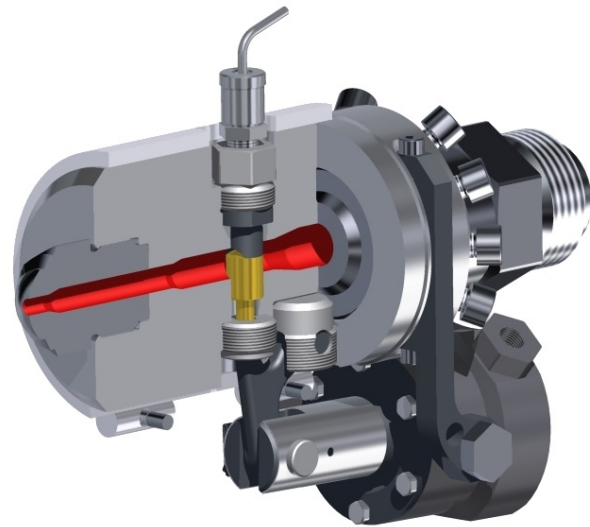


Machine bolt shut-off nozzle type BHP

pneumatically or hydraulically controlled



Applications:

Thermoplastics, shear sensitive materials,
parts with long cavities (reduced pressure loss)

Shut-off mechanism:

Bolt shut-off with integrated 2-way actuator
pneumatically or hydraulically operated

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Safety instructions



This symbol indicates explanations about important matters. Failure to read these or false handling could result in injury or damage.

Please pay attention to the following safety instructions and precautions



Handling

- Installation and servicing to be only carried out by suitable personnel according to the installation and service instructions.
- Nozzle can become extremely hot. Full face protection and heat resistant gloves must be worn.



Damage precaution

- Do not drop the nozzle or exert it to unnecessary forces.
- Take care that no foreign bodies enter the working parts of the nozzle.
- No adjustment or manipulation when nozzle is in operation.
- Never heat steel parts over **520°C**.
- The actuator is designed for temperatures up to **180°C**.
- Nozzle is only to be used for injection molding purposes.



Operational notes

- Maximum injection rate / temperature: **3000 bar at 400°C**.
- Torques on screws and threaded parts must be adhered to.
- Noise emissions from the nozzle do not exceed 70 dB(A).



Explosion danger

- Some plastics produce gases if they stay for a longer time in a heated environment. There is a risk that the gas may escape explosively through the nozzle orifice.

Keep this manual in a convenient place for future reference.

Initial operation



Read safety instructions!

Initial operation:

1. Bring nozzle to operating temperature
2. **Only by first initial operation:** tighten screws and heater band screws to the maximum recommended torques
3. Make sure that the Polymer is completely melted
4. Eject the heated material. This follows after extrusion at low speed (time ca. 25 - 30 S) or through injecting out at three to five times the rate of injection

Actuator:

Operational data according to engraving on cylinder

Leakage:

Between bolt and guide there is a melt film which prevents the needle from blocking. The melt film will be continuously renewed and will eventually leak out of the nozzle.



At machine downtimes: nozzle temperature must be lowered.

Cleaning instructions

While the nozzle is still installed, clean as far as possible in a heated state and finally disassemble completely and clean individual parts.

Plastics such as; LCP or PPS burn away when the nozzle is heated in an oven for tow hours at 500°C.



Never heat steel parts above 500°C!
Clean pneumatic or hydraulic actuator separately with max. 150°C!
Avoid kinking the heater band and sensor cables!

