



With a shot capacity of 4000 grams Ps, the precision LV625 is available with 4 tip styles and 10 standard lengths, making it ideally suited for most large moulding applications.

## Precision LV625

PRECISION LV BUSHINGS

### Maximum Shot Weight (Grams)

Sprue Gate	Gating on runners
Pp, Ps	4000
LDPe, PVC-p, SAN	3000
ABS, HDPe, Pa	2000
PET, POM	1500
PBT, Pc, PMMA, PPO	1000

Ring Gate	Gating on parts with Witness Ring
Pp, Ps	4000
LDPe, PVC-p, SAN	3000
ABS, HDPe, Pa	2000
PET, POM	1500
PBT, Pc, PMMA, PPO	1000

Collar Gate	Gating on parts without Witness Ring
Pp, Ps	4000
LDPe, PVC-p, SAN	3000
ABS, HDPe, Pa	2000
PET, POM	1500
PBT, Pc, PMMA, PPO	1000

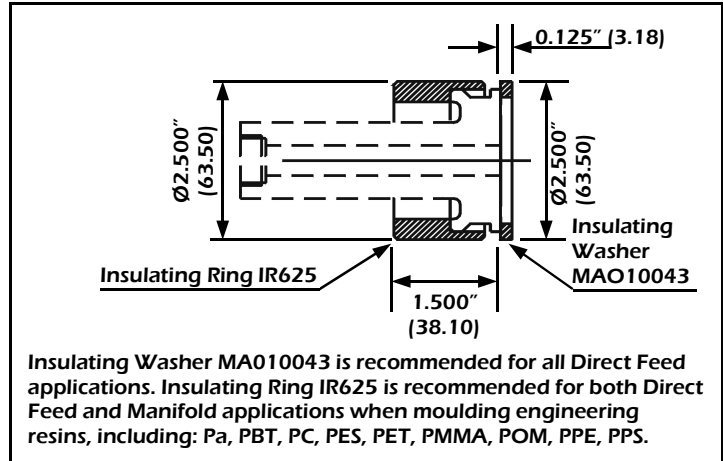
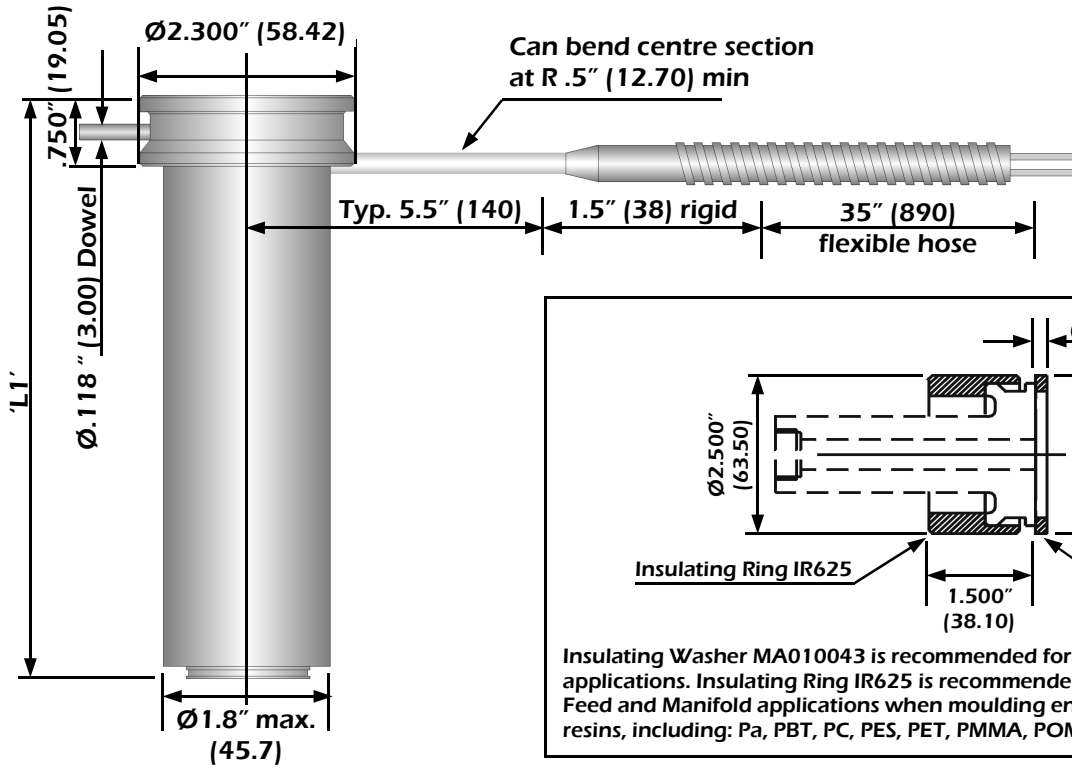
**Note:** Maximum shot weights may be reduced, depending on polymer grade & component dimensions.

