

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

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.

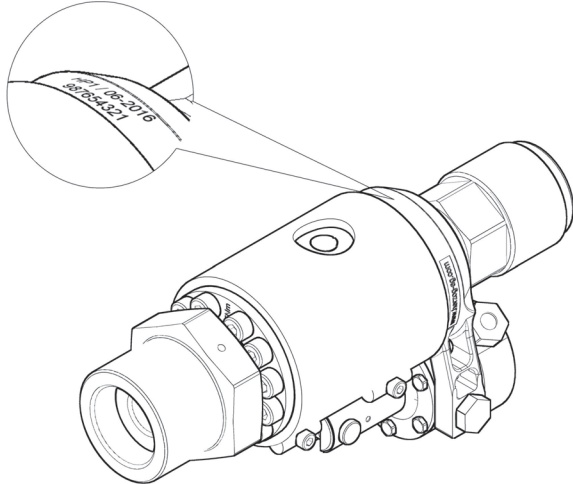
Explosion danger



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.

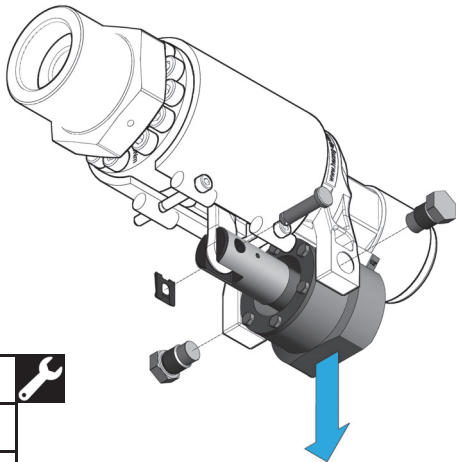
Useful information

Nozzle identification location



HP0	13
HP1	17
HP2	17

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

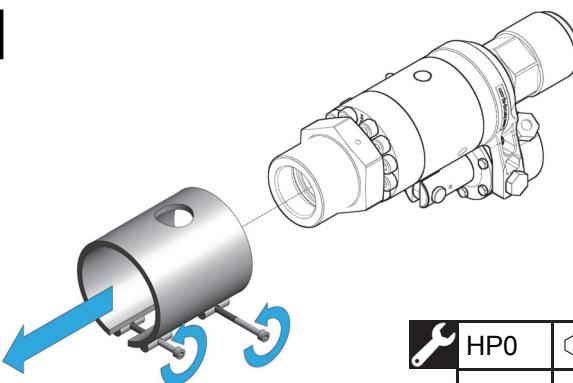


Await temperature equalisation



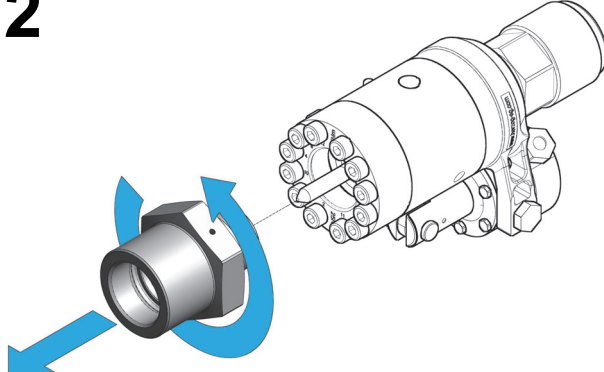
Attention

1



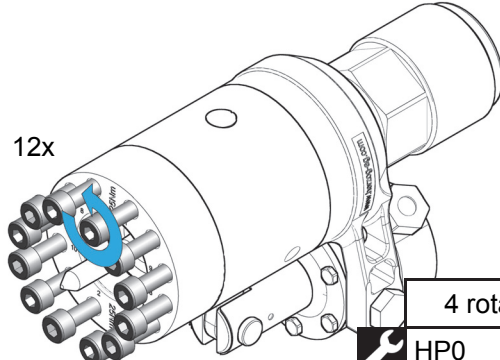
HP0	4
HP1	4
HP2	4

2



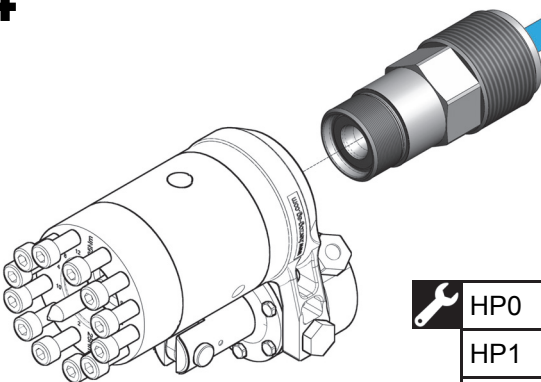
Customer specified

3



4 rotations	
HP0	5
HP1	6
HP2	10

4



HP0	27
HP1	36
HP2	55

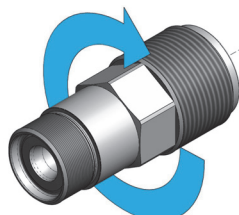
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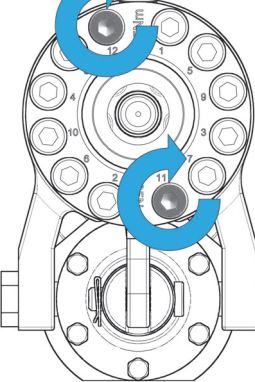


