

## Installation and Pin Adjustment Guide

### PRE INSTALLATION

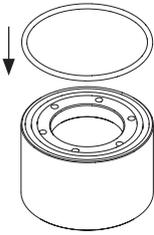
1. Verify the actuator pockets and air circuits are machined in the back plate as shown in figure 5.
2. Ensure there are no sharp edges or burrs in the actuator pockets.
3. Ensure the actuator pocket and air circuits are clean.
4. Cut pins to length and profile end to shut off angle (refer nozzle drawing ex-Mastip)
5. Assemble the fixed half of the mould including hot runner nozzles and manifold excluding backplate.  
→ Refer to the Technical Specifications section of the Technical Guide

### INSTALLATION

ONE

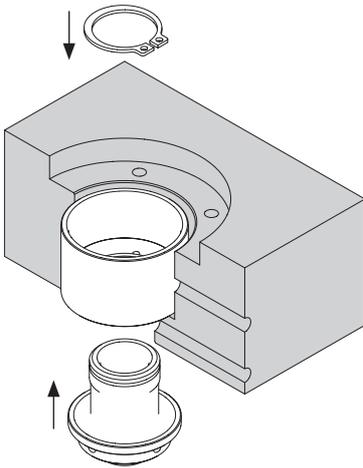
Ensure all components are clean

TWO



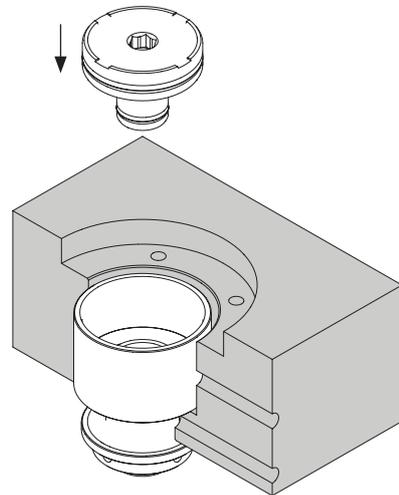
Fit the **Cylinder End Seal** 13 to the **Cylinder** 12  
Apply grease\* to **Cylinder End Seal** 13

THREE



Fit the **Cylinder** 12 and **Location Spacer** 14 to the mould backplate and retain using the **Circlip** 11

FOUR

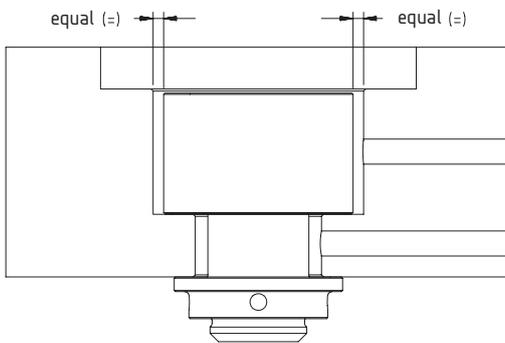
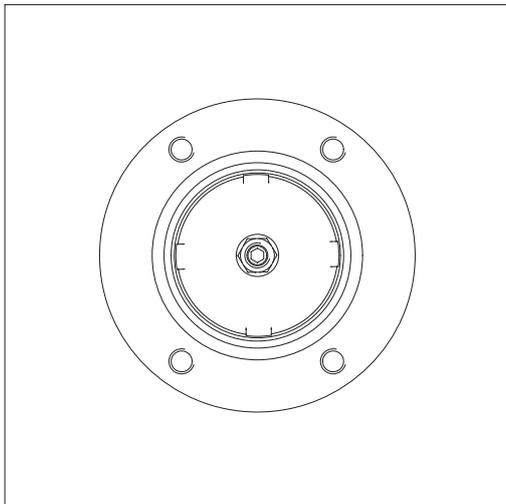


Apply grease\* to the sealing bores of the **Location Spacer** 14 and **Cylinder** 12 and to the pre fitted **Piston Seals** 6 & 10  
Fit **Piston** 9 to the **Cylinder** 12

\* Mastip recommends using high temperature silicon grease

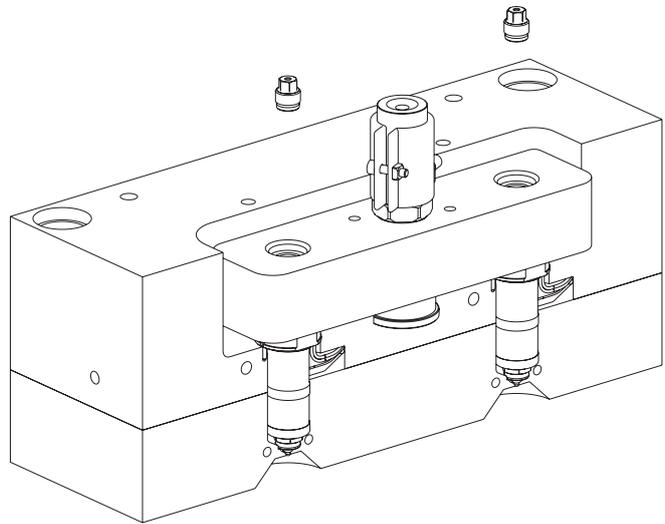
## INSTALLATION CONT.....

