

[Names of Parts]

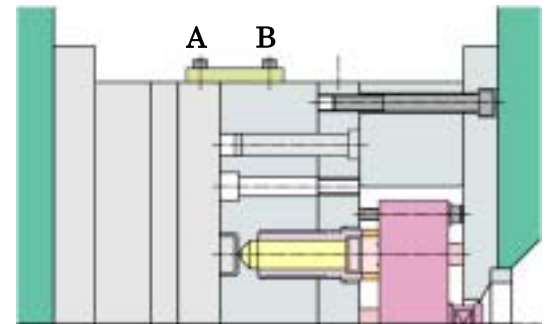
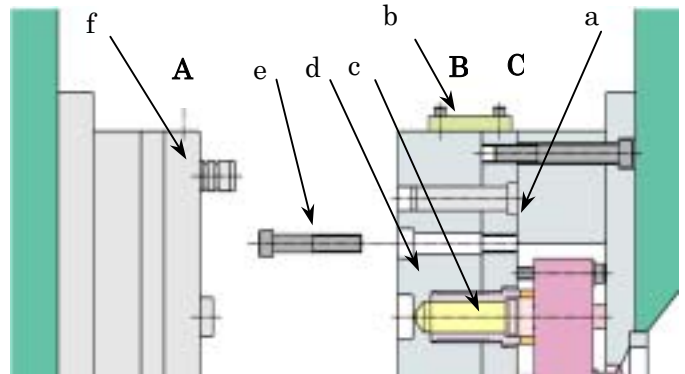
a	Back plate	b	Tension link	c	Insulative layer
d	Cavity plate	e	Mold Plate Locking Bolt	f	Core plate

WARNING

- Pay attention to the structure of the mold before beginning the procedure.
- Make sure you wear all the protection to avoid any possible injury or skin burn. (Heat-resistant gloves, glasses, etc.)

CAUTION

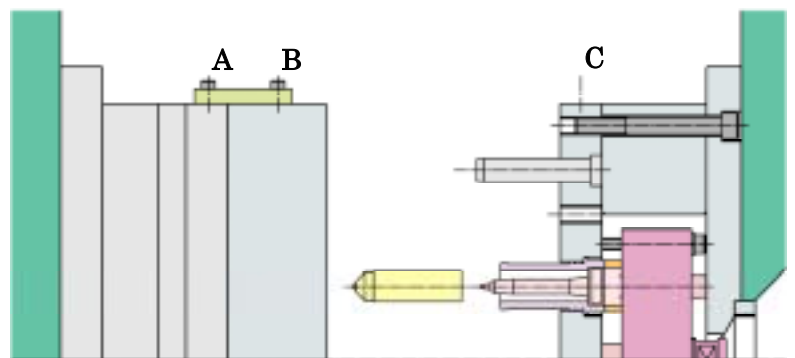
- Heat the manifold and the probes up to the heat-deformation temperature of the plastic resin (4.6kgf/cm²).
- The cavity plate is to be pulled with the movable platens. Pay attention not to damage the water hoses.
- Back plate have to be cooled off by running water during the procedure, otherwise the plate expands and disturb the mold closing.
- Pay attention not to damage the Spear tip, etc.



1. Remove Mold Plate Locking Bolt[e] while the mold is open.

2. Close the mold.

Slide a tension link[c] to the position between A and B (Shown in a figure at right), and connect a cavity plate[d] and a core plate[f]. Insert the tip of the pulling tool.



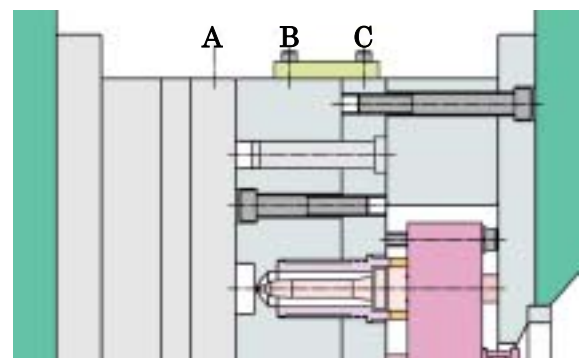
3. When the mold is open, a cavity plate will be slide off. (Attached to the core plate side.)

Take insulative layer[c] out. (Do not damage the spear tip.)

4. Take insulative layer[c] out.

(Do not damage the spear tip.)

5. Close the mold and slide back a tension link[b] to the position between B and C (Shown in a figure at right).



6. Open the mold again and tighten a Mold Plate Locking Bolt [e].

When you clean the solidified resin on insulative layer, set the body temperature 50 ~ 100°C lower than the molding process temperature. For the manifold, work right after the heater is turned off.