# Precision LV Series Technical Specifications

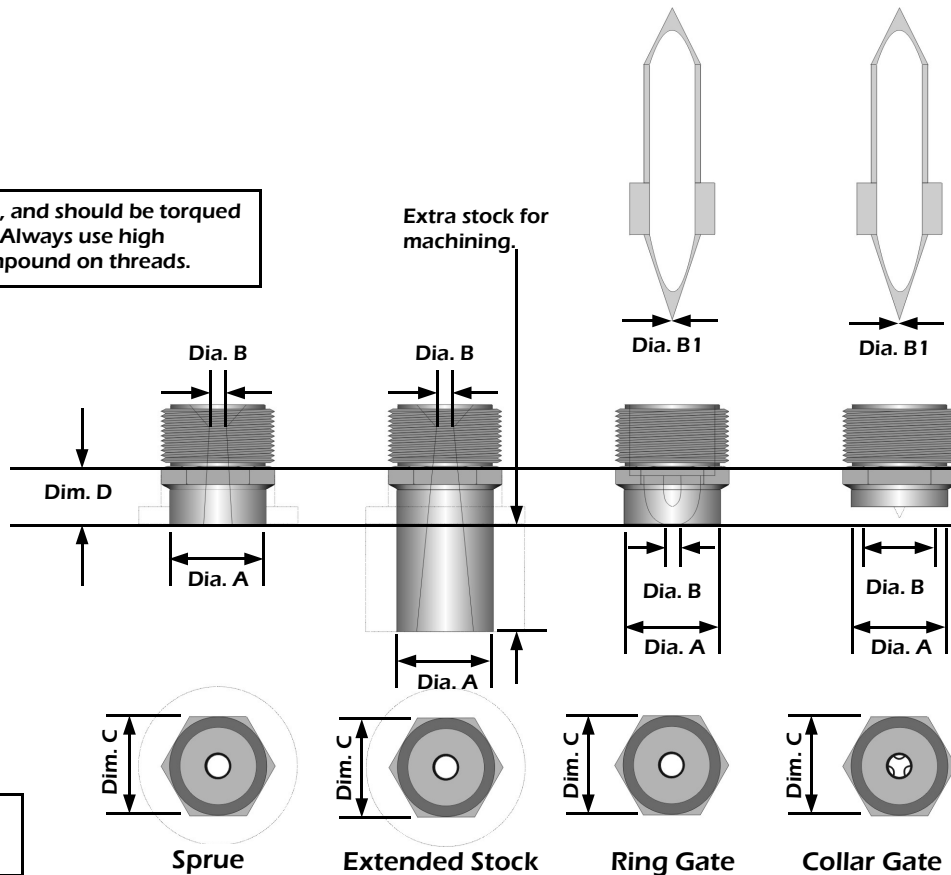
PRECISION LV BUSHINGS

## Precision LV625

Body Dimensions—Excluding Tip  
Dimensions in Inches (mm)



Tips have 1" -16NS threads, and should be torqued down to 40 ft.lbs (54 Nm). Always use high temperature anti-seize compound on threads.



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Overall Bush Length  
 $L' = L1 + D$

# Precision LV Series Technical Specifications

## Precision LV625—Ordering Chart

Body & Heater Part Numbers	Body Assembly	Len. 'L1'	Spare Heater	Watts
	PLV625-03000	3.000" (76.20)	LPH35060K	750
	PLV625-04000	4.000" (101.60)	LPH35085K	750
	PLV625-05000	5.000" (127.00)	LPH35110K	750
	PLV625-06000	6.000" (152.40)	LPH35135K	750
	PLV625-07000	7.000" (177.8)	LPH35160L	1000
	PLV625-08000	8.000" (203.20)	LPH35185L	1000
	PLV625-09000	9.000" (228.60)	LPH35210L	1000
	PLV625-10000	10.000" (254.00)	LPH35235L	1000
	PLV625-11000	11.000" (279.40)	LPH35260L	1000
	PLV625-12000	12.000" (304.80)	LPH35285L	1000

Optional  
Insulating Ring      IR625  
Insulating washer    MA010043

Tip Part Numbers	Gate Style	Tip Alloy	Part Number	Dia. 'A'	Dia. 'B'	Dim. 'C'	Dim. 'D'
	Sprue	Standard	TP620100	1.000" (25.40)	.187" (4.75)	1.500" (38.10)	.500" (12.70)
		Extended	Standard	TP620200	1.000" (25.40)	.187" (4.75)	1.500" (38.10)
	Ring Gate	Standard	TP620300	1.000" (25.40)	.125" (3.18)	1.250" (31.75)	.500" (12.70)
	Collar Gate	Standard	TP620400	.800" (20.32)	.625" (15.88)	1.125" (28.58)	.710" (18.03)

