

Manifold End Plug Replacement



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Replacing Manifold End Plugs with an Orientation Guide

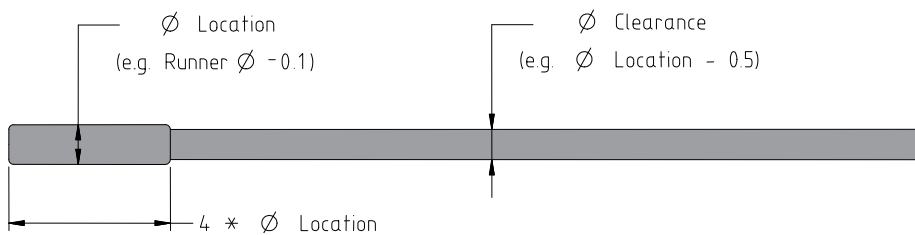
ONE

Ensure all runners are clear of plastic and debris

TWO

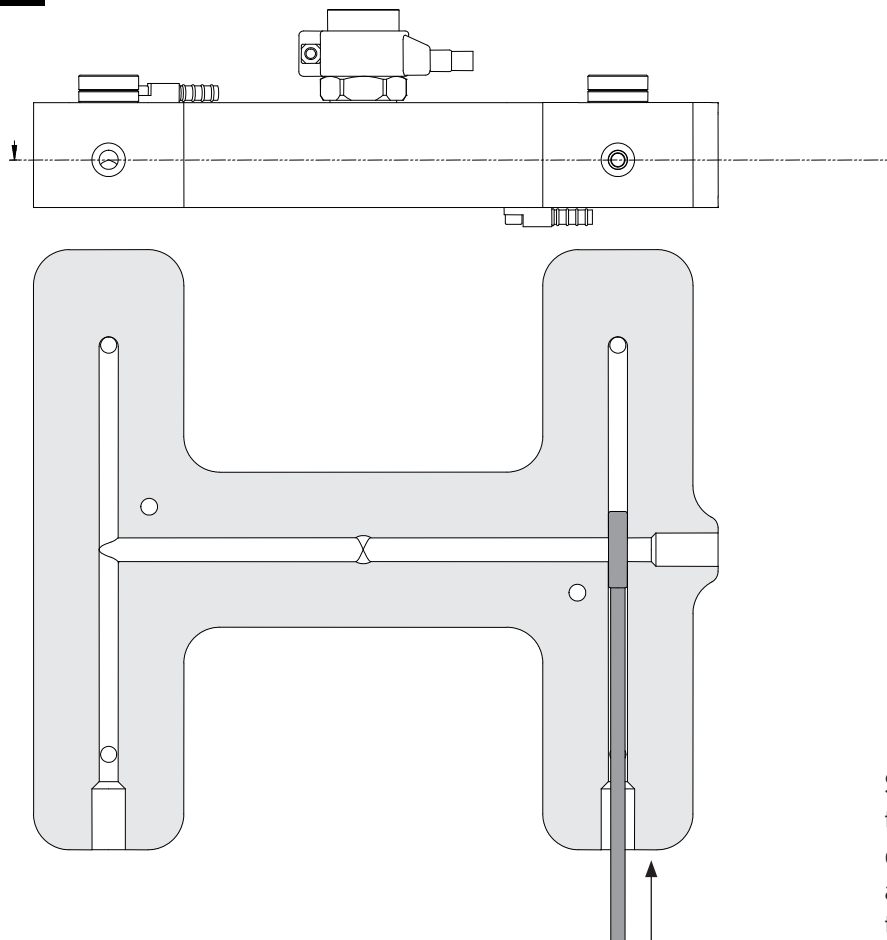
Ensure the conical sealing faces on the manifold and end plug are not damaged, and are clear of all plastic and debris

