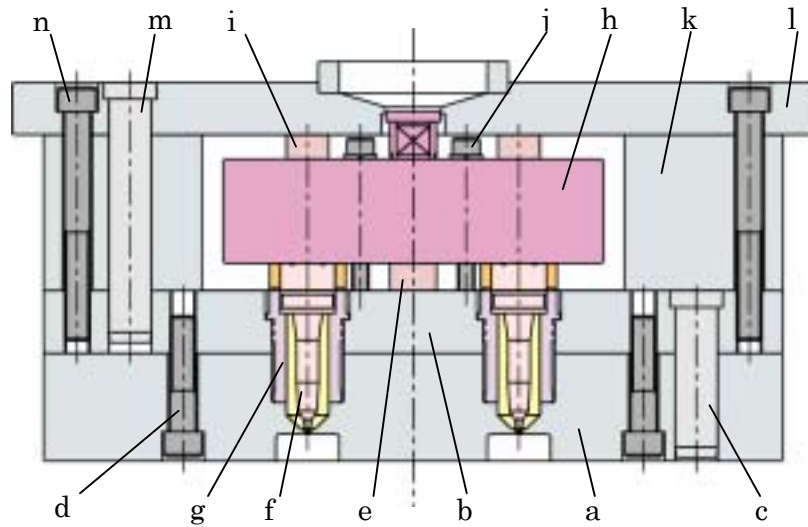


[Structure of the D series Mold]



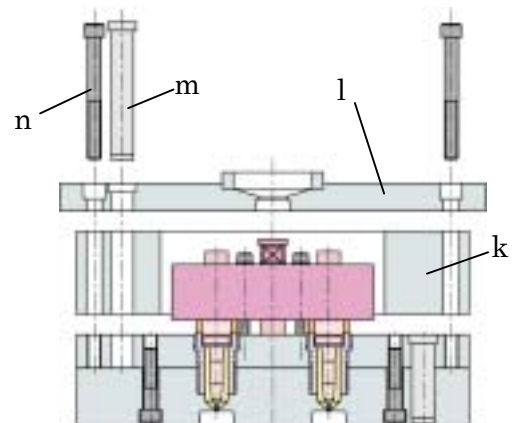
[Names of Parts]

a. Cavity Plate	b. Back Plate	c. Guide Pin A
d. Mold Plate Locking Bolt A	e. Lower Riser Pad (Center Ring)	f. Spear D series
g. Runner Bushing	h. Manifold	i. Upper Riser Pad
j. Manifold Locking Bolt	k. Spacer Block	l. Clamping Plate
m. Guide Pin B	n. Mold Plate Locking Bolt B	o.

WARNING

Make sure to turn the power off before starting these processes. Failure to follow this instruction may result in extreme injury or death by electric shock. These conditions may also damage the Spear D series and the cartridge heater.

These processes are based on the standard Seiki system. Please check your system carefully before starting these processes.



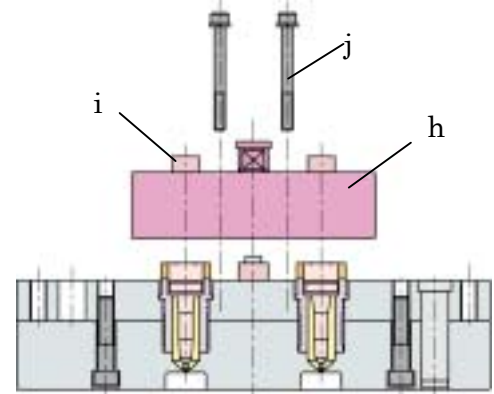
[Preparation for Disassembly]

Please detach the mold from the connector box before disassembling the mold.

[Disassembly]

1. Remove mold plate locking bolt B [n] and a guide pin B [m].
2. Remove a clamping plate [l] and a spacer block [k].
3. Remove manifold locking bolts [j] and manifold [h].

Manifold and Spear D series are connected with a runner. Lift the manifold slightly (about 1mm) and split the runner by tapping the mold with a plastic hammer.



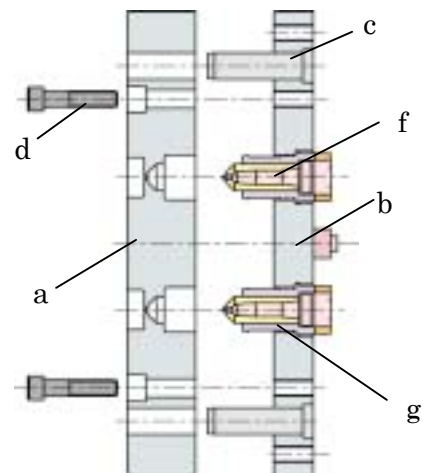
WARNING

The manifold could be very hot and may result in personal injury if you do these processes right after molding process.

4. Remove Spear D series [f] and runner bushing [g].

Removing the manifold releases Spear D series [f] and runner bushing [g].

* For the maintenance of the Spear D series please refer [Spear_D Series Maintenance].



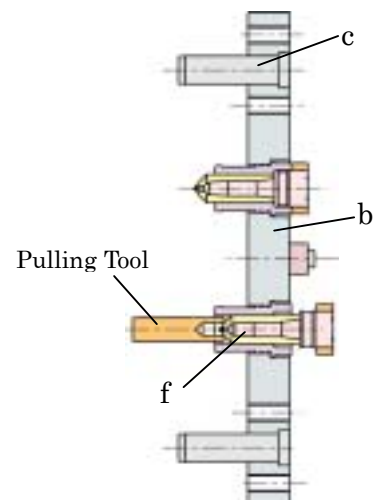
5. If the Spear D series don't come off.

If the Spear D series don't come off, go back to step 4 and stand the mold upright then unbolt the mold plate locking bolts A.

Unbolting the mold plate locking bolts A releases the cavity plate.

WARNING

Latch the back plate [b] to prevent the mold from falling when you work on step 5.



6. Remove Spear D series [f].

Insert a pulling tool (such as copper stick) to the tip of the Spear D series. Remove the Spear D series by tapping the pulling tool lightly.

< Pulling tool for D series Spear D series >
 Dia.16 (outer diameter) × 60 (length)---Made with copper (soft metal)
 Dia.8 (inner diameter) × 15 (depth) clearance hole
 (to prevent the tips from chipping)

*** We provide the pulling tool by request.**

⚠ WARNING

Please handle the Spear D series with care when you use a pulling jig or the tips will be chipped.

⚠ CAUTION

Latch the back plate [b] to prevent the mold from falling when you work on step 6.

7. Remove runner bushing [g]

Insert a pulling tool (such as copper stick) into the tip of the runner bushing [g].Remove the runner bushing by tapping the pulling tool lightly.

< Pulling tool for runner-bushing >
 About the size of the runner bushing ---Made with copper (soft metal)

⚠ WARNING

Latch the back plate [b] to prevent the mold from falling when you work on step 7.

