

FISA Corporation

The American company based in Tullahoma, Tennessee, is the marketing, distributions, and

Versatility and ease of use with the PLAGATE Nozzle

Well balanced gate for multicavity production

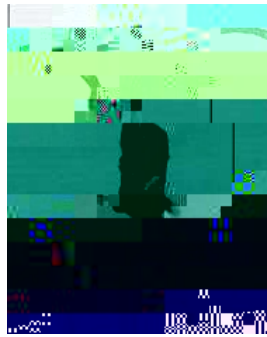
Multicavity gate opens only after the pressure in all nozzles is equal, thus all nozzles open and close simultaneously. This also prevents the nozzles from injecting uneven amounts of resin, insuring continuity in production.

Perfect Gate Seal

The perfect sealing of the gate, through the use of a powerful spring and piston, eliminates problems normally encountered with stringing or drooling of resin, as well as unwanted stubs or projections.

No Build Up Points

PLAGATE Molded Products

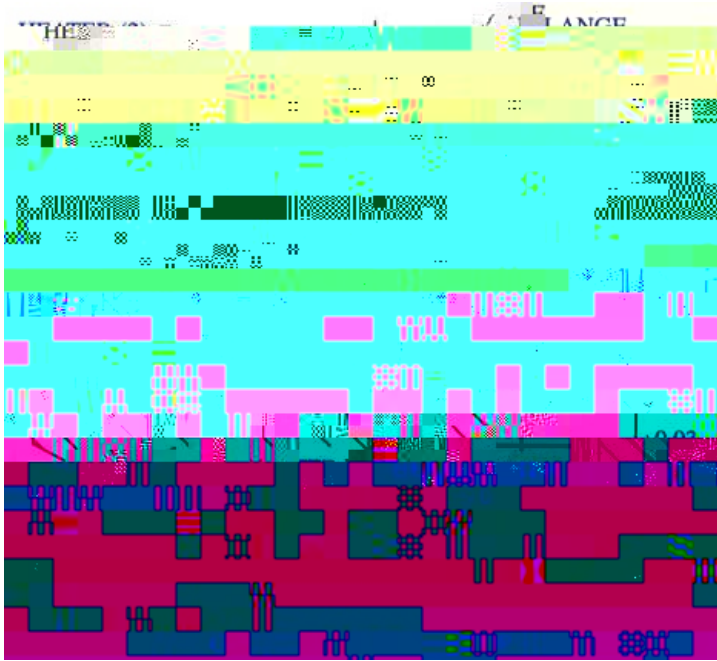


Through the use of the proper

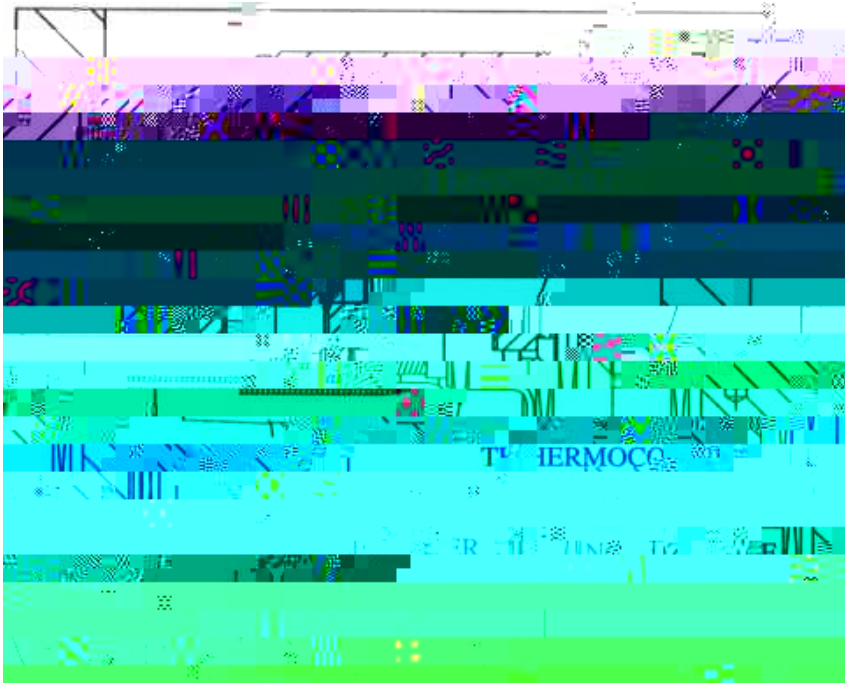
When there is low resin pressure in the nozzle,