THREE



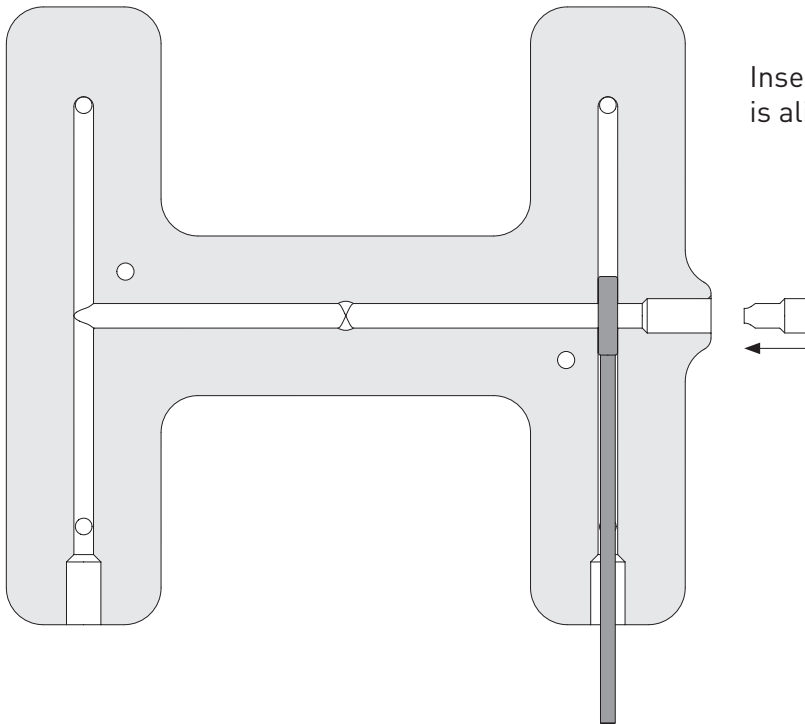
Manufacture the orientation guides to suit all size runners required

FOUR



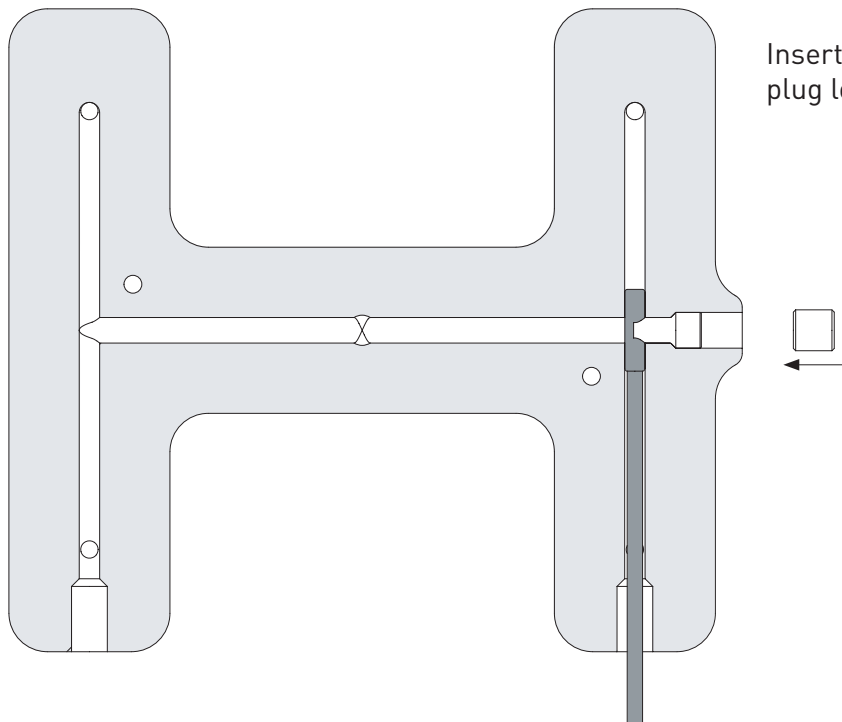
Starting at the end plug nearest the manifold sprue, insert the orientation guide into the runner adjacent to the end plug to be tightened.