HP0	36
HP1	46
HP2	65

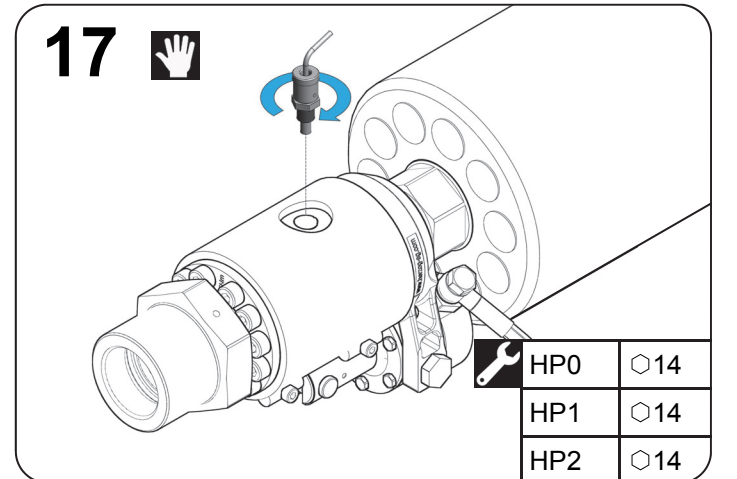
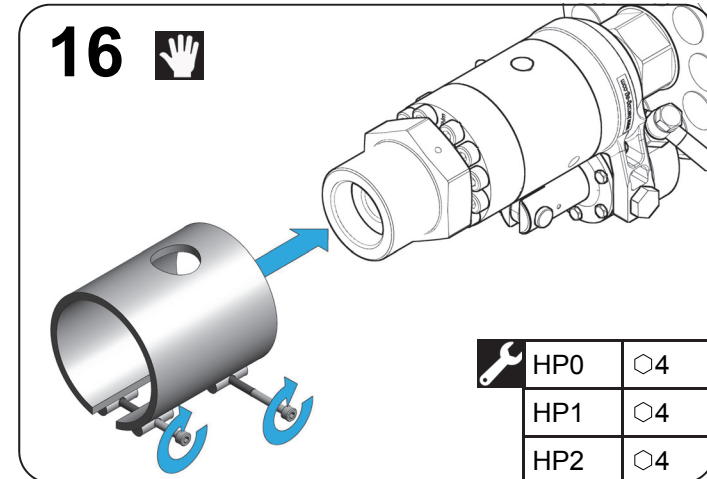
