

For oversized tips, please see: Quick installation guide - Needle shut-off nozzle type HP (Oversize tip version).

Safety instructions and precautions

Please pay attention to the following safety instructions and precautions

Handling

- Installation and servicing to be only carried out by suitable personnel according to instructions.
- Nozzle can become extremely hot. Full face protection and heat resistant gloves must be worn.
- Heavy parts. Use correct lifting equipment.



Damage precaution

- Do not drop the nozzle or exert it to unnecessary forces.
- Take care that no foreign bodies enter the working parts of the nozzle.
- No adjustment or manipulation when nozzle is in operation.
- Never heat steel parts over **520°C**.
- The actuator is designed for temperatures up to **180°C**.
- Nozzle is only to be used for injection molding purposes.

Operational notes

- Maximum injection pressure / temperature: **3000 bar at 400°C**.
- Torques on screws and threaded parts must be adhered to.

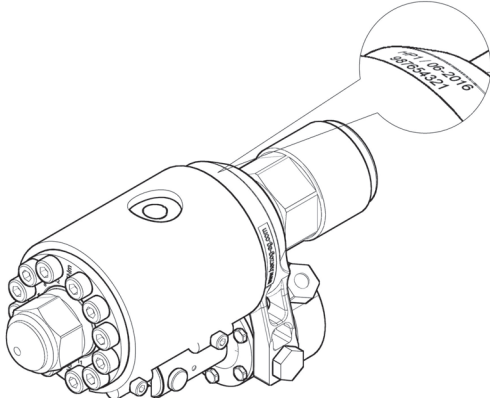
Explosion danger



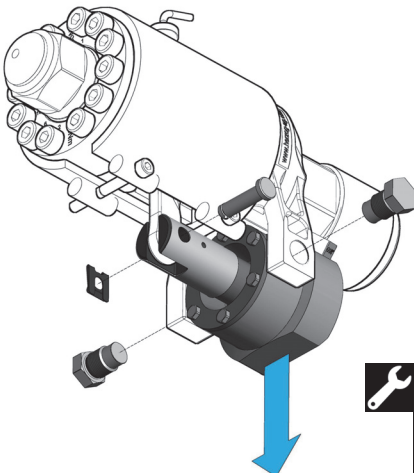
Some plastics produce gases if they stay for a longer time in a heated environment. There is a risk that the gas may escape explosively through the nozzle orifice.

Useful information

Nozzle identification location



For more convenient installation actuator may be removed and re-fitted once nozzle body is installed.



HP0	13
HP1	17
HP2	17

Machine installation instructions

Read safety instructions!

Wear protective clothing at all times!



