

Installation and Pin Adjustment Guide

PRE INSTALLATION

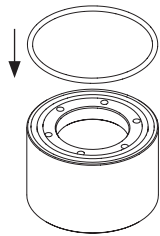
1. Verify the actuator pockets and air circuits are machined in the back plate as shown in figure 5.
2. Ensure there are no sharp edges or burrs in the actuator pockets.
3. Ensure the actuator pocket and air circuits are clean.
4. Cut pins to length and profile end to shut off angle (refer nozzle drawing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

INSTALLATION

ONE

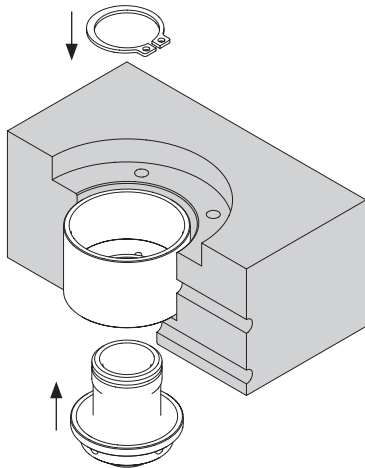
Ensure all components are clean

TWO



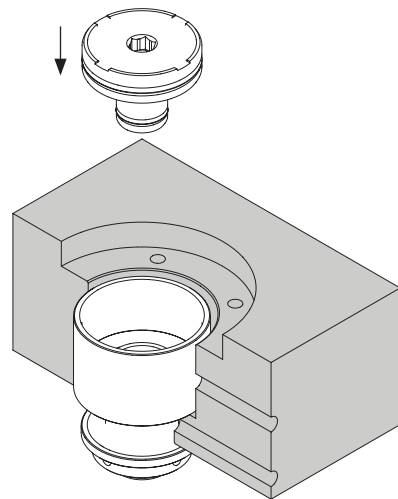
Fit the **Cylinder End Seal 13** to the **Cylinder 12**
Apply grease* to **Cylinder End Seal 13**

THREE



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

FOUR

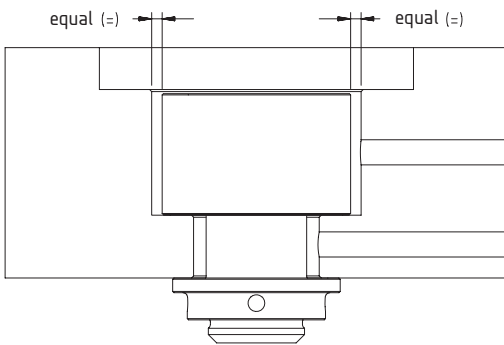
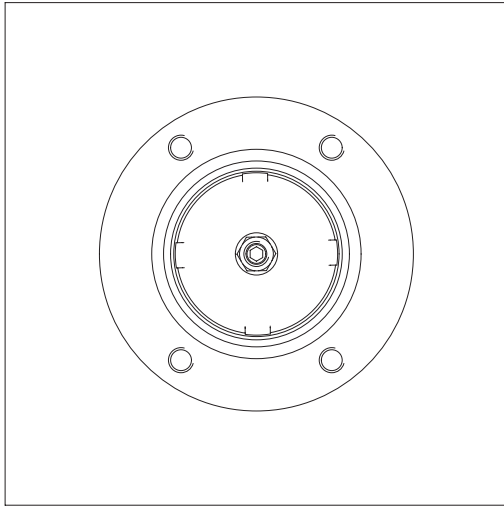


Apply grease* to the sealing bores of the
Location Spacer 14 and **Cylinder 12** and to
the pre fitted **Piston Seals 8 & 10**
Fit **Piston 9** to the **Cylinder 12**

* Mastip recommends using high temperature silicon grease

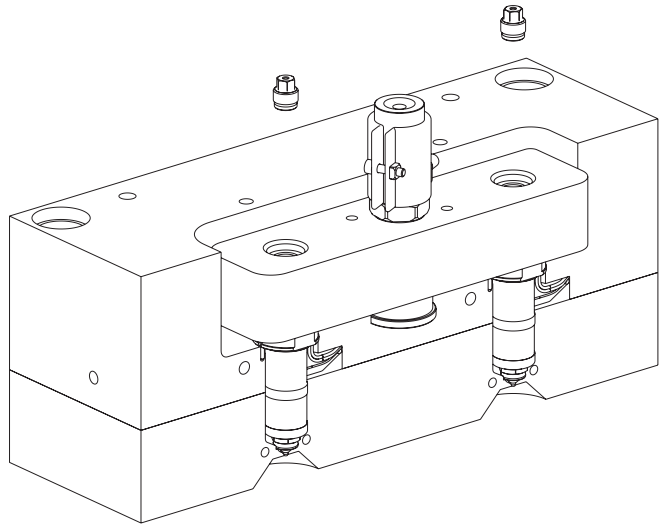
INSTALLATION CONT.....

