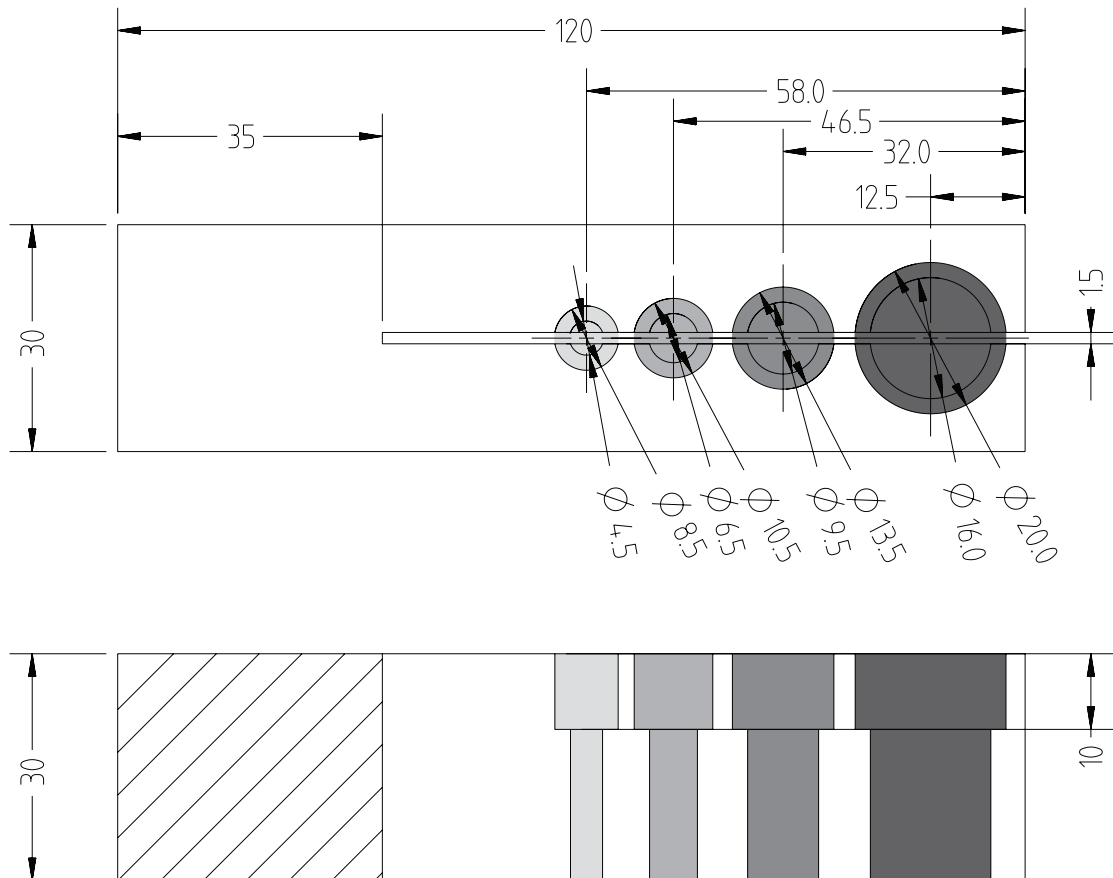


Removal of Tips from Sprue & Bush Nuts

Preparation

Manufacture a steel holding tool to the dimensions in the drawing below.
The four different size holes correspond to the X Range tip sizes.



X Range Nozzles Torque Settings

X Range Series	G1 Tip	G5 Tip or YCN/YV Nuts
X13	15 Nm (11 lb ft)	30 Nm (22 lb ft)
X16	20 Nm (15 lb ft)	40 Nm (30 lb ft)
X19	25 Nm (18 lb ft)	50 Nm (37 lb ft)
X27	30 Nm (22 lb ft)	60 Nm (44 lb ft)

1.0



Fit tip and nut into holding tool and clamp tool into bench vice.

1.1



Heat nut to 250°C – 300°C to soften plastic until it is molten.

Warning: To avoid weakening the nut; do not overheat.

1.2



Place a spanner around the nut and place a soft pry bar under the hex of the nut. Simultaneously lever upwards with the soft pry bar and turn the nut with the spanner. Patiently work the nut upward while the plastic is molten. If the plastic cools and prevents the nut coming off, apply more heat to the nut to return plastic to molten state.

Complete

Allow tip, nut and holding tool to cool before carrying out any further maintenance.