

**Changed STRAIGHT BUCKLE heater/Tip/Front processes.**  
Attention: For best performance use **HEATLOCK** original components.

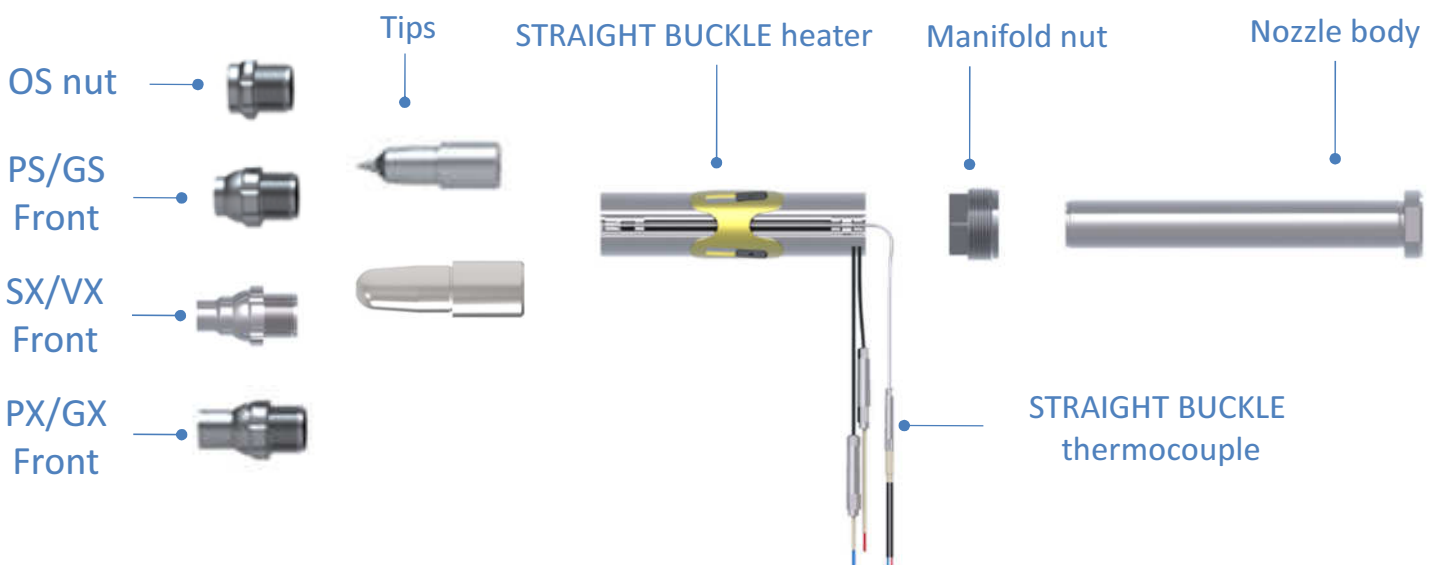
### — . Disassembly :

1. Take off the front ;
2. Carefully slide STRAIGHT BUCKLE heater off from nozzle as below :

Open the buckle, and take off the STRAIGHT BUCKLE heater from nozzle body;



3. Changed the tip and front no need to disassembly the manifold nut.



### 二 . Assembly :

1. Opposite processing to disassembly.
2. STRAIGHT BUCKLE heater assembly:

1). Make sure the buckle is open.



Open buckle direction

2). Put the STRAIGHT BUCKLE heater on nozzle body, and close the buckle .

STRAIGHT BUCKLE heater should be same position with the chamfer of body.



\*Please make sure the heater can not move after locked the buckle.  
Finish the STRAIGHT BUCKLE heater replacement.

### 3. Instructions for replacement of spare part T/C

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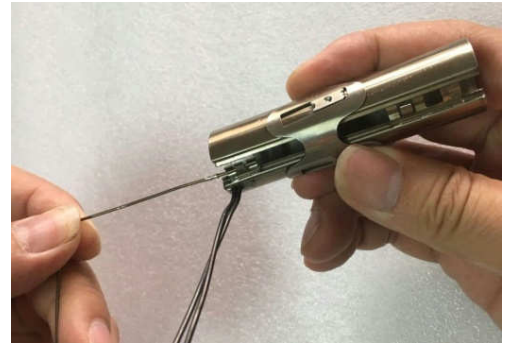
1). Open the lug on top;



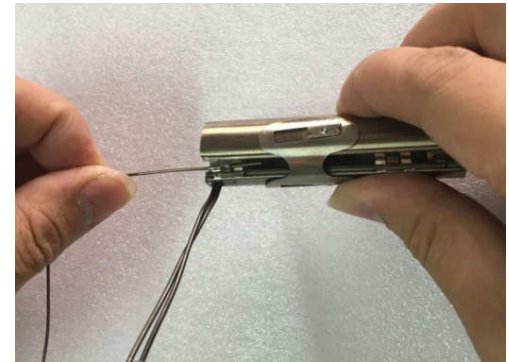
2). Then open the lug at the end of heater;



3). Take out the T/C slowly;



4). Slide the new T/C up to the stop position.



stop position



5). Closed the lug over the position-ring for fixation.



position-ring



\*Make sure the position-ring is under the lug to keep the T/C in the right position.

6). Closed other lug at end of STRAIGHT BUCKLE heater.



Finish the new T/C replacement.

### 4. 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	Manifold nut
Size 04	4	-
Size 05	11	90
Size 07	18	145
Size 10	25	340
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

5. Measure the height of nozzle same as project book drawing.

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If there are any problems encountered during assembly, please call (86) 757- 2991 5868.