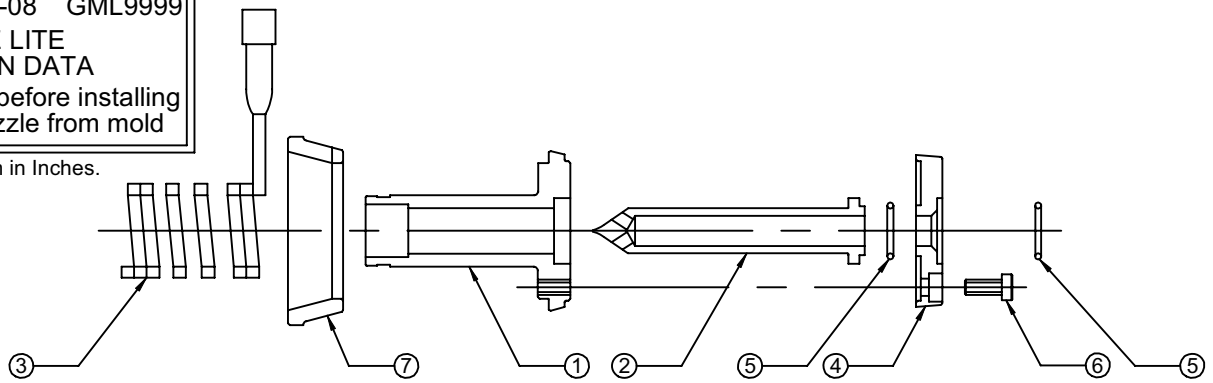


ME-G51-0036-D 09-08 GML9999

**GATE MATE LITE
INSTALLATION DATA**

Please read carefully before installing
and/or removing nozzle from mold

NOTE: Dimensions are shown in Inches.



DESCRIPTION

NOZZLE ASSEMBLY	DETAIL #1 BODY	DETAIL #2 TIP	DETAIL#3		DETAIL#4 RETAINER	DETAIL #5 SEAL RING	DETAIL #6 S.H.C.S.	DETAIL #7 SLEEVE
			HEATER	WATTAGE				
GML1042	GMC0162	GMT0015	GMH1940	325	GMR0052	EHR7155 Qty 2 Required	M410LH Qty 3 Required	GMS0163
GML1052	GMC0162	GMT0015	GMH1940	325				GMS0162
GML1060	GMC0163	GMT0017	GMH1950	375				GMS0163
GML1070	GMC0163	GMT0017	GMH1950	375				GMS0162
GML1080	GMC0164	GMT0019	GMH1960	400				GMS0163
GML1090	GMC0164	GMT0019	GMH1960	400				GMS0162
GML1100	GMC0165	GMT0021	GMH1970	450				GMS0163
GML1110	GMC0165	GMT0021	GMH1970	450				GMS0162
GML1120	GMC0166	GMT0023	GMH1980	500				GMS0163
GML1130	GMC0166	GMT0023	GMH1980	500	GMS0162			

CAUTIONS:

- 1) SAFETY GLASSES MUST BE WORN FOR EYE PROTECTION.
- 2) INSULATED GLOVES MUST BE WORN TO PREVENT BURNS.

NOTES:

- 1) All items are available separately for replacement purposes.
- 2) Heater is 240 VAC, with "J" type thermocouple, 965mm leads, 863mm fiberglass lead protection.
- 3) Seal Rings are sold in a package (quantity of 4 per package).

Tip Removal Procedures:

- 1) Remove screws from nozzle body.
- 2) Heat nozzle to 210°C (410°F).
- 3) Unplug heater from controller.
- 4) While hot, remove plastic from front of tip, then use an Aluminum rod (as shown in figure 1), tap end of rod to press tip out of back end of nozzle body.
- 5) Remove both seal rings and clean any plastic out of seal ring counter bores.

Heater Removal Procedures:

- 1) Unplug heater from controller.
- 2) With nozzle body at room temperature, use wrench and turn clockwise to loosen heater from nozzle body and then slide heater off of nozzle body. Use wrench item # WR112.

Assembly Procedures:

BE CAREFUL NOT TO DAMAGE TIP WHEN ASSEMBLING COMPONENTS:

- 1) Carefully insert tip into nozzle body until shoulder bottoms into counter bore.
- 2) Make sure that seal ring counter bore is clean, then install seal ring into tip.
- 3) Install retainer by aligning screw holes and torque screws to 3.7Nm (33 in.lbs).
- 4) Install sleeve on nozzle body.
- 5) Install heater on nozzle body with wrench.
- 6) Make sure that seal ring counter bore in retainer is clean, then install seal ring into retainer.

