Nozzle Thermocouple Replacement Procedure

1. Disconnect both the power and thermocouple (T/C) connections to the nozzle/bushing from the mold connector insert.

2. Open the wire clip support using a flat head screw driver (Fig. 1) and needle nose pliers (Fig. 2) (be careful not to bend the wires). On single nozzle applications unscrew hex nut on armor cable and expose protective sheathing (white).

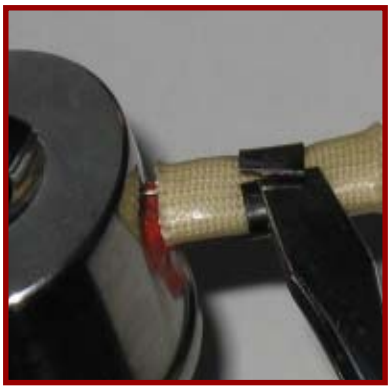

Fig 1

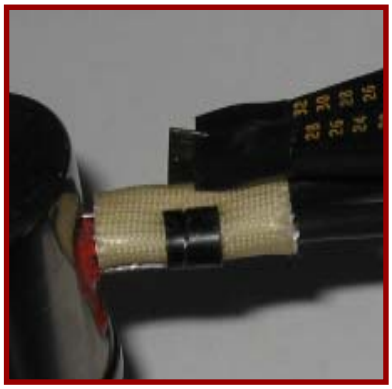

Fig 2

T-1

3. Pull protective sheathing (white) back (Fig. 3), away from nozzle head exposing the two power leads and thermocouple wire (Fig. 4).

Fig 3

Fig 4

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4. Before removing the old T/C wire, mark the location (with magic marker; Fig. 5) closest to the head of the nozzle.

Fig 5

5. Pull T/C out of thermowell (Fig. 6).

Fig 6

6. Take the new T/C and put it next to the old T/C and mark the length (again using a margic marker). The purpose of this is to insure that the new T/C goes back into the nozzle thermowell to the same location.

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7. Take new T/C and pull the lead through your thumb and index finger (Fig. 7) giving it a generous curl (this will assist in feeding T/C into thermowell at the start).

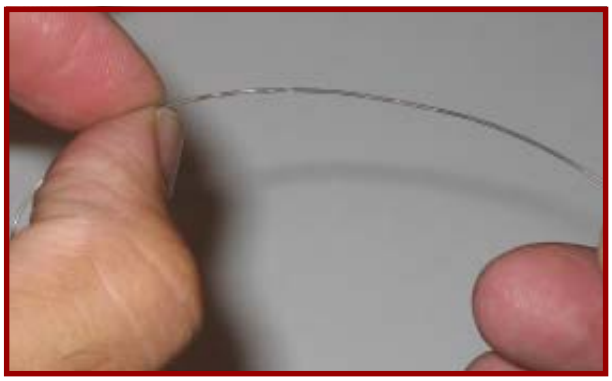

Fig 7

8. Prior to inserting the T/C into the thermowell place a drop of lubricant (WD40 or equivalent) on the table and touch the end of the T/C to it. This will help the T/C pass through any residue that may be present within the thermowell.

9. Take a needle nose pliers and tape both ends to prevent damaging T/C. Insert T/C into thermowell by hand (Fig. 8). Take pliers and grab T/C to feed into the thermowell (Fig. 9). You must grab the T/C very close to the thermowell to prevent "kinking" of T/C while feeding into thermowell. Feed T/C in 1/8" increments (you may find you can feed in larger increments once you're well into the thermowell with the T/C).

Fig 8

Fig 9

Nozzle Thermocouple Replacement Procedure

10. Once you've determined that the T/C is in place (you should feel T/C "bottoming out"), check mark to insure that you are in fact all the way in with the T/C. Using heat resistant tape secure T/C to one of the power leads. This will help prevent any premature movement of T/C within the thermowell.

Fig 10

11. Push sheathing back over the wires (Fig. 11) and close the wire support (Fig 12). Make sure clip support is firmly closed (Fig. 13) to insure that there will be no movement of the T/C in and out of the thermowell.

Fig 11

Fig 12

Fig 13

12. Check continuity & resistance of T/C to verify that it is functioning properly.

13. Connect heater and T/C wires to mold connector insert.