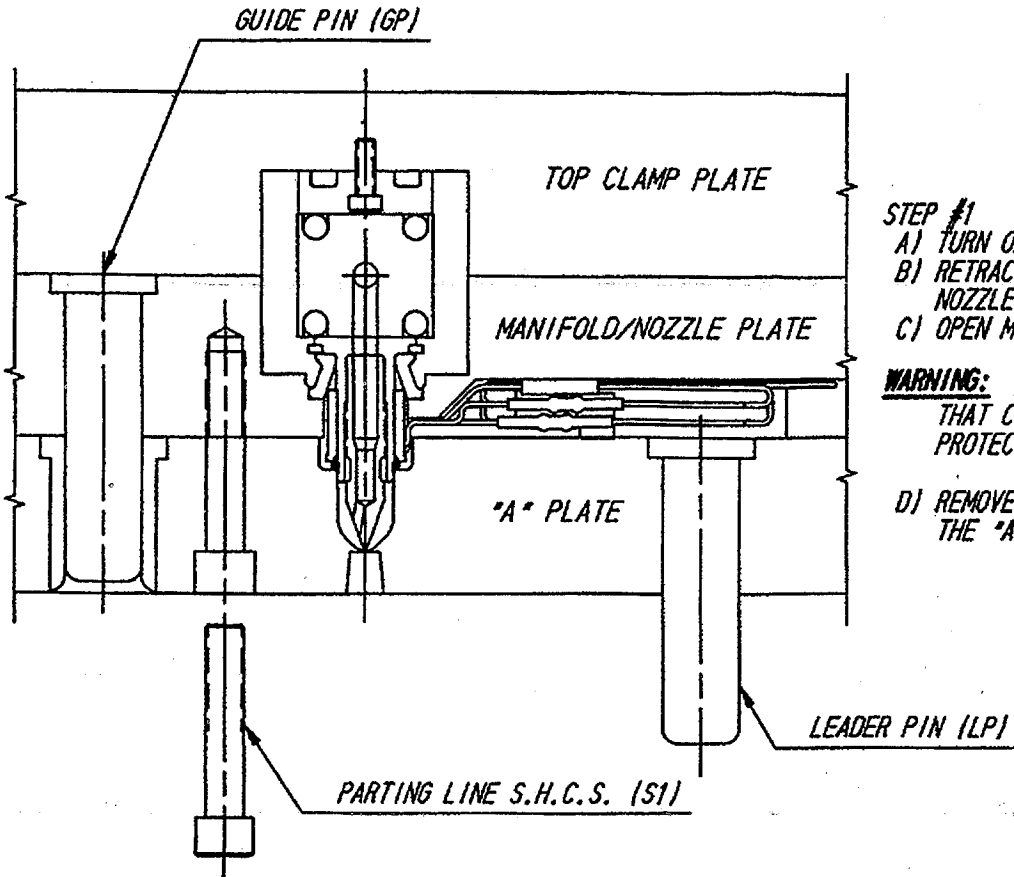


GALAXY NOZZLE HEATER AND THERMOCOUPLE REPLACEMENT INSTRUCTIONS

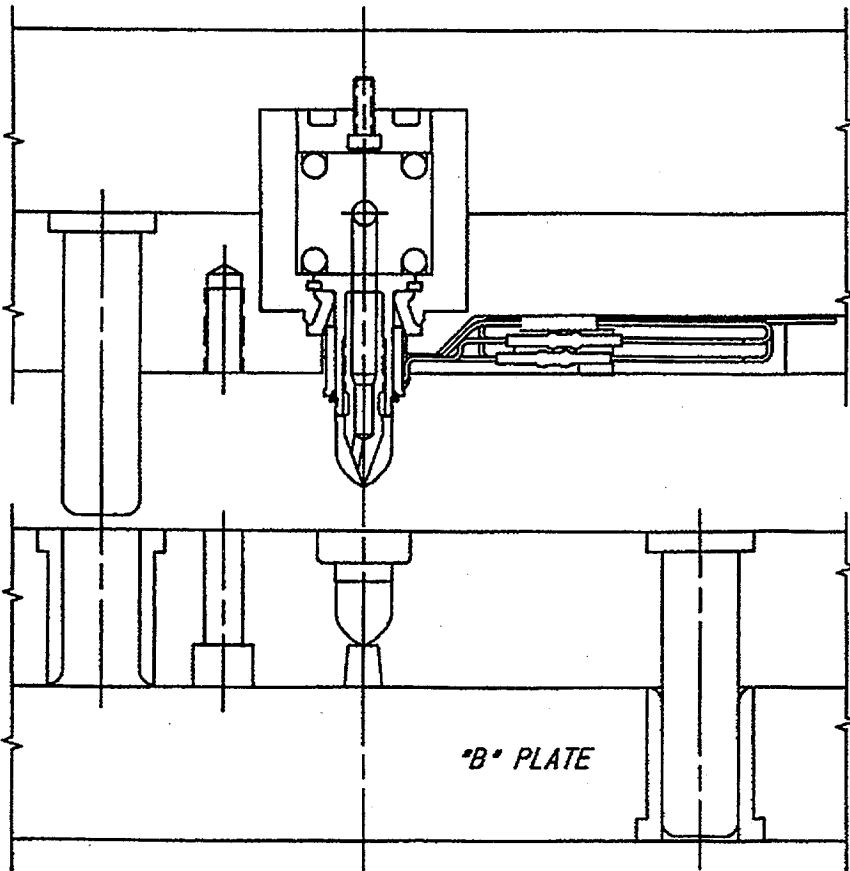


STEP #1

- A) TURN OFF POWER TO MANIFOLD(S) AND NOZZLE(S).
- B) RETRACT INJECTION UNIT TO DISENGAGE MACHINE NOZZLE CONTACT WITH MOLD.
- C) OPEN MOLD.

WARNING: ALL MOLD PLATES MAY RETAIN HIGH HEAT THAT COULD CAUSE BURNS WITHOUT PROPER PROTECTION.