FIVE



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

SIX

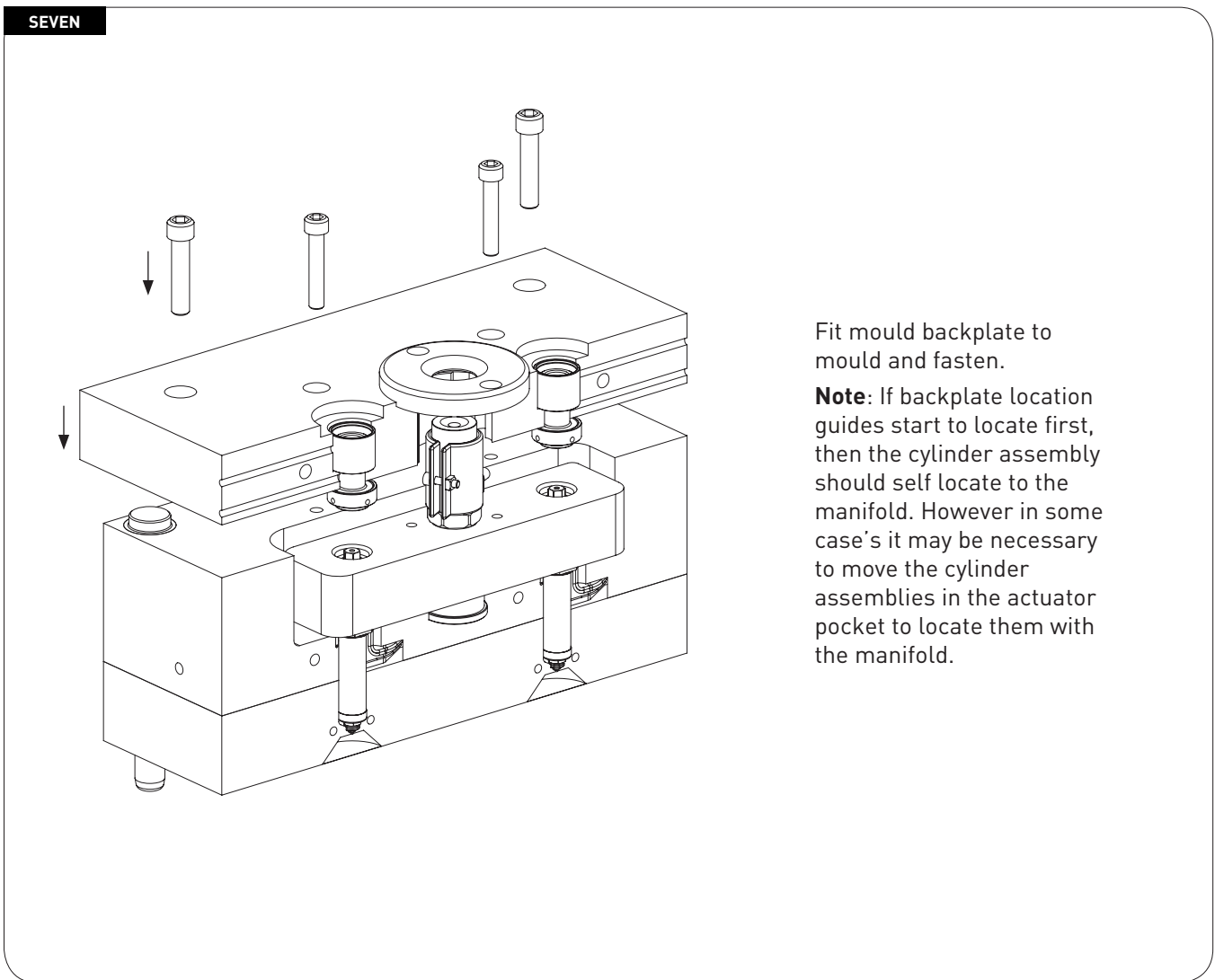


Clean any residue material from the pin seal pocket and thread in the manifold.

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.....

