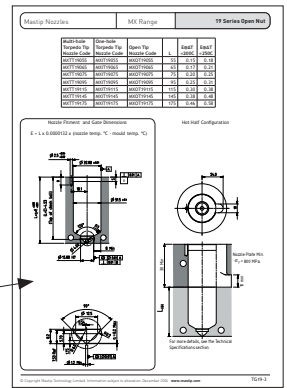


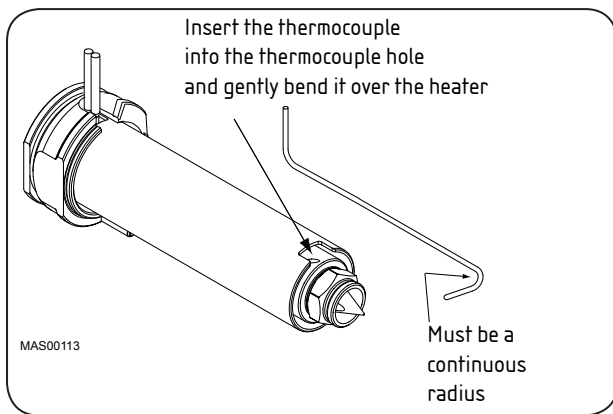
MX Nozzle Installation Instructions

Preparing

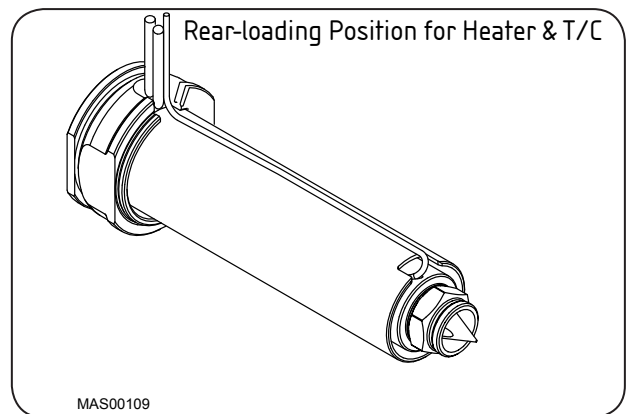
- ❑ Calculate nozzle expansion.
(Use <http://www.mastip.com/uploads/CalcGateSingle.aspx> to check your calculations).
- ❑ Machine the nozzle cavity including room for expansion.
- ❑ Check that the nozzle cavity is within tolerance.
(Refer to Nozzle catalogue pages for machining tolerances.)
- ❑ Complete the thermal gate nozzle check sheet
(<http://www.mastip.com/Downloads/ICTGNozzles.pdf>)
- ❑ Remove the nozzle(s) and thermocouple(s) from the box. Remove the plastic end cap from the nozzle. If nozzle has a sprue nut, modify the nut to suit the application (see Modifying the Sprue Nut section in the Technical Specifications for more information).



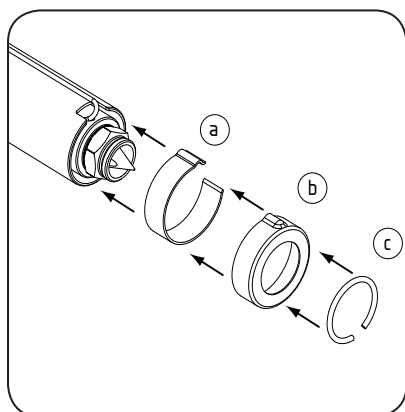
Installing Nozzles in a Rear-loading Configuration



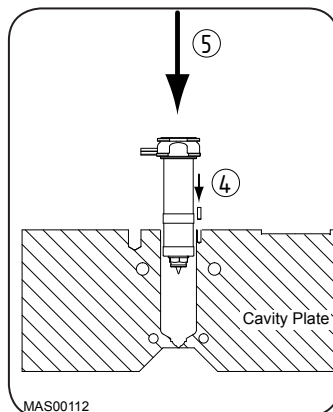
1. Insert the T/C in the hole near the nozzle tip and bend it over the heater as shown.