- D) REMOVE ALL PARTING LINE S.H.C.S. THAT ATTACH THE "A" PLATE TO THE MANIFOLD/NOZZLE PLATE.



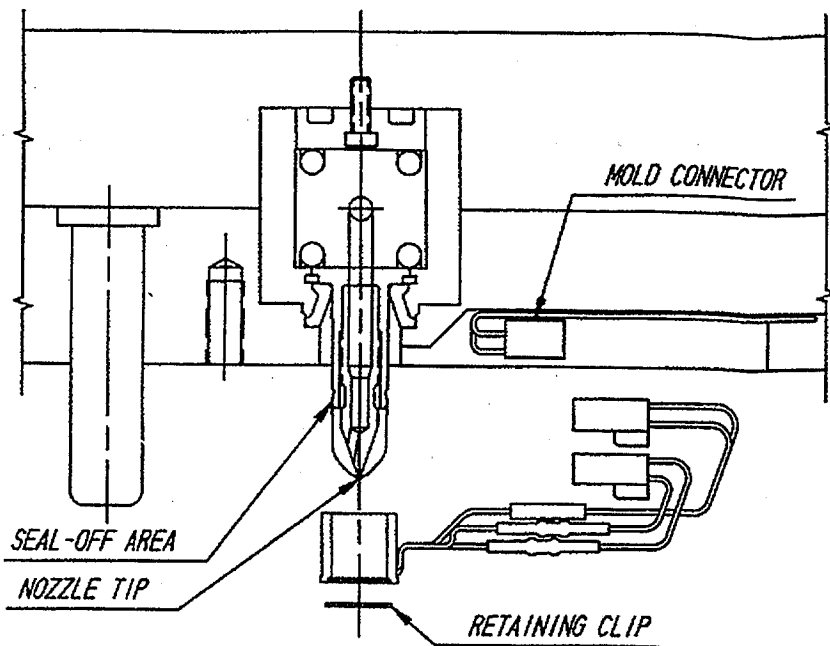
STEP #2

- A) DE-ACTIVATE EJECTION MECHANISM.
- B) CLOSE MOLD SLOWLY.
- C) LATCH "A" PLATE TO MOVABLE SIDE.
- D) SLOWLY OPEN MOLD SEPERATING "A" PLATE FROM MANIFOLD/NOZZLE PLATE.