LV625 Plus: Tip Part Numbers	Gate Style	Tip Alloy	Part Number	Dia. 'A'	Dia. 'B'	Dim. 'C'	Dim. 'D'
	Sprue	Standard	TP610110	.875" (22.22)	.187" (4.75)	1.125" (28.58)	.750" (19.05)
		Wear Resist	TP620111	.875" (22.22)	.187" (4.75)	1.125" (28.58)	.750" (19.05)
	Extended	Standard	TP620210	.875" (22.22)	.187" (4.75)	1.125" (28.58)	1.500" (38.10)
Wear Resist		TP620211	.875" (22.22)	.187" (4.75)	1.125" (28.58)	1.500" (38.10)	

LV625 Plus: Tip Part Numbers	Gate Style	Tip Alloy	Part Number	Dia. 'A'	Dia. 'B'	Dim. 'C'	Dim. 'D'
	Ring Gate	Standard	TP620410	.875" (22.22)	.100" (2.54)	1.125" (28.58)	.750" (19.05)
		Standard	TP620411	.875" (22.22)	.125" (3.18)	1.125" (28.58)	.750" (19.05)
		Standard	TP620412	.875" (22.22)	.150" (3.81)	1.125" (28.58)	.750" (19.05)
		Wear Resist	TP620413	.875" (22.22)	.100" (2.54)	1.125" (28.58)	.750" (19.05)
		Wear Resist	TP620414	.875" (22.22)	.125" (3.18)	1.125" (28.58)	.750" (19.05)
		Wear Resist	TP620415	.875" (22.22)	.150" (3.81)	1.125" (28.58)	.750" (19.05)
	Collar Gate	Standard	TP620416	.875" (22.22)	.100" (2.54)	1.125" (28.58)	.750" (19.05)
		Standard	TP620417	.875" (22.22)	.125" (3.18)	1.125" (28.58)	.750" (19.05)
		Standard	TP620418	.875" (22.22)	.150" (3.81)	1.125" (28.58)	.750" (19.05)
		Wear Resist	TP620419	.875" (22.22)	.100" (2.54)	1.125" (28.58)	.750" (19.05)
		Wear Resist	TP620420	.875" (22.22)	.125" (3.18)	1.125" (28.58)	.750" (19.05)
		Wear Resist	TP620421	.875" (22.22)	.150" (3.81)	1.125" (28.58)	.750" (19.05)





# Precision LV Series Technical Specifications

PRECISION LV BUSHINGS

## Precision LV 625—Engineering Charts

625 & 625+ Series Resin Compatibility	Gating Options		Tip Alloy	Commodity Resin	Engineering Resin	Glass-Filled Resin	
	625 Series						
	Sprue		Standard	●	●	○	
	Extended Sprue		Standard	●	●	○	
	Ring Gate		Standard	●	●	○	
	Collar Gate		Standard	●	●	○	
	625+ Series						
	Sprue		Standard	●	●		
			Wear Resist	●	●	●	
	Extended Sprue		Standard	●	●		
		Wear Resist	●	●	●		
Ring Gate		Standard	●	●			
		Wear Resist	●	●	●		
Collar Gate		Standard	●	●			
		Wear Resist	●	●	●		

● = Recommended      ○ = Possible

625 & 625+ Series Gate Diameters	Tip Type	Low Viscosity	Medium Viscosity	High Viscosity	
	Sprue				
	All	.187" - .312" (4.7–7.9 mm)	.187" - .312" (4.7–7.9 mm)	.187" - .312" (4.7–7.9 mm)	
	Spreader Needle				
	Ring Gate .100" Flat	.120" - .140" (3.0–3.6)	.140" - .162" (3.6–4.1)	.162" - .194" (4.1–4.9)	
	Collar Gate .100" Flat	.120" - .140" (3.0–3.6)	.140" - .162" (3.6–4.1)	.162" - .194" (4.1–4.9)	
	Ring Gate .125" Flat	.145" - .165" (3.7–4.2)	.165" - .187" (4.2–4.7)	.187" - .219" (4.7–5.6)	
	Collar Gate .125" Flat	.145" - .165" (3.7–4.2)	.165" - .187" (4.2–4.7)	.187" - .219" (4.7–5.6)	
	Ring Gate .150" Flat	.170" - .190" (4.3–4.8)	.190" - .212" (4.8–5.4)	.212" - .244" (5.4–6.2)	
	Collar Gate .150" Flat	.170" - .190" (4.3–4.8)	.190" - .212" (4.8–5.4)	.212" - .244" (5.4–6.2)	

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	4000
	LDPE, PVC-p, SAN	3000
	ABS, HDPE, Pa	2000
	PET, POM	1500
	PBT, Pc, PMMA, PPO	1000

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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