

**INSTALLATION DATA FOR STELLAR WITH STANDARD HEATER**

- a) SXF5000 or SXF5100 retainer used with SXT4010, SXT5010 or SXT5200 TIPS
  - b) SXT1040 - Sprue Tip
- Please read carefully before installing and/or removing nozzle from mold

**HEATER AND THERMOCOUPLE REPLACEMENT INSTRUCTIONS**

1. STELLAR nozzle sub-assembly with tip sub-assembly. (see Fig. #1) Threaded style nozzle with point gate tip shown.
2. Safety glasses and gloves should be worn when working on mold.
3. Turn off heater and disconnect heater and thermocouple leads from connectors on mold.
4. Remove retainer and tip. See Instructions on the next page. If need it, clean plastic from around the tip and retainer.(see Fig #2). For configurations with snap ring, remove snap ring with retaining ring pliers. (Fig #3)
5. Remove heater with thermocouple from nozzle body. (see Fig #4)
6. Remove thermocouple from heater end cap groove. (see Fig #5)
7. Place new thermocouple into heater end cap groove with lead coming out the slot. Use 8mm (5/16") point diameter drift punch by hand to spread the thermocouple into the heater end cap groove. This will allow the heater with thermocouple to slide onto nozzle body. (see Fig #6)  
Caution: DO NOT USE A HAMMER TO TAP ON THE PUNCH.
8. Bend thermocouple leads 90° along the length of the heater. Measure heater/thermocouple leads "X" (see Fig #4) from the heater/thermocouple that was removed, and bend leads to the correct "X" length (see Fig #7) at 90° angle to the heater.  
Caution: REPEATED BENDING OF HEATER AND THERMOCOUPLE LEADS CAN FRACTURE LEAD WIRES. TRY TO BEND ONLY ONCE, IF POSSIBLE.
9. Slide heater with thermocouple over nozzle body. (see Fig #4)
10. Place the tip in the retainer and thread retainer into the nozzle body and torque to 13.9 Nm.
11. Wire heater and thermocouple leads to connectors on mold.

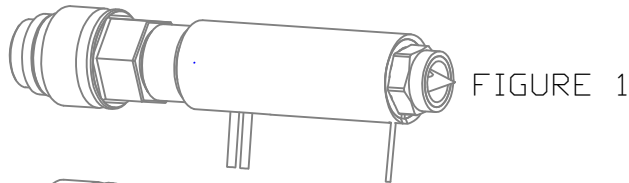


FIGURE 1

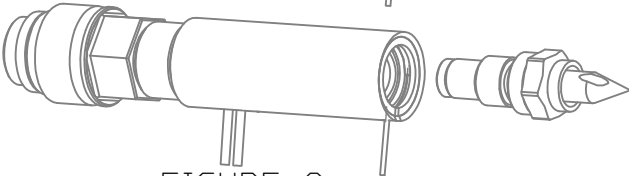


FIGURE 2

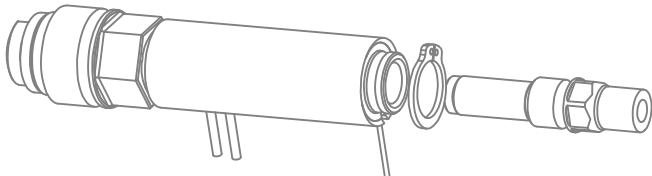


FIGURE 3

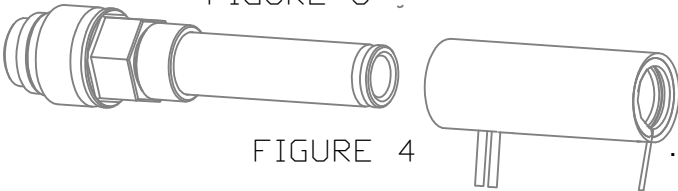


FIGURE 4

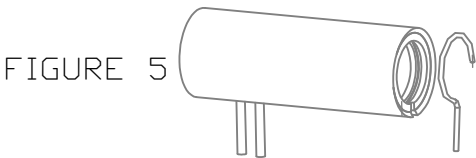


FIGURE 5



FIGURE 6

NOTE: DRIFT PUNCH NOT SUPPLIED BY D-M-E.

