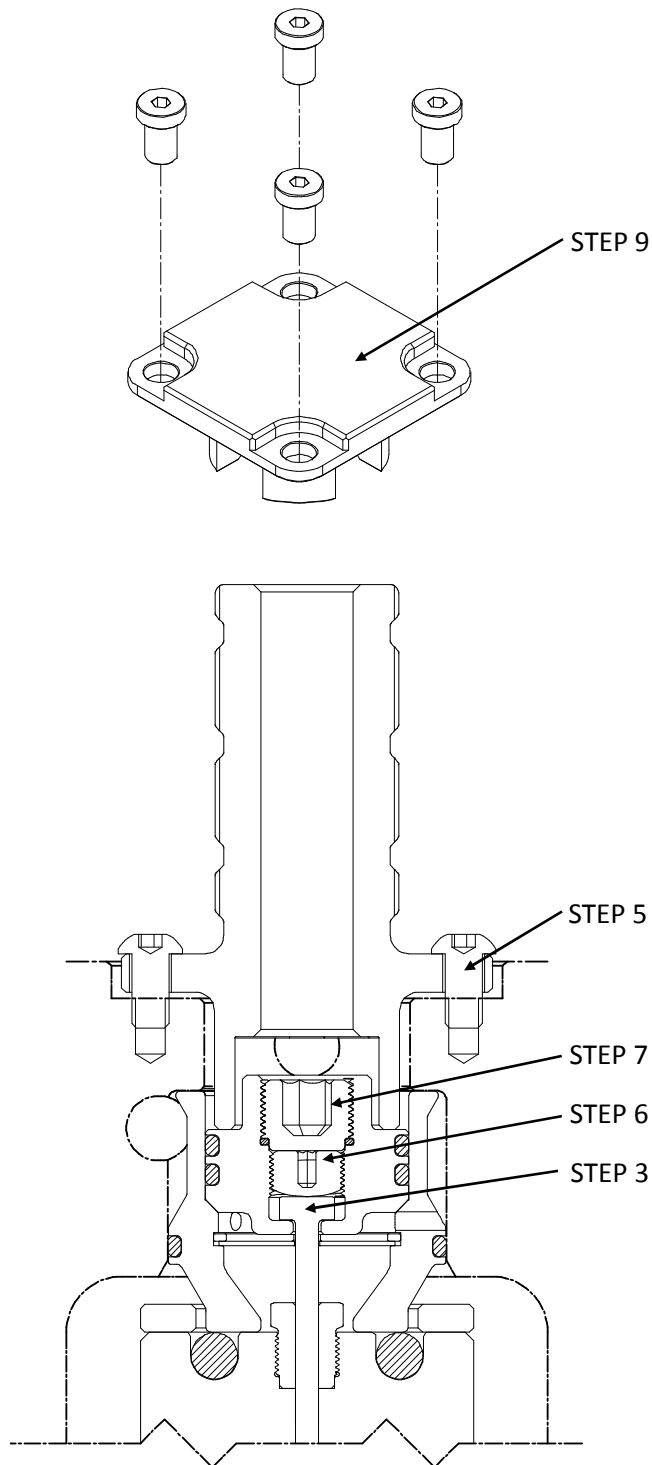


HOW TO SET THE VALVE GATE PIN:

1. Before setting the pins, the cavity plate must be installed onto the Hot Runner
2. Remove all cover plates (VGCP-200) and set screws (VGN-503L, VGN-605R) to have access to the pistons
3. Insert pin into piston
4. Turn on all zones and cooling to processing temperatures. Wait 5 minutes allowing the manifolds, nozzles and pins to reach final expansion
5. Place the set wrench (VGSW-100) over the piston tightening it down with $\frac{1}{4}$ -20 screws
 - a. Note: Do not over tighten this screw as it will put excessive pressure on the gate
6. Insert VGN-503L ($\frac{1}{2}$ " left hand set screw) into piston just until it touches the pin head
 - a. Note: Do not over tighten this screw as it will put excessive pressure on the gate
7. Insert VGN-605R ($\frac{5}{8}$ " right hand set screw) on top of the $\frac{1}{2}$ " set screw tightening the screw firmly by hand
8. Remove the set wrench tool
9. Place the cover plate (VGP-200) on top and tighten all four $\frac{1}{4}$ -20 low head cap screws securely by hand (be sure a -126 O-ring is installed on the cover plate)
 - a. Note: Use anti-seize compound