

Cleaning instructions

1. Dismantle nozzle according to instructions
2. Clean individual parts with kerosene
3. Rinse all parts with a grease remover if necessary. Hardened material can be removed by hand

⚠ Never heat nozzle above 110°C!

Before reassembly check all parts for damage or wear.
All O-rings should be replaced after cleaning.

Benefit from our cleaning service. The nozzle is disassembled, inspected and repaired if necessary after customer approval.

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Installation guide - Needle shut-off nozzle type NE

herzog®

Installation videos and further documentation available at www.herzog-ag.com.

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 / aluminium parts over **110°C**.
- Nozzle is only to be used for **elastomer** injection moulding purposes.

Operational notes

- Maximum injection pressure / temperature: **3000 bar at -20°C to 110°C**.
- Torques on screws and threaded parts must be adhered to.

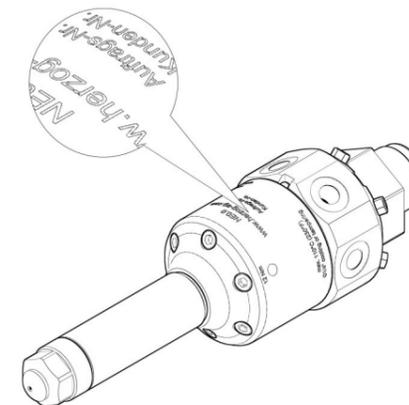
Explosion danger



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



Tip option: three-piece diving tip



	Ø15	Ø13
	Ø16	Ø13
	Ø20	Ø17

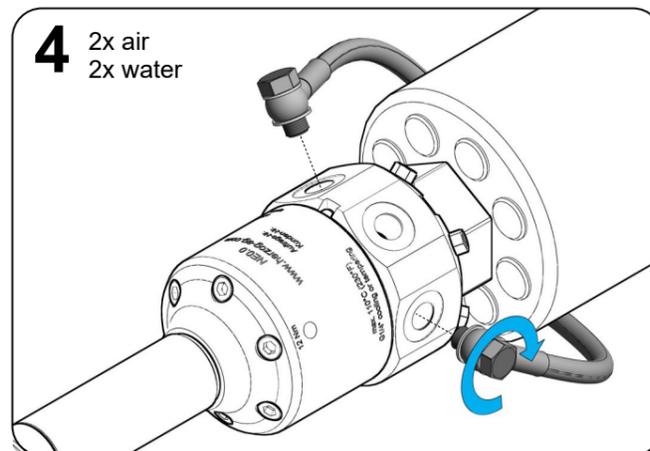
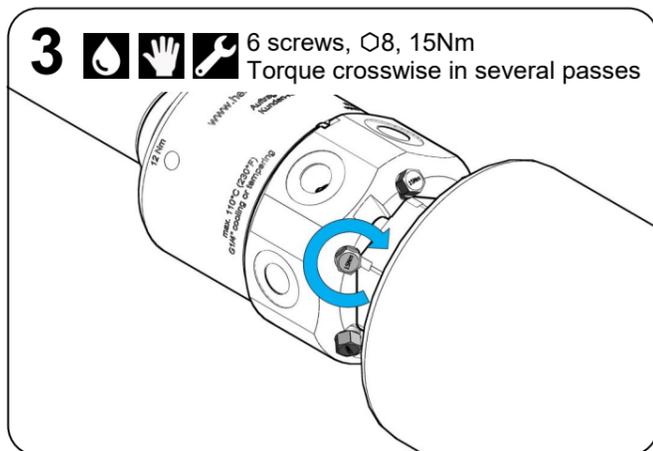
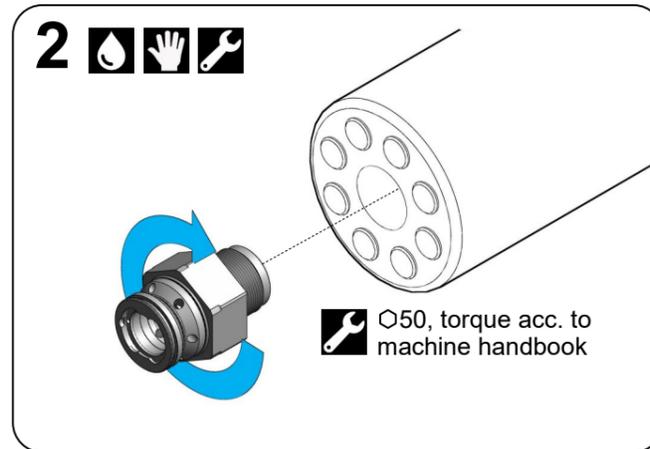
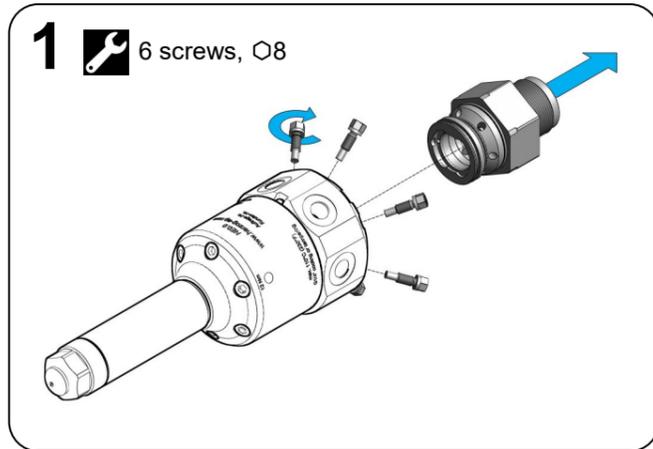
Machine installation instructions

Read safety instructions!
Wear protective clothing at all times!



