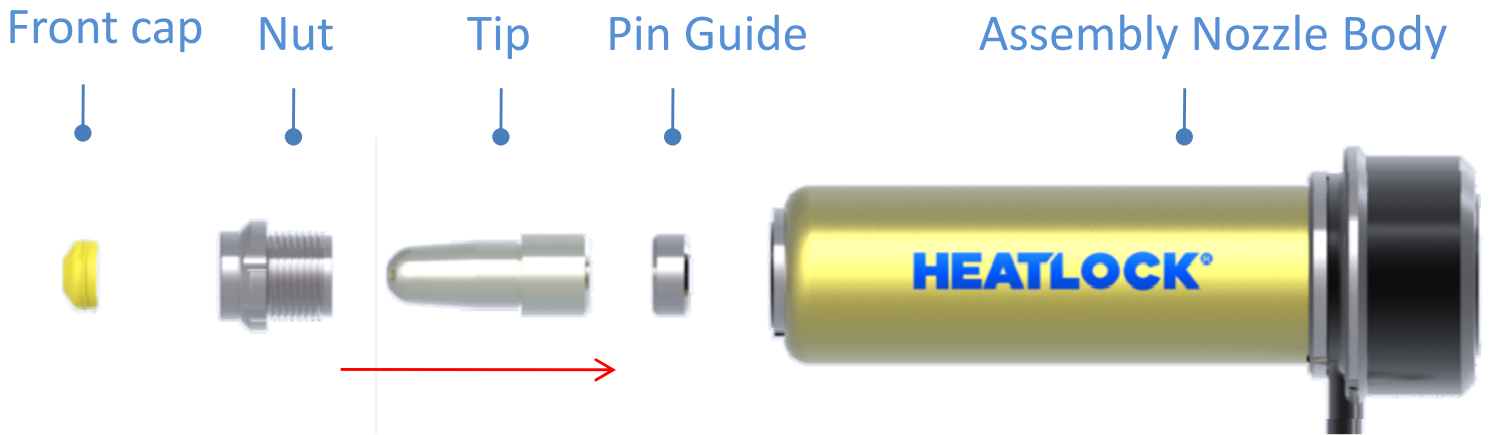


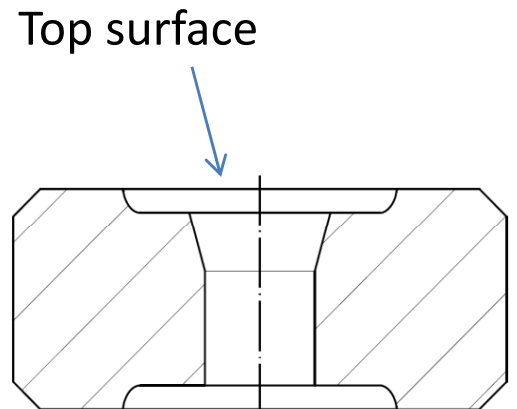
I . Assembly Nozzle



1. Make sure the bore where fix with tip in nozzle body is clean.
2. Assembly the pin guide in to nozzle body.

Note:

The top surface with the lead in angle should be installed facing the sealing surface of the nozzle bore.