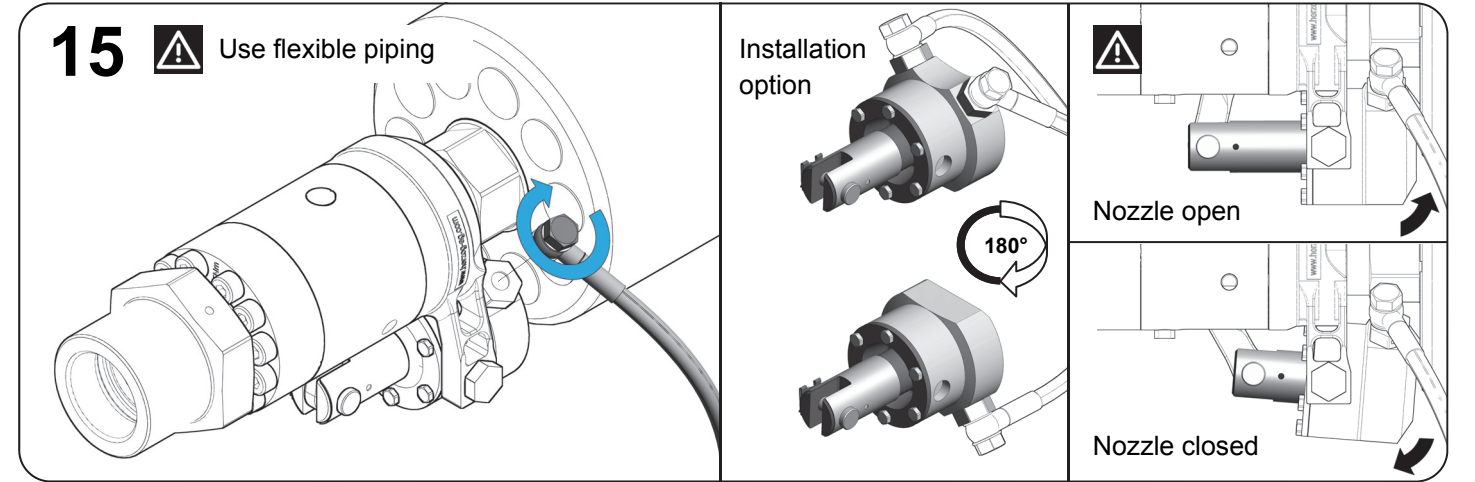
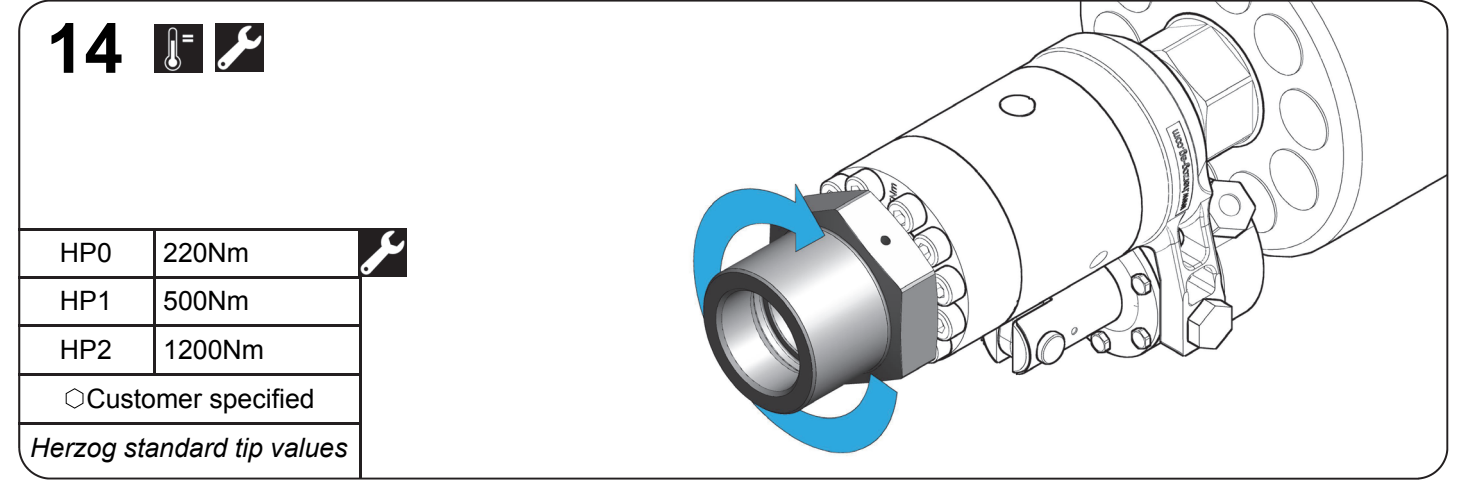
