Manifold End Plug Replacement
Replacing Manifold End Plugs with an Orientation Guide

ONE

Ensure all runners are clear of plastic and debris

TWO

Ensure the conical sealing faces on the manifold and end plug are not damaged, and are clear of all plastic and debris

THREE

Starting at the end plug nearest the manifold sprue, insert the orientation guide into the runner adjacent to the end plug to be tightened.

Manufacture the orientation guides to suit all size runners required

FOUR
FIVE

Insert the end plug so the runner groove is aligned with the manifold runner.

SIX

Insert and fully tighten the end plug locking screw.
**SEVEN**
Remove the orientation guide.

**EIGHT**
Repeat steps 1-7 for the next runner end plug until the dropper end plugs remain.

**NINE**
To align the remaining dropper end plugs the orientation guide must be inserted through the dropper.
Replacing a Manifold End Plug (with locking screws)

Where the end plug is not able to be reached with an orientation guide, [e.g. a runner between 2 Deviation plugs], the end plug will continue to use an locking screw. See below for replacement instructions.

ONE
Once the tool has cooled down disassemble the fixed of the mould. Do not bow or distort manifold or mould plates.

TWO
Remove the manifold from the mould plates

THREE
Locate and remove the End Plug M4 location grub screws from the top or bottom faces. You may have to remove the heater if screws are located at bottom of heater groove. You may need to reheat the manifold to loosen the screws and plugs.

FOUR
Remove the End Plug locking screw from behind the End Plug. Use a slide hammer attached to the M6 thread in back of End Plug.
**Mastip Head Office New Zealand**
558 Rosebank Road
Avondale 1026, Auckland
PO Box 90-651
Victoria Street West
Auckland 1142
New Zealand
Phone: +64 9 970 2100
Fax: +64 9 970 2070
Email: mastip@mastip.com

**Mastip Regional Office Europe**
Phone: +33 4 724 72 800
Fax: +33 4 724 72 801
Email: europe@mastip.com

**Mastip Regional Office China**
Phone: +86 21 644 77838
Fax: +86 21 644 77828
Email: china@mastip.com

**Mastip Regional Office North America**
Phone: +1 262 644 9400
Fax: +1 262 644 9402
Email: northamerica@mastip.com