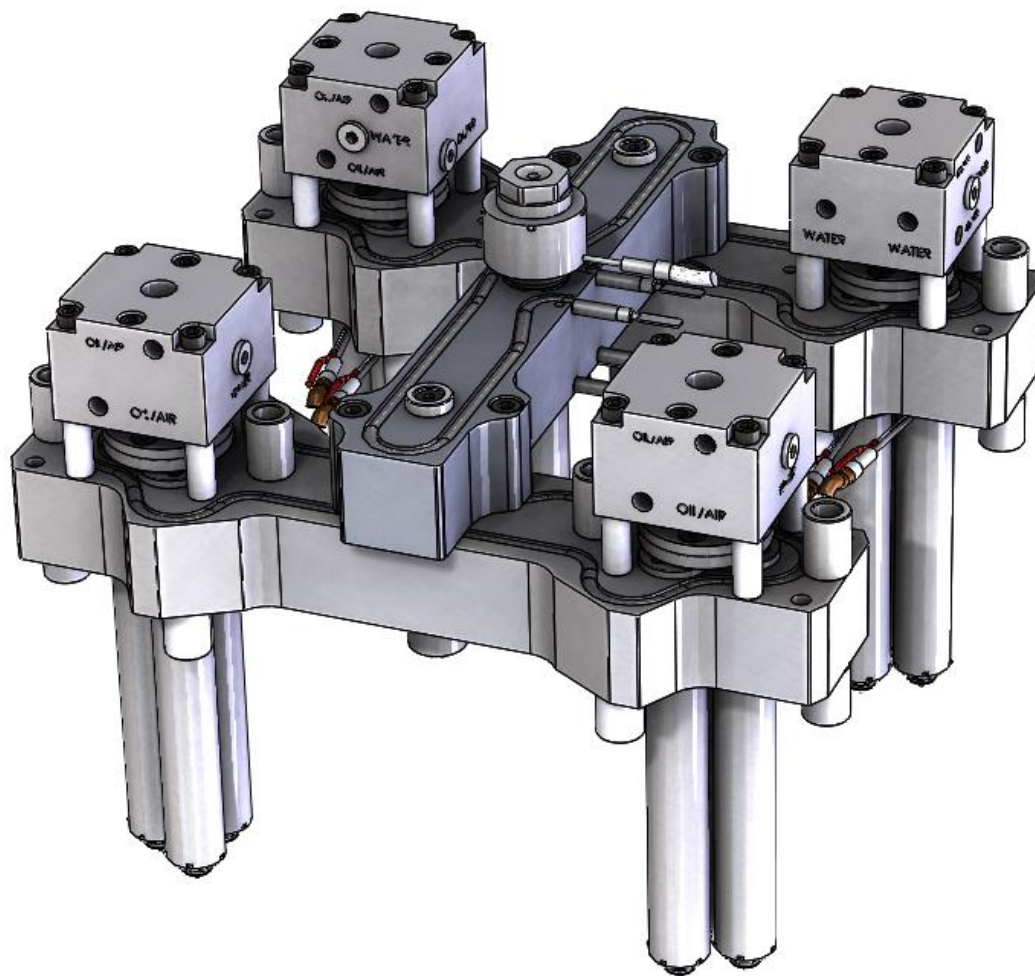


MP PIN ADJUSTMENT LIFTING PLATE

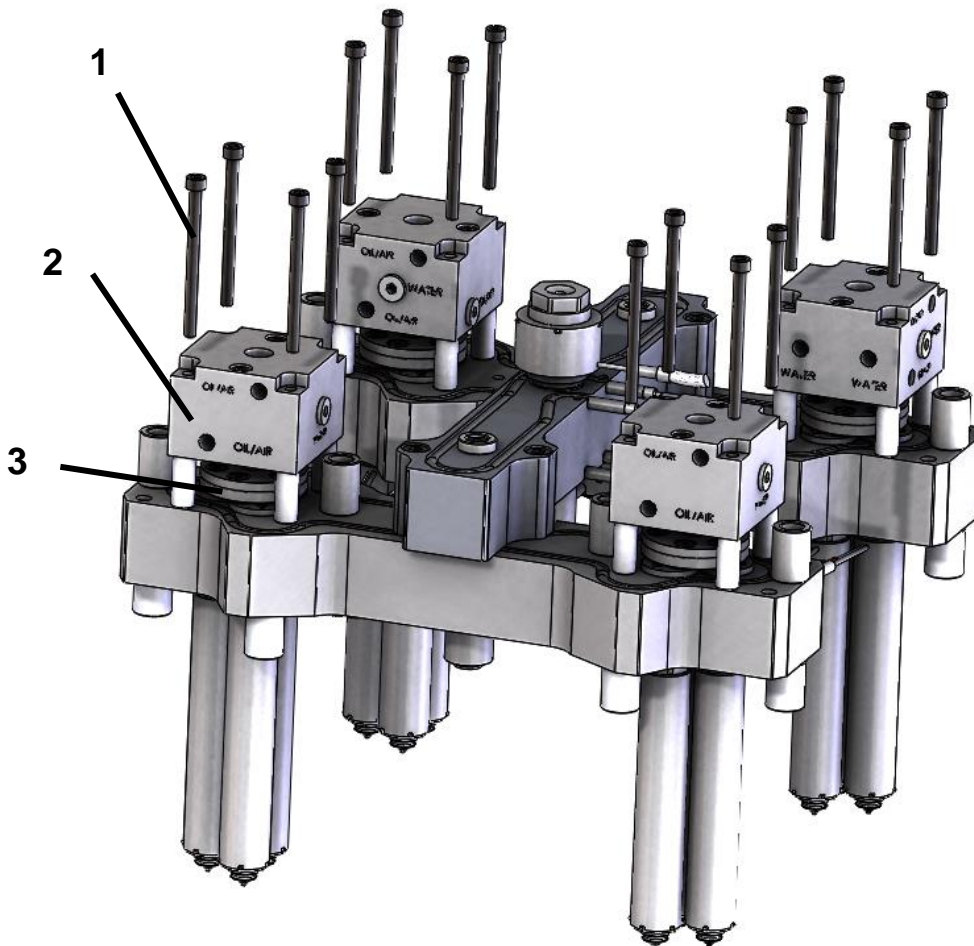


 **MasterFlow**®

LEADER IN HOT RUNNER TECHNOLOGY

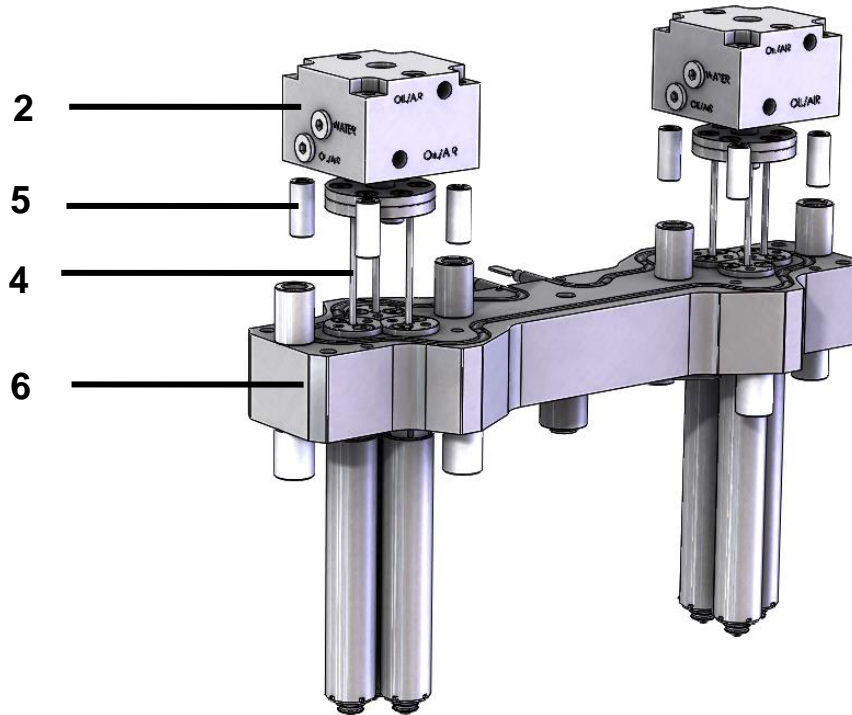
Pin Adjustment Instruction LIFTING PLATE

1. Disassemble the mould tool enough to gain access to the hot runner system.
2. If the hot runner system is new, it is not necessary to heat the system. If not, the hot runner system must be heated to production temperature to adjust the pin.
3. Remove the screws (1) that hold the CylinderBlock (2) and take out the CylinderBlock with lifting plate (3) and pins as one unit.



4. Move Pins Forward

