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- 1.- Objective**
- 2.- Material affected**
- 3.- Disassembly procedure.**

CHECKLIST

Check.	Date	Pages affected	Reason
1	03.10.09	All	Building assembly instructions.

Prepared:

Name: AR

Sign:

Revised:

Name:

Sign:

Aproved:

Name:

Sign:

1.- OBJECTIVE:

This technical instruction is intended to define the assembly or change process of nozzles machine type B55.

2.- MATERIAL AFFECTED:

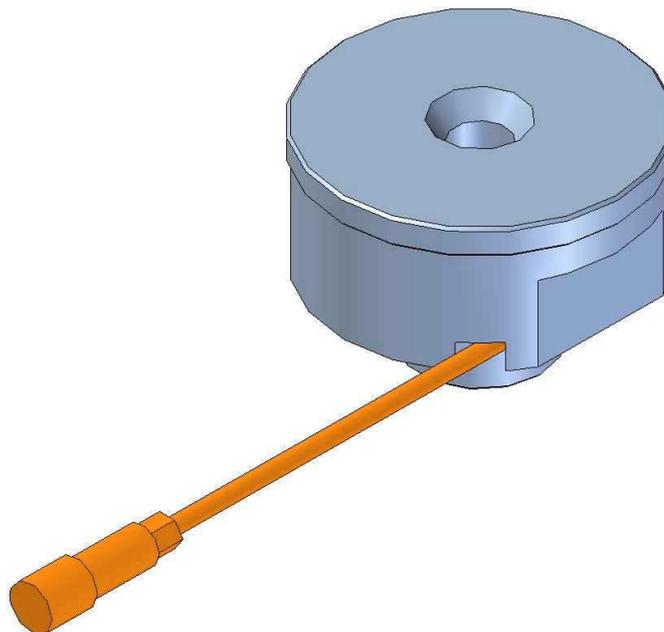
This technical instruction can be use in all manifolds with machine nozzles type B55.

3.- DISASSEMBLY PROCEDURE:

Note:

-The usually reasons to have to change the machine nozzle are:

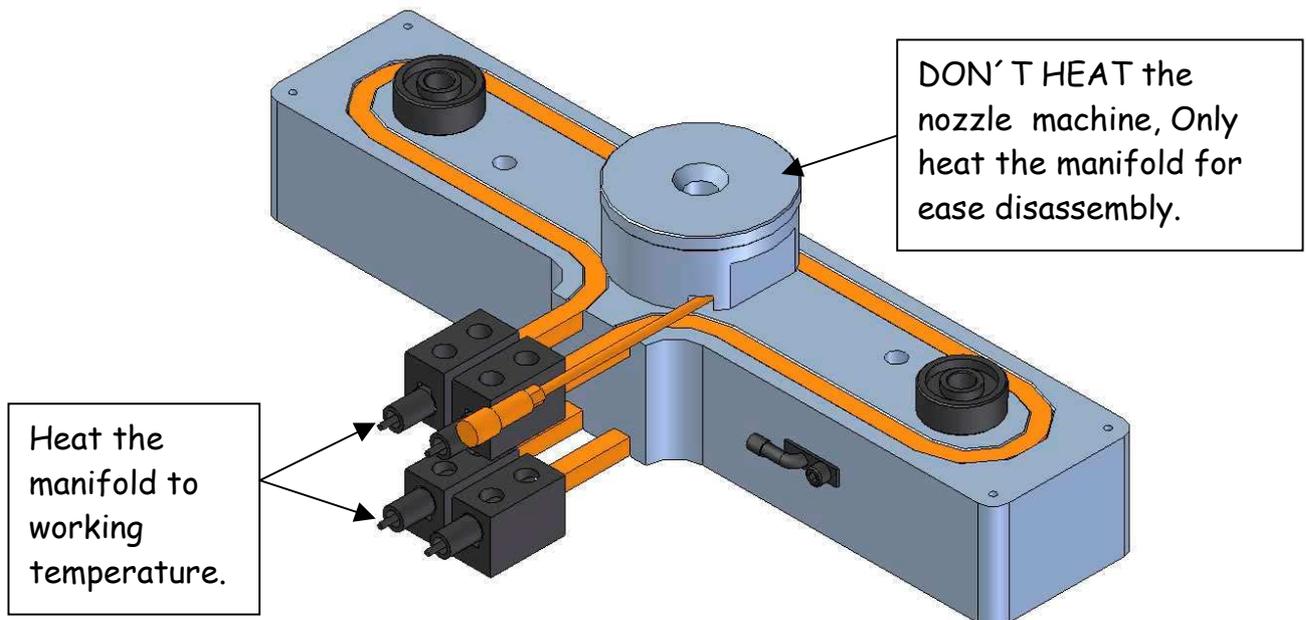
- 1.-You have to change the heater.
- 2.-You have to revise the angle or the radius of the nozzle.
- 3.-You have to change one manifold heater and you need disassemble the nozzle machine.



A.-Tools:



B.-Before you unscrew the nozzle machine you must heat the manifold.



