plus tips only.**

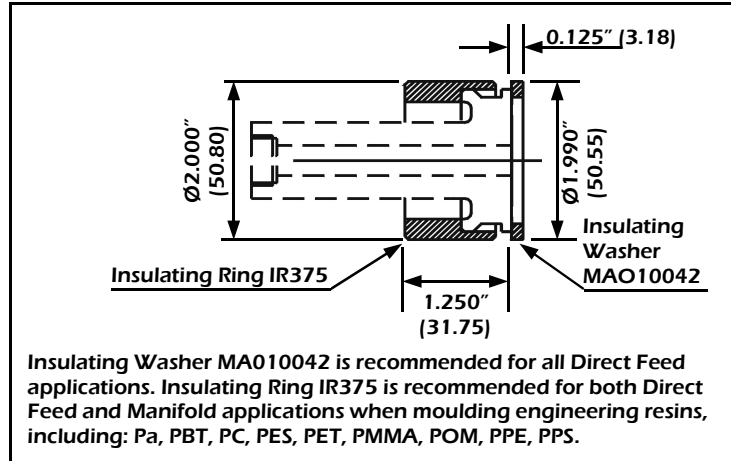
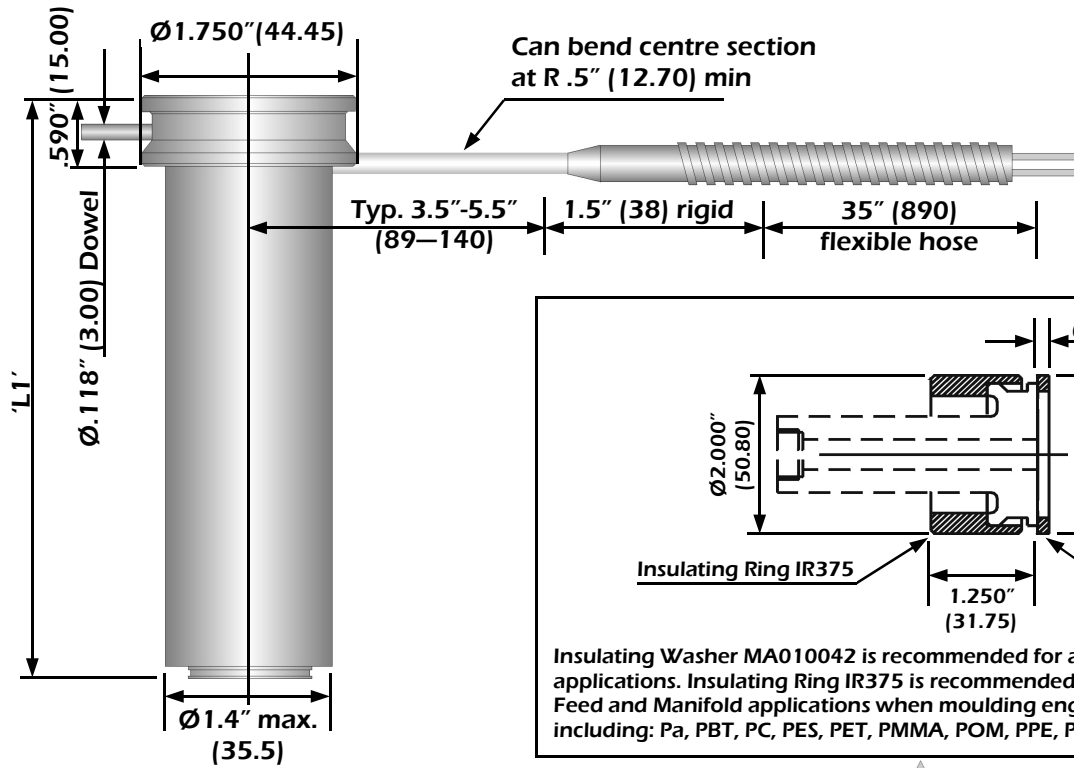
**Information on the now obsolete standard range of tips is available from our technical department or can be downloaded for our website.**

