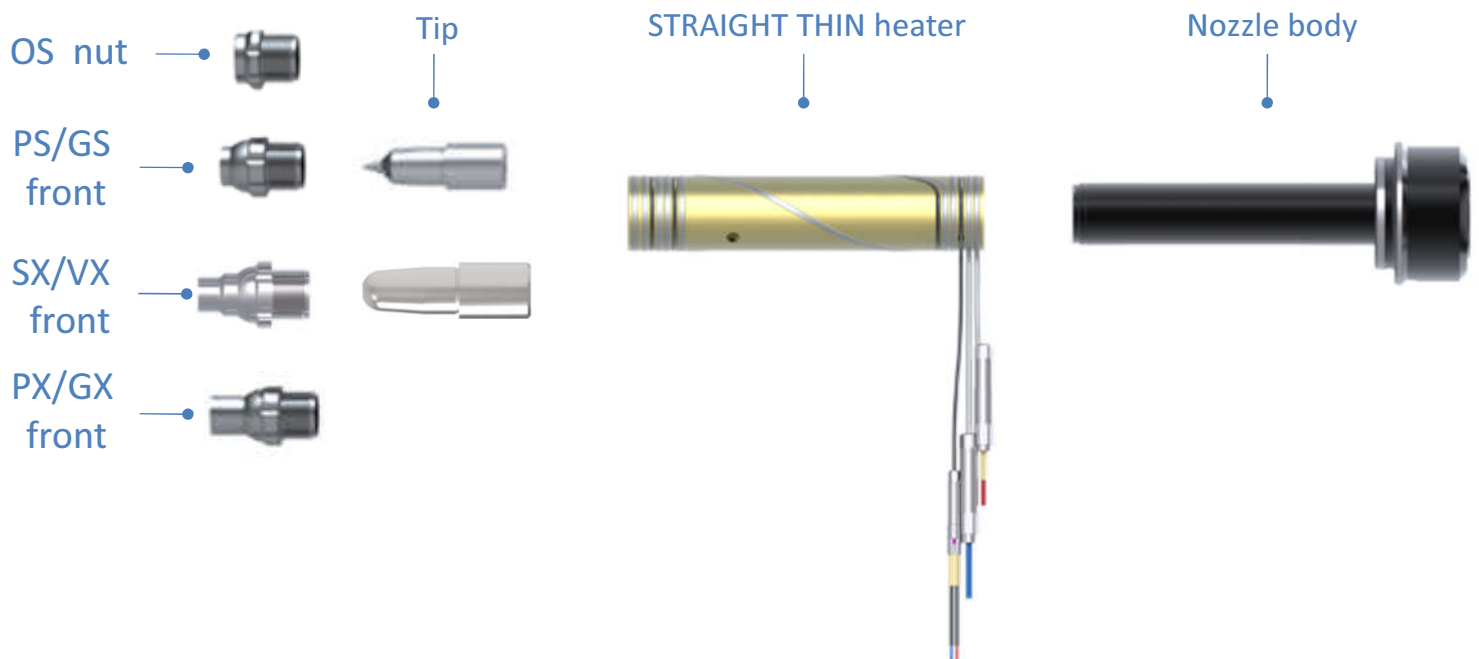


## 一 . Disassembly:

1. Take off the front ;
2. Carefully slide STRAIGHT THIN heater off from nozzle;



## 二 . Assembly:

1. Opposite processing to disassembly.
2. Ensure that the tip is in full contact with the bottom of the bore in nozzle body.

### 3. Front assembly

1). Fix the nozzle body in vise and make sure the inside of body is clean.



2). Clean the front and tip.



3). Apply appropriate Lubricant on the thread.



4). Use the special fixture and torsional spanner to tighten the front.



When disassembly or assembly the front must be use torsional spanner. Torque as table.

Assembly Torque(Nm)		
Size	Front	Manifold nut
Size 04	4	-
Size 05	11	90
Size 07	18	145
Size 10	25	340
Size 17	30	-

Please use our special fixture to assembly:

Size No.	Part No.
Size 04	A305FXFR0813
Size 05	A305FXFR1612
Size 07	A307FXFR1915
Size 10	A310FXFR3122
Size 17	A317FXFR3727

4. Measure the height of nozzle same as project book drawing.

Attention:

For best performance use HEATLOCK original components.

If there are any problems encountered during assembly, please call (86) 757- 2991 5868.