NOTE: Dimensions are shown in Inches.

To compensate for the nozzle's growth when heat is applied, the linear expansion of the nozzle (BE) at a given temperature must be added to the nominal "A" dimension. The formula below shows how to figure boring depth (dimension "A" + BE). The tip of the nozzle will now be flush with cavity line.

Formula for determining this expansion factor is as follows:
BE = "A" dimension x 0.00000633 x (Nozzle set point temperature - 68°F).

EXAMPLE: Given a 3 inch "A" dimension, with a nozzle set point temperature of 500°F:
BE = 3 x 0.00000633 x (500 - 68) = 0.008
Thus "A" + BE will be 3.008

Note: The above information is only given as an example. Variations may occur based on mold configurations and cooling factor. In some instances it may be necessary to obtain an empirical factor.

RING GATE TIP SUB-ASSEMBLY

CATALOG NUMBER | EHT 0040

NOTE: Nozzle Assembly requires Nozzle Sub-assembly and Tip-assembly.
**WARNING**

Failure to comply can 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.

**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.

**ASSEMBLY PROCEDURE - "ALL PARTS MUST BE CLEAN"**

1. Apply an anti-seize compound on both the heater cover and tip threads.
2. Install the heater using a Square Coil Heater wrench (Wrench included with replacement heater). After the heater is installed, it should cover the entire length of the nozzle body - stretch the heater by hand if necessary.
3. Firmly screw the tip sub-assembly into the shank of the nozzle body. Tighten and untighten two or three times making sure there is a good contact between the tip and the shank. Torque to approximately 30 ft-lbs.

**DISASSEMBLY PROCEDURE**

1. Place the nozzle in a vice using "V" Block, then secure it firmly at the nozzle head.
2. For removal of tip from nozzle, a six point deep well socket is recommended. The nozzle must be at processing temperature and the heater should be turned off when removing tip counter-clockwise from the nozzle. If nozzle is still in the mold, the nozzle must be "keyed" to prevent wire damages.
3. Tip must be cleaned of any material before reassembling.
4. Remove the heater using a Square Coil Heater wrench (Wrench is included with replacement heater).
5. Cast-in heater may be removed if failure occurs and replaced with a Square Coil Heater. Follow assembly procedures for Square Coil Heater.

**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).