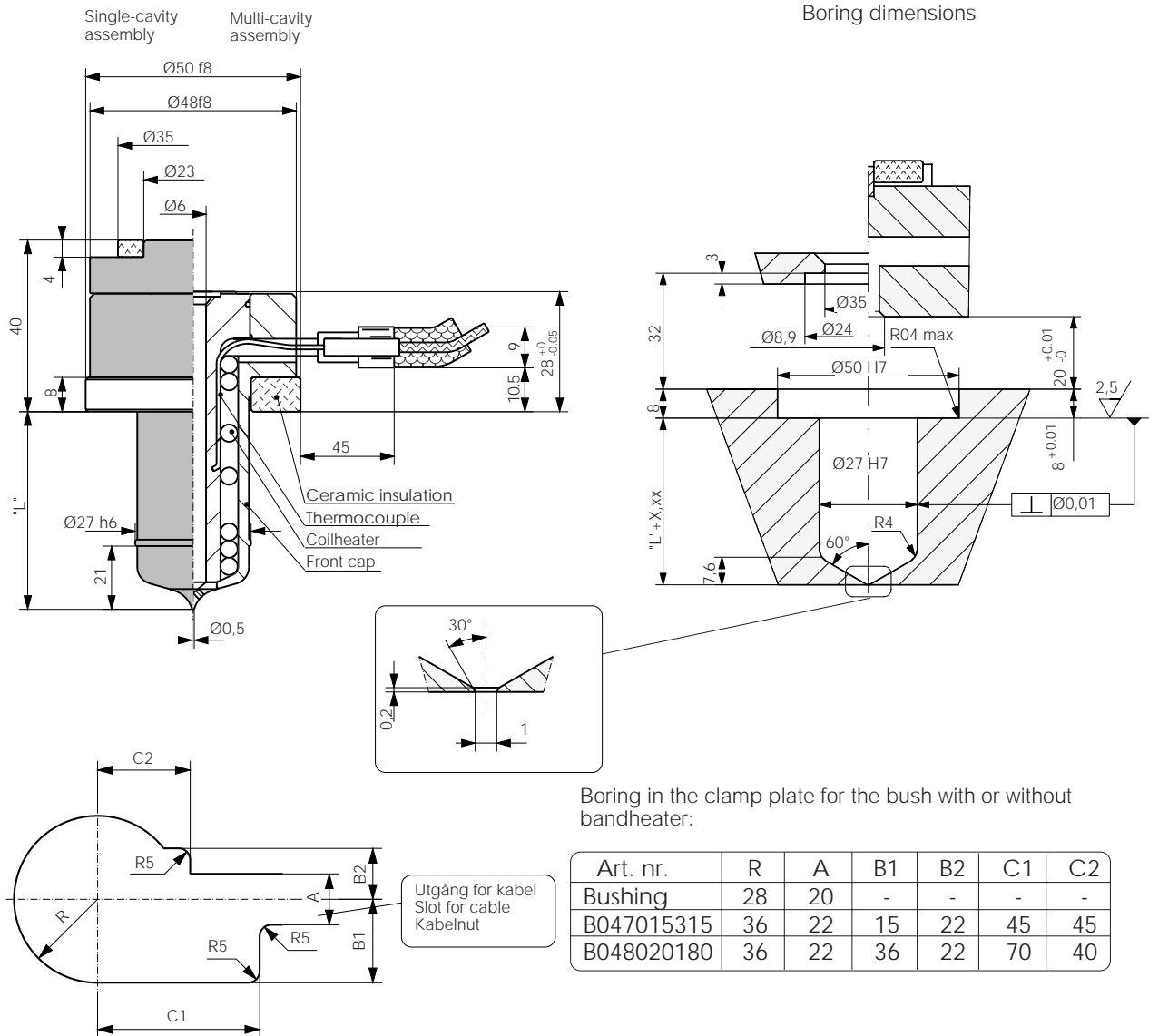




# NPT2..., NEEDLE POINT TOPLESS

## Instructions for installations.

Max permitted contact force from machine nozzle: 4T



Boring in the clamp plate for the bush with or without bandheater:

Art. nr.	R	A	B1	B2	C1	C2
Bushing	28	20	-	-	-	-
B047015315	36	22	15	22	45	45
B048020180	36	22	36	22	70	40

## Colour code for thermocouple wires.

Black (red) wire + (Iron)    White (blue) wire —.