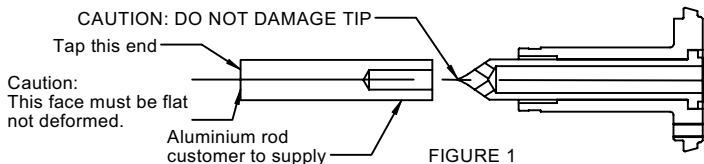


FIGURE 1

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.



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 sensors to electrical power. It will damage the product and it can 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 low Voltage or power to drive out residual moisture before applying full power. Failure to do so may cause damage to this product.



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.

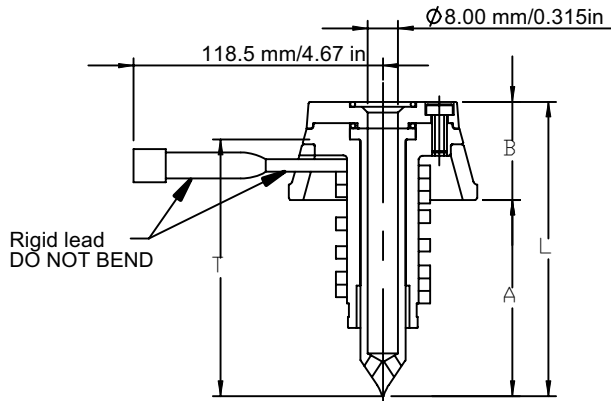
Physical contact with molten plastic may result in severe burns. Proper protective equipment, including eye protection, must be worn. This product has heated surfaces. Use caution when operating and servicing the system to avoid severe burns. Proper protective equipment should be worn.

D-M-E SHALL NOT BE LIABLE FOR MISUSE OR FAILURE TO FOLLOW THE ENCLOSED INSTRUCTIONS AND SPECIFICATIONS. D-M-E HERBY TO DISCLAIMS ALL IMPLIED WARRANTIES, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. IN NO EVENT SHALL D-M-E BE RESPONSIBLE FOR LOSS OF USE, REVENUE OR PROFIT, OR FOR INCIDENTAL OR CONSEQUENTIAL DAMAGED.

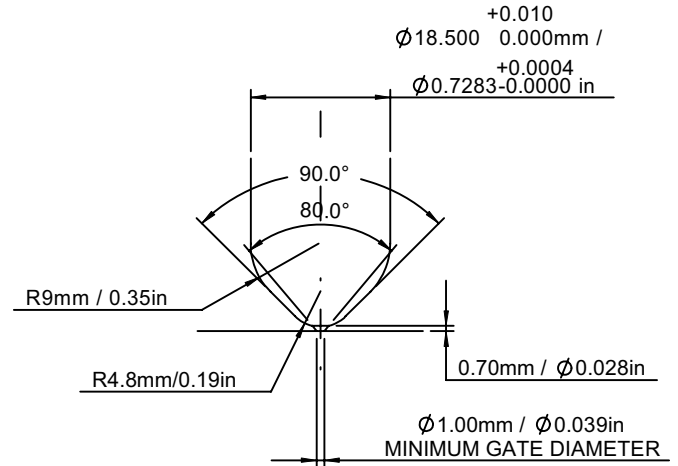
**GATE MATE LITE
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Gate Mate Lite Point Gate Nozzle Assembly



