11 Dismounting and Mounting Manifold Plugs

There are two kinds of manifold plugs from Synventive Hot Runner Systems:

- Standard manifold plugs which have to be replaced only by Synventive.
- Replaceable manifold plugs which the user can dismantle and install.

This chapter describes dismantling and installation of replaceable manifold plugs.

**NOTICE**

If your Hot Runner System has not replaceable manifold plugs, please contact Synventive Customer Services for dismantling and installing the manifold plugs.

11.1 Dismounting Manifold Plugs (APT)

1) Remove the heat shields if necessary.
2) Unscrew the set screw.

3) Using a slide hammer, thread into the head of the runner plug.
4) Remove the plug (according to size use a M5, M6, M8 or M12 screw).

**NOTICE**

Be careful not to misplace the dowel.
11.1.1 Cleaning the Flow Bores

1) Damages at the Hot Runner System's flow bores can cause material degradation and leakage.

**NOTICE**
To prevent this do not damage the contact surface between nozzle and manifold. Use a brass brush or Scotch-Brite ®.

11.2 Mounting Manifold Plugs (APT)

1) Set the manifold plug into the bore.

2) Set the dowel into the appropriate bore.

3) Lubricate the set screw with high-temperature assembly paste (anti-seize compound).

**NOTICE**
This is an important measure to prevent thread corrosion due to aggressive gases, which could be released during plastics processing.

4) Screw the set screw into the thread.

**NOTICE**
Use torque wrench with wrench insert and the torques indicated in the torque table (section 13).