Typical Installations

NH & AH Mono Flange Installation

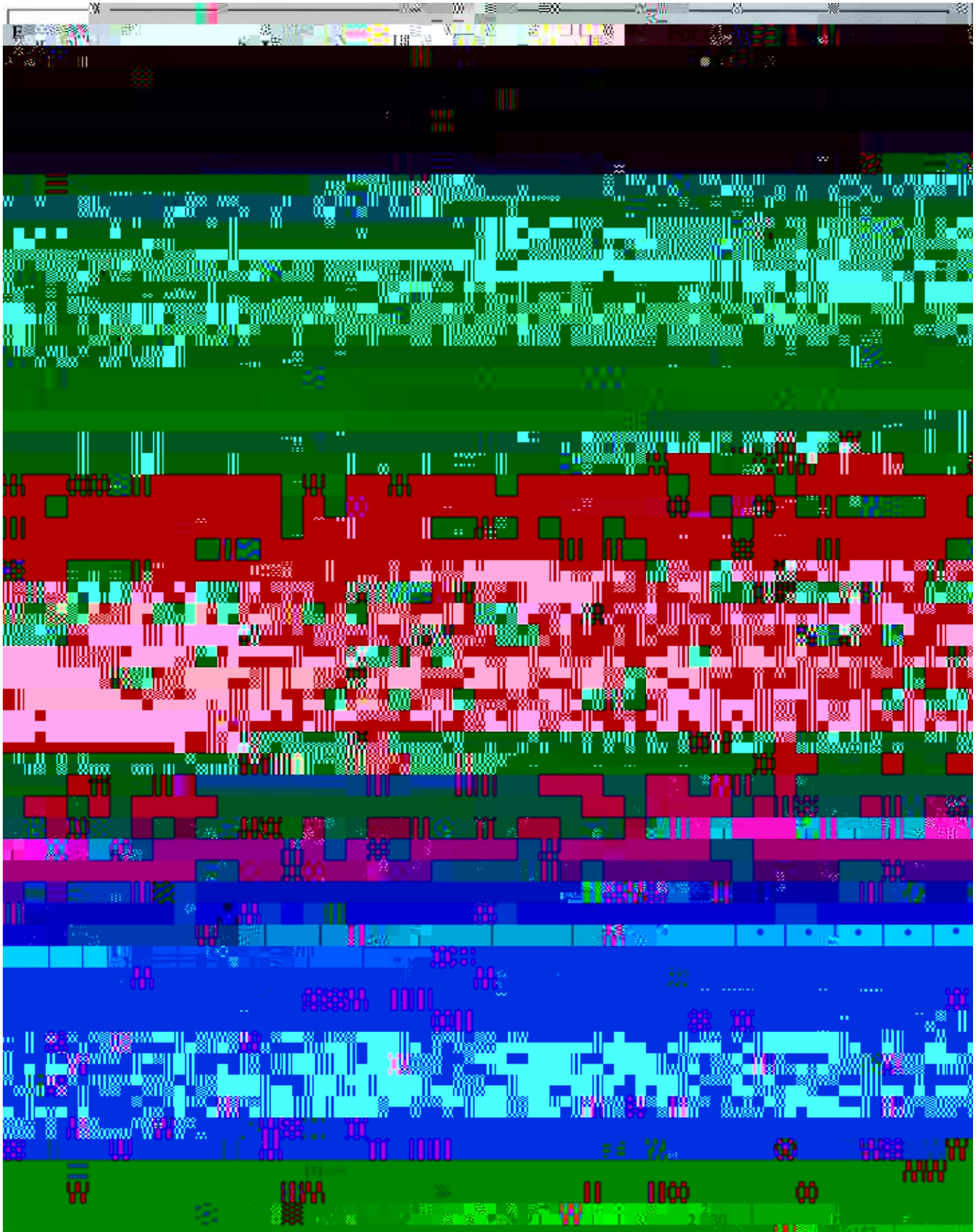


NH & AH Multi-Flange Installation



PLAGATE Nozzles

NH Standard Specifications

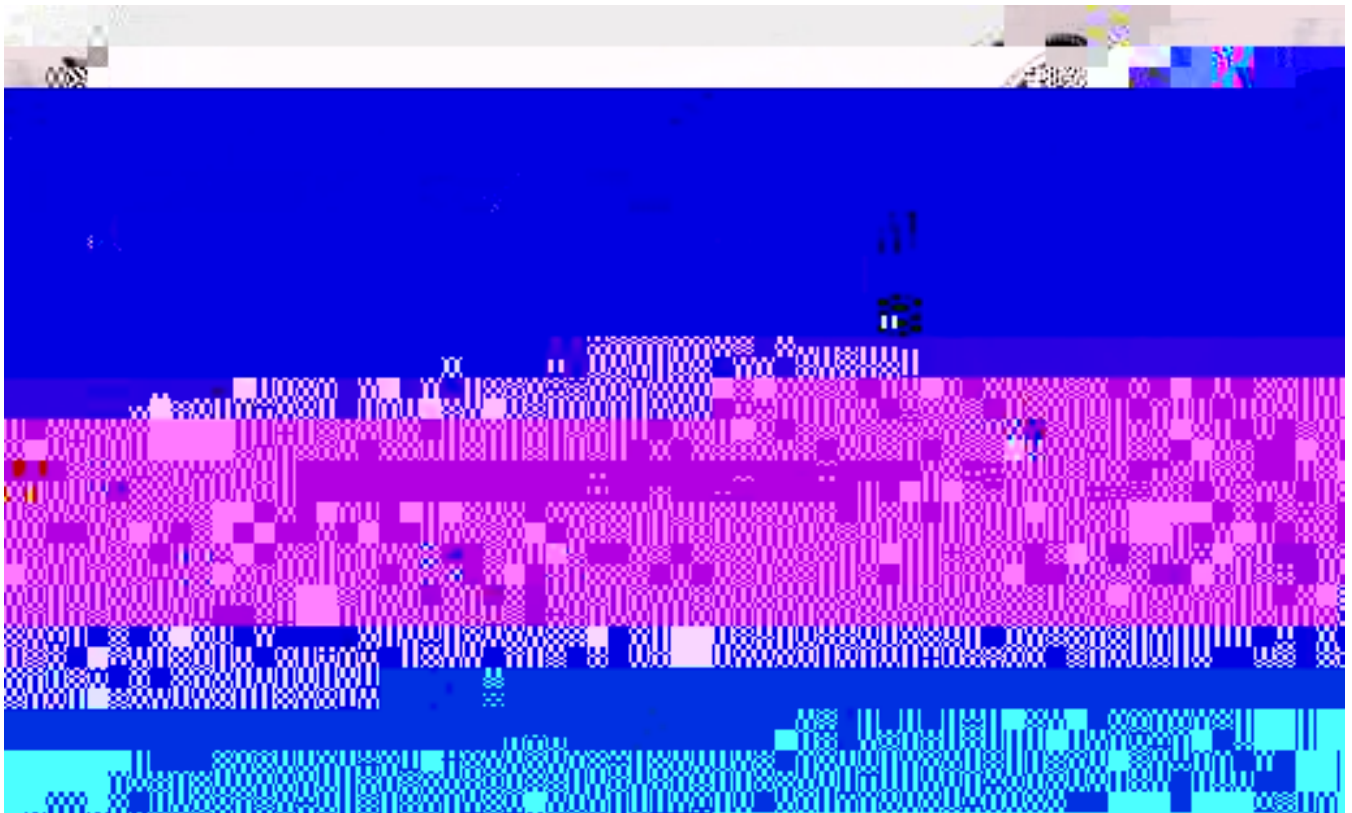


Maintenance Procedure
NH/NR Nozzles
(For

D. Nozzle Components and Nomenclature.



10. Temperature Controller





4. Cleaning the Piston - Use the hand pads to remove any deposits from all surfaces of the piston, including the sealing area grooves. The removal of very

7. Reassembly of the Nozzle - After LIGHTLY coating the seal portion of the piston with the copper based anti-seize, replace parts into the body, in this order: (1) Torpedo rear, (2) Spring, (3) Piston/Torpedo assembly (test piston motion), (4) Cap (hand tight). Coat the body threads with copper anti-seize compound. Place the cap in the vise jaws and torque the body tight (NH2 - 700kg-cm or 50 ft. lbs, 1

Evaluation

NH and AH styles Operating Procedure

C. Startup of System

(With Component(s) Not Full of Resin)

Set the temperature of all "full" components, at the operating temperature. Set the "not full" components to 100 degrees Fahrenheit (55 degrees Celsius) below operating temperature.

the temperature of full components = operating temperature
the temperature of not full components = operating temperature - 50 °F

FISA Anecdote/Things to Know

Topless Systems: When purchasing a topless system, the point of the piston exceeds the top of the cap into the molding area. You do not want the tip to collide with the opposite molding surface. These pistons are made to be ground back from a point. It is fine to take off some of the point, this will not affect the system function.

Cleaning and checking for cracks: This should include a flat surface and some fine grit emery paper. The bottom of the cap should be cleaned, using a flat surface with the emery paper, swirl the cap so that you make sure the surface is flat and cleaned. This is important on.

Notes on PS157 Ring:

Make sure that the PS157 ring is in the machined ring seat.

