

SR NO.	CHECK POINTS	OBJECTIVES	CHECKING METHOD	ACTUAL	REMARKS
<b>CORE SIDE</b>					
1	Parting Line	Free from damage,bulging,rust,Burr etc	Visual/Manual		
2	Core Surface	Free from rust,damge,dulging etc. Ejector pins/blocks should be matching to core surface	Visual/Manual		
3	Core Surface ( Textured)	Free from Rust &damage	Visual/Manual		
4	Gate Insert	Free from damage,surface damage,loose fitment	Visual/Manual		
5	Core Pins/Ejector/Sleeves/Return Pins	Free from scoring,bend & dimension check	Visual/Manual		
6	Guide Pillar/Bush	Free from scoring,bend & loose fitment	Visual/Manual		
7	Cooling System	Cooling channels to be free from rust,Leakage & blockage. Water flow rate:5-6 ltr/minfor cooling channel dia 6mm&16-20ltrs/min for cooling channel dia10-12 mm. Hole thread should be free from damage Cooling plugs free from leakage	Visual/Manual		
8	Ejector System	Free from noise,movement,jam etc. Ejector back plate should be free from scorig,bellmouth,etc.	Visual/Manual		
9	Ejector Springs,Gas Springs	Free from damages,mis-location,bolt losseness & check for tension	Visual/Manual		
10	<b>Air Vents</b>	<b>Free from damage,dust etc.( Perodic Cleaning with WD -40 cleaning Agent )</b>	Visual/Manual		
<b>SLIDERS,SIDE CORE</b>					
1	Angular Rod	Free from scoring,bend & loose fitment	Visual/Manual		
2	Wedges,Wear Plates,Guide rails	Free from scoring,bend & loose fitment	Visual/Manual		
3	Springs	Free from breakage,Misalignment,lack of strength/Tension	Visual/Manual/Lab testing		
4	Stoppers,Ball Catchers	Free from damge,screw hole damage,jam,etc.	Visual/Manual		
5	Cooling System	Cooling channels to be free from rust,Leakage & blockage. Water flow rate:5-6 ltr/minfor cooling channel dia 6mm&16-20ltrs/min for cooling channel dia10-12 mm. Hole thread should be free from damage Cooling plugs free from leakage	Visual/Manual		
6	Side Core Product Area ( Textured)	Free from Rust &damage	Visual / Manual		
<b>LIMIT SWITCHES,CONNECTORS</b>					
1	Limit Switch	Free from damage,looseness & mis-position./Check for continuity in the limit switch cables	Visual/Manual Multimeter		
2	Connectors	Check for working condition & loose wiring	Visual/Manual		
<b>OBSERVATION ON PART/MOULD HISTORY</b>					
1	Parting line flash	Check for Parting line,Blue matching	Manual/Spotting Press/On Injection		
2	Welding/Burnmark/Shortfill	Free from airvents blockage/No Change in process parameters	Visual/Manual		
3	Flash on Ejectors	Check for Ejector hole "Bellmouth Formation"	Visual/Manual		
4	Ribs/Features Catching	Check for rusting in Rib/Feature area,Burr on edges,etc	Visual/Manual		