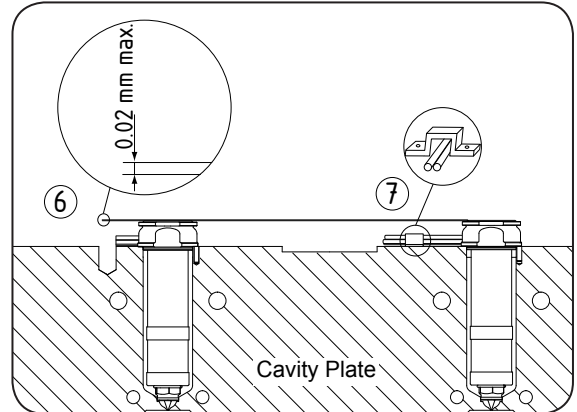
2. Bend the T/C along the outside of the heater and bend it again with the heater wires at the nozzle head.



3. Install the T/C clip (a), the heater cap (b), and snap ring (c) (in that order).



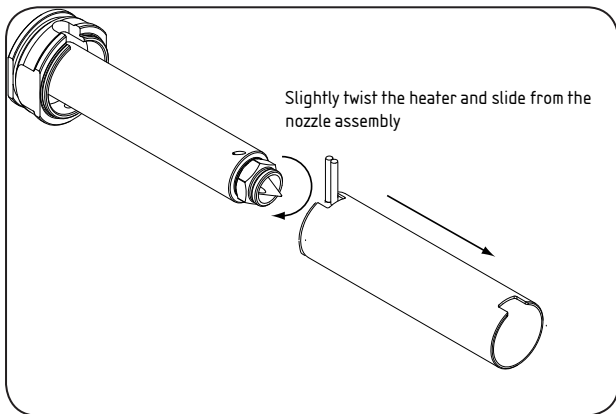
4. Fit the dowel(s) in the dowel hole in the Cavity Plate.
5. One-by-one fit the nozzles into the Cavity plate. This should be a slide fit.



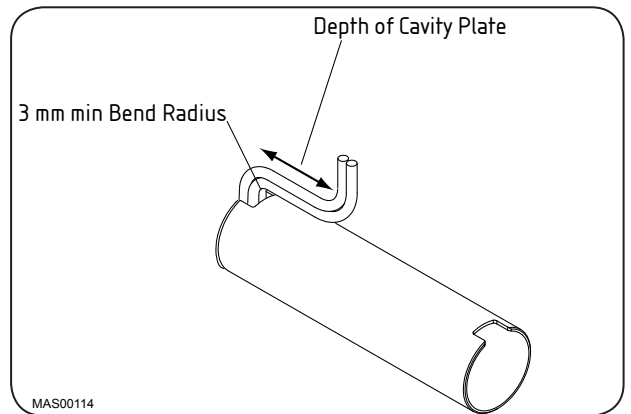
6. Check that all nozzle sealing faces are level within 0.02 mm.
7. Clip the wires to the Cavity Plate to prevent the wires from touching the manifold.

MX Nozzle Installation Instructions

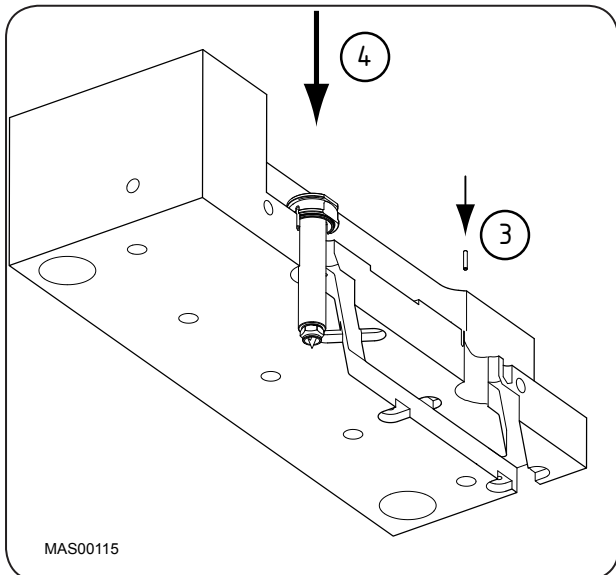
Installing Nozzles in a Front-loading Configuration