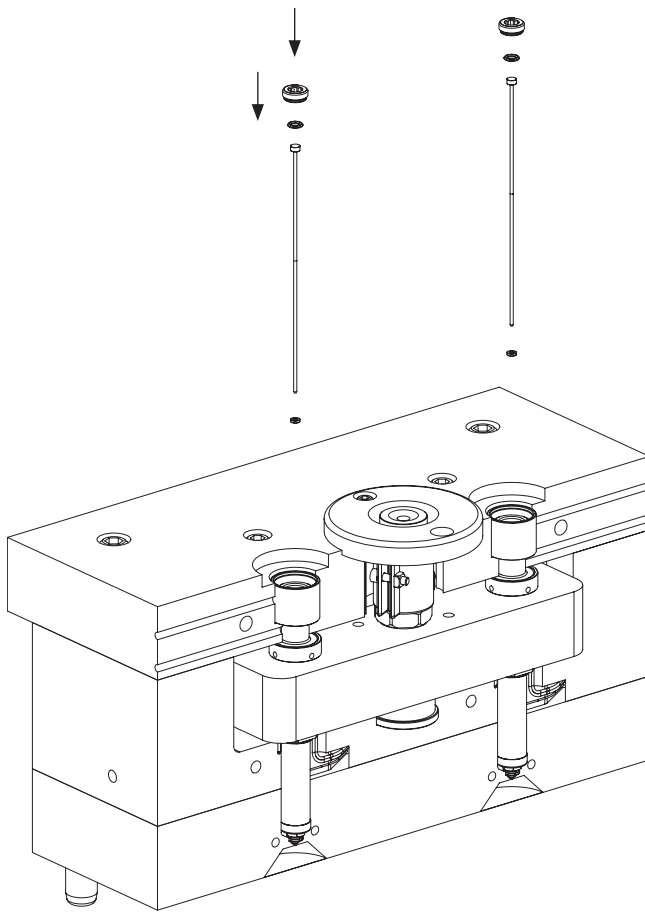


Fit mould backplate to mould and fasten.

Note: If backplate location guides start to locate first, then the cylinder assembly should self locate to the manifold. However in some case's it may be necessary to move the cylinder assemblies in the actuator pocket to locate them with the manifold.

INSTALLATION CONT.....

EIGHT



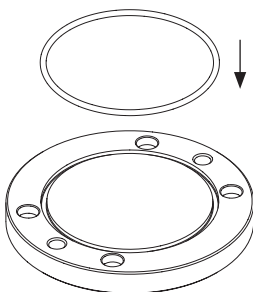
Insert the **Pin Adjustment Spacer** 7 into the **Piston** 9

Fit the **Valve Pin** 6 to **Piston** 9

Fit the **Spring Washer Stack** 5

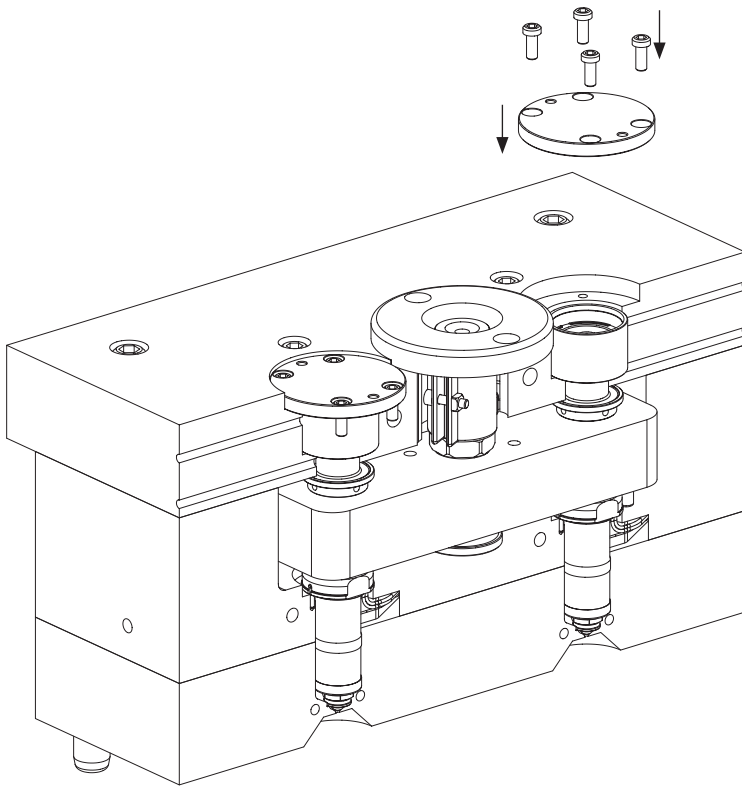
Fit the **Locking Screw** 4 to the **Piston** 9

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