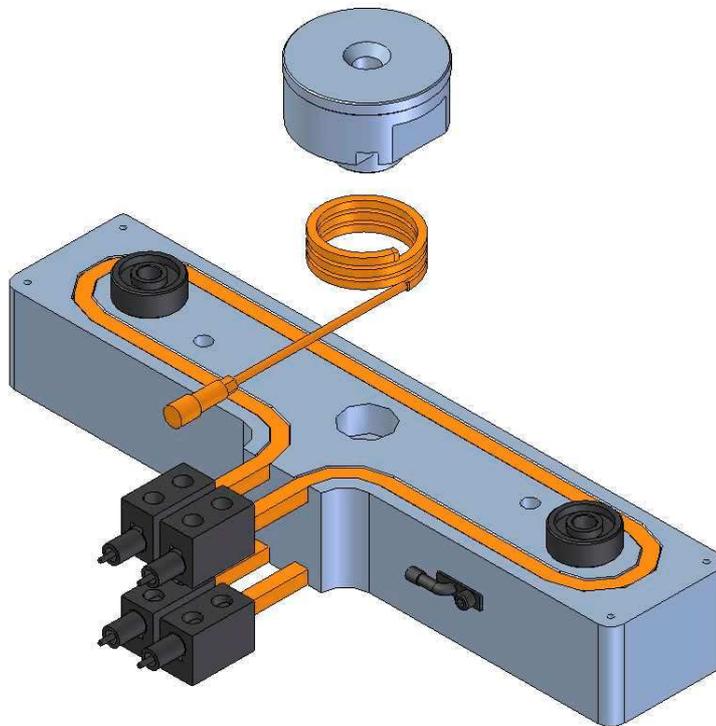


Note:

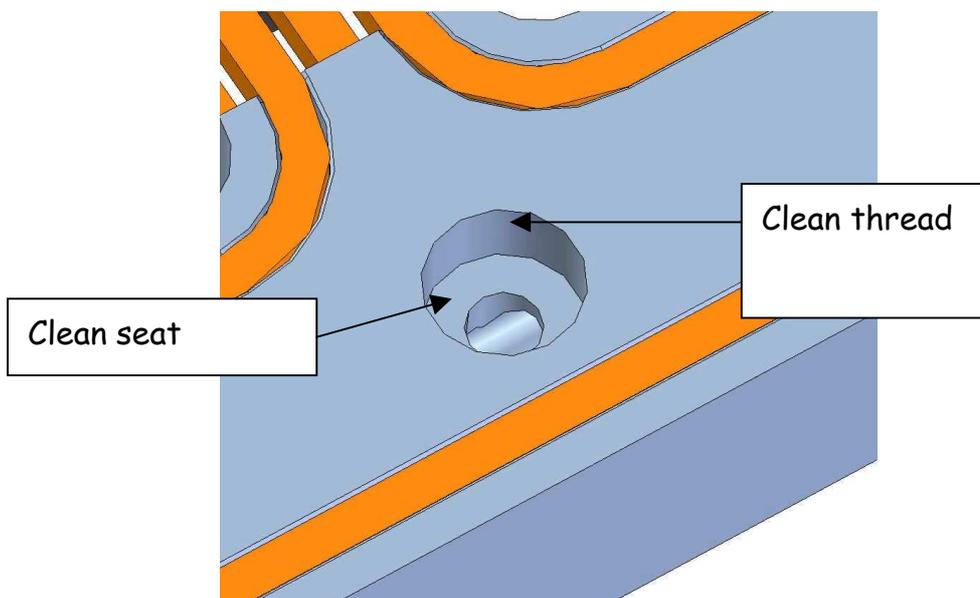
-Only when the manifold heaters were damaged, you can heat the with a welding torch.



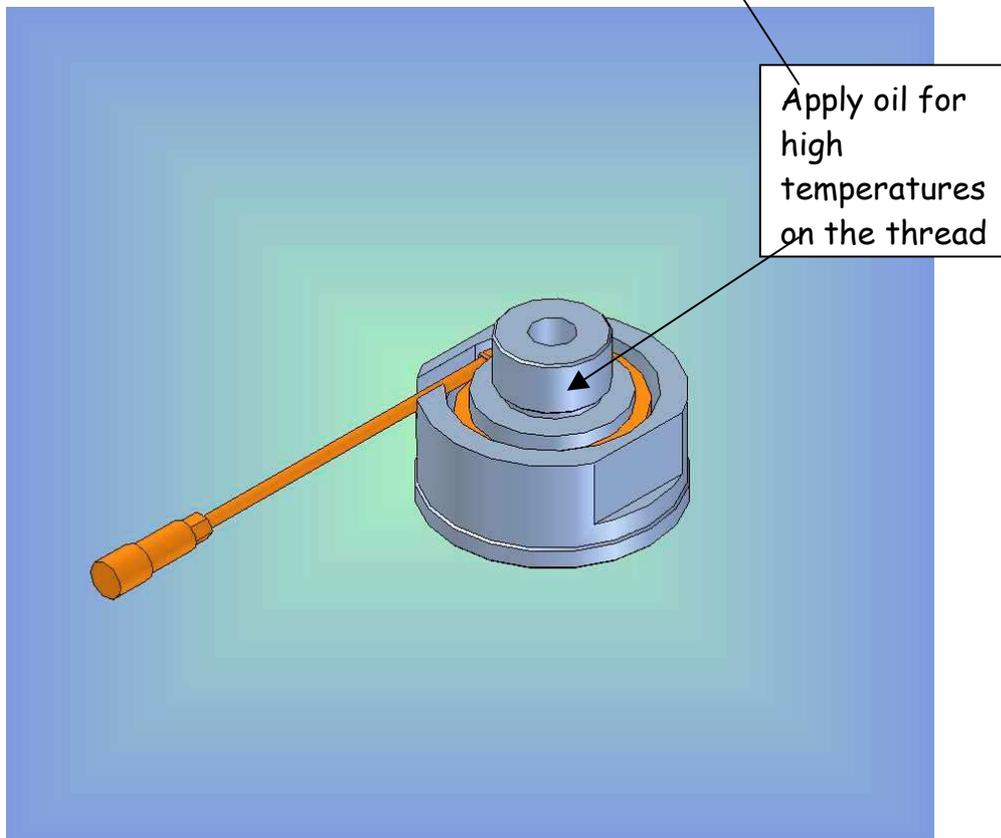
C.-Assembly.



