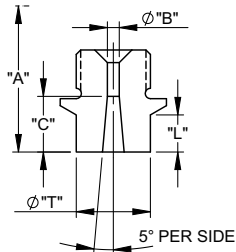


625 SERIES TIP SUB-ASSEMBLIES PACKING SLIP

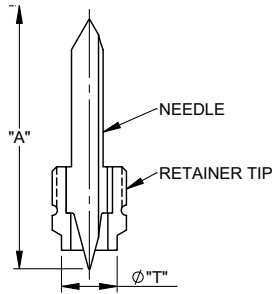
Tip Sub-Assemblies

All 625 Series tips have 1"-16 UN threads



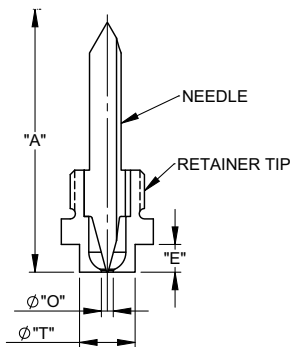
Sprue Gate/Extended Sprue Gate

TIP	ITEM NUMBER	"B" DIA.	"T" DIA.	"L"	"C"
SPRUE GATE	EHT0022	.187	1.000	.250	.500
EXTENDED SPRUE GATE	EHT0023			1.000	1.250



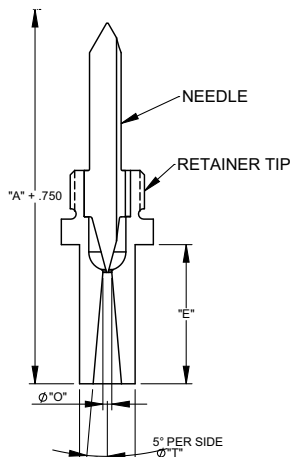
Point Gate (Bodyless)

TYPE	ITEM NUMBER	INCLUDES		"T" DIA.
		NEEDLE	RETAINER TIP	
STANDARD	EHT1306	EHN0019	EHT1354	.625
	EHT1311		EHT0326	
WEAR RESISTANT	EHT1307	EHN0402	EHT0326	
	EHT1310		EHT1354	



Point Gate (Full Body)

TYPE	ITEM NUMBER	"T" DIA.	"O" DIA.	"E"	INCLUDES	
					NEEDLE	RETAINER TIP
STANDARD	EHT2021	1.000	.125	.250	EHN0019	EHT0036
WEAR RESISTANT	EHT2022				EHN0402	EHT1336



Extended Point Gate (Full Body)

TYPE	ITEM NUMBER	"T" DIA.	"O" DIA.	"E"	INCLUDES	
					NEEDLE	RETAINER
STANDARD	EHT2321	1.000	.125	1.000	EHN0019	EHT2336
WEAR RESISTANT	EHT2322				EHN0402	

For selection of gate diameter it is important to take into consideration the materials flow characteristics, shear rate of resin, molding conditions, fill time requirements, gate vestige, wall thickness and configuration of part to be molded. Situations requiring high injection velocities must be considered when selecting small gate diameters. High injection rates may require larger gates due to shear heat build up (e.g. high weight thin wall applications). See material manufactures literature for further information regarding materials to be molded.

To compensate for nozzle's growth when heat is applied, the linear expansion of the nozzle (BE) at a given temperature must be added to the nominal "A" dimension (See catalog for "A" lengths). The formula below shows how to figure boring depth (dimension "A" + BE). The tip of the nozzle will now be flush with the cavity line at processing temperature.

Formula for determining this expansion factor is as follows:

$$BE = "A" \text{ dimension} \times 0.0000063 \times (\text{Nozzle set point temperature} - 68^{\circ}\text{F})$$

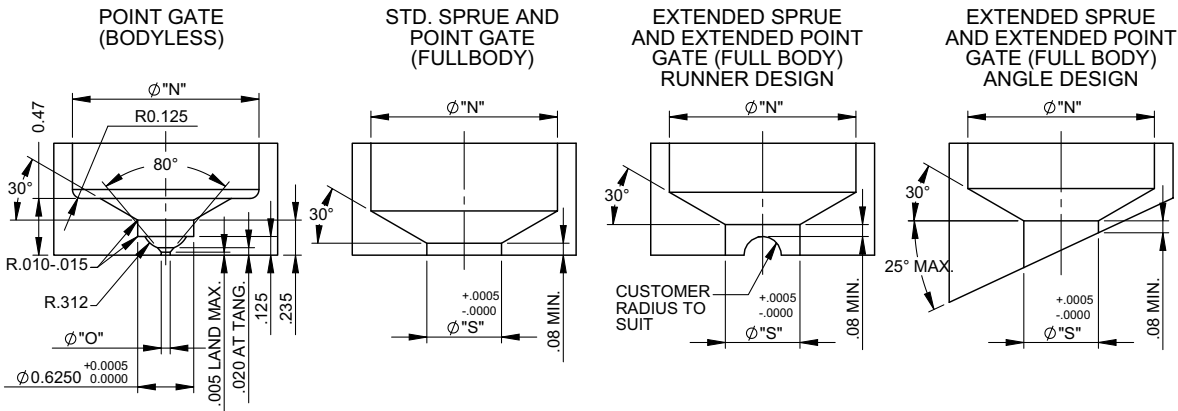
EXAMPLE: Given a 4 inch "A" dimension, with a nozzle set point temperature of 500 °F:

$$BE = 4 \times 0.0000063 \times (500 - 68) = 0.011$$

Thus "A" + BE will be 4.011

Note: the above information is only given as an example, variations may occur based on mold configurations and cooling factor. In some instances it may be necessary to obtain an empirical factor.

