

# IPS

Industrial Protective Shields, Ltd.

Instructions for  
**Mold Chute Products**  
Assembly & Installation Guide

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## Mold Chute Types

**RMC** - Right Angle Mold Chutes are designed to evacuate molded parts to either side of the molding machine. They are designed to open and close with the mold when attached to the mold halves or platens. They may be mounted stationary.

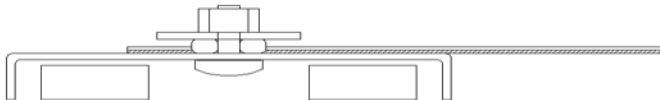
**IMC** - Inline Mold Chutes are designed to evacuate molded parts inline with the molding machine. They are designed to be mounted stationary only.

**S/TMC** - Straight / Tapered Mold Chutes are designed to guide molded parts in their drop downward. They may be mounted to open and close with the mold or mounted stationary.

## Magnet Assembly Instructions

IPS Mold Chutes are supplied with the best hardware for most installations. Each Mold Chute comes with the appropriate number of magnets, Velcro straps, nuts, bolts and washers. They should be assembled in the following order:

- 1) Put the screw into magnet hole with the head of screw inside the magnet house.
- 2) Place the Velcro with teeth against magnet house onto screw.
- 3) Place the washer onto screw.
- 4) Place the nut onto screw and tighten.



## Mounting Instructions.

Step 1) Unpack, straighten chute and allow it to regain it's shape prior to installation.

Step 2) Assemble Velcro straps onto the magnets.

Step 3) Place ½ of the assembled magnets on the bottom of each mold half. Take care not to trap iron filings or dirt between the magnets and the frame.

Step 4) Hook the Mold Chute Velcro to the magnet Velcro. Adjust magnet locations and trim Velcro to adjust chute height, opening and location.

Step 5) Straps with eyelets are supplied on all chutes. They are for a permanent mounting situation.

Step 6) Before starting operation slowly open and close the mold to observe if the Mold Chute is in the best location at both mold open and mold close. The Mold Chute should not be crushed between obstructions.

Step 7) Start normal operation. Observe operation. Make any adjustments necessary and continue automatic operation.

**Unhook the Velcro from one side of the mold before opening the mold wider than the chute. Failure to do so can result in damage to the chute or water lines.**

Mold Chutes are most effective when sized 2” – 5 cm wider than the mold width.

IPS Mold Shields are the perfect mate for IPS Mold Chutes.

Careful handling will prolong the life of the chute.

### **\* CAUTION \***

SHARP OBJECTS such as knives or pins will puncture the Mold Chute!

OPEN FLAMES such as propane torches will destroy the Mold Chute!

RUBBING tie bars or other fixed objects will wear holes in the Mold Chute!

HOT PURGINGS will destroy the Mold Chute!

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## Mold Chute Application Notes

Note 1 - Mold chutes should not be permanently attached to the magnets. The Velcro straps provide for easy detachment.

Note 2 - Horizontal water lines, hydraulic lines, etc. present a challenge when installing Mold Chutes. The Velcro straps provide flexibility in getting around most obstructions. There may be molds that require extensions from the magnet to the desired location of the Velcro because of obstructions. Extensions can be made from 1/8" x 1" - 0.3cm X 2.5 cm flat bar. Smooth any sharp edges of the extensions prior to use to avoid cutting the chute.

Note 3 - There are installations where it is desirable to mount the mold chute directly to the platens. This may require extensions as mentioned in Note 2.

Note 4 – Mold chutes are designed to achieve effective evacuation of molded product. In certain applications due to part design or static charging, molded parts may not totally evacuate. Where product specifications and on site regulations allow, the following remedies may be used.

- Polish slide with wax.
- Spray slide with an antistatic spray.
- Add Teflon tape the length of chute.
- Use an antistatic air generator.
- Use an air brush at back of chute.

### WARNING

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OPEN FLAMES such as propane torches will destroy the mold chute!

RUBBING tie bars or other objects will wear holes in the mold chute!

HOT PURGINGS will destroy the mold chute!

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## **TIE BAR COVER APPLICATION NOTES**

- 1] SHINEY SIDE OF COVER SHOULD BE AGAINST TIE BAR.**
- 2] MOUNT MAGNETS TO STRAPS WITH SCREW HEAD INSIDE MAGNET.**
- 3] ASSEMBLE ONTO TIE BAR WITH ZIPPER DOWN AND AWAY FROM MOLD. VELCRO STRAP SHOULD BE AT NON - MOVABLE PLATEN**
- 4] SET TABS WITH MAGNETS ONTO MOVABLE PLATEN.**

## **WARNING!**

**Hot purging will destroy Tie Bar Covers.**

**Standing on Tie Bar Covers is not safe.**