**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.
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 7

NINE

Fit Blanking Plate Seal 3 to Blanking Plate 2
Fit **Blanking Plate 2** to the mould backplate and fasten using **Blanking Plate Screws 1**