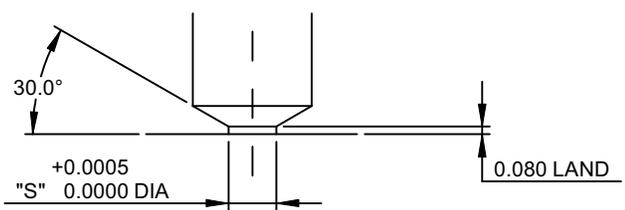
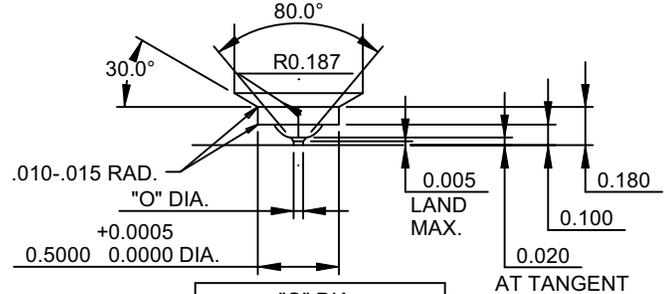


SPRUE AND RING GATE MACHINING DIMENSIONS



"T" DIA.	"S" DIA.
.500	.5005
.750	.7505
1.000	1.0005

POINT GATE MACHINING DIMENSIONS



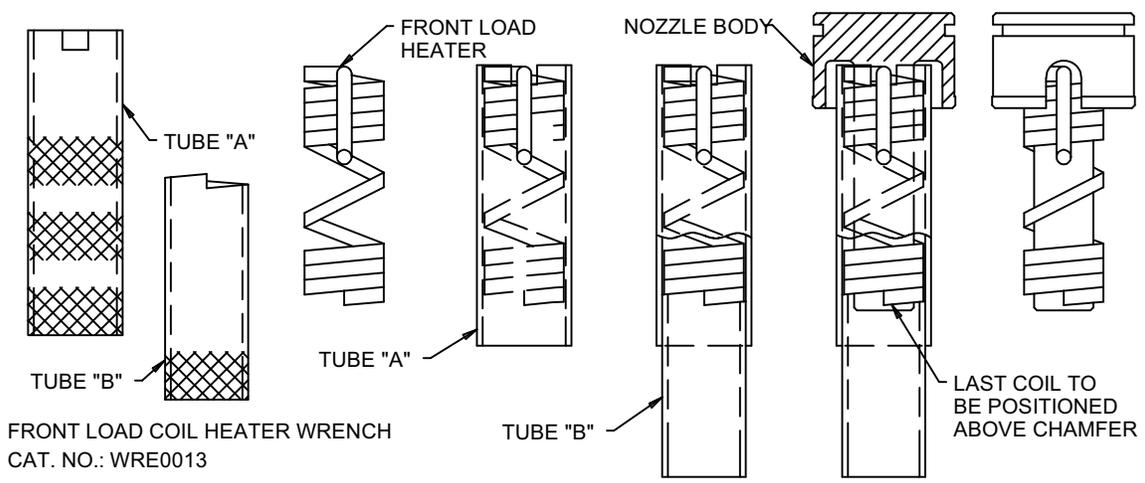
"O" DIA.	
UNFILLED RESIN	FILLED RESIN
.028 MIN.	.060 MIN.

For selection of tips and gate diameters it is important to take into consideration the materials flow characteristic, shear rate of resin, molding conditions, fill time requirements, gate vestige, wall thickness and configuration of part to be molded. Situations requiring high injections 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 material to be molded.

RECOMMENDATIONS AND GUIDELINES

1. Front Load Coil Heaters are designed to be used with 375 Series Nozzles.
2. The nozzle head must be held in such a manner to keep it from rotating upon installation of the Front Load Heater. This may be done by making a key for the head to match the flat on the nozzle's head or by circle interpolation.
3. Nozzle plate must be designed so that the heads of the socket head cap screws are exposed when the mold is split on the on the parting line.
4. After the nozzle has been located and positioned in the nozzle plate with manifold secured in place and "A" plate removed, the heater can be installed on the nozzle body as follows:
 - a. Place heater within Tube "A" so that the bending exit lead lies within the slot of the tube.

- b. Insert Tube "B" with angle cut within Tube "A" so that the angle of the tube mates with the last coil of the heater.
 - c. Rotate Tube "A" counterclockwise while at the same time rotate Tube "B" clockwise. This action will spring open the coils enough to slide the heater onto the shaft of the nozzle body.
 - d. Slide the heater onto the nozzle body shaft aligning the heater exit lead within the relief slot in the nozzle's head.
 - e. Position heater so that the end of the last coil is above the chamfer.
5. The power and thermocouple leads may be spliced in the wiring channel for ease of heater replacement. Leads may be spliced using Thomas & Betts nylon insulated disconnects.
 Male Cat. No.: 18RA-251T
 Female Cat. No.: 18RA-2577
 6. Secure wires in wire channel with D-M-E Wire Covers before assembling "A" plate to mold.



WIRING INFORMATION

Square Coil Heaters are supplied with 2' prestripped 36" long leads. Heaters are 240 VAC. 2 power leads are Multi Color. 1 ground lead is GREEN. Thermocouple is "J" Type. Thermocouple is supplied with 36" 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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