The connector sleeve of the thermocouple has a max. temperature resistance of 240 °C.

When temperatures of 250–260 °C and above are needed it may be advantageous to install a heater band at the back end. This is also the case when shearsensitive materials are to be moulded.

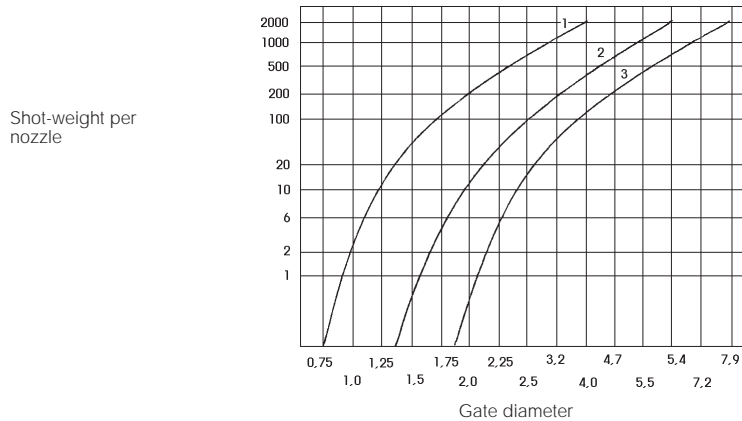
## Length of the bushing.

To ensure minimum vestige on the part.  
 Measure the actual "L" measurement on each bush, add the length expansion according to the adjacent table to get the hole depth ("L"+X,xx) to be drilled in the cavity plate

°C	°C="L"+X,xx		
	26	46	66
200	+0,10	+0,17	+0,23
250	+0,13	+0,21	+0,30
300	+0,16	+0,26	+0,36
350	+0,19	+0,30	+0,42

## Size of gate.

The diameter of tip is 0.5 mm. With a gate diameter of 1 mm the gap will therefore be about 0.25 mm.

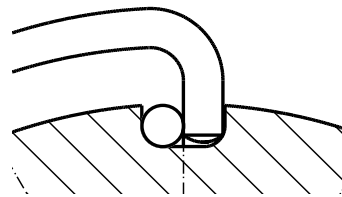


1. Low-viscosity material (PS, PE, PP)
2. Medium-viscosity material (ABS, SAN, PA, POM)
3. High-viscosity material (PC, PMMA, Noryl, fylda material)

The diagram gives guideline figures for the gate diameter needed for different plastics and shot weights. Note: If the gate diameter is too small, an unnecessarily high bushing temperature will have to be set for the gate not to freeze between shots.

## Disassembly , instructions for changing the coilheater or thermocouples.

1. Unscrew the screws at the rear end.
2. Take off the rear screws and the back cap, in single-cavity only, and the front cap.
3. Take off the spring that keeps thermocouple in place.
4. Take off the tape that keeps heater and thermocouple extensions together.
5. Depending on how hard the coil heater fits the pipe it can either be pulled of or "unscrewed". Unscrewing works easily if you push on the spiral heater extension. This will open the spiral if at the same time you open the spiral at the other end with a suitable tool. The thermocouple must not follow if the spiral element is rotated or pulled off, since it may break. Treat the thermocouple with great care. The tube is only 1 mm diameter.



## Assembly

To be done in opposite order to disassembly.

If a new thermocouple is to be fitted it must be bent to fit the bushing. The tip of the thermocouple must be located where the groove ends, i.e. about half-way along the tube. Min. bending radius 3 mm.

Tighten the element so that the heating spiral makes contact with the tube.

If you have any questions about installing the bushing, please get in touch with us.

NPT2