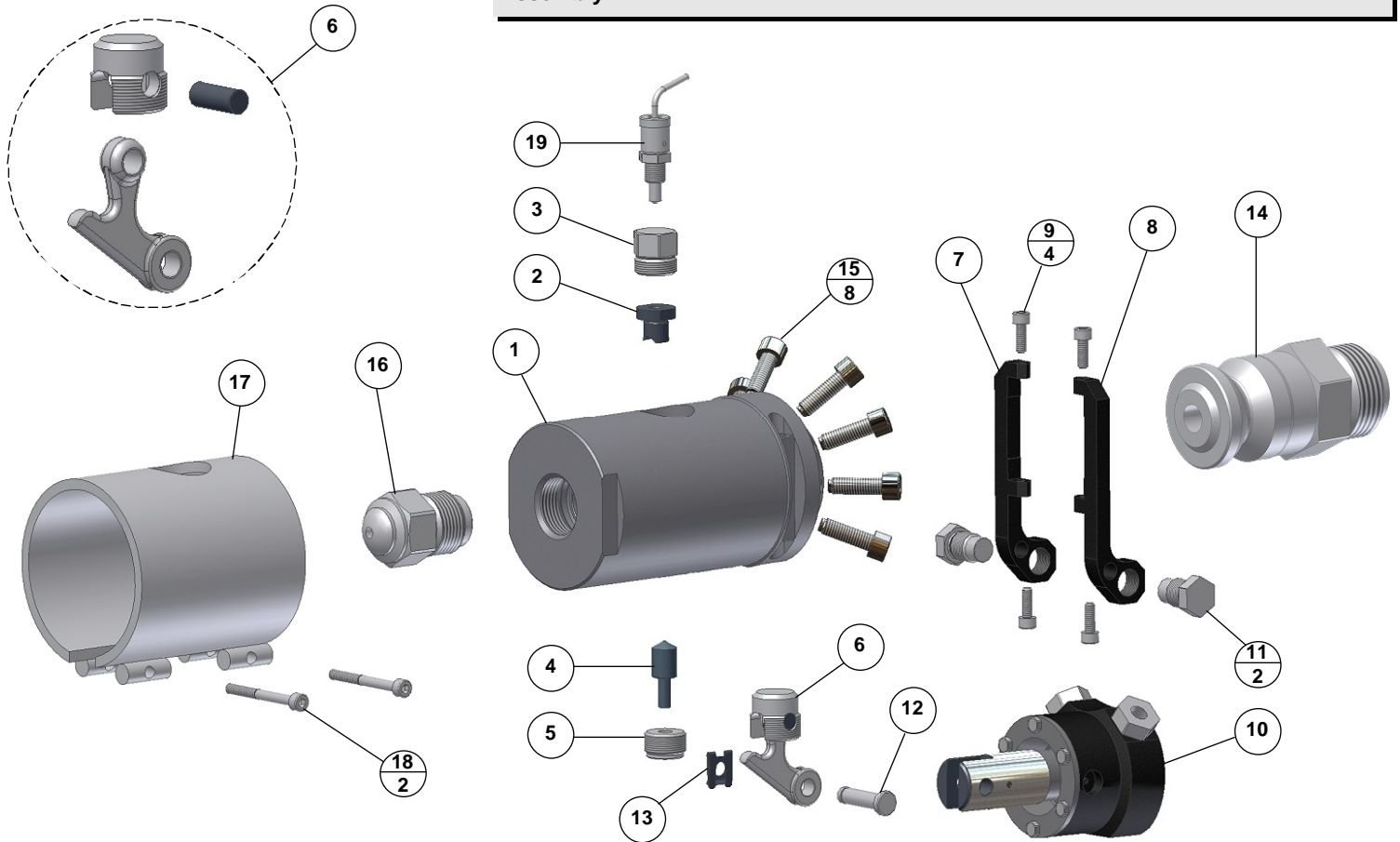
Help tools for cleaning:

- Sand fluidized bed
- Glass bead blasting
- Cleaning oven
- Gas burner
- Wire brush
- Steel wool

Before reassembly check all parts for damage or wear.

Profit from our cleaning service. The nozzle is disassembled, checked and repaired if necessary after customer approval.

Assembly



⚠ Read safety and cleaning instructions!

Assembly / Disassembly Notes:

Lever unit (pos. 6) should not be disassembled in normal circumstances.
 Pull out pos. 2 from above using a screw. If required, use the bolt (pos. 4) and a soft punch to carefully tap out from below.
 Assemble according to the numerical order. Disassemble in the opposite direction.
 Grease all threads with high temperature lubricant.

Order	Qty.	Description	Tool size (torque)		
			BHP0	BHP1	BHP2
1	1	Body	Counter SW50	Counter SW50	Counter SW90
2	1	Insert	-	-	-
3	1	Locking screw	SW14 (30 Nm)	SW19 (80 Nm)	SW24 (340 Nm)
4	1	Shut-off bolt	-	-	-
5	1	Stop screw	SW10 (30 Nm)	SW12 (80 Nm)	SW19 (340 Nm)
6	1	Lever unit	Manually	Manually	Manually
7	1	Bracket - right	-	-	-
8	1	Bracket - left	-	-	-
9	4	Screw	SW4 (5 Nm)	SW4 (5 Nm)	SW6 (35 Nm)
10	1	Actuator	-	-	-
11	2	Bolt screw	SW13 (12 Nm)	SW17 (30 Nm)	SW22 (80 Nm)
12	1	Bolt	-	-	-
13	1	Spring clip	-	-	-
14	1	Adapter	SW36 (Machine handbook)	SW50/60 (Machine handbook)	SW65 (Machine handbook)
15	8	Flange screw	SW8 (15 Nm)	SW10 (40 Nm)	SW8 (80 Nm)
16	1	Tip	SW32 (150 Nm) = M30*2 Ø8	SW32 (150 Nm) = M30*2 Ø8	SW46 (400 Nm) = M45*3 Ø19
17	1	Heater band	-	-	-
18	2	Heater band screw	SW4 (Hand-tight)	SW4 (Hand-tight)	SW4 (Hand-tight)
19	1	Temperature sensor	SW14 (Hand-tight)	SW14 (Hand-tight)	SW14 (Hand-tight)

Parts subject to wear / ordering spare parts

Your contact information:

Company	
Street	
City / Zip	
Contact	
Tel. / Fax	
E-Mail	

Lasered nozzle identity no.: please insert here

Quantity	Part (for part name, see chapter Assembly)

Send to:

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