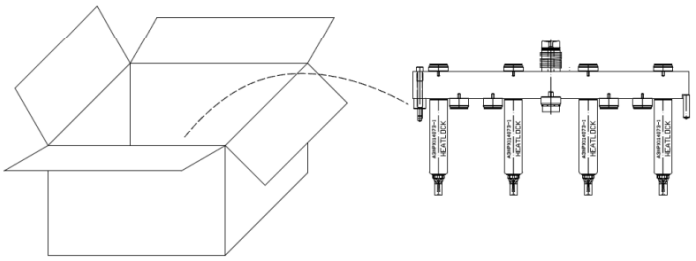
Step 1: Unpack

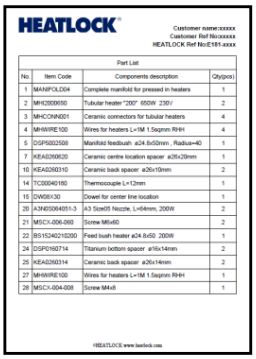
Take out of the system from box with care.



(pic1)

Step 2: Be familiar with all components

Make sure all the components on the list are provided.(refer to pic 2)



HEATLOCK

Customer name:xxxxx
Customer Ref No:xxxxx
HEATLOCK Ref No:E181-xxxx

Part List

No.	Item Code	Components description	Qty(pcs)
1	MANIFOLD04	Complete manifold for pressed in heaters	1
2	MH2000650	Tubular heater "200" 650W 230V	2
3	MHCONN001	Ceramic connectors for tubular heaters	4
4	MHWIRE100	Wires for heaters L=1M 1.5sqmm RHH	4
5	DSPS02506	Manifold feedbush ø24.8x50mm , Radius=40	1
7	KEA0260620	Ceramic centre location spacer ø26x20mm	1
10	KEA0260310	Ceramic back spacer ø26x10mm	2
14	TC00040160	Thermocouple L=12mm	1
15	DWDB1X30	Dowel for center line location	1
20	A3H0S064051-3	A3 Size05 Nozzle, L=64mm, 200W	2
21	MSCX-006-060	Screw M6x60	2
22	BS1524021X200	Feed bush heater ø24.8x50 200W	1
24	DSPS192714	Titanium bottom spacer ø16x14mm	2
25	KEA0260314	Ceramic back spacer ø26x14mm	2
27	MHWIRE100	Wires for heaters L=1M 1.5sqmm RHH	1
28	MSCX-004-008	Screw M4x8	1

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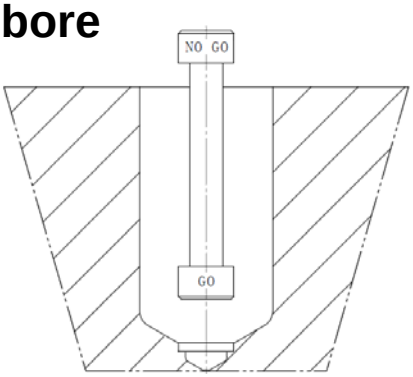
(pic2)

Step 3: Check dimensions

Measure mold plate thickness .Compare the measurements with those dimensions on the GA drawing ,make sure they match requirements on HEATLOCK GA drawing.

Step 4: Check sealing dimension of nozzle bore

Use GO and NO GO gauge to measure the sealing dimension of nozzle bore ,make sure nozzle fit into the bore.(refer to pic 3)



(pic3)

Step 5: Check TB dimension

Use digital micrometer to measure TB dimension, compare with the TB dimension on the drawing, and make a record. (refer to pic 4)

(pic4)

Step 6: Adjust the height of center location spacer

Tip is in gate center at working temperature, check TB in mould (MTB) following assembly drwg and adjust spacer:

1).If MTB larger than TB in drawing ,grind the spacer of MTB-TB in drawing .Thickness control MTB-TB in drawing within the tolerance in 0.01mm;

2).If MTB smaller than TB in drawing ,re-machine the bore depth to reach the same result of tolerance.(refer to pic 5)

(pic5)

(pic6)

Step 7: Adjust the height of manifold support

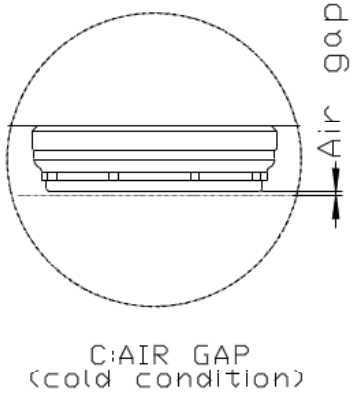
Adjust the height of manifold support to make sure with the height of center location spacer in -0.01mm.(refer to pic 6)

Step 8: Install the system

Put the system into the mold .

Step 9: Adjust air gap

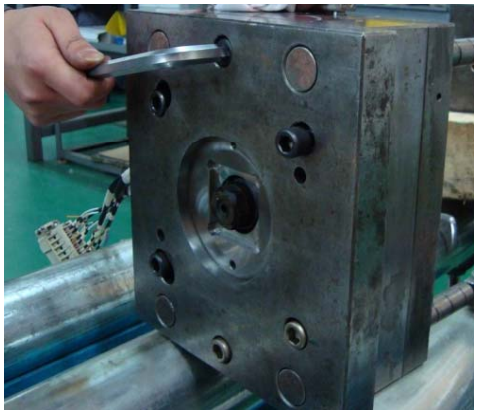
Measure the height from manifold to mold plate, adjust the height of back support to keep the air gap same as the gap on the drawing.(refer to pic 7)



(pic7)

Step 10: Tighten the claim plate screws

(refer to pic 8)



(pic8)

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