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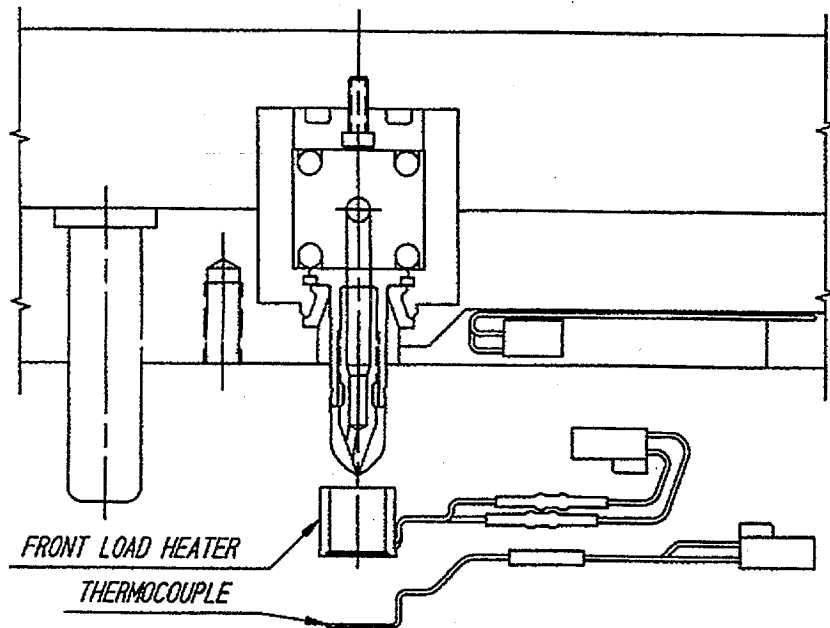
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NOTE: BE CAREFUL NOT TO DAMAGE NOZZLE TIP AND SEAL-OFF AREA WHEN REMOVING OR REPLACING NOZZLE COMPONENTS.

STEP #3

- A) REMOVE HEATER RETAINING CLIP ON NOZZLE BODY.
- B) UNPLUG POWER AND THERMOCOUPLE FROM MOLD CONNECTOR OR UNWIRE FROM TERMINAL MOUNTING BOX IF MOLD CONNECTORS ARE NOT USED.
- C) REMOVE HEATER AND THERMOCOUPLE SUB-ASSEMBLY FROM NOZZLE BODY.



NOTE: DO NOT CUT RIGID HEATER OR THERMOCOUPLE LEADS.

STEP #4

- A) REMOVE THERMOCOUPLE FROM GROOVE ON THE INSIDE OF THE HEATER.
- B) BEND NEW THERMOCOUPLE LEADS TO THE CORRECT POSITION USING OLD THERMOCOUPLE AS A GUIDE.
- C) BEND NEW HEATER LEADS TO THE CORRECT POSITION USING OLD HEATER AS A GUIDE.
- D) PLACE NEW THERMOCOUPLE INTO THE INSIDE GROOVE OF THE HEATER.
- E) SLIDE HEATER AND THERMOCOUPLE SUBASSEMBLY ONTO NOZZLE BODY. NOTE THAT THE "TIP END" IS INDICATED ON THE HEATER FOR PROPER ORIENTATION.
- F) SNAP RETAINER CLIP ONTO NOZZLE BODY.
- G) PLUG IN HEATER AND THERMOCOUPLE TO MOLD CONNECTOR OR WIRE TO TERMINAL MOUNTING BOX IF MOLD CONNECTORS ARE NOT USED.
- H) USING A MULTIMETER CHECK HEATER AND THERMOCOUPLE RESISTANCES.

WARNING: DO NOT CLOSE MOLD WHEN NOZZLES ARE HOT - DAMAGE MAY OCCUR DUE TO THERMAL EXPANSION OF NOZZLE SEAL-OFF AREA.

- I) SLOWLY CLOSE MOLD.
- J) LATCH "A" PLATE TO MANIFOLD/NOZZLE PLATE
- K) SLOWLY OPEN MOLD.
- L) ASSEMBLE ALL S.H.C.S. FROM PARTING LINE TO ATTACH "A" PLATE TO MANIFOLD/NOZZLE PLATE
- M) ACTIVATE EJECTION MECHANISM.

FRONT LOAD HEATERS (240 VAC)

| CAT. NO. | LEAD LENGTH (mm) | WATTS |
|----------|------------------|-------|
| GXH3023 | 90 | 150 |
| GXH3123 | 1220 | |
| GXH3043 | 90 | 175 |
| GXH3143 | 1220 | |
| GXH3063 | 90 | 200 |
| GXH3163 | 1220 | |

FRONT LOAD THERMOCOUPLES (J TYPE)

| CAT. NO. | LEAD LENGTH (mm) |
|----------|------------------|
| GXC1023 | 90 |
| GXC1123 | 1220 |
| GXC1043 | 90 |
| GXC1143 | 1220 |
| GXC1063 | 90 |
| GXC1163 | 1220 |