Gate Detail Machining Dimensions

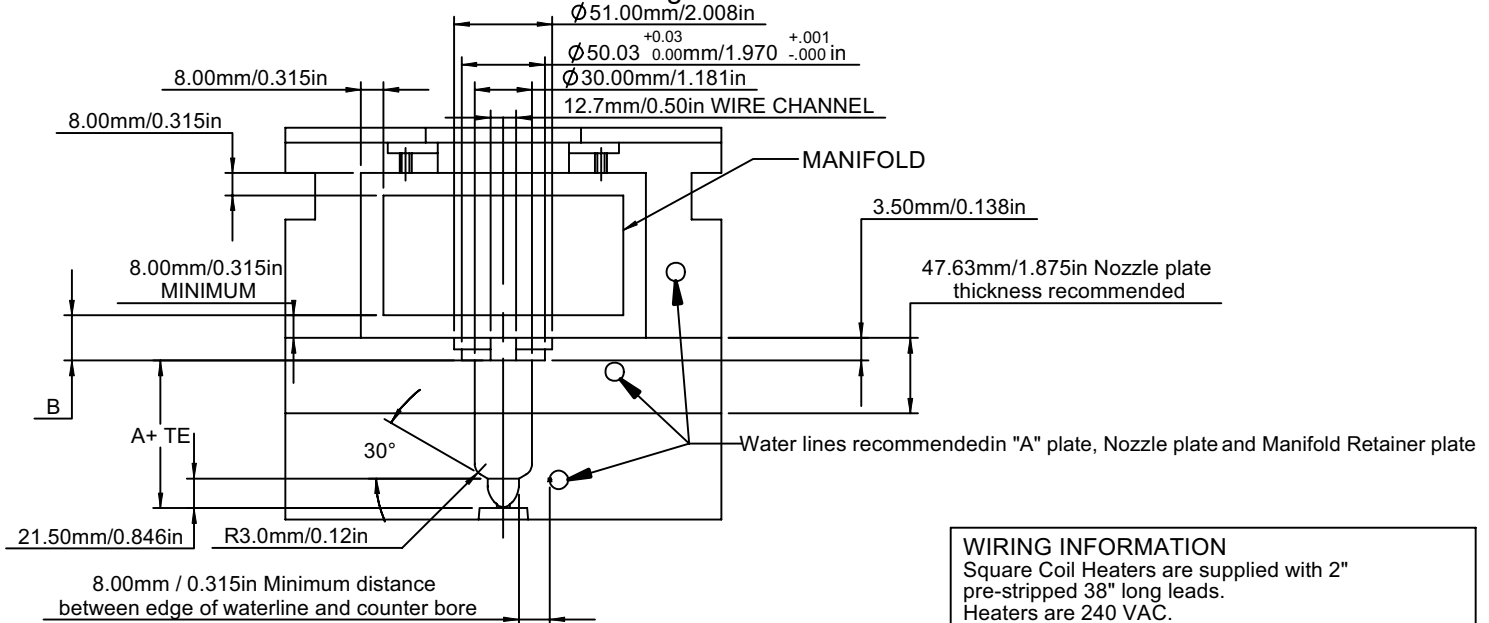


NOTE: The expansion factor must be taken into consideration prior to machining and installing nozzle. This factor (TE) must be added to the nominal "A" dimension. Formula for determining this expansion is as follows:

TE= "T" dimension X 0.0000175mm X (Nozzle setpoint Temperature{°C}-20) or
"T" dimension X 0.0000097in X (Nozzle setpoint Temperature {°F} -68)

EXAMPLE for GML1070: "A" =70.00mm, "T"= 86.00, Setpoint = 260°C:
TE = 86.00 X 0.0000175 X (260-20) = 0.36 . . . thus "A" (70.00) + TE (0.36) = 70.36

Nozzle Plate and "A" Plate Machining Dimensions



For ancillary hot runner components and temperature controls, contact DME.

WIRING INFORMATION

Square Coil Heaters are supplied with 2" pre-stripped 38" long leads.
Heaters are 240 VAC.
120 VAC are available per request.
2 power leads are MULTI COLOR
1 ground lead is GREEN.
Thermocouples are "J" Type.
1 T/C lead is WHITE and negative (-) constantan (non-magnetic).
1 T/C lead is BLACK and positive (+) iron (magnetic).

NOZZLE ASSEMBLY	"A" DIM		"T" DIM		"L" DIM		"B" DIM	
	mm	in	mm	in	mm	in	mm	in
GML1042	42.00	1.654	68.00	2.677	78.00	3.071	36.00	1.417
GML1052	52.00	2.047	68.00	2.677	78.00	3.071	26.00	1.024
GML1060	60.00	2.362	86.00	3.386	96.00	3.780	36.00	1.417
GML1070	70.00	2.756	86.00	3.386	96.00	3.780	26.00	1.024
GML1080	80.00	3.150	106.00	4.173	116.00	4.567	36.00	1.417
GML1090	90.00	3.543	106.00	4.173	116.00	4.567	26.00	1.024
GML1100	100.00	3.937	126.00	4.961	136.00	5.354	36.00	1.417
GML1110	110.00	4.331	126.00	4.961	136.00	5.354	26.00	1.024
GML1120	120.00	4.724	146.00	5.748	156.00	6.142	36.00	1.417
GML1130	130.00	5.118	146.00	5.748	156.00	6.142	26.00	1.024

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