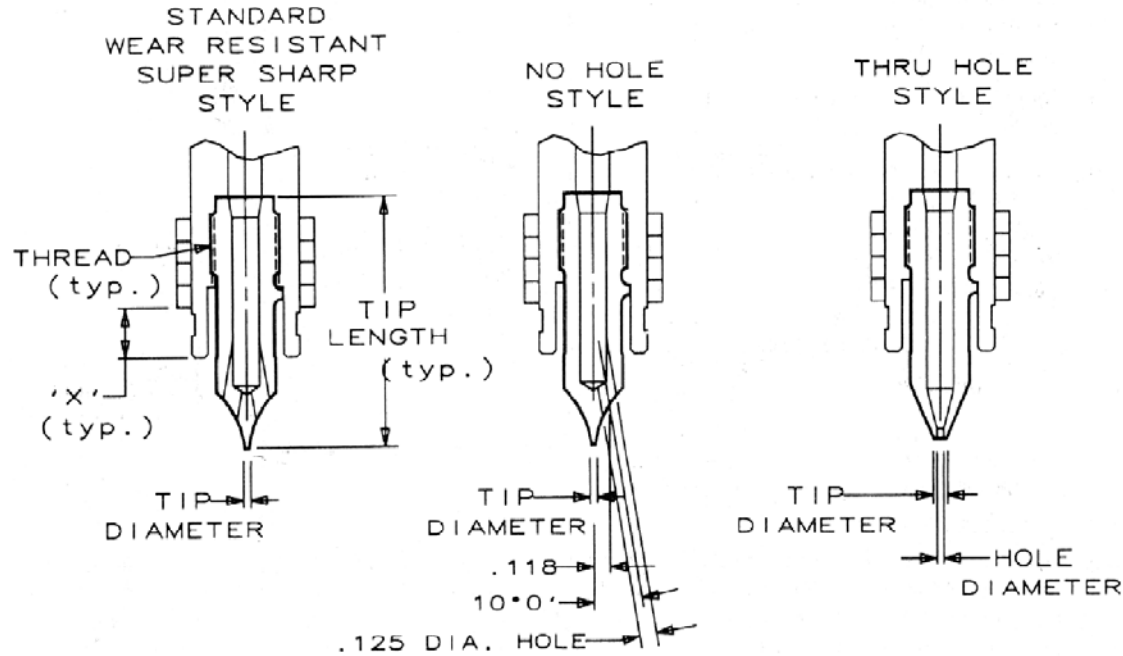


INSTALLATION DATA

For: ALL GATE MATE STYLE TIPS

Please read carefully before installing components.



"X" DIMENSION INDICATES CORRECT POSITION OF THE HEATER ON THE BODY	
"X"	BODY STYLE
0.218	MINI GATE-MATE
0.250	MEDIUM GATE-MATE AND GATE-MATE 4 AND JUMBO GATE-MATE

NOTES:
MOLDMAKER TO MACHINE DIMENSIONS SHOWN IN INCHES

TIP STYLE	TIP CAT. NO.	TIP LENGTH	TIP DIAMETER	HOLE DIAMETER	THREAD	BODY STYLE
STANDARD WEAR RESISTANT*	GMT0100	1.086	0.010	N/A	1/2-20	MINI GATE-MATE
STANDARD WEAR RESISTANT*	GMT4101		0.024	N/A		
STANDARD WEAR RESISTANT*	GMT-2	1.730	0.010	0.50	1/2-20	MEDIUM GATE-MATE AND GATE-MATE 4
SUPER SHARP**	GMT0301		0.090			
SUPER SHARP WEAR RESISTANT*	GMT0401		0.090			
THRU HOLE***	GMT0302	1.690	0.090	0.50	1/2-20	MEDIUM GATE-MATE AND GATE-MATE 4
THRU HOLE WEAR RESISTANT	GMT0402		0.090			
NO HOLE****	GMT0303	1.730	0.024	N/A	3/4-16	JUMBO GATE-MATE
STANDARD WEAR RESISTANT*	GMT0004	1.855	0.030	N/A		
STANDARD WEAR RESISTANT*	GMT0406		0.140	0.100		
THRU HOLE***	GMT0007	1.815	0.140	0.100		
THRU HOLE WEAR RESISTANT*	GMT0407		0.140	0.100		

