



TOOL PREVENTIVE MAINTENANCE CHECK LIST

JAIRAJ ANCILLRIES PVT LTD. - A'BAD
Format no.: F/TR/03 .00. 01.01.2020

Tool/Part Name : Bush plastic	PM Done By : Amol wanthule	Plan Date :
Part Number : S2KZ01102B	Checked By : Ganesh mhaske	PM Done Date : 24/06/23

SR NO.	CHECK POINTS	OBJECTIVES	CHECKING METHOD	ACTUAL	REMARKS
COMMON ELEMENTS OF THE TOOL					
1	Lifting Hole	Free from thread damage & rust etc.	Visual/Manual	dust सापडली	कपड्याने साफ केली.
2	Mold Lock Plate	Free from damage & missing bolts .Presence of all lock plates.	Visual	NA	-
3	Tool Leg	Free from damage,looseness,rusting etc.	Visual/Manual	NA	-
4	Cooling Manifold,QRC	Free from damage,leakage,Damages etc.	Visual	NA	-
5	Hydraulic Systems	QRC-Free from damages & leakage. QRC Should get locked smoothly.	Visual/Manual	NA	-
6	Mold Overall Surface	Free from damage, rust etc.	Visual/Manual	Rust सापडली	WD40ने ने साफ केले
7	Latches,CAM Rod etc	Free from damage,Scoring & rust etc.	Visual/Manual	NA	-
8	Top & Bottom Plate Surface,Color code checking	Free from damage, rust etc./Cheack Customer wise identification color code	Visual/Manual	NA	-
9	Mould Status Color Code,Calendar Up date	Check status update.Check expiry year	Visual/Manual	NA	-
10	Loading insert area	Check all critical dimensions,Check for damages, rust, scoring.	Visual/Manual	Rust सापडली	कपड्याने व WD40ने ने साफ केले
CAVITY SIDE					
1	Parting Line	Free from damage,bulging,rust,Burr etc	Visual/Manual	Burr सापडली	पॉलिश पेपर ने धावून काढली.
2	Cavity Surface (Textured)	Free from Rust & damage	Visual	Rust सापडली	WD40ने ने साफ केले
3	Cavity Surface (Polished)	Free from Scratches,dents,rust etc.	Visual	OK	OK
4	Connectors	Free from damage & improper tightening	Visual/Manual	OK	OK
5	Cooling System	Cooling channels to be free from damages & wear out.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	OK	OK
6	Guide Pillar/Bush	Free from scoring,bend & loose fitment	Visual/Manual		ऑयलिंग केले
HOT RUNNER SYSTEM					
1	HRS System & Manifold	Check for continuity to all heaters .Check for continuity to all thermocouples.Check for material leakage	Multimeter, Visual/ Manual	NA	-
2	HRS Connector	Free from damage,looseness,loose wiring,dust etc.	Visual/Manual	NA	-
3	Heat Insulator Plate	Free from damage,loose mounting	Visual/Manual	NA	-
4	Sequential Valve	Free from damage,loose mounting,loose wiring,etc.	Visual/Manual	NA	-
5	Hot Runner Assembly	Free from leakage,loose mounting	Visual/Manual	NA	-

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CORE SIDE					
1	Parting Line	Free from damage, bulging, rust, Burr etc	Visual/Manual	Rust सापडली	क्याचीने साफ केले
2	Core Surface	Free from rust, damage, bulging etc. Ejector pins/blocks should be matching to core surface	Visual/Manual	OK	OK
3	Core Surface (Textured)	Free from Rust & damage	Visual/Manual	Rust सापडली	वॉशने साफ केले
4	Gate Insert	Free from damage, surface damage, loose fitment	Visual/Manual	OK	OK
5	Core Pins/Ejector/Sleeves/Return Pins	Free from scoring, bend & dimension check	Visual/Manual	OK	OK
6	Guide Pillar/Bush	Free from scoring, bend & loose fitment	Visual/Manual	OK	OK
7	Cooling System	Cooling channels to be free from damages & wear out. Water flow rate: 5-6 ltr/min for cooling channel dia 6mm & 16-20 ltr/min for cooling channel dia 10-12 mm. Hole thread should be free from damage. Cooling plugs free from leakage	Visual/Manual	OK	OK
8	Ejector System	Free from noise, movement, jam etc. Ejector back plate should be free from scoring, bellmouth, etc.	Visual/Manual	Ejector plate Jam	Ejector plate खोलून पुन्हा मॉडेल
9	Ejector Springs, Gas Springs	Free from damages, mis-location, bolt looseness & check for tension	Visual/Manual	Bolt loose	Bolt टाईट केले
10	Air Vents	Free from damage, dust etc.	Visual/Manual	Dust सापडली	क्याचीने साफ केले
SLIDERS, SIDE CORE					
1	Angular Rod	Free from scoring, bend & loose fitment	Visual/Manual	NA	-
2	Wedges, Wear Plates, Guide rails	Free from scoring, bend & loose fitment	Visual/Manual	NA	-
3	Springs	Free from breakage, Misalignment, lack of strength/Tension	Visual/Manual/Lab testing	NA	-
4	Stoppers, Ball Catchers	Free from damage, screw hole damage, jam, etc.	Visual/Manual	NA	-
5	Cooling System	Cooling channels to be free from damages & wear out. Water flow rate: 5-6 ltr/min for cooling channel dia 6mm & 16-20 ltr/min for cooling channel dia 10-12 mm. Hole thread should be free from damage. Cooling plugs free from leakage	Visual/Manual	NA	-
6	Side Core Product Area (Textured)	Free from Rust & damage	Visual/Manual	NA	-
LIMIT SWITCHES, CONNECTORS					
1	Limit Switch	Free from damage, looseness & mis-position./Check for continuity in the limit switch cables	Visual/Manual Multimeter	NA	-
2	Connectors	Check for working condition & loose wiring	Visual/Manual	NA	-
OBSERVATION ON PART/MOULD HISTORY					
1	Parting line flash	Check for Parting line, Blue matching	Manual/Spotting Press/On Injection	OK	मॅनवली मॅचिंग केले.
2	Welding/Burnmark/Shortfill	Free from air vents 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	Visual/Manual		
5	Break Downs	Check Mould last break down History and Customer Complaints related to moulds	Visual/Manual		
Prepared By (with Date): Amol wahstule - Amol		Checked By (with Date): Ganesh mhaske - Ganesh		Verified By (with Date):	