Replacing the Tip & Seal Assembly

ONE
- a. Remove snap ring
- b. Remove heater cover

TWO
- Remove thermocouple from nozzle

THREE
- Remove heater.
- Using an AF8mm deep socket unscrew tip from body

FOUR
- a. Clean any plastic & debris from the tip pocket in nozzle body.
- b. Smear a small amount of anti-seize around new tip thread.
- c. Screw new tip into the body and torque to 4Nm (3lb ft). **Warning: Do not overtighten.**
- d. Fit the heater, thermocouple, heater cover & snap ring.

Replacing the Thermocouple

ONE
- a. Remove snap ring
- b. Remove heater cover

TWO
- Remove existing thermocouple from the nozzle
Replacing the Heater

ONE

a. Remove heater cover and snap ring.
b. Remove thermocouple.
c. Holding heater at the base slightly twist the top heater coils in a clockwise direction and pull the heater from the nozzle body.
d. Clean any plastic or debris from the nozzle body.
e. Slide the new heater onto the nozzle body, ensuring the top coil of heater reaches the bottom of the tip hex.
f. Fit thermocouple, heater cover and snap ring.

THREE

a. Slide thermocouple probe into thermocouple hole in tip.
b. Holding thermocouple probe secure in the hole, wind thermocouple around tip above heater coil in a clockwise direction to the space between the heater coils. To ensure the probe is held secure the space between the heater coils should be equivalent to 1 full wind of the thermocouple.
c. Wind thermocouple down nozzle between the heater coils, keeping thermocouple tight against the nozzle body.
d. When heater wire exit is reached thread the wires through wire channel with heater wires.

FOUR

Fit heater cover and snap ring.