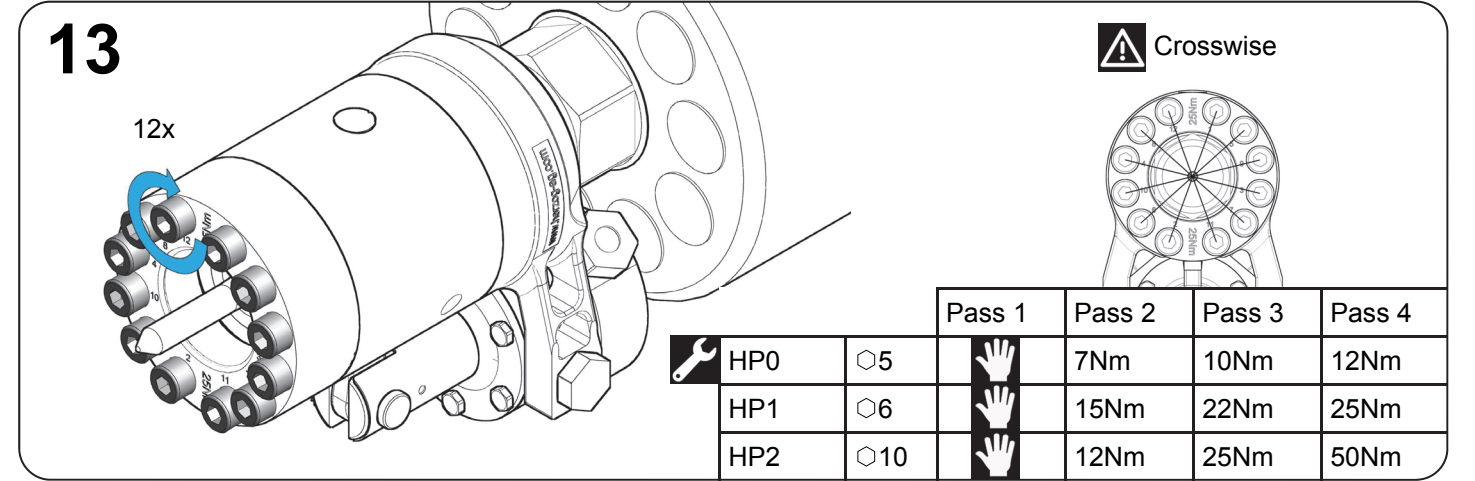
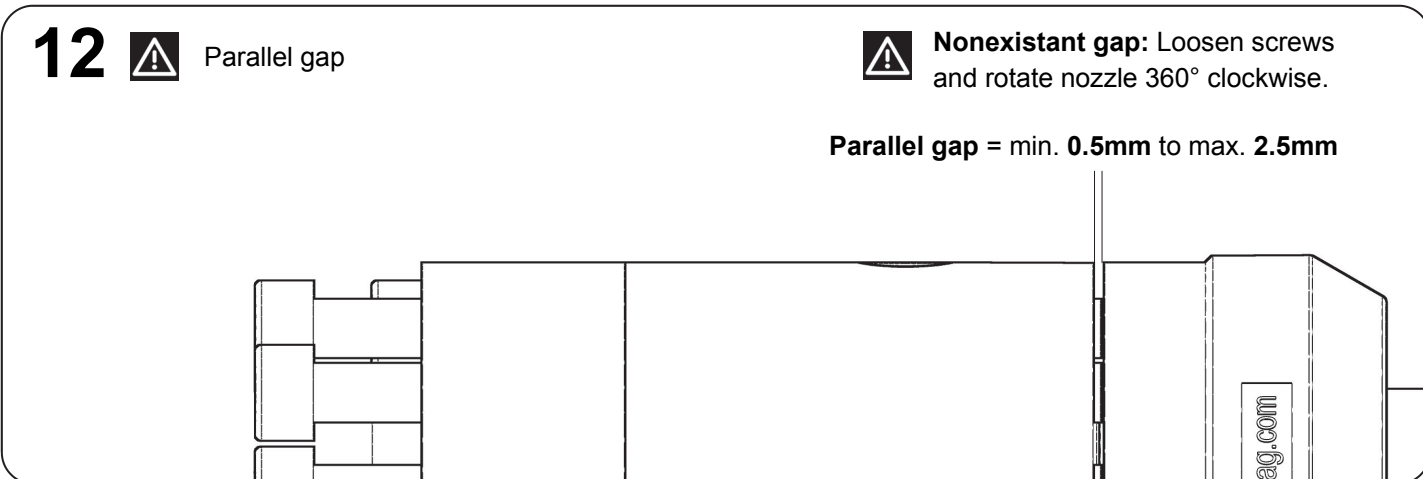
