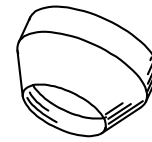
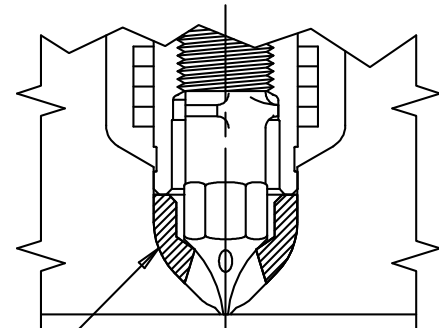
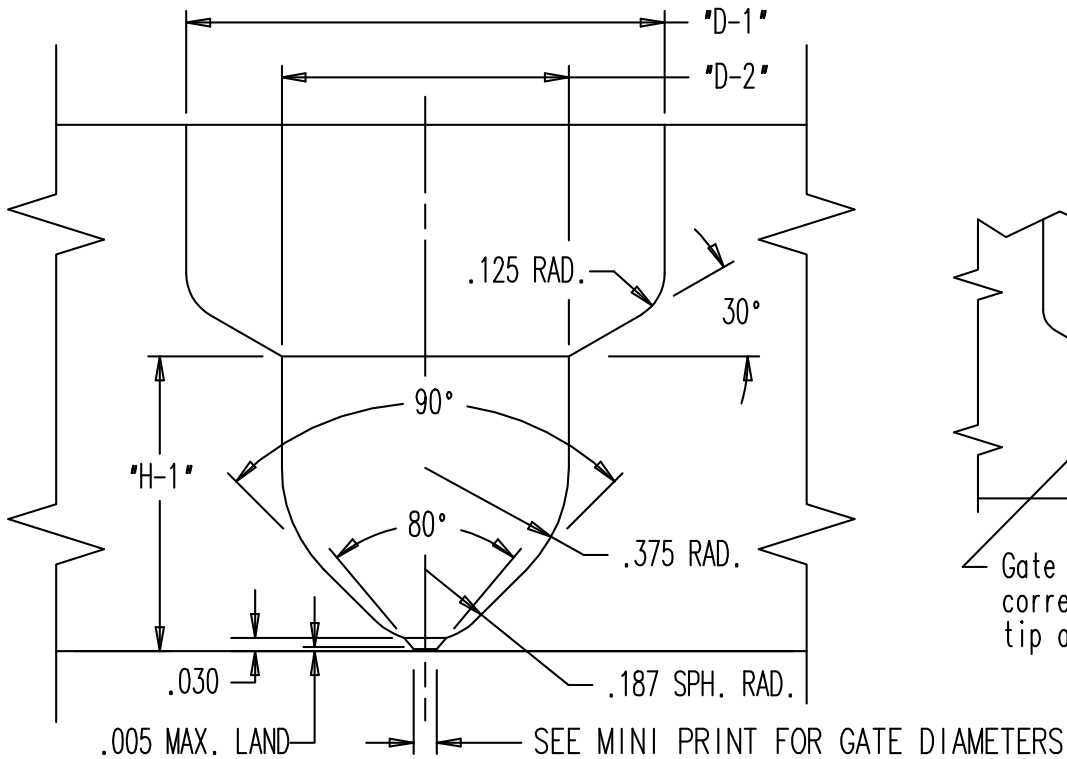


D-M-E GATE SHELL INSULATOR INSTALLATION DATA

Please read carefully before installing gate shell insulator
GS19998
ME-0739-PS-421-A 8-96



GATE MACHINING DIMENSIONS



Gate Shell Insulator shown in correct position with standard tip and Gate-Mate 4 Nozzle.

CATALOG NUMBER	D-1	D-2	H-1	USED WITH TIP STYLE	USED WITH BODY STYLE
GS10001	1.250	.7500	.770	STANDARD-SUPER SHARP-NO HOLE	GATE-MATE 4 NOZZLE
GS10002	1.250	.7500	.770	THRU HOLE	
GS10003	2.000	1.2500	1.000	STANDARD	JUMBO GATE-MATE BUSHING AND NOZZLE
GS10004	2.000	1.2500	1.000	THRU HOLE	
GS10005	1.625	.7500	.875	STANDARD-SUPER SHARP-NO HOLE	MEDIUM GATE-MATE BUSHING
GS10006	1.625	.7500	.875	THRU HOLE	

1. Gate machining must be done accordingly to D-M-E specifications found on detail above.
2. Nozzle tip must not be altered in any way for Gate Shell Insulator to preform properly.
3. Make sure Gate Shell Insulator is fully seated in the gate well.
4. For best results, outer surface of tip should be free from all plastic resin.
5. If dissimilar resins are to be processed in the same tool, it is recommended that the processing temperature of thhe resins be within the same temperature range of each other
6. Wait a minimum of 5 minutes after set point has been reached for sufficient thermal growth to occur creating proper seal.
7. The Gate Shell Insulator will not melt and can continuously with stand temperatures to 550°F (288°C).
8. If. the tip must be removed from the nozzle body, it is recommended that both the tip and the Gate Shell Insulator be free from all plastic resin befroe reassembling.