625 SERIES GATE MACHINING DIMENSIONS



"O" DIA.		"N" DIA.		"S" DIA.
UNFILLED RESIN	FILLED RESIN	SQUARE COIL HEATER	HIGH PERFORMANCE HEATER	
0.080 MIN.	0.100 MIN.	1.875 MIN.	2.125 MIN.	1.0005

OPERATING & SERVICING INSTRUCTIONS:

All interchangeable nozzles are similar, and differ only in size and material flow capacity.

OPERATING PROCEDURE

The nozzles are supplied with a Square (Flat) Coil or High Performance heater equipped with a Type "J" Thermocouple. It is recommended to use a DME closed loop Temperature Controller for optimum temperature control with Step Smart or Smart Step. These systems will allow heater to dissipate any moisture and then change automatically to set point. It is essential to use controllers with the proper voltage and wattage capabilities. The voltage and wattage of each heater is clearly marked on the heater tag. Step Smart, Smart Step and DME are all registered trademark of DME company.

DISASSEMBLY PROCEDURE

1. Nozzle has been designed to have the tip removed in the press.
2. For removal of tip from nozzle, a 6 point deep well socket is recommended. The nozzle must be at processing temperature and the heater should be turned off when removing tip counter-clockwise from the nozzle.

ASSEMBLY PROCEDURE

1. Tip and nozzle thread area must be clean of any material before reassembling.
2. Apply an anti-seize compound on the tip threads.
3. Torque tip into the shank of the nozzle body. Torque and untorque two or three times making sure there is a good contact between the tip and the nozzle. Torque the tip into the nozzle using 30±5 ft-lbs. For protection of the tip a six point deep well socket is recommended.

IMPORTANT SAFETY INFORMATION

A hot-runner system includes electrical elements and may contain molten plastic at elevated temperature and pressure. To avoid injury, exercise caution by reading these instructions before servicing or operating the system. These instructions must be passed on to the end user where they should be read before using this product. Failure to do so can result in serious injury or death.



DANGER

Failure to comply will result in serious injury or death.

ELECTRICAL HAZARDS

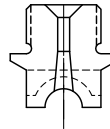
Improper voltages or grounding can result in electrical shock. Use only with proper voltage and a proper earth ground.
To avoid electrical shock, do not operate product when wet.
Do not operate this equipment with covers or panels removed.
To avoid electrical shock, turn off main power disconnect and lockout/tag out before servicing this device. Do not connect temperature sensor to electrical power. It will damage the product and it could cause fire, severe injuries or even death.
If green ground wire present, wire must be connected to the ground.
Do not rebend rigid leads. Rebending leads might result in damage to circuit. Product might absorb moisture when cool. Use Voltage or power to drive out residual moisture before applying full power. Failure to do so may cause damage to this product.



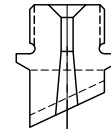
WARNING

Failure to comply can result in serious injury or death.
STORED ENERGY AND HIGH TEMPERATURE HAZARDS
This product maintains molten plastic at high pressure. Use caution when operating and servicing the system.
Physical contact with molten plastic may result in severe burns. Proper protective equipment, including eye protection, must be worn.
This product has heated surfaces. Use caution when operating and servicing the system to avoid severe burns. Proper protective equipment should be worn.

EXTENDED SPRUE AND EXTENDED POINT GATE (FULL BODY) RUNNER DESIGN MACHINING



EXTENDED SPRUE AND EXTENDED POINT GATE (FULL BODY) ANGLE DESIGN MACHINING



Nozzle body head must be keyed to prevent body from turning when tip is installed into body. Customer to torque tip into shank of nozzle body in mold three times to set tip before marking the runner or angle on the tip. This will ensure that the tip will line up after runner or angle is machined onto tip. Customer may machine relief on Extended Sprue Gate Tips for molding heat sensitive or engineering grade materials. Contact DME Technical Service before deciding and machining the possible relief above the seal off diameter area.

DME SHALL NOT BE LIABLE FOR MISUSE OR FAILURE TO FOLLOW THE ENCLOSED INSTRUCTIONS AND SPECIFICATIONS. DME HEREBY TO DISCLAIM ALL IMPLIED WARRANTIES, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE IN NO EVENT SHALL DME BE RESPONSIBLE FOR LOSS OF USE, REVENUE OR PROFIT, OR FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES.

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625 SERIES TIP SUB-ASSEMBLIES
PACKING SLIP



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