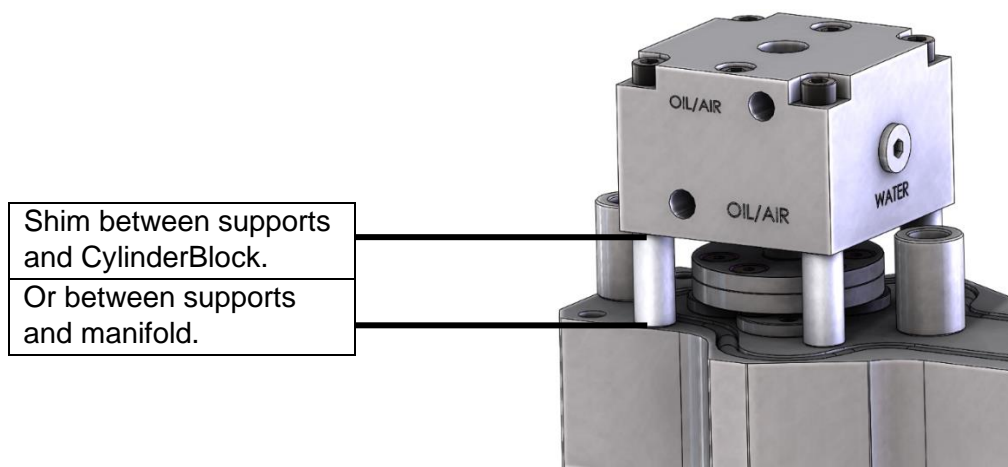
To adjust the pins (4) so that they go further down into the plastic part, machine on the four supports (5). **Note:** The CylinderBlock must, individually, have supports with identical height. If not, valve pins and manifold seals will have premature wear.



Move Pins Backward

To adjust the pins (4) so that they stop further up (away from the plastic part), put a shim between the CylinderBlock (2) and the supports (5) or between the supports (5) and manifold (6).

Please note. It is not possible to adjust the height inside the CylinderBlock.



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