# Precision LV Series Technical Specifications

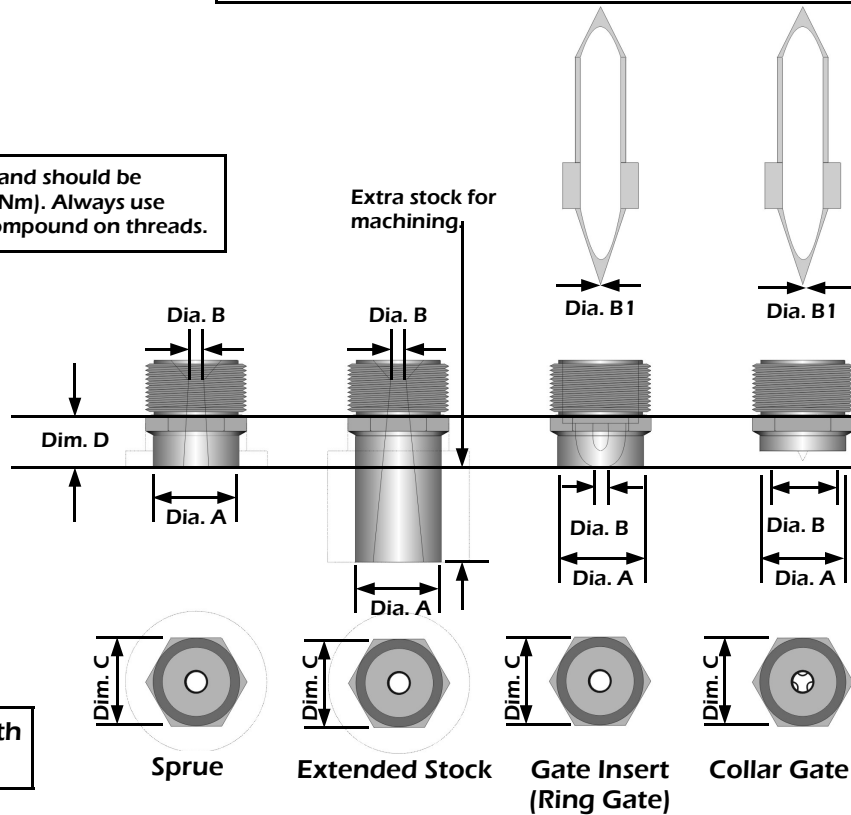
PRECISION LV BUSHINGS

## Precision LV375

Body Dimensions—Excluding Tip  
Dimensions in Inches (mm)



Tips have 5/8" -20NS threads, and should be torqued down to 35 ft.lbs (48 Nm). Always use high temperature anti-seize compound on threads.



Overall Bush Length  
 $L' = L1 + D$

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# Precision LV Series Technical Specifications

## Precision LV375—Ordering Chart

Body & Heater Part Numbers	Body Assembly	Len. 'L1'	Spare Heater	Watts
	PLV375-02125	2.125" (53.98)	LPH25035F	460
	PLV375-02625	2.625" (66.68)	LPH25050F	460
	PLV375-03125	3.125" (79.38)	LPH25065G	610
	PLV375-03625	3.625" (92.08)	LPH25080G	610
	PLV375-04125	4.125" (104.78)	LPH25090G	610
	PLV375-04625	4.625" (117.48)	LPH25105H	690
	PLV375-05625	5.625" (142.88)	LPH25130H	690
	PLV375-06625	6.625" (168.28)	LPH25155H	690
	PLV375-07625	7.625" (193.68)	LPH25180K	750
	PLV375-08625	8.625" (219.08)	LPH25205K	750
	PLV375-09625	9.625" (244.48)	LPH25230L	1000
	PLV375-10625	10.625" (269.88)	LPH25255L	1000
	PLV375-11625	11.625" (295.28)	LPH25280L	1000
	PLV375-12625	12.625" (320.68)	LPH25305L	1000
PLV375-13625	13.625" (346.08)	LPH25330L	1000	
PLV375-14625	14.625" (371.48)	LPH25355L	1000	

Optional  
Insulating Ring IR375  
Insulating washer MA010042

LV375+ Tip Part Numbers	Gate Style	Tip Alloy	Part Number	Dia. 'A'	Dia. 'B' / 'B1'	Dim. 'C'	Dim. 'D'
	Sprue	Std / Wear Resist	TP370110/111	.500" (12.70)	.125" (3.18)	.750" (19.05)	.500" (12.7)
		Extended	TP370210/211	.500" (12.70)	.125" (3.18)	.750" (19.05)	1.000" (25.4)
	Gate Insert (Ring Gate)	Std / Wear Resist	TP370410/413	.500" (12.70)	.065" (1.65)	.750" (19.05)	.500" (12.7)
		Std / Wear Resist	TP370411/414	.500" (12.70)	.080" (2.03)	.750" (19.05)	.500" (12.7)
		Std / Wear Resist	TP370412/415	.500" (12.70)	.100" (2.54)	.750" (19.05)	.500" (12.7)
	Collar Gate	Std / Wear Resist	TP370416/419	.500" (12.70)	.065" (1.65)	.750" (19.05)	.500" (12.7)
		Std / Wear Resist	TP370417/420	.500" (12.70)	.080" (2.03)	.750" (19.05)	.500" (12.7)
		Std / Wear Resist	TP370418/421	.500" (12.70)	.100" (2.54)	.750" (19.05)	.500" (12.7)

