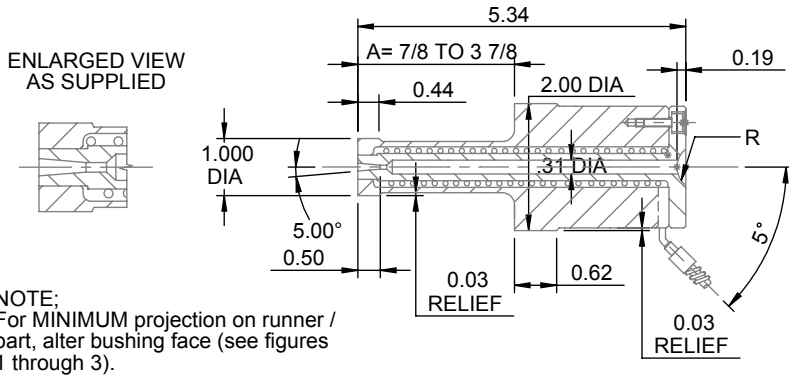




**ER-SERIES (LONG STYLE)**

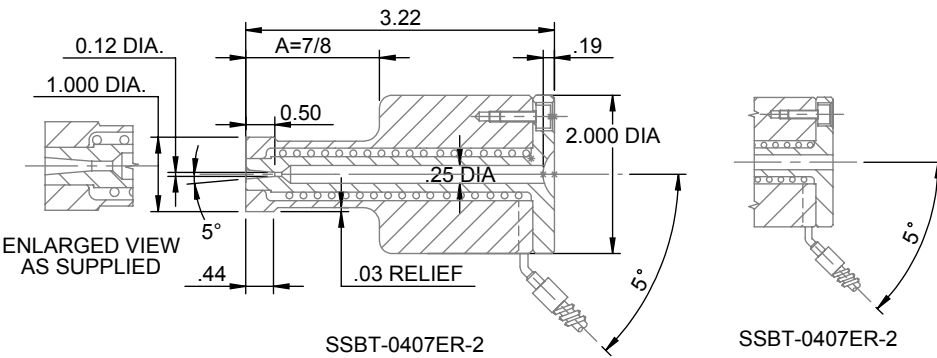


D-M-E Standard ER-Series Straight-Shot Hot Sprue Bushings (Long and Short Styles) like the Standard E-series, are supplied with a 0.25 extra stock allowance on the front face to permit machining of runner profiles or part contours into that face.

These bushings feature a "reverse taper" design that originates from under heat source, providing easier start-ups when molding nylon or polyester. . . even during an interrupted molding cycle.

The ER-Series design can also be used when a reverse taper will benefit a particular application. These bushings are supplied with a 0.12 diameter orifice and a 0.50 long reverse taper. The orifice may be enlarged and the taper increase to suit.

**ER-SERIES (SHORT STYLE)**



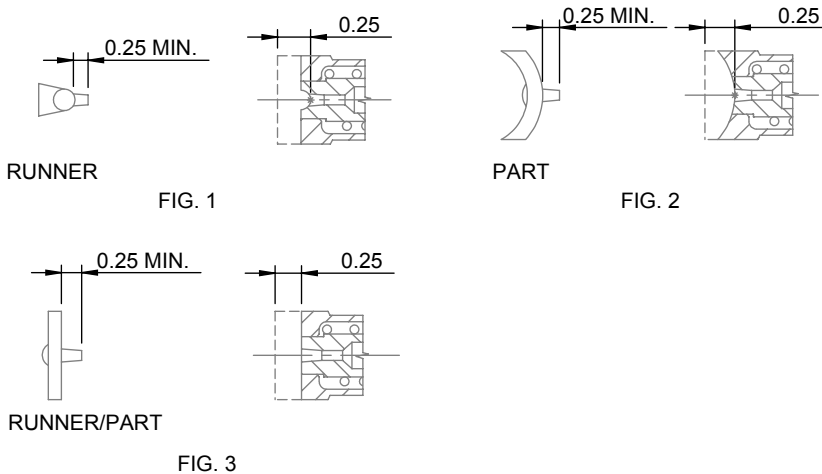
The D-M-E Standard ER-Series Straight shot (Long Style) is available in seven standard shoulder lengths with either a 1/2 or 3/4 spherical radius and 120 or 240 volt heater. The ER-series straight shot (long Style) can be retrofitted to suit the particular molding application.

NOTE; The 5° heater lead is standard. A 90° heater lead is available on special request.

The D-M-E Standard ER-Series Straight Shot (Short Style) is intended to suit the requirements of smaller injection molding machines such as Arburg, Boy and Jaco. It is supplied with a 7/8 "A" dimension can be altered to suit the particular molding application.

NOTE: The 5° heater lead is standard. A 90° heater lead is available on special request.

**DESIGN GUIDELINES FOR ALTERING ER-SERIES  
 STRAIGHT - SHOT HOT SPRUE BUSHINGS  
 (Long and Short Styles).**



For MINIMUM projection on runner/part, machine the runner profile or part contour 0.25 deep into the bushing face at the centerline of the orifice (see figures 1 and 2).

When gating into a flat surface, remove the 0.25 extra stock allowance on the bushing face (See Figure 3). However, do not weaken the bushing face by exceeding the 0.25 dimension. The "A" dimension can be altered by removing stock from the front face of the 2.00 diameter bushing shoulder.

**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.