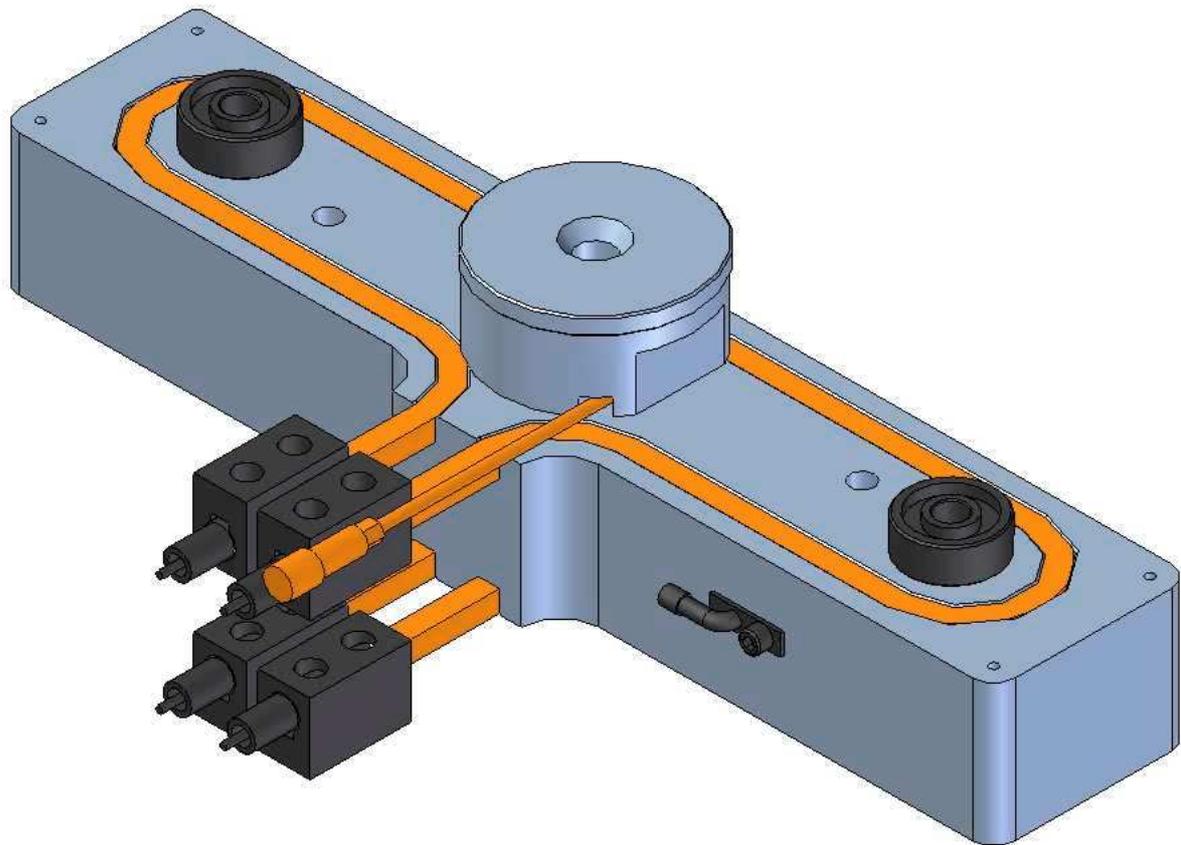
D.-Before you assembly the parts you must clean the plastic and the oil of the hole (thread and seat).



E.-Apply oil for high temperatures on the thread of the nozzle.



F.-Nozzle machine assembled.



ORIHUELA Y MORET, S.A.

DATE: 03.11.09

CHECK 1

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TITULO: NOZZLE MACHINE B55 ASSEMBLY INSTRUCTION.