



Finished Mould Checklist

Program Name: Part Name: Tool Name: Tool source: Tool Steel: Resin: Program No.: Part No.: Tool No.: Customer: No. of Cavities: Machine Size:

CAVITY

What is the customer required core hardness? HRC 48-52degree
What is the hardness? 50 degree
Is the material type and hardness stamped on bottom surface of each cavity block?
What is the required surface finish on the cavity?
What is the cavity surface finish?
Is any EDM visible on cavity surface?
Does the cavity surface have a good visual appearance free of marks, dints, and machining marks deemed unexceptable?
If yes what are the issues?
Are cavity molding surfaces free of scratches?
Are cutter marks visible on the cavity surface?
Does the cavity require texturing?
What is the customer required texture?
Is the cavity textured?
If so what is the texture type?
Are ribs polished in line of draw?
Is any EDM visible in the ribs?
Are cutter marks visible in the ribs?

CORE

What is the customer required core hardness? HRC 48-52degree
What is the hardness? 50 degree
Is the material type and hardness stamped on bottom surface of each core block?
What is the required surface finish on the core?
What is the core surface finish?
Is any EDM visible on core surface?
Does the core surface have a good visual appearance free of hammer marks, dints, and machining marks deemed unexceptable?
If yes what are the issues?
Are core molding surfaces free of scratches?
Are cutter marks visible on the core surface?
Does the core require texturing?
What is the customer required texture?
Is the core textured?
If so what is the texture type?
If so what is the texture and depth?
Is Recycle Logo required?
Are ribs polished in line of draw?
Is any EDM visible in the ribs?
Are cutter marks visible in the ribs?

## Finished Mould Checklist

### SLIDES

Are slides tight? _____	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Are slides loose? _____	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Are the seal off angles under the slides >5°? _____	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
If not what angle is it? _____	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Are grease fittings installed? _____	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Are the slides spring loaded? _____	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Is there a positive locking method for open position? _____	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
What is it? _____				
Is it capable of holding the slide weight? _____	<input checked="" type="checkbox"/>			
Are slides equipped with hydraulics? _____	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
If so are limit switches installed? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No

### **Slide Finishes**

What is the customer required hardness? _____		HRC 48-52degree		
What is the hardness? _____		50degree		
Is the material type and hardness stamped on a non molding surface of each lifter or slide? _____	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
What is the required surface finish on the molding surfaces? _____				
What is the surface finish? _____				
Are ribs polished in line of draw? _____	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Is any EDM visible in the ribs? _____	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Do the slides have a good visual appearance free of hammer marks, dints, and machining marks deemed unexceptable? _____	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
If yes what are the issues? _____				
Are the molding surfaces free of scratches? _____	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Are cutter marks visible in the ribs? _____	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No

### LIFTERS

Are guide bushing installed? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Are grease fittings and lines installed? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Do square lifter have grease groove? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Are the square lifters made with P20? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
If so are they nitrided? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Are the square lifters made with H13? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
What is the customer requested hardness? _____				
What is the actual hardness? _____				
<b>Lifter Finishes</b>				
What is the customer required hardness? _____				
What is the hardness? _____				
Is the material type and hardness stamped on a non molding surface of each lifter or slide? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
What is the required surface finish on the molding surfaces? _____				
What is the surface finish? _____				
Are ribs polished in line of draw? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Is any EDM visible in the ribs? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Do the lifters have a good visual appearance free of hammer marks, dints, and machining marks deemed unexceptable? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
If yes what are the issues? _____				
Are the molding surfaces free of scratches? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Are cutter marks visible in the ribs? _____	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No

## Finished Mould Checklist

### INSERTS

What is the customer required hardness? HRC 48-52degree

What is the hardness? 50degree

Is the material type and hardness stamped on a non molding surface of each lifter or slide?  Yes  No

What is the required surface finish on the molding surfaces? \_\_\_\_\_

What is the surface finish? \_\_\_\_\_

Are ribs polished in line of draw?  Yes  No

Is any EDM visible in the ribs?  Yes  No

Do the inserts have a good visual appearance free of hammer marks, dints, and machining marks deemed unexceptable?  Yes  No

If yes what are the issues? \_\_\_\_\_

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Are the molding surfaces free of scratches?  Yes  No