Legend

- Tool \varnothing size
- Lubricate with high temperature grease
- Manually / Hand tight
- Await temperature equalisation
- Attention



Initial operation

Actuation: Operating data according to engraving on nozzle

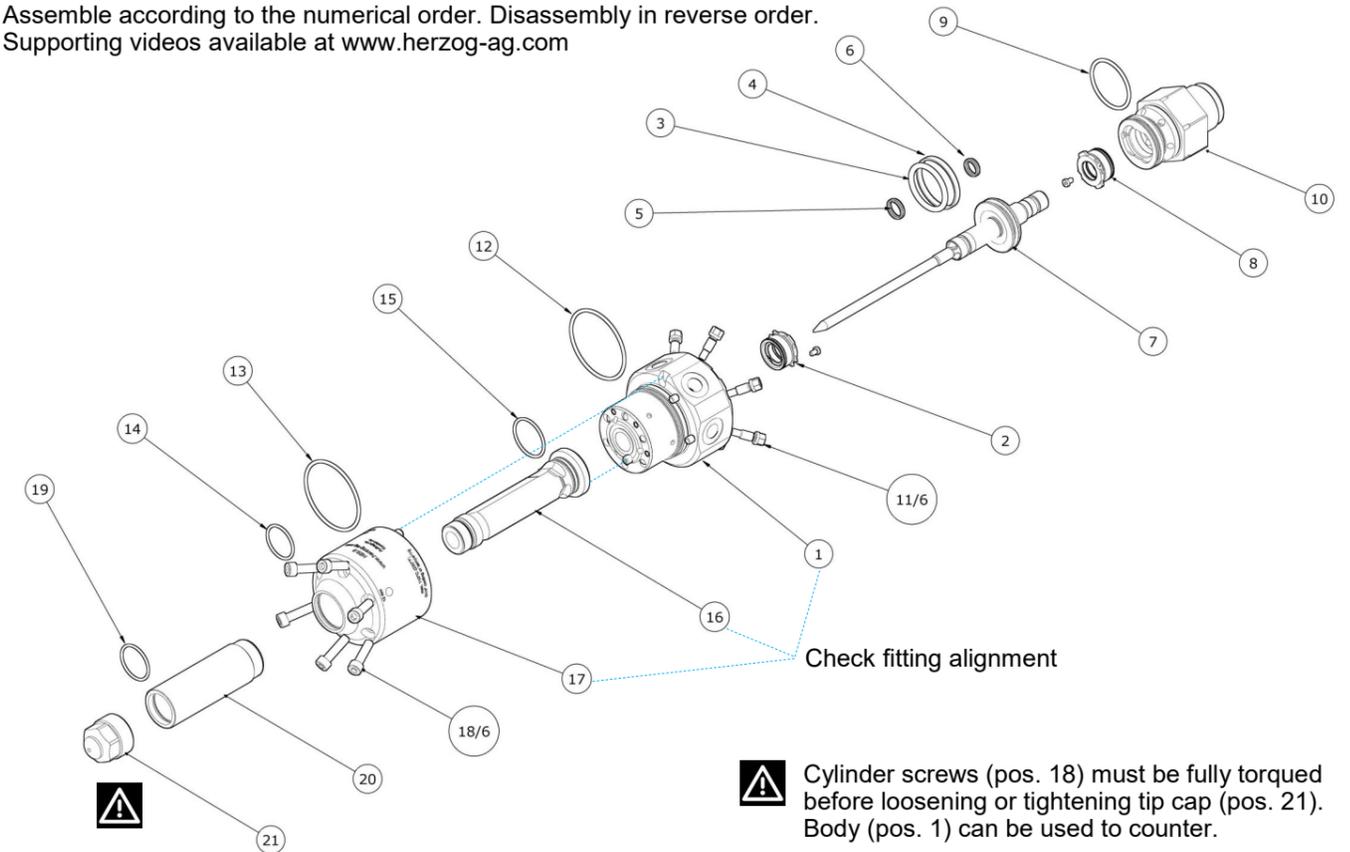
Leakage: Between needle and guide there is a melt film which prevents the needle from blocking. Melt film will be continuously renewed and eventually leaks out of nozzle.

Retightening the screws: After approx. 1000 shots, check all screw torques (see **Assembly**) and retighten when necessary.

Machine downtime: At machine downtimes do not switch off the nozzle tempering system. If a longer period of inactivity is forecast, the nozzle should be completely flushed clean.

Assembly

Assemble according to the numerical order. Disassembly in reverse order.
Supporting videos available at www.herzog-ag.com



Pos.	Description	Tool size (torque)
1	Body	2 x G1/4 for actuator (pneumatic 4-10bar), 2 x G1/4 for tempering (max. 110°C)
2	Seal insert with seals	-
3	Piston o-ring $\varnothing 33$	-
4	Piston seal ring $\varnothing 42$	-
5	Seal ring $\varnothing 13$	-
6	Seal ring $\varnothing 11$	-
7	Needle	-
8	Seal insert with seals	-
9	O-ring $\varnothing 38$	-
10	Adapter	AF50 (torque according to machine handbook)
11	Flange screws	AF8 (tighten crosswise in several passes - 15Nm)
12	O-ring $\varnothing 55$	-
13	O-ring $\varnothing 55$	-
14	O-ring $\varnothing 30$	-
15	O-ring $\varnothing 27$	-
16	Tip base	-
17	Tip flange	-
18	Cylinder screws	AF5 (tighten crosswise in several passes - 12Nm)
19	O-ring $\varnothing 26$	-
20	Cooling cover	-
21	Tip cap	AF27 (120Nm)