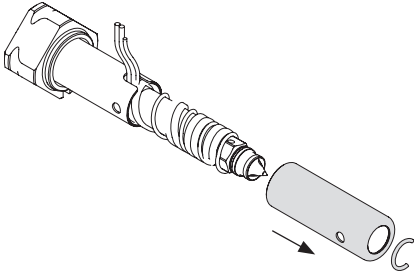


Replacing the Tip & Seal Assembly

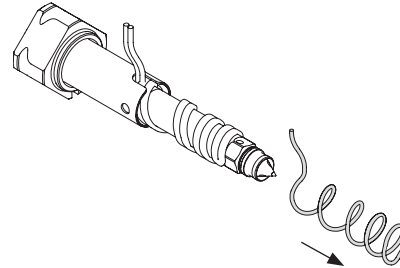
ONE

- Remove snap ring
- Remove heater cover



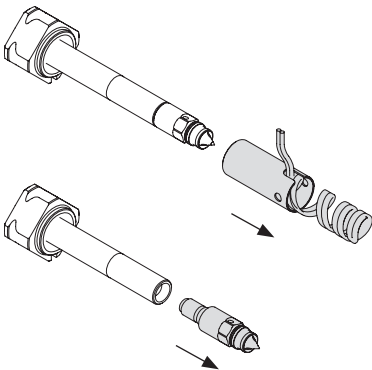
TWO

Remove thermocouple from nozzle



THREE

Remove heater.
Using an AF8mm deep socket unscrew tip from body



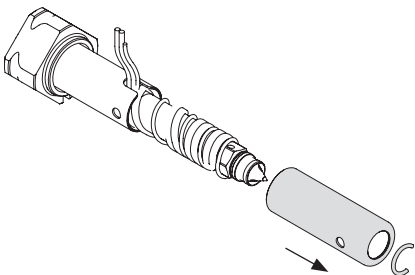
FOUR

- Clean any plastic & debris from the tip pocket in nozzle body.
- Smear a small amount of anti-seize around new tip thread.
- Screw new tip into the body and torque to 4Nm (3lb ft). **Warning: Do not overtighten.**
- Fit the heater, thermocouple, heater cover & snap ring.

Replacing the Thermocouple

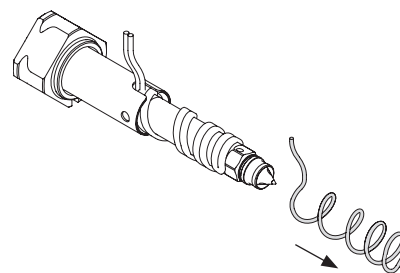
ONE

- Remove snap ring
- Remove heater cover

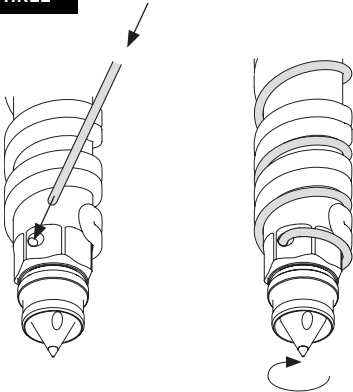


TWO

Remove existing thermocouple from the nozzle

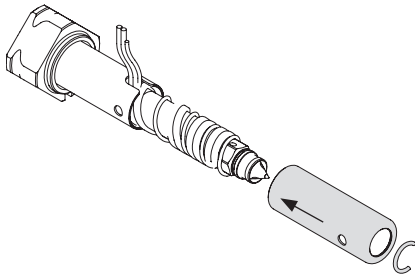


THREE



- a. Slide thermocouple probe into thermocouple hole in tip.
- b. Holding thermocouple probe secure in the hole, wind thermocouple around tip above heater coil in a clockwise direction to the space between the heater coils. To ensure the probe is held secure the space between the heater coils should be equivalent to 1 full wind of the thermocouple.
- c. Wind thermocouple down nozzle between the heater coils, keeping thermocouple tight against the nozzle body.
- d. When heater wire exit is reached thread the wires through wire channel with heater wires.

FOUR



Fit heater cover and snap ring.

Replacing the Heater

ONE

- a. Remove heater cover and snap ring.
- b. Remove thermocouple.
- c. Holding heater at the base slightly twist the top heater coils in a clockwise direction and pull the heater from the nozzle body.
- d. Clean any plastic or debris from the nozzle body.
- e. Slide the new heater onto the nozzle body, ensuring the top coil of heater reaches the bottom of the tip hex.
- f. Fit thermocouple, heater cover and snap ring.