Are cutter marks visible in the ribs?  Yes  No

Are ribs polished in line of draw?  Yes  No

Is any EDM visible in the ribs?  Yes  No

Are cutter marks visible in the ribs?  Yes  No

### PARTING LINE

Parting lines width \_\_\_\_\_

surface finish of parting line \_\_\_\_\_

Relief depth -land width. \_\_\_\_\_

Is any EDM visible in the ribs?  Yes  No

Do the inserts have a good visual appearance free of hammer marks, dints, and machining marks deemed unexceptable?  Yes  No

If yes what are the issues? \_\_\_\_\_

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### VENTING

Parting line vent width & depth 4X0.2

Are ejector pins vented?  Yes  No

Are runners vented?  Yes  No

Are guide pin bushings holes vented?  Yes  No

Is last place to fill vented?  Yes  No

### VISUAL APPEARANCE OF PLATES



## Finished Mould Checklist

### Cavity ejection

#### 2 stage ejection

- |   |                          |     |                          |    |
|---|--------------------------|-----|--------------------------|----|
| Does the mold have multi stage ejection   | <input type="checkbox"/> | Yes | <input type="checkbox"/> | No |
| Do the latches pocket into the core and cavity plates                               | <input type="checkbox"/> | Yes | <input type="checkbox"/> | No |
| Does the multi stage ejection use spring loaded latches pocketed into cavity plate? | <input type="checkbox"/> | Yes | <input type="checkbox"/> | No |
| Is so are shoulder bolts installed?   | <input type="checkbox"/> | Yes | <input type="checkbox"/> | No |
| Is the surface to seat the shoulder bolt spotted flat?                              | <input type="checkbox"/> | Yes | <input type="checkbox"/> | No |

### HYDRAULIC SYSTEM

- |   |                          |     |                          |    |
|---|--------------------------|-----|--------------------------|----|
| Does the mold have hydraulic ejection?        | <input type="checkbox"/> | Yes | <input type="checkbox"/> | No |
| Are Flow dividers installed?                  | <input type="checkbox"/> | Yes | <input type="checkbox"/> | No |
| Are switches mounted and wired?               | <input type="checkbox"/> | Yes | <input type="checkbox"/> | No |
| Ejector system - moves freely?                | <input type="checkbox"/> | Yes | <input type="checkbox"/> | No |
| Ejector pins guided square to ejector system? | <input type="checkbox"/> | Yes | <input type="checkbox"/> | No |

### COOLING

- |  |                                     |     |                                     |    |
|--|-------------------------------------|-----|-------------------------------------|----|
| Are water lines stamped to customer specifications?                      | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |
| Are water lines numbered to customer specifications?                     | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |
| Are water lines correct size to customer specifications?                 | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |
| Are waterlines counterbored?   | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |
| Are the o-rings pocketed on the core retainer plate?                     | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |
| Are the o-rings pocketed on the core?                                    | <input type="checkbox"/>            | Yes | <input checked="" type="checkbox"/> | No |
| Describe o-ring fit in groove _____                                      |                                     |     |                                     |    |
|  |                                     |     |                                     |    |
| Are the quality of all o-rings good enough?                              | <input type="checkbox"/>            | Yes | <input type="checkbox"/>            | No |
| Have water lines been pressure tested (10 bars, half hour)?              | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |
| Are there any water leaks?   | <input type="checkbox"/>            | Yes | <input type="checkbox"/>            | No |
| If so where? _____   |                                     |     |                                     |    |
| Do the water lines match the plaque?                                     | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |
| Are all the baffles and plugs installed?                                 | <input type="checkbox"/>            | Yes | <input type="checkbox"/>            | No |
| Are Jiffy connectors installed?  | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |
| Are the customer specified fitting installed?                            | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |
| Fitting names and model numbers _____                                    |                                     |     |                                     |    |
| Is there enough space between fitting to install all the fitting easily? | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |
| Are extension pipes used?  | <input type="checkbox"/>            | Yes | <input checked="" type="checkbox"/> | No |
| If so why? _____   |                                     |     |                                     |    |
| Water lines connected internally?  | <input type="checkbox"/>            | Yes | <input checked="" type="checkbox"/> | No |
| Water lines connected hard tubing  | <input type="checkbox"/>            | Yes | <input checked="" type="checkbox"/> | No |
| If so why? _____   |                                     |     |                                     |    |
| Are water jumpers installed?   | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |
| Are water lines sealed by socket tapped screw? Not use swarf.            | <input checked="" type="checkbox"/> | Yes | <input type="checkbox"/>            | No |

