



[ Disassembly ]

1. Remove mold plate locking bolt B [ n ] and the guide pin B [ m ] .

2. Remove the clamping plate [ m ] and a spacer block [ k ] .

3. Remove manifold locking bolts [ j ] and manifold.

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



The manifold could be very hot if you disassemble it right after the molding process. Work cautiously to prevent personal injury.

4. Spear ESN [ f ] are visible now.

\*For the maintenance of the Spear ESN at this point, please refer [ Spear\_ESN Maintenance ] .

5. Remove Spear ESN anchor blocks [ g ] .

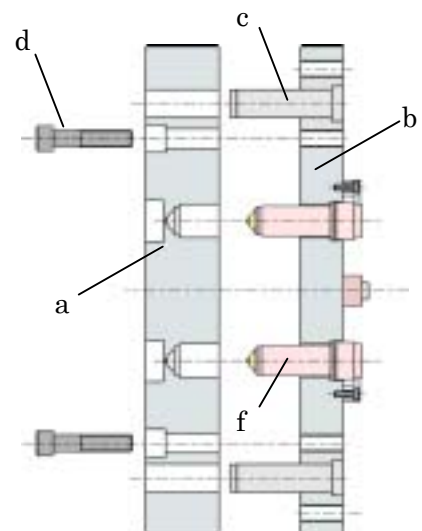
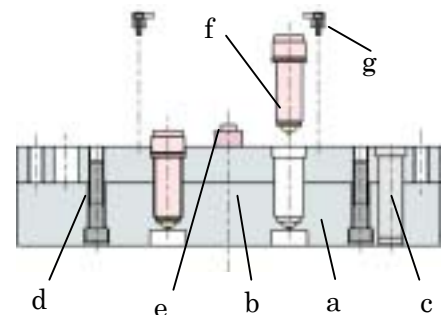
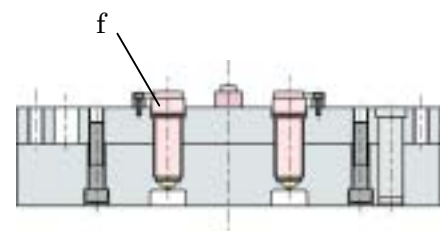
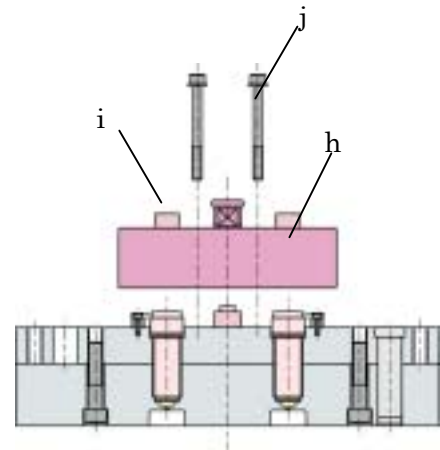
Spear ESN anchor blocks [ g ] are bolted down with M4 bolt (C.S.B).

Unbolting them releases the Spear ESN anchor blocks.

6. Remove Spear ESN [ f ] .

Removing the Spear ESN anchor blocks [ g ] releases Spear ESN.

\*For the maintenance of the Spear ESN, please refer [ Spear\_ESN Maintenance ]



**7. If the Spear ESN wouldn't come off.**

If the Spear ESN wouldn'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.



**CAUTION**

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

**8. Remove the Spear ESN anchor blocks [ g ] and insert a pulling tool (such as Cu stick) into the tip of the Spear ESN.**

\* Remove the Spear ESN by tapping the pulling tool lightly. \*

**< Pulling tool for Spear ESN >**

16 (outer diameter) × 60 (length)---Made with Cu (soft metal)

8 (inner diameter) × 15 (depth) clearance hole (to prevent the tips from chipping)

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



**CAUTION**

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

