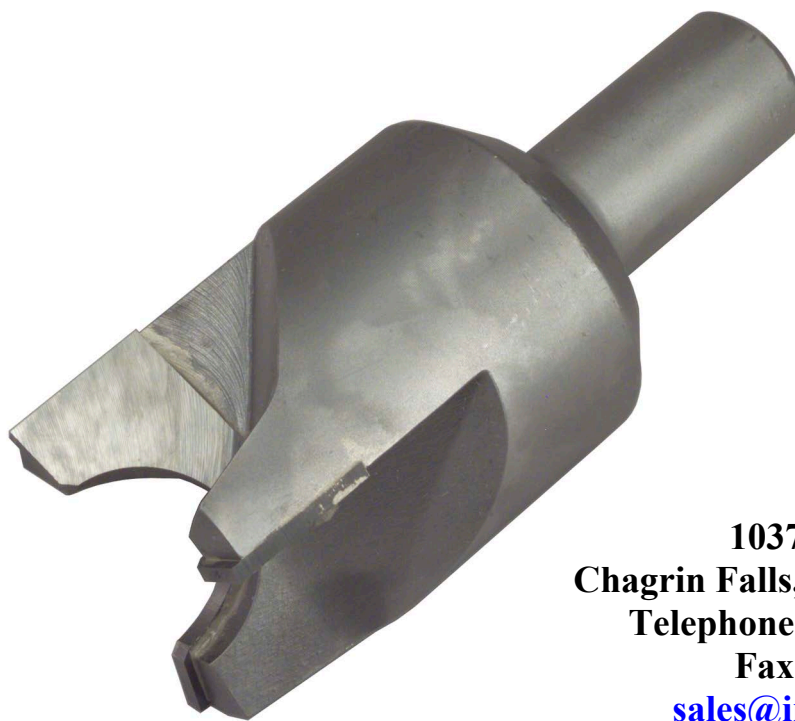




NOZZLE RADIUS REFACING TOOL

**IMS #126252, 127806, 120624,
121727, 121724**
(NZXX-NZL500, NZXX-NZL750, NZXX-NZLM100
NZXX-NZLM150 NZXX-NZLM155)



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REVISIONS				
ECN#	REV	DESCRIPTION	DATE	APPROVED
	001	Deleted Obsolete Part #104957. Added new Part #127806. Added graphic for new part number.	5/04	TEG, TMB, GDH

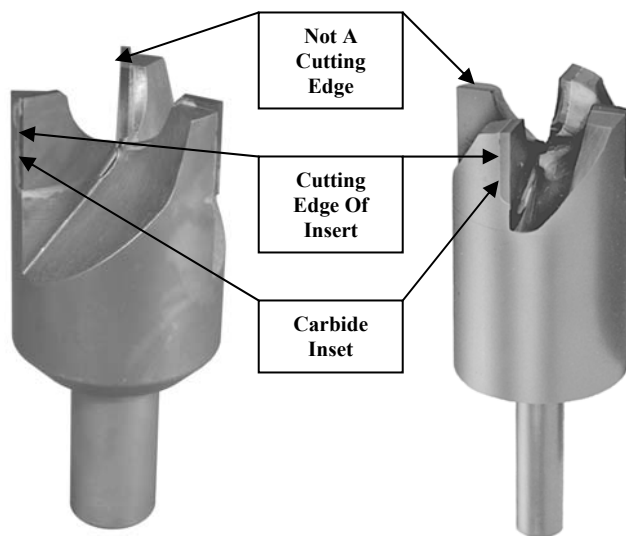
DESCRIPTION

The IMS Nozzle Radius Refacing Tool is a carbide-tipped rotary tool to dress the existing radius on a nozzle. It leaves a smooth, machined surface, ready for polishing.

The smooth, well-shaped surface is needed for a good seal between the nozzle and the sprue bushing. IMS also stocks similar tools for refacing the sprue bushing radius.

INSTRUCTIONS

1. Tool and nozzle must be well aligned and rigidly held. If they are not, the carbide tips on the tool are likely to chip. An engine lathe is the best machine for the job, but you can use a drill press if you rigidly fixture the nozzle in proper alignment with the tool.
2. The best cutting speed is 56 rpm.
3. The tool is not meant to remove large amounts of material.
4. Do not run tool into hexes or into radius that blends polished tip with body. For that reason, the tool cannot be used on 1½" long nozzle tips.
5. Set nozzle in cutter and make sure only the cutting edges of the cutter inserts will touch nozzle.
6. Make sure there is clearance between the non-cutting edges of the tool and the radius that blends the polished tip of the nozzle into the nozzle body. If there is not, turn nozzle body back to allow clearance.
7. Coat nozzle radius with oil to make cutting easier and to make tool last longer.
8. Lightly apply tool to nozzle. Shave off just a small amount of material at a time.
9. After refacing, polish nozzle as required.



Part #126252, 127806

Part #120624, 121727, 121724

Only cutting edge of inserts should touch nozzle. Turn nozzle back if necessary.