### MOULD FIT TO PRESS

- |  |                                     |                      |                                     |    |
|--|-------------------------------------|----------------------|-------------------------------------|----|
| Any obstructions on bottom surface of mould?                 | <input type="checkbox"/>            | Yes                  | <input checked="" type="checkbox"/> | No |
| If so what are they? _____                                   |                                     |                      |                                     |    |
|  |                                     |                      |                                     |    |
| Is the customer specified locating ring installed?           | <input checked="" type="checkbox"/> | Yes                  | <input type="checkbox"/>            | No |
| What is the customer specified locating ring size?           |                                     | 10mm                 |                                     |    |
| Is the locating ring at least 4MM higher than mold surface?  | <input checked="" type="checkbox"/> | Yes                  | <input type="checkbox"/>            | No |
| Is the customer specified sprue bushing installed?           | <input type="checkbox"/>            | Yes                  | <input type="checkbox"/>            | No |
| What is Sprue radius orifice and size?                       |                                     | R12                  |                                     |    |
| Are the eyebolts balance so the mould hangs straight?        | <input checked="" type="checkbox"/> | Yes                  | <input type="checkbox"/>            | No |
| Safety Straps (2) (Red or contrasting Yellow).               | <input type="checkbox"/>            | Yes                  | <input type="checkbox"/>            | No |
| Clamp slot size and locations _____                          |                                     |                      |                                     |    |
| Are they to customer spec.?                                  | <input type="checkbox"/>            | Yes                  | <input type="checkbox"/>            | No |
| Mould Length, Width, Height.                                 |                                     | 320x300x281          |                                     |    |
| To swing mould, record corner to corner size.                |                                     | 515mm                |                                     |    |
| What is customer specified K.O. holes size and pattern size? |                                     | The diameter is 40mm |                                     |    |
| Mould K.O. holes size and pattern size.                      |                                     | same                 |                                     |    |

## Finished Mould Checklist

### MISCELLANEOUS

Should all screws not be machined and cut? Has all been hardened?	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Guide pin length. <u>145mm</u>				
Is the customer specified Leader pin fit and installation done?	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
What is the Leader Pin fit and installation process?				
<hr/>				
Return pin length. (nothing contacting cavity) <u>136mm</u>				
Are return pins spring loaded?	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Pry bar slots.	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Plates numbered and lettered.	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Insulation plate.	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Gate type used <u>side gate</u>				
Is cashew gate being used	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
cashew gate type (Name of manufacture or homemade)				
Is ejection stroke long enough to fully eject cashew gate?	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Is shot counter required?	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Is shot counter installed?	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Are all screw heads below the surface?	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Are eyebolt hole threads deep enough to fully seat eyebolt?	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
If no describe situation _____				
<hr/>				
Are there threaded lifting holes in all parts over 50 lbs (22.7kg)	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Have all mold workpieces and spare part been inspected with record?	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Does the mold have a good visual appearance free of hammer marks, dints, and machining marks deemed unexceptable?	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Are angled seal that are <5° at least 4rc different or 1 side nitrided?	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Is the material type and hardness stamped on bottom surface of each mold part	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Is the customer specified Horn pin fit and installation done?	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
What is the Horn Pin fit and installation process? _____				
<hr/>				
Has the mold used the correct material and treatment with certificate?	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Has the mold drawing been printed and copied in two copies?	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Have the molding condition sheet and sample inspection report prepared?	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Are the both ends of the lifting bar at least 1MM shorter than mold?	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Are date clocks fastened by screws?	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No

### MOULD IDENTIFICATION

Are the following mold plaques on the operator side of the mold?				
Mold Nameplate	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Mould sequence	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Hydraulic schematic	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Waterline schematics	<input checked="" type="checkbox"/>	Yes	<input type="checkbox"/>	No
Electrical schematics	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Thermocouple schematics	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
special instructions	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
Is "TOP OF MOULD". Stamped on the top of the mould?	<input type="checkbox"/>	Yes	<input checked="" type="checkbox"/>	No
Is the mould painted the customer specified colour?	<input type="checkbox"/>	Yes	<input type="checkbox"/>	No
What colour is it painted? _____				
Comments: _____				
_____				
_____				
_____				
_____				

Completed by: \_\_\_\_\_ Date: \_\_\_\_\_