

Mold Maintenance Operation

Instructions

模具维护保养作业指导书

Date: _____
Revision: _____

Project Name: _____ Part Name: _____ Tool Name: _____ Tool source: _____ Tool Steel: _____ Resin: _____	Project Number _____ Part Number: _____ Tool Number: _____ Customer: _____ No of Cavities: _____ Machine Size: _____
--	---

No. 序号	Inspection and maintenance items 检查保养项目	Inspection and maintenance contents 检查维护内容	Frequently Asked Questions 查见问题	Solution 解决方法	Instrument 工具	Precautions 注意事项	Remark 备注
1	Mould lifting, mould opening and mould turning 模具吊运、开模和模具翻转	Mold 模具主体	The mold hoisting level is unstable 模具吊装水平不稳	Reattach the lifting rope or maintain equal loop length and balanced positioning. 重新穿插吊绳或吊环长度和位置	lifting rope, single-beam bridge crane 吊绳、单梁行吊	The two lifting ropes are of equal length, and the mold is level when it lands on the ground. Check that there is no foreign matter in contact with the mold and the ground to prevent damage or contamination of the bottom surface of the mold.	Protect the lock module 上下模做好锁模块保护
2	Mold parting surface 模具分型面	Core & Cavity mold and parting surfaces(check if there are part collapsing.) 凸凹模及分型面	Ppart collapsing 出现小的凹坑	Tell the mold engineer and modify it after confirming the cause.	Visual inspection, 目测	Welding is not allowed without the consent of the technical department 没经技术部同意不得焊接	
		Is there Flash? 有没有披锋	Sliders, R angles, flanging shaping edges, etc. 滑块、R角、翻边整形刀口等	Smooth and polish with an oilstone 用油石打磨抛光	Oilstone, sandpaper, etc. 油石、砂纸等	Grinding machine is not allowed 不允许用砂轮机打磨	Reference production final part 参考制作最终零件
3	Disassembly of mold parts 模具零件的拆卸	Various parts of the mold 模具各部件	Missing parts, such as pins, ejector pins, etc., high spacers, springs, etc. 缺少零件, 如销钉、顶杆等、高垫片、弹簧等。	Replenish or replace damaged parts 更换损坏的部件	T-shaped wrench, Allen wrench, etc. T形扳手、六角扳手等	The specifications and models of the replaced parts are the same as the original ones 更换的零部件规格型号与原厂相同	Parts are classified and arranged in order 零件按顺序分类摆放
4	Guide parts 导向零件	Guide pins, guide sleeves and guide plates, etc. 导柱、导套和导板等	Flashing, looseness and large gaps, etc. 披锋、松动和间隙大等	Use oilstone to smooth, tighten and adjust the gap 用油石推光滑、紧固、调整间隙	Oilstone, Allen wrench, etc. 油石、内六角扳手等	Grinding machine is not allowed 不允许用砂轮机打磨	If the gap is large, the mold engineer will arrange for repair.
5	Positioning parts 定位零件	Positioning pins, positioning blocks 定位销、定位块	Missing, loose, damaged 缺失、松动、损坏	Replenish or replace and tighten 补充或更换并拧紧	Allen wrench, pin puller 六角扳手、拔销器	When replacing parts, the location cannot be changed 更换零件时, 位置不能改变	
6	Lifting device, unloading device 顶、卸料装置	Ejector pins, cylinders, pressure plates, etc. 弹顶销、气缸、压料板等	Damage, air leakage, spring failure, etc. 损坏、漏气、弹簧故障等。	Replacement parts, cylinder repair 更换零件、气缸维修	screwdriver, Allen wrench, etc. 螺丝刀、六角扳手等	Cylinder problems must be arranged by the tooling operator 气缸问题必须由工具操作人员安排	
7	Fastening parts, safety parts 紧固件、安全件	Various bolts, safety pins, etc. 各类螺栓, 安全插销等。	Missing, damaged 缺少, 损坏	Replenish or replace and tighten 补充或更换并拧紧	Allen wrench, pin puller 六角扳手、拔销器	Do not use short ones to replace long ones. Removed bolts, pins, etc. must be placed in containers to prevent loss or use in moisture.	

8	Cooling system 冷却系统	Water fitting, waterline 接头、运水。	The water fitting is corroded and the water line is not smooth 接头腐蚀，运水不畅	Replace water fitting, disassemble mold cavity, check and clean water line 更换接头、拆卸 模腔检查清理运水	Allen wrench, special cleaner 六角扳手、专 用清洁剂	Check whether the water fitting specifications are correct; check whether the water line sealing ring is installed in place and does not leak water 检查接头规格是否正确	
9	Hot runner system 热流道系统	Grafting ranking method, fitting, adaptor 嫁接排位方式、线头连接	The ranking method does not match, wire ends fall off, etc. 排位方式不符，线头脱落 等	Use a multimeter to check the resistance of the heating couple and the temperature sensor, confirm, and re-engage the screws that fix the wire ends. 使用万用表检查	Multimeter, screwdriver 万用表，螺丝 刀	Check and cut off the power supply during measurement; reconnect it and then re-energize it for inspection. 测量时检查切断电源； 嫁接重新连接后重行送 电检查	
10	Cleansing 清擦	Various parts of the mold 模具各部位	Oil stain 油污	Wipe with a cloth 用擦布清擦	Wipes, mold cleaner 擦布、模具清 洗剂	Check each part while cleaning 清擦的同时对各零件进 行检查	
11	lubricating 润滑	Guide pins, guide sleeves, guide plates, etc. 导柱、导套、导板等	Surface "scratches" 表面“拉伤”	Use oilstone or abrasive paste to remove 使用油石、研磨 膏去除	Oilstone, grinding paste 油石、研磨膏	All relatively moving parts need to be lubricated with grease 对所有相对运动部份都 需涂润滑脂	Clean the repaired area without any foreign matter 清理修理部 位无残留物
12	Assembly 装配	All removed parts 所有卸下的零件	Wrong order, wrong position, missing 顺序、位置错误，漏装	Assemble strictly in the order of disassembly 严格按照拆下时 的顺序装配	Pin puller, Allen wrench, T-wrench, etc. 拔销器、内六 角扳手、T形 扳手等	Be careful during assembly and beware of collisions between parts 组装时要小心，注意零 件之间的碰撞	
13	Checking 检查	Mold all 所有模具	Wrong or missing installation, bolts not tightened, etc. 错漏装、螺栓未把紧等	Replenish and tighten as required 按要求补齐并紧 固	Pin puller, Allen wrench, T-wrench, etc. 拔销器、内六 角扳手、T形 扳手等	After the inspection, fill in the "Mold Periodic Maintenance and Repair Record Form" and ask the team leader to review it 检查完毕后，填写《模	
14	Closing 合模	Mold all 所有模具	The mold is not closed properly(PL), and the front and back of the mold are merged in the opposite direction. 合模不到位、模具前后面 合反	Reopen mold, Try again 重新打开合模	Copper rods, 紫铜棒等	The steel wire ropes used in the mold must be of the same length 要求合模具所用的钢丝 绳同长	
15	Hoist the mold back to the mold storage area 将模具吊回模具存放地	Mold 模具	Mold placement is crooked, etc. 模具放歪等	Reposition the suspension line or keep the hoisting ring's equilibrium 重新定位吊索或 保持吊环的平衡	lifting rope, single-beam bridge crane 吊绳、单梁行 吊	Take dust prevention measures 做好防尘措施	
		prepared by 编 制	Proofreading 校 对	Audit 审 核	Team Leader 组长	approve 批 准	
Mark and number 标记及数目							



Completed by(完成人):

Date(日期):