

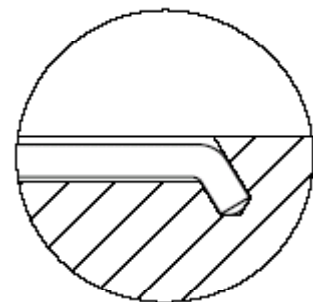
### 一 . Disassembly:

1. Take off the front ;
2. Open lock ring ;
3. Remove reflector ;
4. Carefully slide heater off of nozzle ;
5. Remove T/C ;



### 二 . Assembly:

1. Opposite processing to disassembly  
If necessary , replace T/C by inserting new T/C into small hole at the end of slot.



2. Ensure that the tip is in full contact with the bottom of the bore before bending the T/C along the slot.  
Install heater onto nozzle ensuring that the T/C is not displaced. Bundle the heater and T/C together using high temperature adhesive tape.

### 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(TZM-SHZ)	Front(HBM-CDC)	Front	Manifold nut
Size 04	-	-	6	-
Size 05	7	7	15	100
Size 07	12	12	20	130
Size 10	-	-	25	-
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.