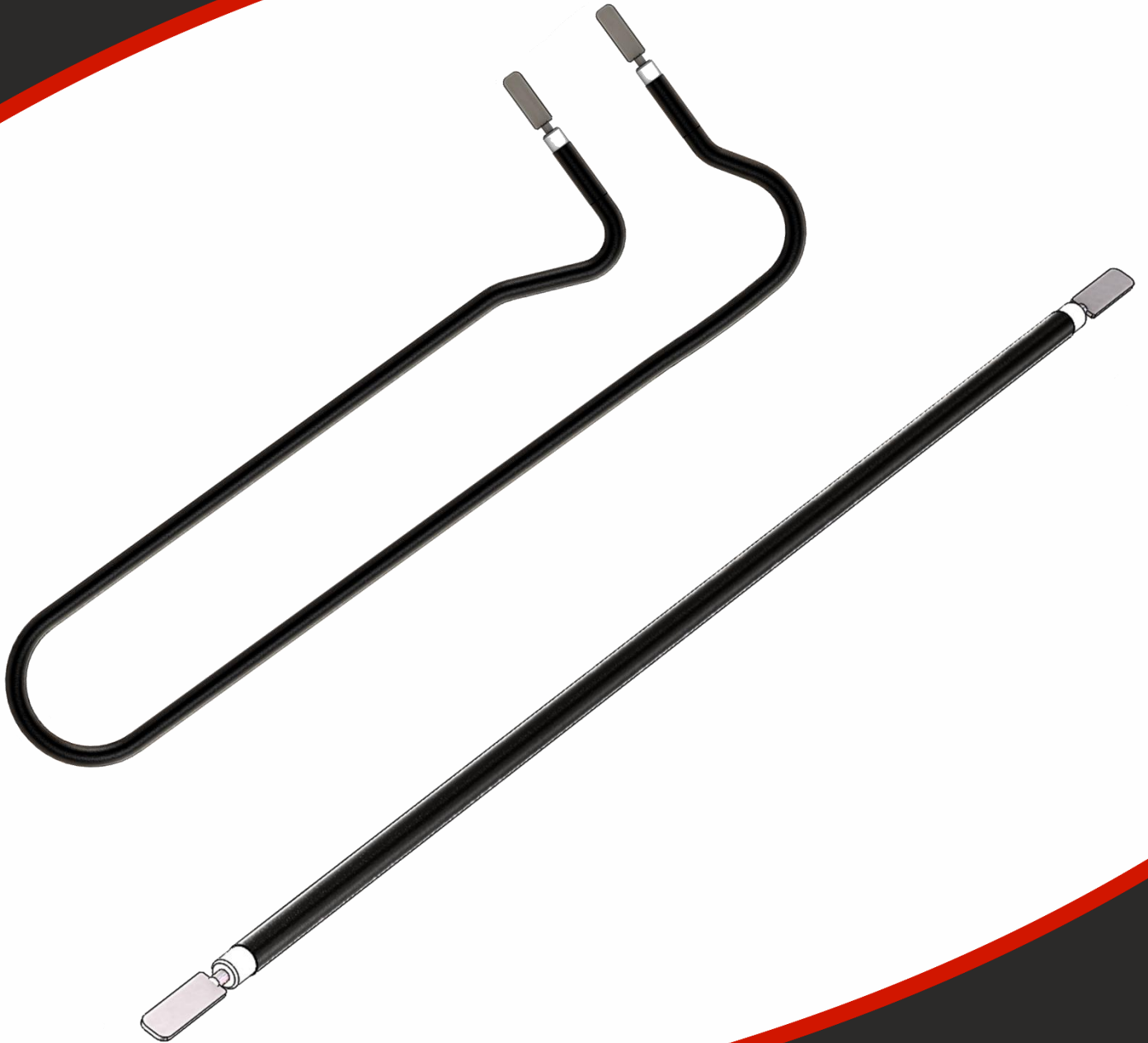


TUBULAR HEATER RHK 5.0/6.5 REPLACEMENT



 **MasterFlow**[®]

LEADER IN HOT RUNNER TECHNOLOGY

1. Carefully remove the existing tubular heaters. Make sure not to damage the groove in the manifold. Any voids or dent should be smoothed out.
2. Measure and mark the mid-point of the groove in the manifold (a piece of rope can be useful).
3. Measure and mark the mid-point of the tubular heater.
4. Use a copper-hammer to fix the tubular heater in the mid-point first.
5. Hammer down the tubular heater into the groove from the mid-point in one direction at the time. *Do not worry if the tubular heater will be squeezed/deformed.*
6. Use a pair of pliers to bend the tubular heater when the groove is turning. **IMPORTANT:** Be careful NOT to hammer the tubular heater towards the edge of the groove. If the sheath-material breaks, Magnesium oxide will leak and the tubular heater must be replaced.
7. When the tubular heater is in place, use a 5 mm brass bar and grind it off slightly on one side. Place this 5 mm bar on the tubular heater and hammer on it. This is to make sure that the tubular heater sits tight in the groove to get full contact, for best performance.