Legend

 Tool

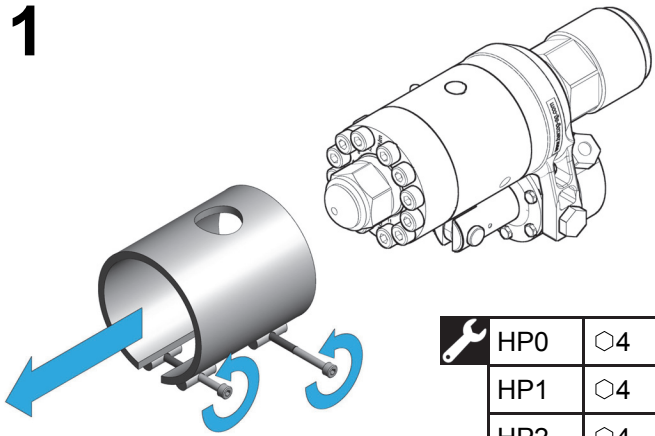
 Lubricate with high temperature grease

 Manually / Hand tight

 Await temperature equalisation

 Attention

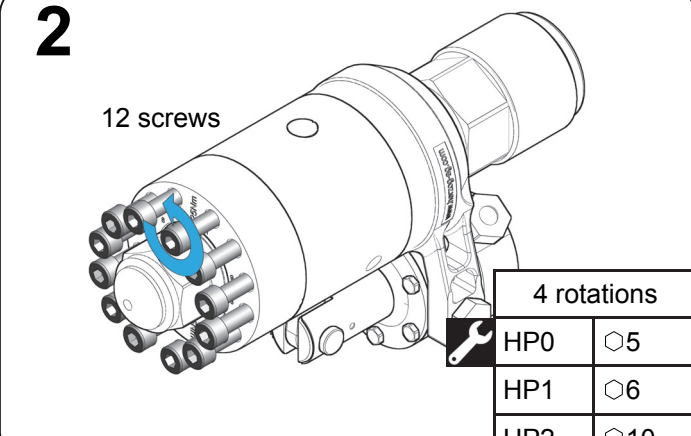
1



HP0	4
HP1	4
HP2	4

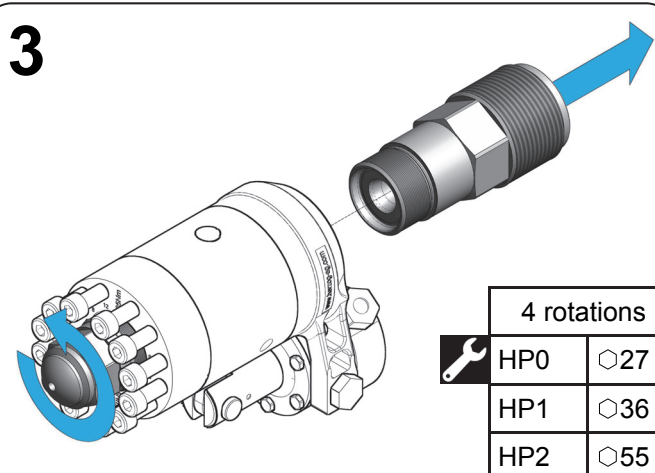
2

12 screws



4 rotations	
HP0	5
HP1	6
HP2	10

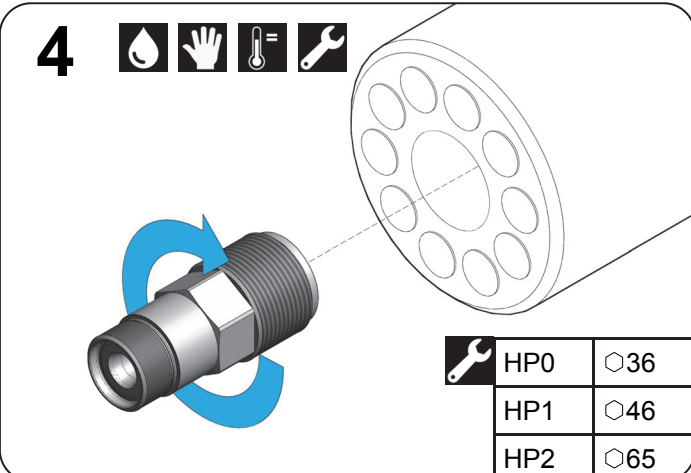
3



4 rotations	
HP0	27
HP1	36
HP2	55

4



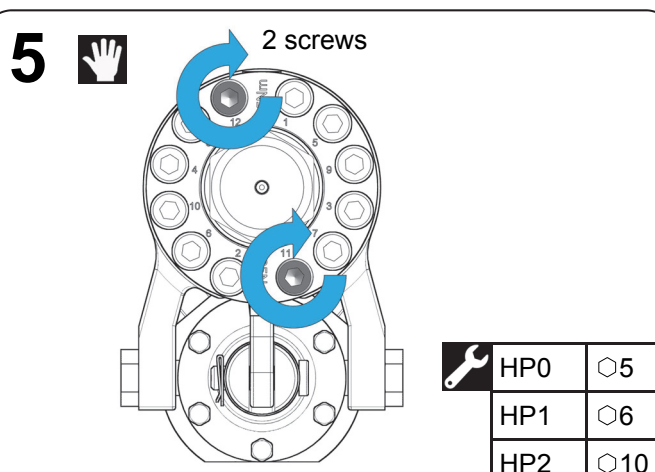


HP0	36
HP1	46
HP2	65

5

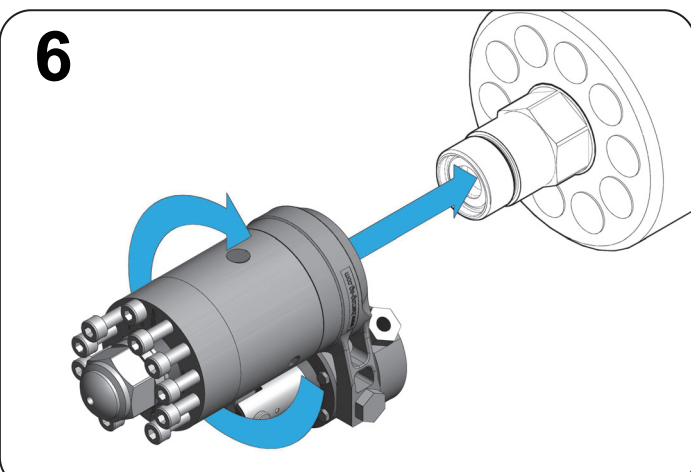


2 screws



HP0	5
HP1	6
HP2	10

6



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I_HP_EN_V1

7

HP0	○27	
HP1	○36	
HP2	○55	

8

2 screws

4 rotations		
HP0	○5	
HP1	○6	
HP2	○10	

13

Crosswise

			Pass 1	Pass 2	Pass 3	Pass 4
	HP0	○5		7Nm	10Nm	12Nm
	HP1	○6		15Nm	22Nm	25Nm
	HP2	○10		12Nm	25Nm	50Nm

9

1/2 rotation

HP0	○27	
HP1	○36	
HP2	○55	

10

Align: Min. 1/4 rotation

14

Use flexible piping

Installation option

Nozzle open

180°

Nozzle closed

11

2 screws

HP0	○5	
HP1	○6	
HP2	○10	

15

	HP0	○4
	HP1	○4
	HP2	○4

16

	HP0	○14
	HP1	○14
	HP2	○14

12

Parallel gaps

Nonexistent gap B: Loosen screws and rotate nozzle 360° clockwise.

Gap A = 0mm to max. 1mm

Gap B = min. 0.5mm to max. 2.5mm

17

One-piece tip			Two-piece tip			
			Tip base		Tip cap	
HP0	○27	220Nm	HP0	○36	220Nm	○27 120Nm
HP1	○36	500Nm	HP1	○41	500Nm	○32 200Nm
HP2	○55	1200Nm	HP2	○65	1200Nm	○41 600Nm

Herzog standard tip values

Initial operation

1. Bring nozzle to operating temperature
2. **Only for first operation:** tighten 8 body screws and heater band screws to maximum recommended torques
3. Make sure that polymer is completely melted
4. Purge heated melt. This follows after extrusion at low speed (time ca. 25 - 30s) or through injecting out at three to five times injection time.