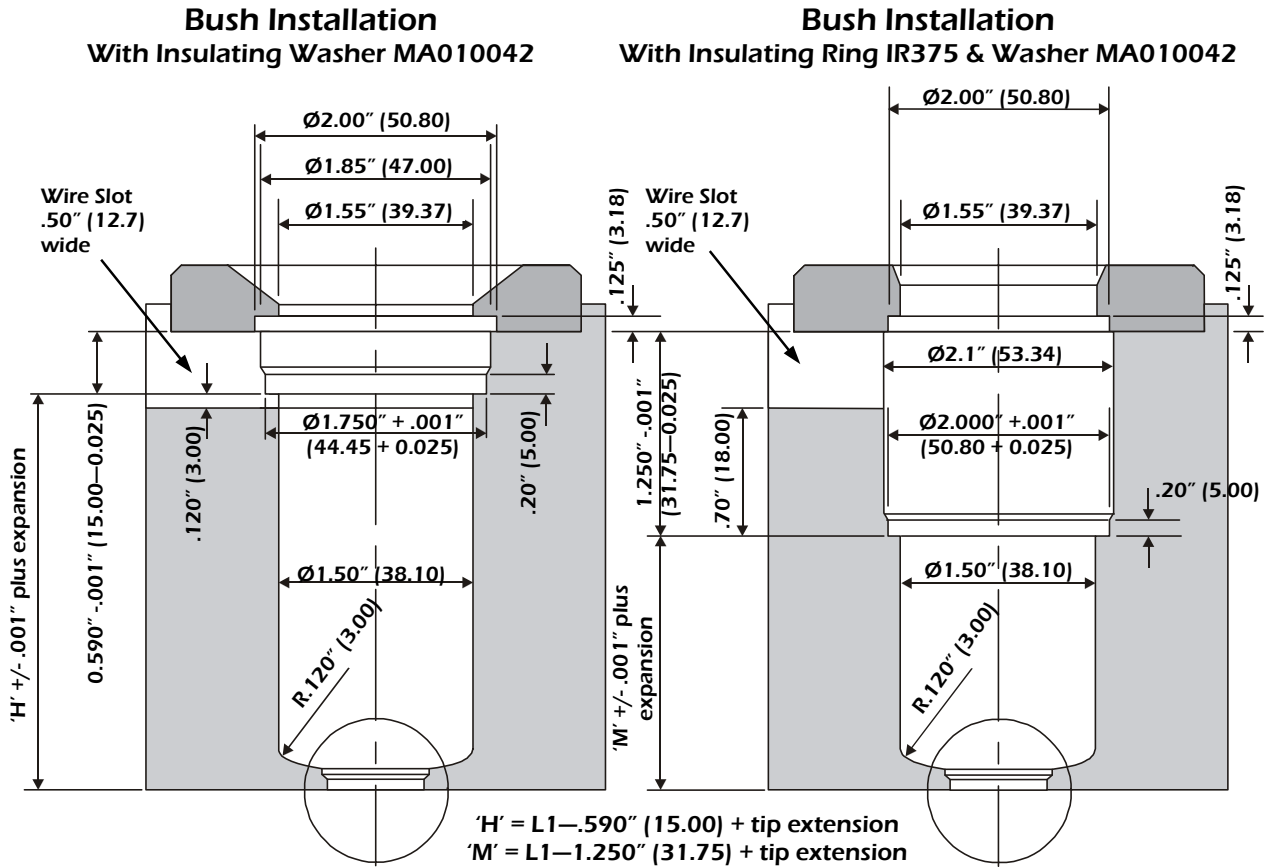
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# Precision LV Series Technical Specifications

