IPS

Moldshield ™

Assembly, Installation & Operating Instructions

Distributed by:

plastiXs® manufacturing solutions

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Operating Instructions

There is no need to remove Moldshields to see into your mold.

When you have a need to reach into your mold, UN-HOOK one side of the Moldshield and allow the Moldshield to recoil slowly. If necessary UN-HOOK both sides of the Moldshield and place it in a safe location while you are working on the mold. After completing the work inside your mold, RE-HOOK the Moldshield and continue normal operation.

If there is a need to open your mold wider than the 24" [60 cm] Moldshield width, UN-HOOK your Moldshield first to avoid sliding the magnets off of the outside surface of your mold.

WARNING

Moldshields must be protected from open flames, sharp objects and hot purges. Careful handling will prolong the life of your Moldshields.

Magnet Assembly Instructions

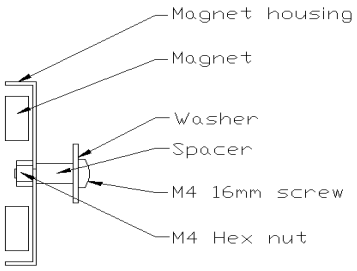
IPS Moldshields are supplied with the best hardware for most installations. Should you have a special need refer to the Moldshield application notes.

Hardware packet consists of:

- (8) screws
- (8) washers
- (8) hex nuts
- (8) spacers

They should be assembled to the magnet in the following sequence.

1] Washer onto screw.
2] Spacer onto screw.
3] Insert screw into magnet house top.
4] Secure with hex nut.



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Installation Instructions

Each Moldshield set contains two (2) IPS Moldshields, eight (8) magnets and one (1) packet of hardware.

Step 1. Assemble magnets. CAUTION! Do not permanently attach magnets to the plastic handles.

Step 2. On each side of your mold place two (2) assembled magnets at appropriate locations. Take care not to trap any dirt or iron filings between magnet and mold frame.

Step 3. Hook the moldshields to the magnets being sure to use at least one (1) fixed hook on each side of each shield.

Step 4. Before putting the mold into production, open and close slowly. Make adjustments to the magnet positions to ensure the moldshields are parallel and are not being crushed between obstructions.

Step 5. Start normal operation.

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Moldshield Handle Information

Here is information about the number of handles that are attached to the various sizes of Moldshields and which are fixed and which are sliding. This information is provided so that you can adjust the positioning of the handles to facilitate water lines and other issues.

MS-20	2	handles fixed handles both
MS-30	3	handles fixed handles numbers 1-3
MS-40	3	handles fixed handles numbers 1-3
MS-50	4	handles fixed handles numbers 1-4
MS-60	5	handles fixed handles numbers 1-3-5
MS-80	5	handles fixed handles numbers 1-3-6
MS-100	7	handles fixed handles numbers 1-4-7
MS-120	7	handles fixed handles numbers 1-4-7

Fixed handles are at each end and then they are evenly spaced.

Notes:

(1) Non fixed handles move.
(2) Handles can not be removed without damaging shield.
(3) Fixed handles **may** be loosened with a sharp knock at the end of handle. There is no guarantee this action will not damage the shield.
(4) If the handle loop is an obstruction the loop part of the handle only may be cut off.

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Moldshield Application Notes

Note 1 - Moldshields should not be permanently attached to the magnets. The shield hooks should be easily removable.

Note 2 - Magnets should not be mounted on stripper plates. The jarring movement could cause the magnets to move. Place magnets on the next non-moving plate. This may require an extension from the magnet to the shield hook. Extensions can be made from 1/8" x 1"- 0.3 cm X 2.5 cm flat bar or a stiff wire. Smooth any sharp edges of the extensions prior to use to avoid cutting the shield.

Note 3 - Horizontal water lines, hydraulic lines, etc. present a challenge when installing moldshields. If there is 1¼" - 3.2 cm clearance for MS-20 through MS-60 and 2½" – 6.4 cm clearance for MS-80 through MS-120 between the obstructions when the mold is closed the moldshields may be installed. There are movable hooks on each side of the moldshield. Slide the movable hook to a place where it does not interfere with mold obstructions. You may need to fabricate extensions as mentioned in Note 2 if there is no way to place magnets in the desired location. Always use at least one fixed hook per shield side to insure the shield does not creep downward.

Note 4 - Air blasts to assist molded parts drop can create a vortex condition which tends to pull the moldshield into the open mold providing the potential for catching the shield between mold frames at mold close. This is particularly true if the air is not stopped prior to mold close. Using a 1" – 2.5 cm spacer between magnet top and shield hook will provide the opening the vortex needs to draw air without pulling moldshields into the danger zone.

Note 5 - There are installation conditions where mounting the magnets directly onto the platen is desirable. To do this fabricate a 90-degree bracket. This should be long enough to have the moldshield edge at the desired location.