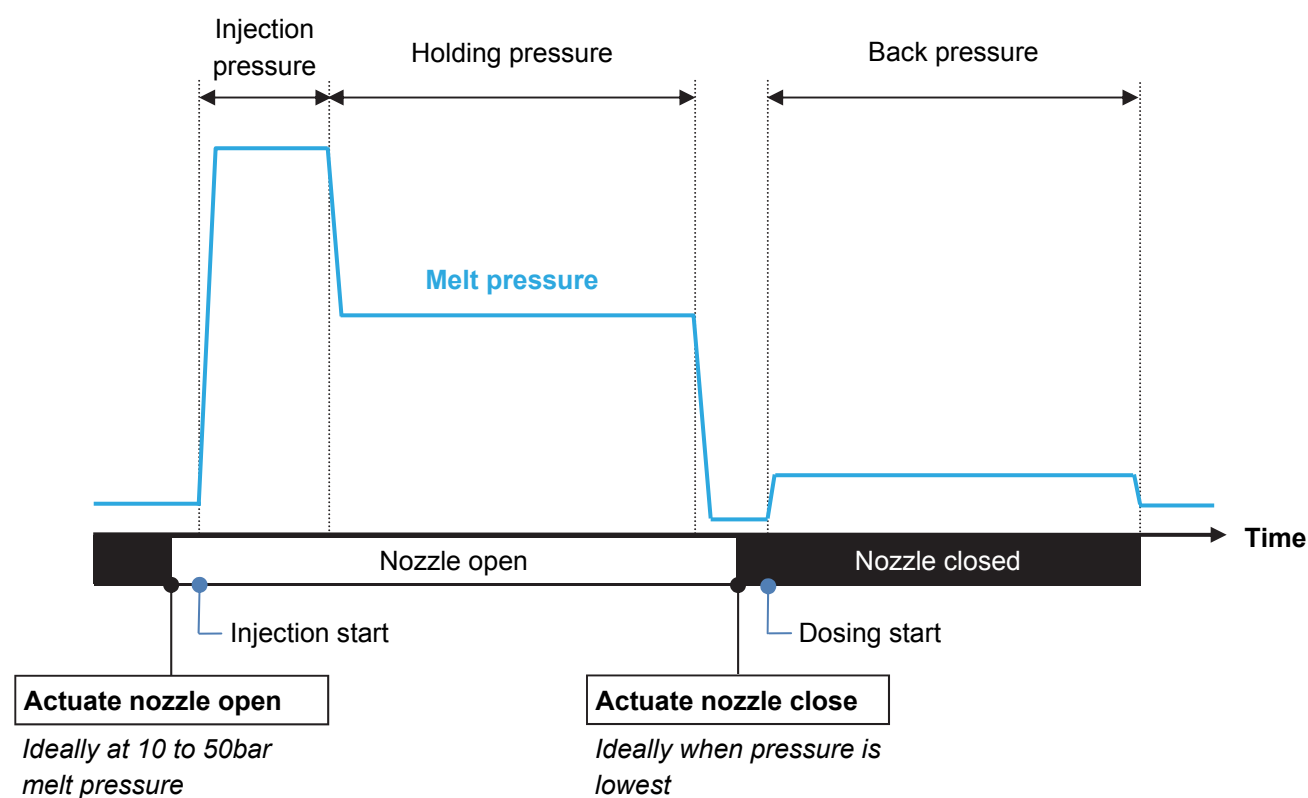
Actuator: Operational data according to engraving on cylinder.

Leakage: Between needle and guide a melt film will form. During processing this film will be continuously renewed and will eventually leak out in the lever area (approx. 1cm³ per day).

Nozzle actuation stages

Actuating nozzle at stages indicated in the graph helps increase longevity of wear parts.

Example melt pressure / time graph:



Machine downtime

When machine is powered off or idle for a long period:

- Purge processed material from nozzle
- Open nozzle
- Reduce nozzle temperature

Contact information

herzog®

Switzerland

herzog systems ag
Feldhofstrasse 65
CH-9230 Flawil

Tel. +41 71 394 19 69
Email info@herzog-ag.com
Skype herzogsystemsag

China

Herzog (China) Co., Ltd.
No.438 Zhujiang Road
Ningbo, PC: 315800

Tel. +86 574 8696 3001
Email asia@herzog-ag.com
Skype herzogchinacolt

USA

Herzog Injection Technology, Inc.
245 Western Ave
Essex, MA 01929

Tel. +1 978 768 0090
Email usa@herzog-ag.com
Skype herzoginjectiontech