FIVE



Centralise **Cylinder Assembly** A  
to the Actuator pocket.

SIX

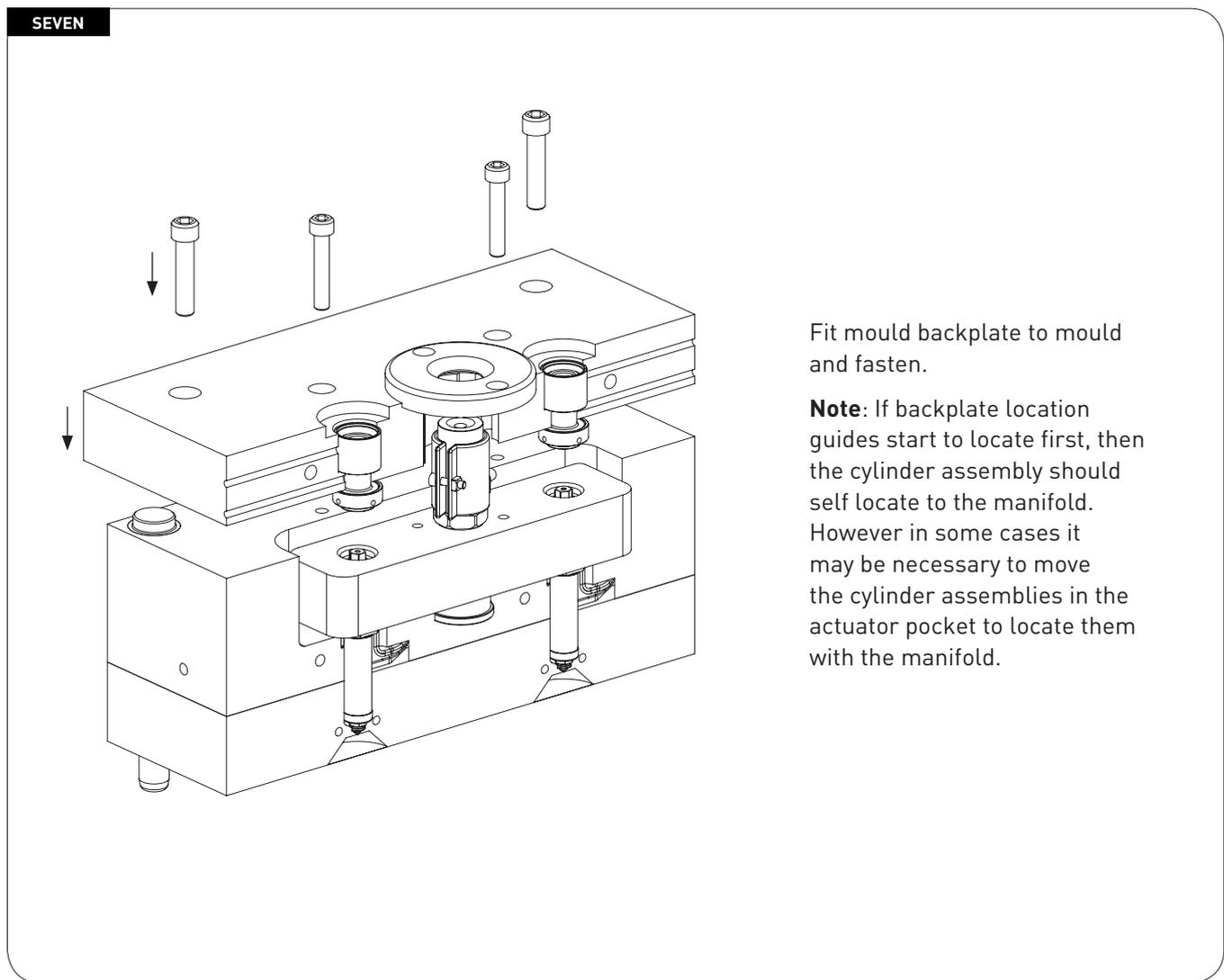


Clean any residue material from the pin seal pocket and thread in the manifold.

Apply heat resistant copper based anti-seize to the thread of the new pin seal and screw into the manifold and tighten to 20Nm.

