

TOOL PREVENTIVE MAINTENANCE CHECK LIST

Tool/Part Name:- Gas Cap		PM Done By -	DONE DATE:-		
Part Number:- S2FF0802B		Checked By -	Page 1 of 2		
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		
2	Mold Lock Plate	Free from damage & missing bolts Presence of all lock plates.	Visual		
3	Tool Leg	Free from damage,looseness,rusting etc.	Visual/Manual		
4	Cooling Manifold,QRC	Free from damage,leakage,Damages etc.	Visual		
5	Hydraulic Systems	QRC-Free from damages & leakage.QRC Should get locked smoothly.Ⓜ	Visual/Manual		
6	Mold Overall Surface	Free from damage, rust etc.	Visual/Manual		
7	Top & Bottom Plate Surface,Color code checking	Free from damage, rust etc./Check Customer wise identification color code	Visual/Manual		
8	Mould Status Color Code,Calendar Up date	Check status update Check expiry year	Visual/Manual		
CAVITY SIDE					
1	Parting Line	Free from damage,bulging,rust,Burr etc	Visual/Manual		
2	Cavity Surface (Textured)	Free from Rust & damage	Visual		
3	Cavity Surface (Polished)	Free from Scratches,dents,rust etc.	Visual		
4	Connectors	Free from damage & improper tightening	Visual/Manual		
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		
6	Guide Pillar/Bush	Free from scoring,bend & loose fitment	Visual/Manual		
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		
2	HRS Connector	Free from damage,looseness,loose wiring,dust etc.	Visual/Manual		
3	Heat Insulator Plate	Free from damage,loose mounting	Visual/Manual		
4	Sequential Valve	Free from damage,loose mounting,loose wiring,etc.	Visual/Manual		
5	Hot Runner Assembly	Free from leakage,loose mounting	Visual/Manual		

CORE SIDE					
1	Parting Line	Free from damage,bulging,rust,Burr etc	Visual/Manual		
2	Core Surface	Free from rust,damage,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/Profile Projector		
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 looseness & check for tension	Visual/Manual		
10	Air Vents	Free from damage,dust etc.	Visual/Manual		
SLIDERS,SIDE CORE					
1	Springs	Free from breakage,Misalignment,lack of strength/Tension	Visual/Manual/Lab testing		
2	Stoppers,Ball Catchers	Free from damge,screw hole damage,jam,etc.	Visual/Manual		
3	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		
LIMIT SWITCHES,CONNECTORS					
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		
OBSERVATION ON PART/MOULD HISTORY					
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	Break Downs	Check Mould last break down History and Customer Complaints related to moulds	Visual/Manual		