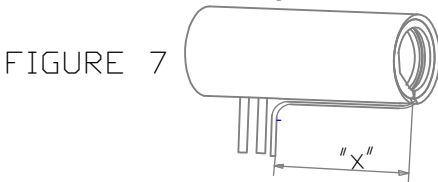


FIGURE 7

**NOZZLE BODY (THREADED STYLE) REMOVAL INSTRUCTIONS**

1. Steps #1 thru #5 of Instructions for "Heater and Thermocouple Replacement Instructions" must be taken before nozzle can be removed from manifold.
2. Remove nut counterclockwise with socket tool D-M-E cat. no. SXW0002 (see Fig. #8).
3. Remove nozzle body from manifold.
4. Clean plastic material from thread and counterbore areas in manifold to ensure proper assembly.
5. Apply high temperature anti-seize compound to nut threads to prevent galling or seizing. Use Fel-Pro C5A or equivalent anti-seize compound.
6. Place nozzle body into manifold and thread nut clockwise into the manifold and torque to 81Nm (60 ft-lbs) using nut socket tool.
7. Follow steps #9 thru #11 of "Heater and Thermocouple Replacement Instructions".
8. Reassemble manifold into the mold.

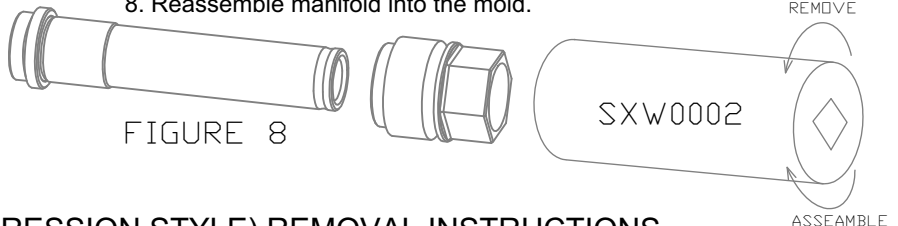


FIGURE 8

**NOZZLE BODY (COMPRESSION STYLE) REMOVAL INSTRUCTIONS**

1. Steps #1 thru #5 of Instructions for "Heater and Thermocouple Replacement Instructions" must be taken before nozzle can be removed from manifold.
2. Carefully remove manifold from mold base.
3. Remove nozzle body from manifold.
4. Remove nozzle head from nozzle body (see Fig. #8 & Fig. #9).
5. Carefully clean area where nozzle body and manifold seat together.
6. Follow steps #5 thru #11 of "Heater and Thermocouple Replacement Instructions".
7. Reassemble manifold into the mold.
8. Assemble nozzle head and nozzle into nozzle plate.

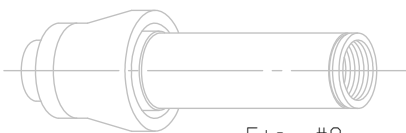


Fig. #8

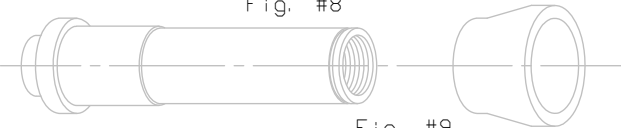


Fig. #9

**INSTALLATION DATA FOR STELLAR WITH STANDARD HEATER**

- a) SXF5000 or SXF5100 retainer used with SXT4010, SXT5010 or SXT5200 TIPS
- b) SXT1040 - Sprue Tip

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**TIP AND RETAINER REMOVAL INSTRUCTIONS**

NOTE: TIP SOCKET TOOL SXW0003 SHOULD BE ORDERED SEPARATELY.