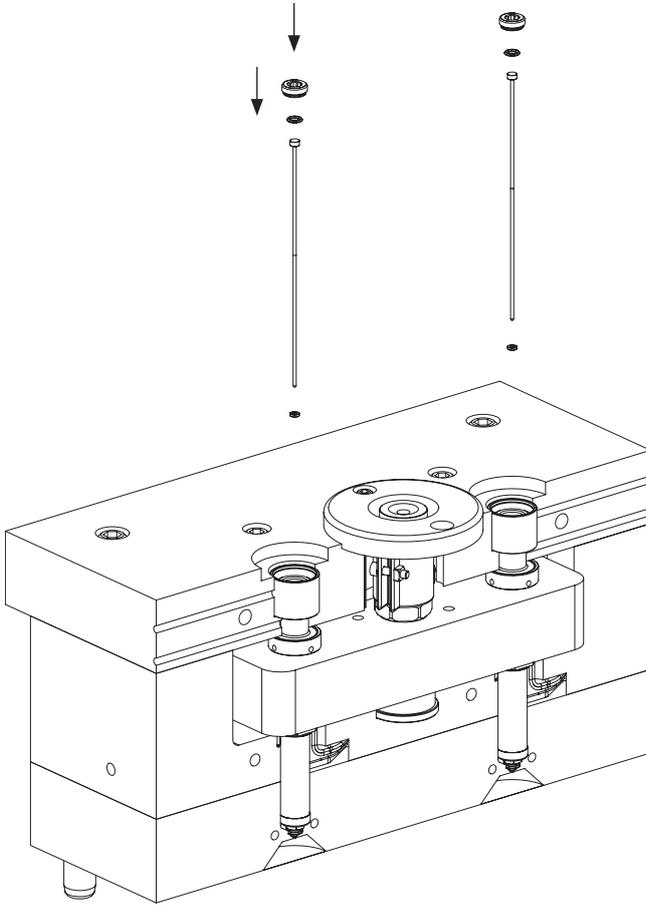
Ensure pins slide smoothly through the pin seal after tightening.

## INSTALLATION CONT.....



## INSTALLATION CONT.....

EIGHT



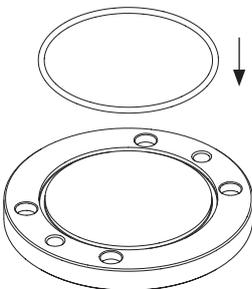
Insert the **Pin Adjustment Spacer** ⑧ into the **Piston** ⑨

Fit the **Valve Pin** ⑤ to **Piston** ⑨

Fit the **Pin Head Seal** ⑦ to the **Valve Pin** ⑤

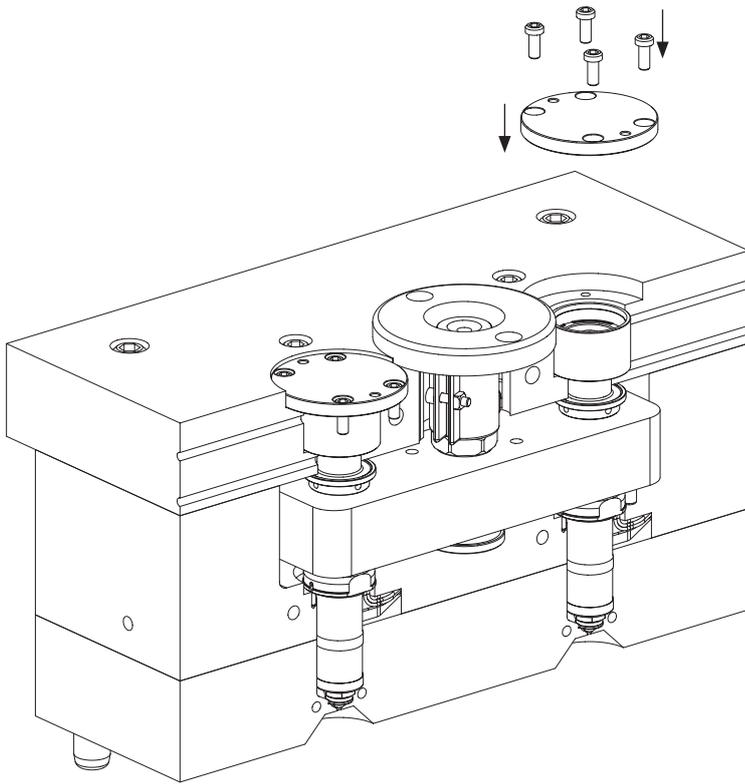
Fit the **Locking Screw** ④ to the **Piston** ⑨

NINE



Fit **Blanking Plate Seal** ③ to **Blanking Plate** ②

TEN



Fit **Blanking Plate 2** to the mould backplate and fasten using **Blanking Plate Screws 1**