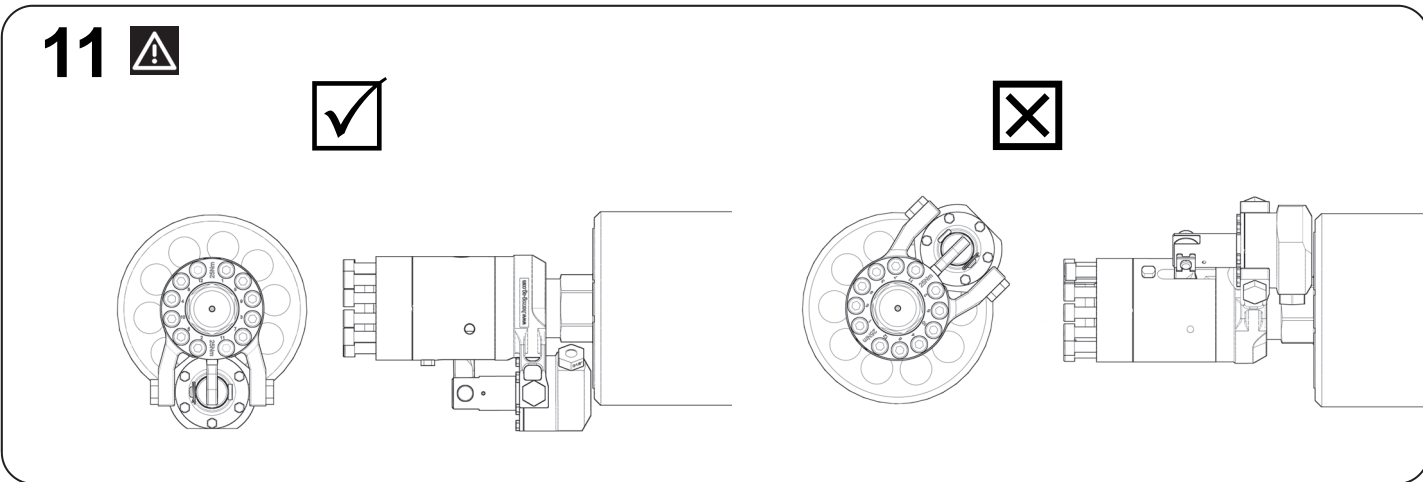
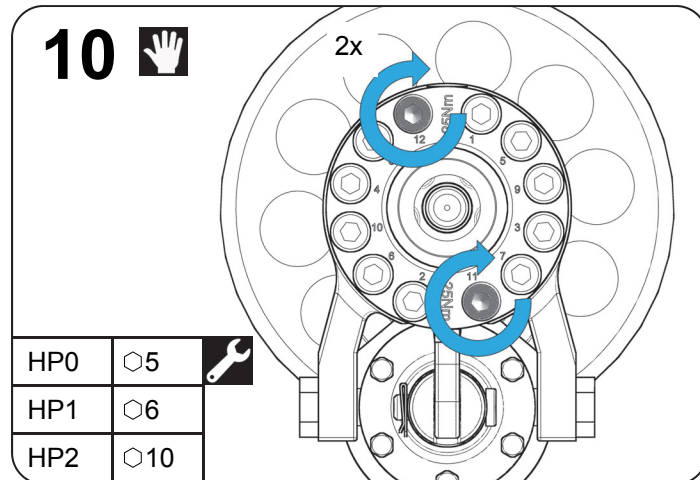
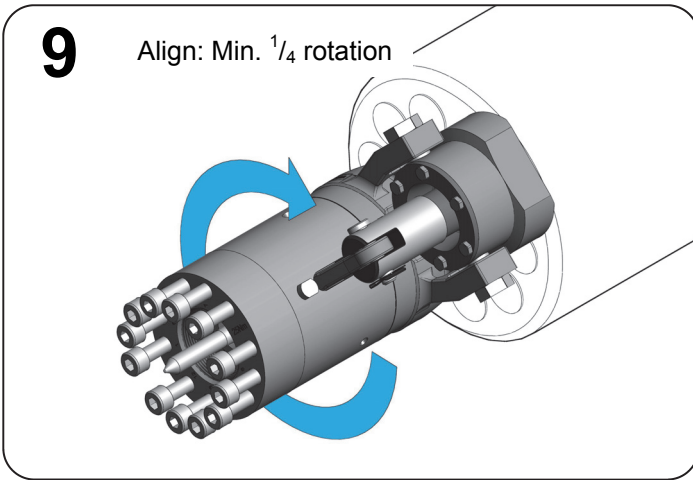