* WEAR RESISTANT TIP ARE RECOMENDED FOR ABRASIVE MATERIALS.
 ** SEE RECOMMENDATIONS AND GUIDELINES NOTE # 8.
 *** SEE RECOMMENDATIONS AND GUIDLINES NOTE # 10.
 **** SEE RECOMMENDATIONS AND GUIDELINES NOTE # 11.

INSTALLATION DATA**For: ALL GATE MATE STYLE TIPS**

Please read carefully before installing components.

**RECOMMENDATIONS AND GUIDLINES**

1. Nozzle (multiple-applications) body or bushing (single-application) body must be cleaned of any material in the seal off area and threaded areas before reassembling.
2. Careful attention should be taken to the tip as damage could occur if tip is dropped or strikes a rigid material. Treat tip like a glass or ceramic material.
3. Do NOT lubricate or use anti-sieze compound on the threads.
4. Tip must be torqued into the nozzle or bushing body using a torque wrench at 20 to 25 ft-lbs. For the GMT4101, GM0400 and GMT0406 wear resistant tips, and 33 ± 5 ft-lbs. for all other tips when reassembling. For protection of the tip point, use a 9 mm deep well 6 point socket thin wall socket for the Mini, use a 11 mm deep well 6 point socket for the Med. and GM4, and 17mm deep well 6 point socket for the Jumbo.
5. Careful attention should be taken to the heater and thermocouple leads as damage could occur when working on nozzle or bushing assembly.
6. Seal ring for nozzle body must be replaced each time nozzle body and / or manifold are removed to ensure seal off.
7. Wait a minimum of 5 minutes after set point has been achieved for sufficient heat to transfer into the tip before molding.
8. A 0.030 min. gate dia. is recommended when using the GMT0301 Super sharp tip.
9. For best processing and lowest gate vestige, tip must be 0.000 to 0.005 into the cavity at processing temperature. The smallest gate diameter will yield the best gate vestige. Depending on part configuration and plastic being used, the gate may have to be enlarged to achieve greater flow. This increase in diameter may result in a larger gate vestige.
10. Use the GMT-2 standard tip machining dimensions when using the GMT0302 thru hole tip and use the GMT0004 jumbo tip machining dimensions when using the GMT0007 thru hole tip. These tips are designed 0.040 shorter in length to be direct replacement for the standard and jumbo tips. Given an "A" dimension of $2.000 + BE$ (NOT $1.960 + BE$) using a GMT0302 tip. For best processing and lowest gate vestige a 0.030 to 0.060 diameter gate is recommended for the GMT0302 thru hole tip and a 0.080 to 0.125 diameter gate for the GMT0007 thru hole tip.
11. Using the GMT0303 no hole tip allows for flow hole alignment in the cavity. The Gate-Mate body must be keyed into the nozzle plate or top clamp plate. "A" plate and / or cavity insert should be removed to expose tip from parting line. Determine location of flow hole on the circumference of the tip and mark that position. Remove the body from the mold and machine a 0.125 diameter hole into the tip at the

marked location. See other side of sheet for more details. Do NOT remove tip from body. Remove any burrs around the 0.125 diameter hole and clean all chips from the tip and body. Reassemble body back into the mold and wire heater and thermocouple into the terminal mounting box.

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.

DISCLAIMER

D-M-E SHALL NOT BE LAIBLE FOR MISUSE OR FAILURE TO FOLLOW THE ENCLOSED INSTRUCTIONS AND SPECIFICATION. D-M-E HEREBY DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. IN NO EVENT SHALL D-M-E BE RESPONSIBLE FOR LOSS OF USE, REVENUE OR PROFIT, OR FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES.

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