

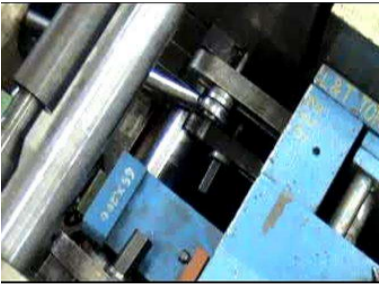



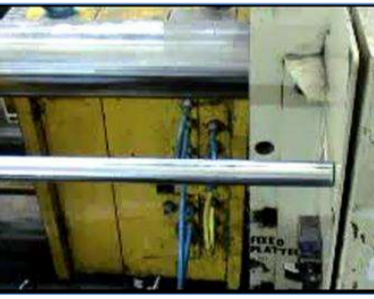







JAIRAJ ANCILLARIES PVT LTD.

MOULD CHANGE (SOP)

Rev details -	Rev 00	New Release	01.01.2020	SOP.No.	WI-QMS-30
	Rev 01	Ejector Rod Adjustment SOP added wrt the Ejector plate loosening issue -Step no 7 & 8 updated.	30.05.2022	Issue Date	26.10.2024
	Rev 02	Mould Core Half Guide pin/Bush check point added with respect to alignment with Cavity Half.	26.10.2024	Rev no.	02'

Step- 1	Step- 2	Step- 3	Step-4	
Anti rust Spray Application inside Mould	Mould closing & Locking	Crain Hook Attachment	Opening of Clamps	
				
Step- 5	Step 6	Step 7	Step 8	
Operator Side & Back Side	Unload Previous Mould	Ejector Rod Adjustment - Check mould centre hole depth and ejector bolt height for ejector bolt adjustment .	Ejector Rod Adjustment - Load the mold considering the bolt size and mould back plate hold size should be equal to avoid bolt loosening issue.	
				
Step- 9	Step- 10		Step-11	Step- 12
Load & adjust next planned Mould inside machine	Mould closing & Mould Height Adjustment with Guide Pillar & Bush Inspection.		Mould Clamping	Operator Side & Back Side
				
Step- 13	Step- 14	Step- 15	Step- 15	Step- 16
Removal of Crane hook & Checking of Mould Opening & Closing	Water Pipe Fitting & Water Leakage Testing	Core In-Out Testing & Limit Switch	Hydraulic Oil Pipe Fittment	Core In-Out Testing & Limit Switch Confirmation Checking
				

Prepared By

Approved By