

# Precision LV Series—Repair Procedure

## Operating & Servicing Instructions

The Precision LV body designs are identical, but vary in diameter and length.

They feature a replaceable coil heater with integral type 'J' thermocouple.

## Startup / Operating Instructions

Whenever possible, use a temperature controller that automatically senses and safely bakes out wet heaters .e.g. Fast Heat Conductor series.

If your temperature controller does not utilise 'wet start' technology, set the controller to 90°C in automatic or 10% in manual.

Bring the machine nozzle into contact with the bush and allow the bush to 'soak' for at least 20 minutes before increasing to the processing temperature, in order to bake out any residual moisture and prolong heater life.

## Tip Removal / Installation

### Removal

Fit the bush firmly in a vice, using the head flats provided.

Use a suitable socket on the tip and turn anti-clockwise to loosen.

It may be necessary to soften the resin first by heating the bush.

### Installation

1. Clamp the bush firmly in a vice, using the head flats provided.

2. Apply anti-seize sparingly on to male threads of tip.

3. Note—excess anti-seize may contaminate the resin being processed.

4. Use a suitable socket on the tip and torque to the settings specified below.

LV187 = 34Nm, LV250 = 41Nm, LV375 = 48Nm, LV625 = 54Nm

## Component Disassembly / Assembly

### Disassembly

1. Remove heater retaining circlip (not on LV187)

2. Slide heater clamps off bush—if necessary, 'spring' open with circlip pliers or similar.

3. Remove heater by placing hand around coil and carefully turning anti-clockwise, while applying pressure where the leads meet the bush.

### Assembly

1. Slide heater on to bush by placing hand around coil and carefully turning anti-clockwise, while applying pressure where the leads meet the bush.

2. Once correctly positioned, tighten the heater to the bush by turning it clockwise.

3. Slide heater clamps into place—if necessary, 'spring' open with circlip pliers or similar.

4. Refit heater retaining clip (not on LV187).

## Power Requirements

- 240 Volts AC—15 Amp fuse.

- Grounding—Fast Heat bushes utilise the direct contact of the bush, mould plates and machine platens to establish a path for grounding.

## Warning

There must be a ground present between the mould 'Hot Half' and the temperature control system or damage may occur to the heater, thermocouple and / or temperature control system.

The logo for Fast Heat, featuring the word 'fast' in a stylized, italicized font, followed by a red lightning bolt symbol, and the word 'heat' in a similar font.

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