

Set-up/Pulling Mold Procedure & Check List

Press _____ PMC Mold No. _____

Setting Up The Mold - Check When Done

Complete N/A

- 1. Review the set-up instructions and make sure area is clean and ready for setup.
- 2. Make sure platen is clean and position mold on stationary platen by aligning locating ring on mold with locating hole in platen.
- 3. Level mold (very important for ejector rod alignment with ejector plate).
- 4. Clamp mold to stationary half - mold clamp bolt as close to mold as possible
- 5. Load program for the mold.
- 6. Plug in all switches sending core signals and ejector back signals.
- 7. Install correct length and type (positive or floating) of ejector rod(s).
- 8. Remove safety strap.
- 9. If positive knockout rods, bolt knock out rods to machine ejector plate.
- 10. If it applies, connect hot runner control wiring.
- 11. Install water line hoses – set water heater to correct temperature
- 12. Install hydraulic hoses on mold with hydraulic core pull.
- 13. Install correct nozzle tip, refer to notes in set-up book or ask process tech.
- 14. If applies; install nozzle tip heater with temperature controller
- 15. Open mold and remove all “mold-saver”
- 16. Clean mold faces with “mold cleaner” - wipe out cavities and clean parting lines.
- 17. Grease core slides, horn pins, and leader pins as applicable.
- 18. Check ejector stroke.
- 19. Perform die height adjustment
- 20. Insert change only

Supervisor Signature / Date

Pulling The Mold - Check When Done

Complete N/A

- 1. Clean mold faces with “mold cleaner” and spray with “mold saver”.
- 2. Purge water lines - Remove water hoses
- 3. Remove hydraulic hoses.
- 4. Remove plug for core signals and ejector signal and plug back into press.
- 5. Remove ejector rods.
- 6. Bolt on safety strap.
- 7. Remove mold from machine and place on mold rack in its place.
- 8. Insert change only

Supervisor Signature / Date