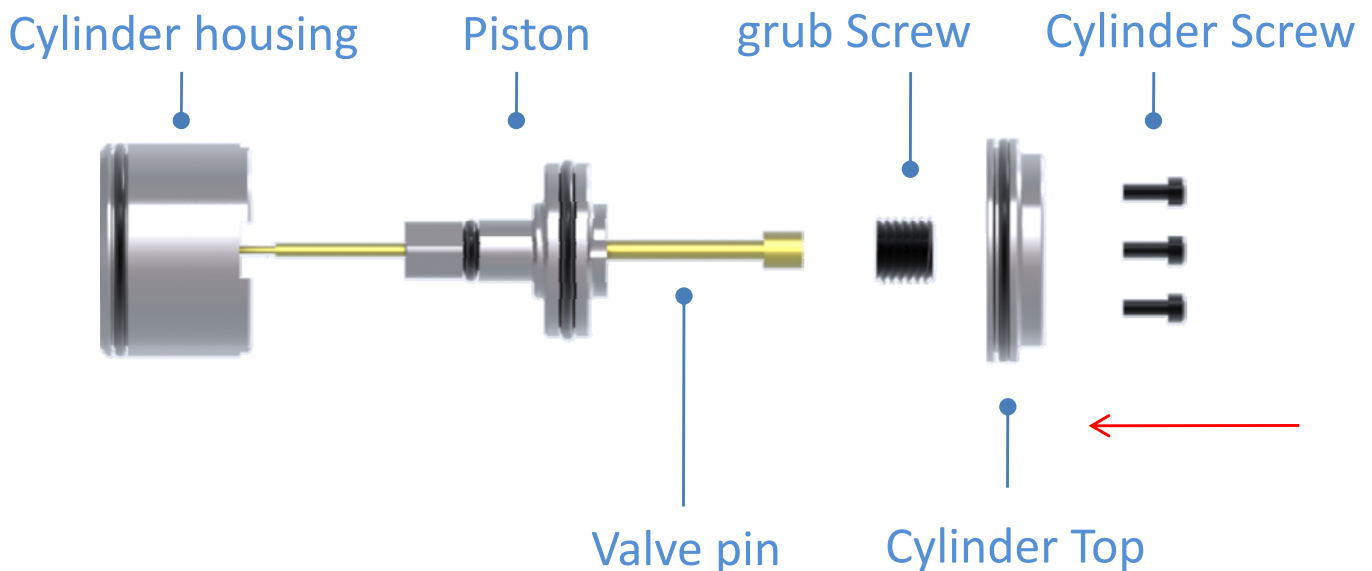


3. Assembly the tip in to nozzle body.
 4. Use nut fixture with torsional spanner to assembly the nut.
- Table for torque.

Nozzle Assembly Torque(Nm)	
Size	Front
Size 05	15
Size 07	20
Size 10	25
Size 17	30

5. Put the front cap into nut.
6. Nozzle assembly is done.
7. Then put the nozzle into mold according to the instruction in your project book.

