

Replacing ta Tip on an MT Nozzle

1. Remove the **nozzle** from the **manifold**.
2. Place the **nozzle** in a three jaw chuck gripping it by the **nozzle head**.
3. Heat the **nozzle** up to the plastics processing temperature. If the tip is full carbide, increase the temperature to fully expand the body steel off the carbide.
4. Unscrew **nut** with a ring spanner.
5. Remove plastic from the **nut** and **tip** taking care not to scratch or damage either one.
6. If the **nozzle** is warm, you should be able to extract the **tip**. Otherwise, measure a soft metal bar and make its diameter 0.5 mm smaller than the dropper hole in the **nozzle head** and gently tap **tip** out.
7. Free the **tip** by inserting the soft metal bar or wooden **dowel** through the **nozzle** exit hole from the **nozzle head** and gently pushing the **tip**, taking care not to damage the end or internals of the **tip**.
8. Once the **tip** is loose, reposition the **nozzle** so it is lying horizontal to prevent the **tip** from falling out and becoming damaged or blunt.
9. Continue pushing the **tip** out with the **dowel**.
10. To reassemble the **nozzle**, use the steps above in reverse. Use the correct torque setting when tightening the **nut**.

MT Nozzle Series	Lb. feet	N.m
10	10	15
13	10	15
16	15	15
19	20	25
22	20	25
27	30	40
33	30	40

