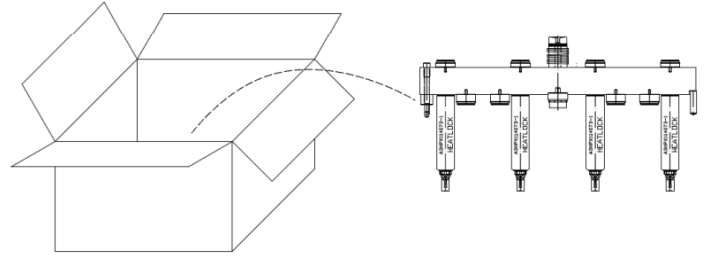


Step 1: Unpack

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:xxxxxx Customer Ref No:xxxxxx HEATLOCK Ref No:HE181-xxxx			
Part List			
No.	Item Code	Components description	Qty/Prs
1	MANFOLD04	Complete manifold for pressed in heaters	1
2	MH200000	Tubular heater 200° 500W 230V	2
3	MHC00001	Ceramic connectors for tubular heaters	4
4	MHWRE100	Wires for heaters L=1M 1 Segment RH#1	4
5	DISP02000	Manifold heater 4x4 300mm 180mm#1	1
7	HEAD00001	Ceramic centre location spacer 40x120mm	1
10	HEAD00010	Ceramic back spacer 40x10mm	2
14	T00040100	Thermocouple L=13mm	1
15	DW00130	Socket for center line location	1
20	A3M000401-3	A3 Spray Nozzle L=60mm 200W	2
21	MESH-006-010	Screen Mesh	2
22	BT104020000	Feed back heater 4x4 8-10 200W	1
24	DISP0100714	Titanium bottom spacer 40x14mm	2
25	HEAD00014	Ceramic back spacer 40x14mm	2
27	MHWRE100	Wires for heaters L=1M 1 Segment RH#1	1
28	MESH-104-038	Screen Mesh	1

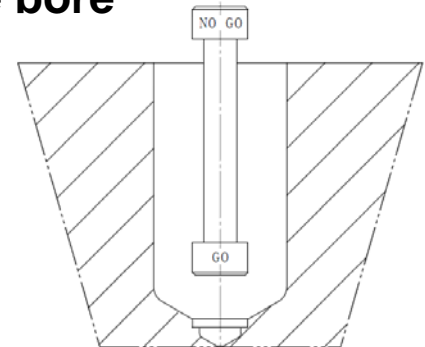
(pic2)

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)



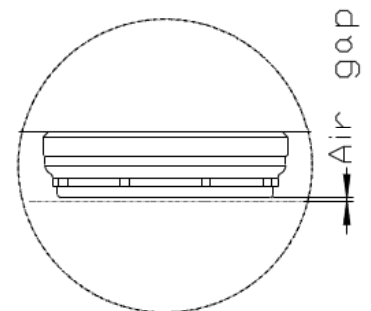
(pic5)



(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)

C: AIR GAP
(cold condition)

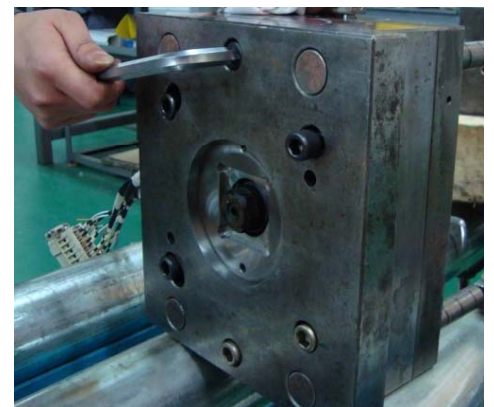
(pic7)

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)



(pic8)

Step 10: Tighten the claim plate screws

(refer to pic 8)