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

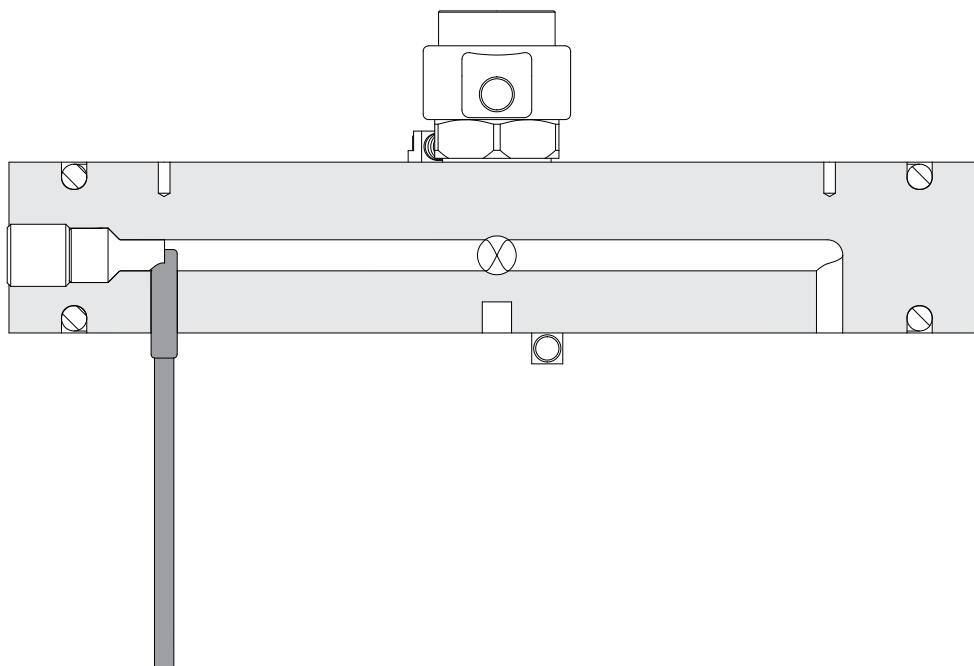
Remove the orientation guide.

EIGHT

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

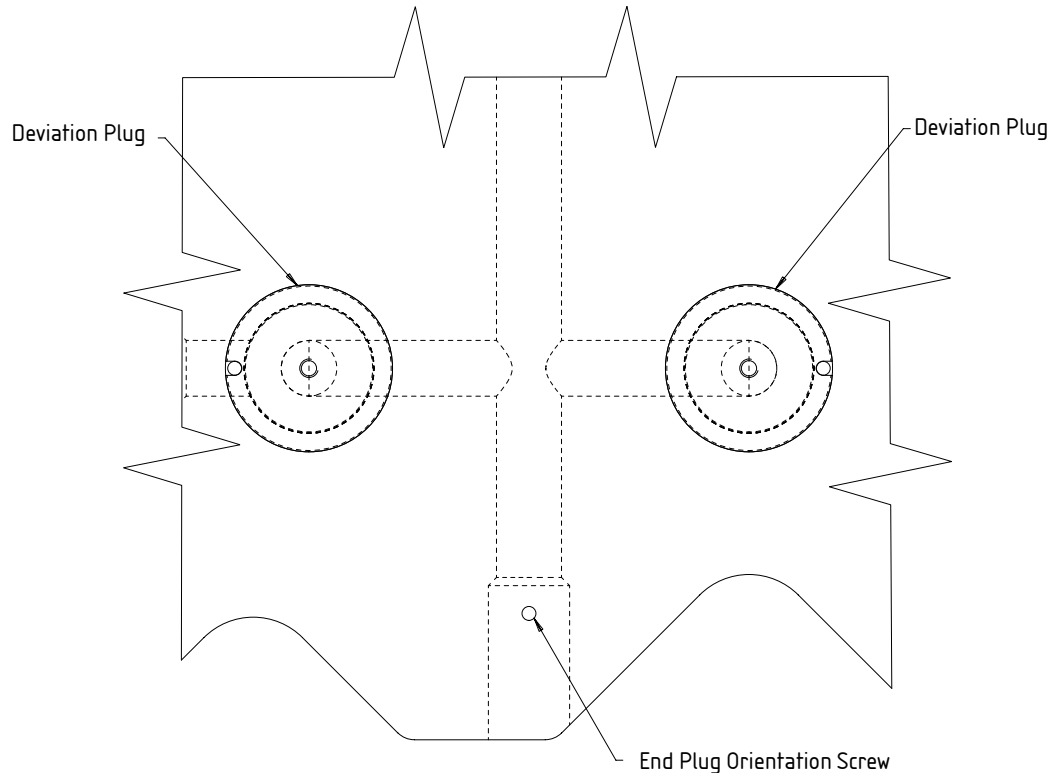
NINE

To align the remaining dropper end plugs the orientaton 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