

DME Galaxy Hot Runner Nozzles - FREQUENTLY ASKED QUESTONS

Q: I notice some Galaxy thermocouples have different color codes for the thermocouple lead wire insulation. What do the different color code sets mean?

A: Note: The following applies to thermocouples (or heaters with integral thermocouples) sold out of the DME USA Hot Runner Catalog. It does not apply to heaters or thermocouples sold out of the DME Molding Supply Catalog.

DME has taken steps to meet the growing needs of our customers around the world. One of these steps has been to progress to an "International" thermocouple color code per IEC 584-3 (Black = positive, White = Negative):








Up to the recent past, most DME thermocouples (or heaters that have integral thermocouples) have had a color code based on the ASTM E230 standard, in which the positive thermocouple wire lead (magnetic) has a white color insulation, and the negative thermocouple lead has a red color insulation. This is traditionally common in North America:



Please note that some products will continue to have the ASTM E230 standard color code (White=positive, Red = negative).

Both color codes shown above are correct. It will be important to ensure proper wire up of the thermocouple. If the thermocouple is wired up backwards (polarity of the thermocouple is reversed), the thermocouple will fail to give the temperature controller a correctly interpretable signal. For clarity, the following color code chart may be used:

J TYPE THERMOCOUPLE STANDARDS			
	STANDARD	+ LEAD (MAGNETIC)	- LEAD
INTERNATIONAL	IEC 584-3	Black	White
	ASTM E230	White	Red
	BS 1843	Yellow	Blue
	DIN 43710	Red	Blue
	JIS C 1610-1981	Red	White
	NFC 42-324	Yellow	Black

Q: I would like some information on servicing or installing my Galaxy hot runner system. Where can I find that information?

A: At this time, general installation information for Galaxy nozzles is not available, since Galaxy nozzle assemblies are not sold out of the DME Catalog. If you need to replace a worn Galaxy nozzle component and do not have the original prints and specifications provided from DME with the Galaxy hot runner system delivery, please contact your DME Customer Service Representative for assistance.

Q: I would like to perform frequent color changes. What do I need with system order?

A: Gate shell insulators are available for Galaxy nozzle assemblies. Usually a DME Technical Representative will recommend the use of gate shell insulators when it is appropriate to use gate shell insulators. For assistance or if you have questions, please contact your DME Customer Service Representative.

Q: I am interested in a Galaxy Hot Runner Package System from DME, but I want to process glass-filled thermoplastic. Can I do this?

A: It is acceptable to process certain glass-filled materials (i.e. certain grades of glass-filled Polypropylene) provided wear-resistant tips are used. For information on whether or not a specific grade of filled plastic can be processed using a Galaxy Hot Runner system, please contact your DME Customer Service Representative, who will put you in contact with a DME Hot Runner Technical Service Representative to review your application requirements.

Q: Can I process plastic at 600°F using a Galaxy Hot Runner system?

A: If you are using standard Galaxy tips, you cannot process plastic at a melt temperature that exceeds 480°F. For temperatures higher than 480°F (249°C), you would require a wear-resistant Galaxy tip. Galaxy wear-resistant tips cannot be used with processing temperatures that exceed 635°F (335°C) however each Galaxy system needs to be reviewed prior to quoting by a DME Hot Runner Technical Service Representative, as it may not be recommended to use a Galaxy Hot Runner system for a specific application that processes at 600°F (316°C).

For additional information regarding DME Galaxy Hot Runner Systems, please contact your regional DME sales representative. In the USA or Canada only, please contact DME Hot Runner Technical Service at FieldTechs@DME.Milacron.com or call 800-626-6653 (U.S.) or 800-387-6000 (Canada).