II . Assembly Valve pin

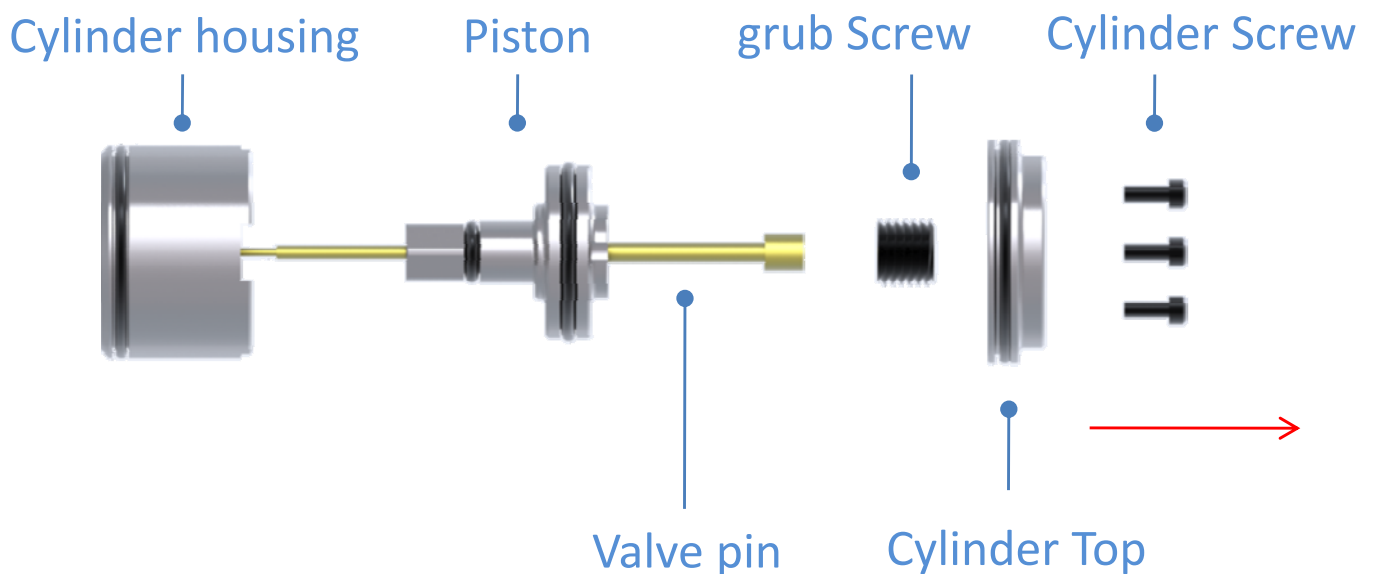


1. Put the valve pin into piston.
2. Use plastic thread seal tape on the grub screw then lock it. Make sure the valve pin is loose after tightened the grub screw.
3. Then assembly the cylinder top.
4. Lock the cylinder screw.

III. Disassembly

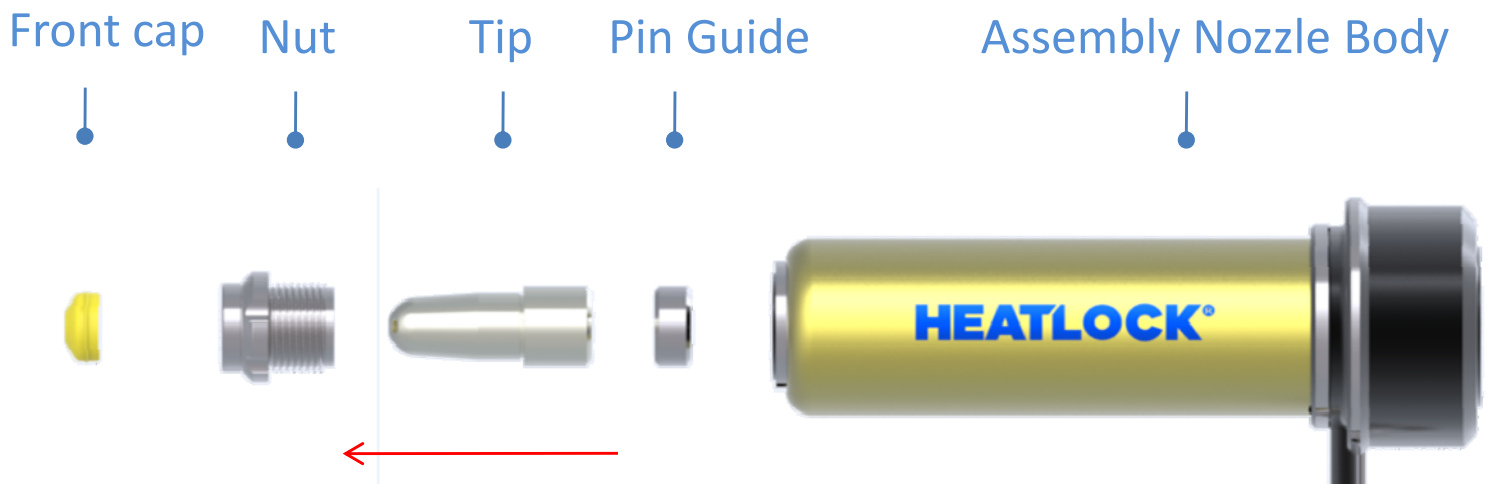
1. Clear up plastics

- 1). Set hot runner system temperature to production, and heat up the hot runner system.
- 2). Clear up the plastics inside nozzle and manifold. That will be easy for us to take out the pin, front and tip from the system.



2. Take out the valve pin from cylinder in clamp plate.

- 1). Remove the cylinder screw in the clamp plate.
- 2). Then take out the cylinder top in the clamp plate, using pull out screw M6.
- 3). Take out the piston from cylinder housing.
- 4). Remove the grub screw from piston.
- 5). Then you can take out the valve pin.
- 6). Throw away the old valve pins, will be use new ones to replace.



3. Take off the front cap, nut and tip from nozzle

1). Fix the nozzle in the vise.

2). Take out the front cap.

3). Use key fixture to loosen nut.

4). Then you can take out the tip from assembly nozzle body.

5). And also can take out the pin guide from assembly nozzle body.