DIRECT FEED APPLICATIONS

## Precision LV375

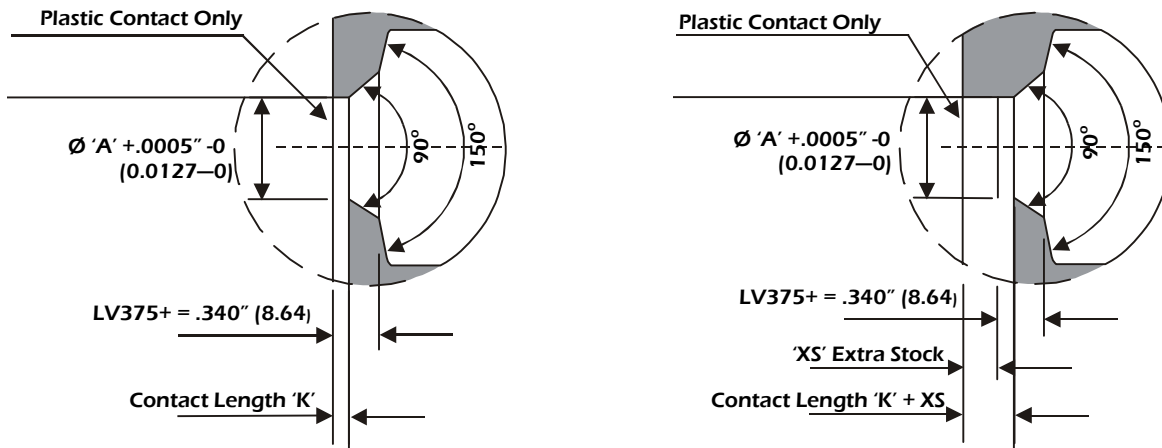
## Bore & Gate Dimensions (Inches)



The thermal expansion of the bush relative to the mould is calculated by the formula:  
 'H' x 0.0000126 x (melt temp. °C - mould temp. °C), where height 'H' = L1 - 0.590" (15.00) + tip extension.

## Standard Sprue & Gate Insert (Ring)

## Extended Sprue

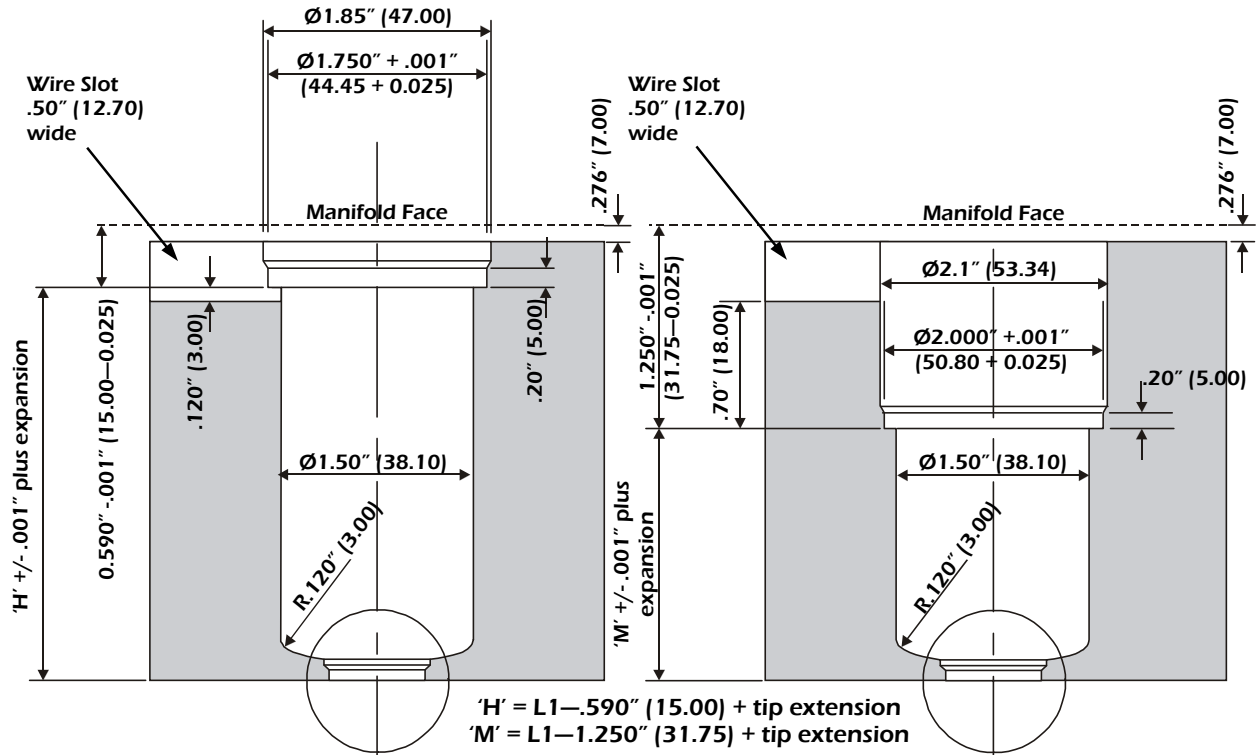


For Standard, Gate Insert (Ring) & Extended Sprue Gates  
 'K' = .060" - .100" (1.5-2.5) for Crystalline resins  
 'K' = .080" - .160" (2.0-4.0) for Amorphous resins  
 Increase 'K' as 'A' increases