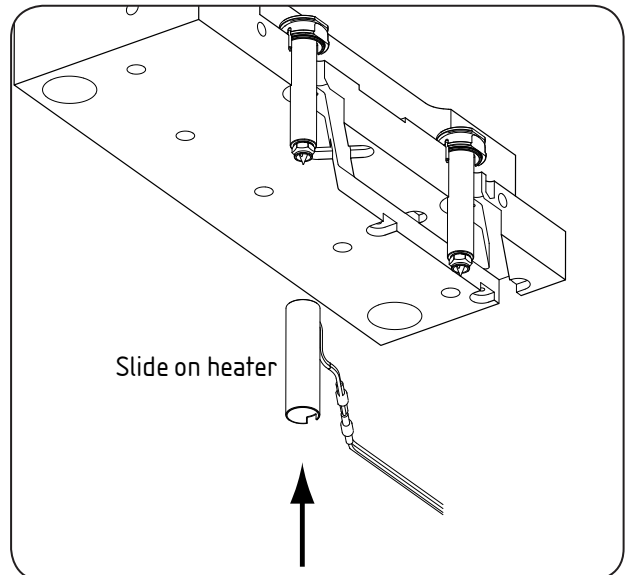
1. Slightly twist the heater and slide it off the nozzle. Take care not to break the heater wires.



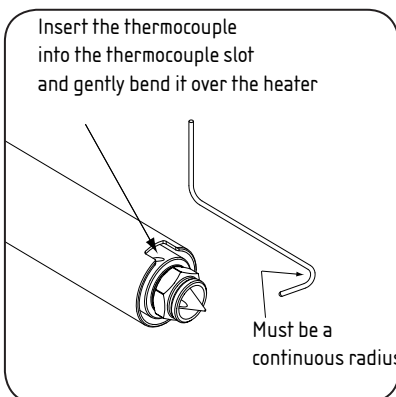
2. Bend the heater wires as shown above.



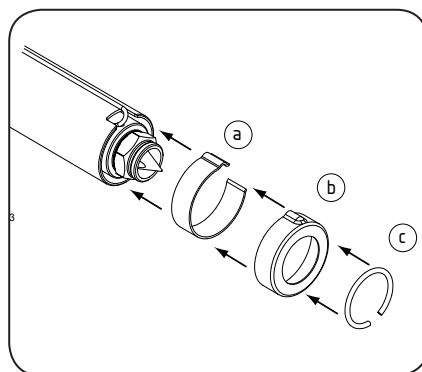
3. Fit the dowel(s) in the dowel hole in the Cavity plate.
4. One-by-one insert the nozzle bodies into the Cavity plate. Check that all nozzles are level within 0.02 mm.



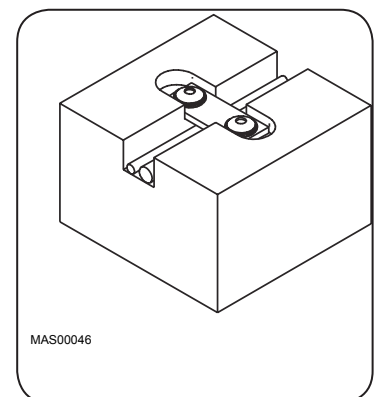
5. Slide the heaters on to the nozzles and thread the wires through the wire channel.



6. Install the T/C as shown above.
7. Thread the T/C wires through the wire channels.



8. Install the T/C clip (a), the heater cap (b), and the snap ring (c) (in that order).



9. Attach the wire clips over the wires in the wire channels. Do not crush wires.