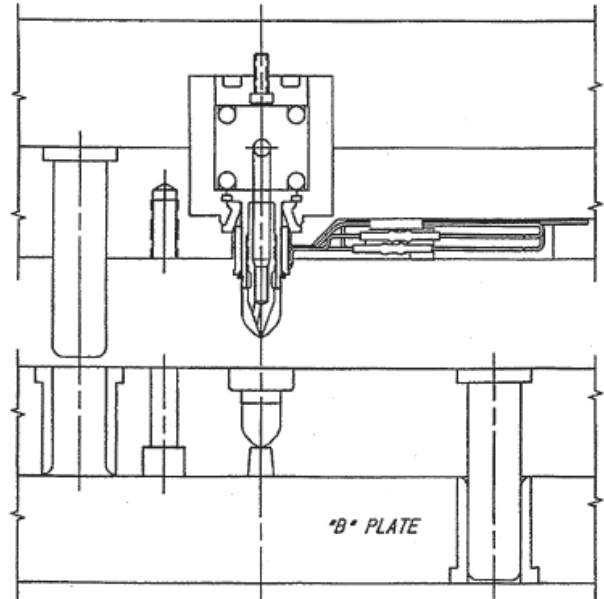
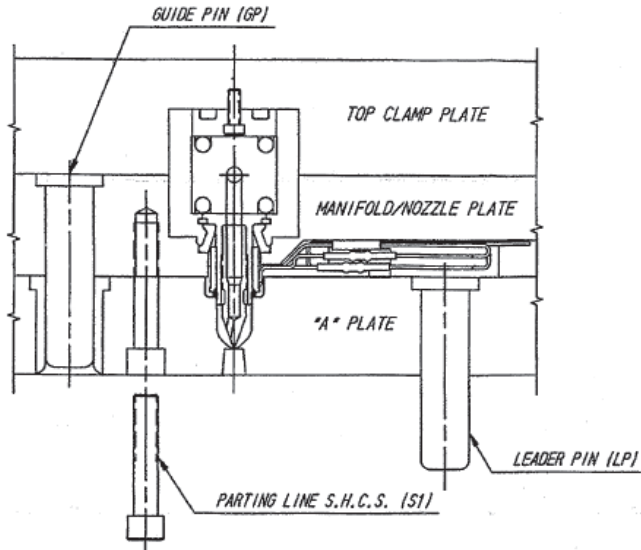




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Galaxy Nozzle Heater & Thermocouple Replacement Instructions



Step 1

- Turn off power to manifold(s) and nozzle(s).
- Retract injection unit to disengage machine nozzle contact with mold.
- Open mold.

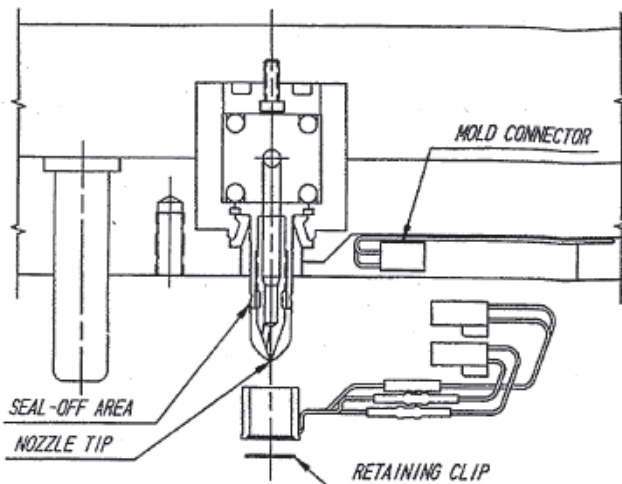
WARNING

All mold plates may retain high heat that could cause burns without proper protection.

- Remove all parting line S.H.C.S. that attach the "A" plate to the manifold/nozzle plate.

Step 2

- Deactivate ejection mechanism.
- Close mold slowly.
- Latch "A" plate to movable side.
- Slowly open mold separating "A" plate from manifold/nozzle plate.



Note:

Be careful not to damage nozzle tip and seal off area when removing or replacing nozzle components.

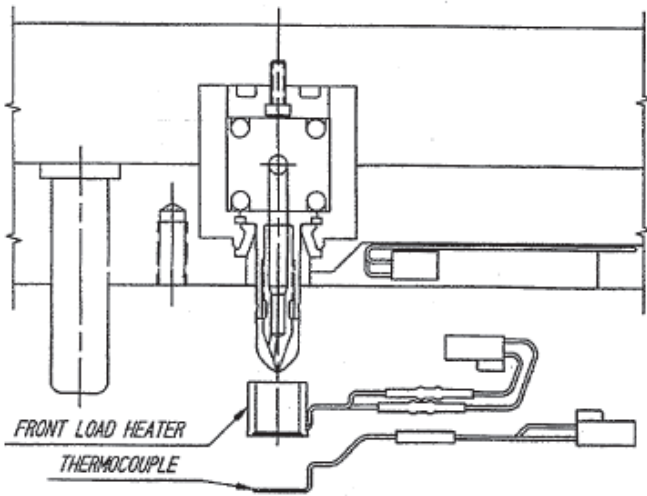
Step 3

- Remove heater retaining clip on nozzle body.
- Unplug power and thermocouple from mold connector or unwire from terminal mounting box if mold connectors are not used.
- Remove heater and thermocouple sub-assembly from nozzle body.



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Galaxy Nozzle Heater & Thermocouple Replacement Instructions



Note:

Do not cut rigid heater or thermocouple leads.

Step 4

- a) Remove thermocouple from groove on the inside of the heater.
- b) Bend new thermocouple leads to the correct position using old thermocouple as a guide.
- c) Bend new heater leads to the correct position using old heater as a guide.
- d) Place new thermocouple into the inside groove of the heater.
- e) Slide heater and thermocouple subassembly onto nozzle body. Note that the "tip end" is indicated on the heater for proper orientation.
- f) Snap retainer clip onto nozzle body.
- g) Plug in heater and thermocouple to mold connector or wire to terminal mounting box if mold connectors are not used.
- h) Using a multimeter, check heater and thermocouple resistances.

WARNING

Do not close mold when nozzles are hot. Damage may occur due to thermal expansion of nozzle seal off area.

- i) Slowly close mold.
- j) Latch "A" plate to manifold/nozzle plate.
- k) Slowly open mold.
- l) Assemble all S.H.C.S. from parting line to attach "A" plate to manifold/nozzle plate.
- m) Activate ejection mechanism.

Front Load Heaters (240 VAC)		
Item #	Lead Length (mm)	Watts
GHX3023	90	150
GHX3123	1220	
GHX3043	90	175
GHX3143	1220	
GHX3063	90	200
GHX3163	1220	

Front Load Thermocouples (J Type)	
Item #	Lead Length (mm)
GXC1023	90
GXC1123	1220
GXC1043	90
GXC1143	1220
GXC1063	90
GXC1163	1220