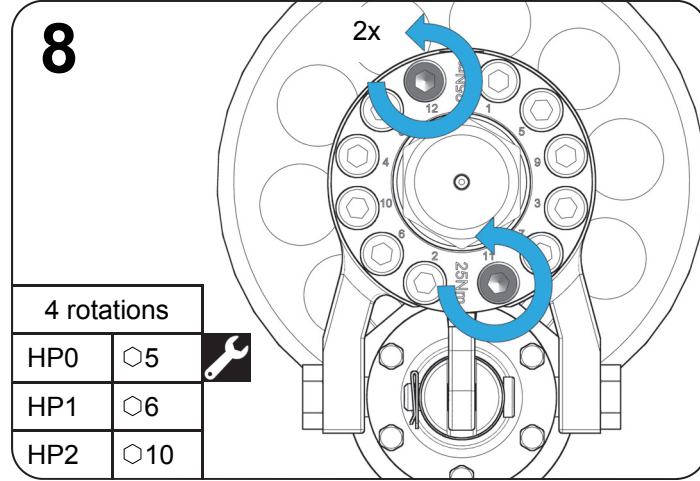
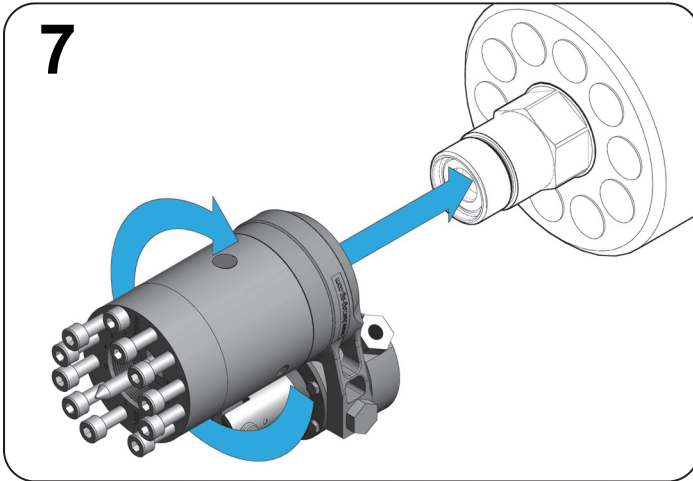
6