WARNING

SHARP OBJECTS such as knives or pins will puncture moldshields!

OPEN FLAMES such as propane torches will destroy moldshields!

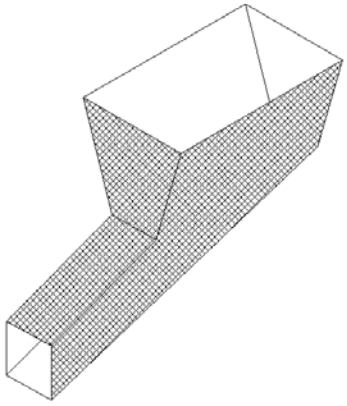
RUBBING tie bars or other fixed objects will wear holes in moldshields!

HOT PURGINGS will destroy moldshields!

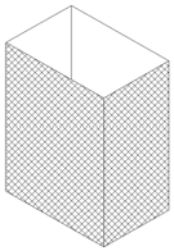
IPS

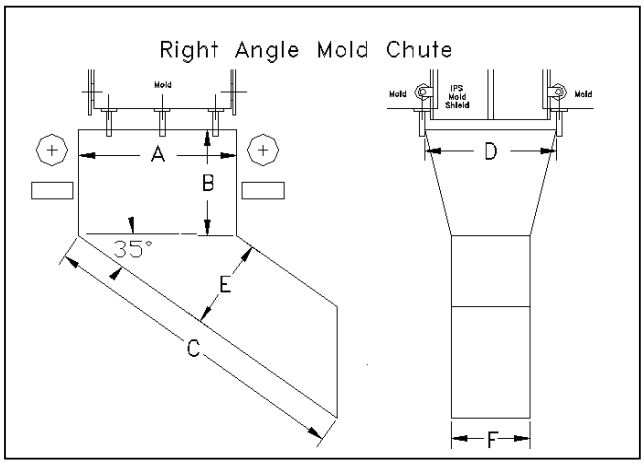
Mold Chutes & Mold Skirts

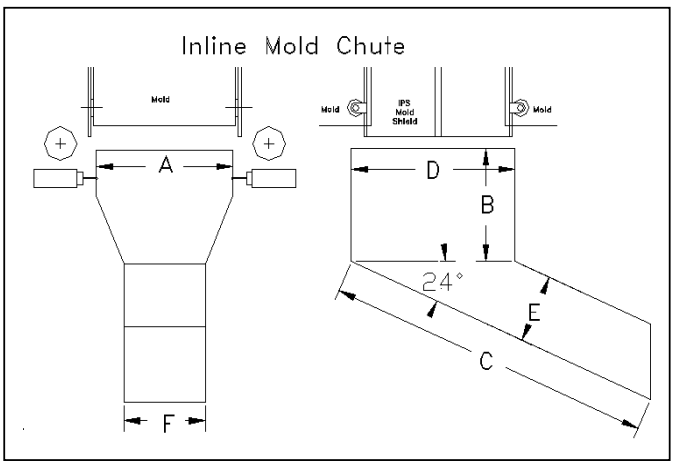
The Perfect Companion to Moldshields



Mold Chutes are the practical alternative to using sheet metal or cardboard fabrications. Mold Chutes guide your product from mold eject onto a conveyor or into a drop box. Mold Chutes reduce contamination and loss of your molded parts. Each Mold Chute comes complete with mounting hardware. Installation is accomplished quickly using magnets and Velcro straps.

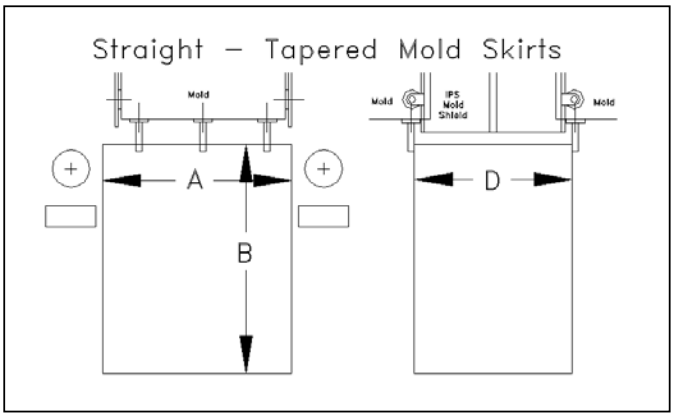






Product Features

- Soft PVC material does not absorb oil or grease.
- Abrasive, puncture and tear resistant.
- Easily cleaned.
- No folds to trap molded parts or contamination.
- Hard PVC insert assists gravity evacuation.



Specification sheets for IPS standard Mold Chutes and Mold Skirts may be viewed or downloaded at:

www.plastixs.com/products/ips/