



## Jet with sieve or DMT mixer assembly regulation

- 1) After assembling the current jet it is necessary to check the condition of the thread and contact surface in the plasticizing head.
- 2) Measure the current hole (thread, shoulder, central hole) in the plasticizing head and compare it to the DUKE jet being assembled.
- 3) Perform injection with a worm in the extreme position and check visually whether the top of the worm does not collide with the DUKE jet being assembled.
- 4) If the DUKE jet thread is not coated ( usually with a MOLY sliding paste up to 1000° C of copper or silver colour), coat the thread with a sliding paste. The thread is better protected against seizing-jamming and it is easier to loose.
- 5) Screw the DUKE jet using hand into the heated plasticizing head and wait (about 40min.) before it is heated to the same temperature as the head. Now tighten the jet using a spanner properly!!!
- 6) Assemble the heating tape to the jet and follow the instructions for assembling the heating tape.
- 7) If you find out any change of the operation conditions during operation (pressure rise, drop or increase of temperature...) above the technologically well-founded state look for the cause in the heating tape-whether it is properly and firmly tightened or as for the sieve whether the sieve is clean from possible dirt. Disassemble the heated jet and check it visually. Never do anything that could increase the operation pressure because that may lead to destroying of the inner labyrinth of the mixer.
- 8) If you find out dirt in the sieve disassemble the heated jet and fix it in a vice by the hexagonal surface. Never grip the jet by the diameter. Get rid off the plastic matter around the sieve and mainly around the disassembling bolt head in the middle. The bolt must be screwed out immediately using a Gola nut. Screw the pin with threads pulling instrument in the thread to the end of the thread (a pole with thread on which a ram is set and secured against removing on both ends). By hitting the sieve with the ram remove the sieve. Then clean it with a wire brush, lubricate the disassembling thread with MOLY paste and screw the disassembling bolt back. Insert the sieve with rotary motion using hand back into the DUKE jet.
- 9) The jet shall be assembled according to articles 4), 5).

Signature of the employee with  
the rule was made known

.....