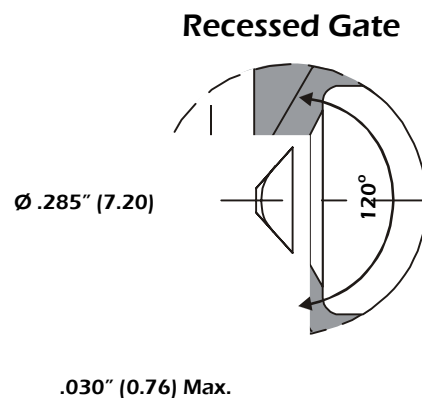
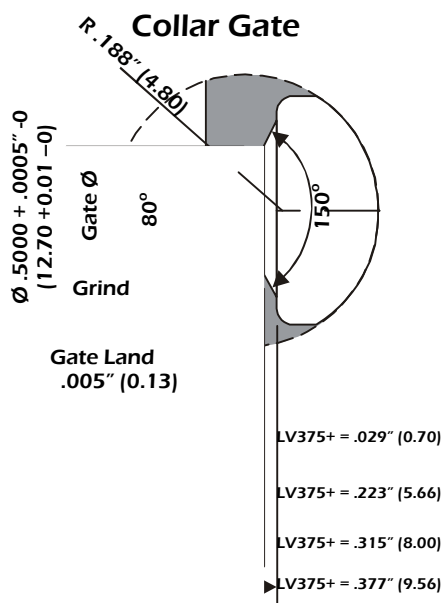
## Precision LV375

### Standard Bush Installation

### Bush Installation With Insulating Ring IR375



The thermal expansion of the bush relative to the mould is calculated by the formula:  
 'H' x 0.0000126 x (melt temp. °C - mould temp. °C), where height 'H' = L1 - 0.590" (15.00) + tip extension.



# Precision LV Series Technical Specifications

PRECISION LV BUSHINGS

## Precision LV375—Engineering Charts

375+ Series Resin Compatibility	Gating Options		Tip Alloy	Commodity Resin	Engineering Resin	Glass-Filled Resin
	Sprue	Standard	●	●		
		Wear Resist	●	●	●	
	Extended Sprue	Standard	●	●		
		Wear Resist	●	●	●	
	Gate Insert (Ring Gate)	Standard	●	●		
		Wear Resist	●	●	●	
	Collar Gate	Standard	●	●		
		Wear Resist	●	●	●	

● = Recommended      ○ = Possible

375+ Series Gate Diameters	Tip Type	Low Viscosity	Medium Viscosity	High Viscosity
	Sprue			
	All	.125" - .250" (3.2—6.4 mm)	.125" - .250" (3.2—6.4 mm)	.125" - .250" (3.2—6.4 mm)
	Spreader Needle			
	Gate Insert .065" Flat	.085" - .105" (2.2—2.7)	.105" - .127" (2.7—3.2)	.127" - .160" (3.2—4.0)
	Collar Gate .065" Flat	.085" - .105" (2.2—2.7)	.105" - .127" (2.7—3.2)	.127" - .160" (3.2—4.0)
	Gate Insert .080" Flat	.100" - .120" (2.5—3.0)	.120" - .140" (3.0—3.6)	.140" - .174" (3.6—4.4)
	Collar Gate .080" Flat	.100" - .120" (2.5—3.0)	.120" - .140" (3.0—3.6)	.140" - .174" (3.6—4.4)
	Gate Insert .100" Flat	.120" - .140" (3.0—3.6)	.140" - .160" (3.6—4.0)	.160" - .194" (4.0—4.9)
	Collar Gate .100" Flat	.120" - .140" (3.0—3.6)	.140" - .160" (3.6—4.0)	.160" - .194" (4.0—4.9)

Tips are supplied with the smallest gate diameter—customer to re-machine if necessary for larger shot weights.

High viscosity = melt flow 0.5—6

Medium viscosity = melt flow 7—16

Low viscosity = melt flow > 16

Shot Weights	Resin Type	Shot Weight (grams)
	Pp, Ps	2000
	LDPe, PVC-p, SAN	1500
	ABS, HDPe, Pa	1000
	PET, POM	750
	PBT, Pc, PMMA, PPO	500

These values are for reference purposes only. The values can be affected by the resin melt flow, part dimensions & wall thickness, mould & melt temperatures and the moulding conditions used.

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