FOR NOZZLE BODY P/N'S:  
 SXB4048, SXB4068, SXB4088, SXB4108,  
 SXB4128 & SXB4148

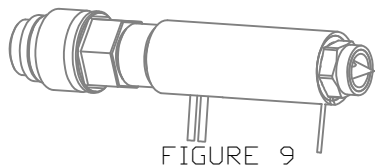


FIGURE 9

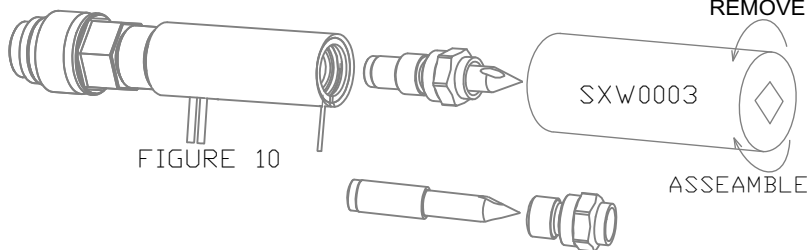


FIGURE 11

1. STELLAR nozzle sub-assembly with tip sub-assembly. (see Fig. #9) Threaded style nozzle and point gate tip shown.
2. Safety glasses and gloves should be worn when working on the mold.
3. Turn nozzle heater on, and set at 10-38°C (50-100°F) below set point of processing temperature to allow for easier tip removal.
4. Notes #5 thru #11 are for point gate and thru hole gate tips only. See notes #13 thru #17 for sprue gate tip instructions.
5. Carefully clean plastic material from around tip and retainer.
6. Remove retainer with DME tip socket tool Cat. # SXW0003 turning counterclockwise. (see Fig #10)
7. Carefully separate retainer from tip. (see Fig #10) Inspect for wear.
8. Clean plastic material from nozzle, tip and retainer threads. Also, clean plastic material from tip counterbore in nozzle body to ensure proper assembly.
9. Turn off nozzle heater and allow to cool down.
10. Replace retainer and tip into the nozzle body.
11. DO NOT LUBRICATE OR USE ANTI-SEIZE ON THREADS.
12. Thread retainer clockwise into the nozzle body and torque to 13.9N.m (10.4 ft-lbs/125in-lbs) using DME tip socket tool and torque wrench.

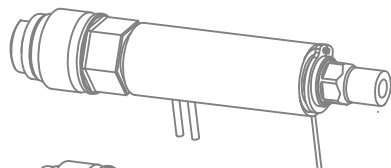


FIGURE 12

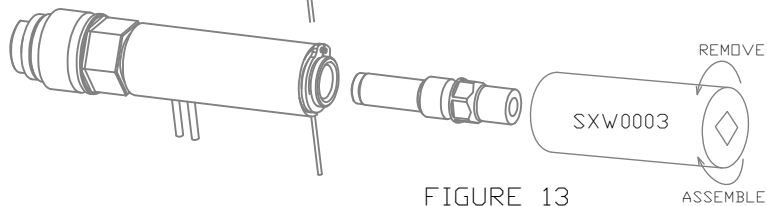


FIGURE 13

13. Remove sprue gate tip with an 8mm deep well socket turning counterclockwise. (see Fig #13) DO NOT DAMAGE 7mm DIAMETER SEAL-OFF AREA OR FRONT MOLDING SURFACE.
14. Clean plastic material from nozzle and tip threads. Also, clean plastic material from tip counterbore in nozzle body to ensure proper assembly.
15. Turn off nozzle heater and allow to cool down.
16. DO NOT LUBRICATE OR USE ANTI-SEIZE ON THREADS.
17. Thread tip clockwise into the nozzle body and torque to 16N.m (12ft-lbs/144in-lbs) using an 8mm deep well socket and torque wrench. (see Fig #13)

**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 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.



**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.

**WIRING INFORMATION**

Standard Coil heater are supplied with 2" pre-stripped 50" long leads. Heaters are 240 VAC.

2 power leads are MULTI COLOR Thermocouples are "J" Type.

Thermocouples are supplied with 36" long leads. 1 T/C lead is WHITE and negative (-) constantan (non-magnetic).

1 T/C lead is BLACK and positive (+) iron (magnetic).

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29111 STEPHENSON HIGHWAY  
 MADISON HEIGHTS  
 MICHIGAN 48071 USA  
 US 800-656-6656  
 CANADA 800-387-6600  
 www.dme.net