2x



HP0	5
HP1	6
HP2	10



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.

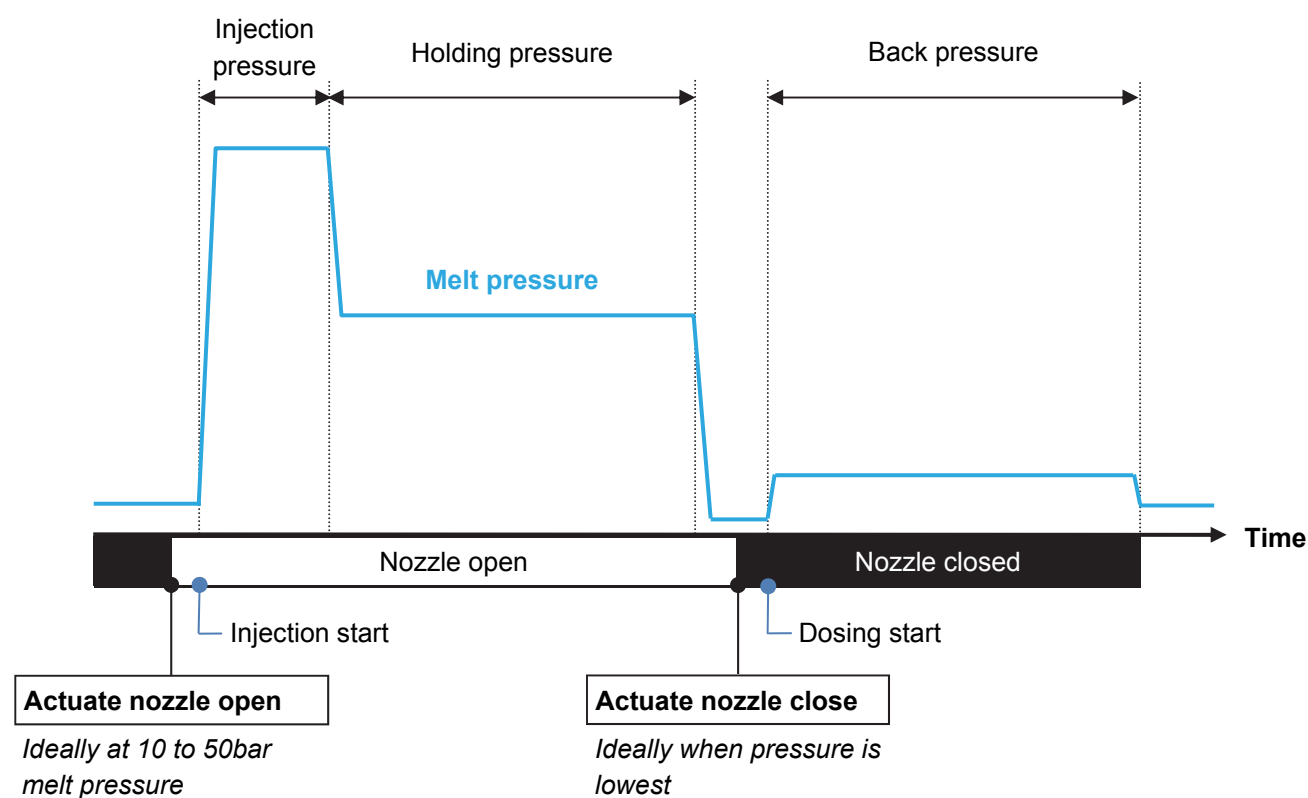
Actuator: Operational data according to engraving on cylinder.

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

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