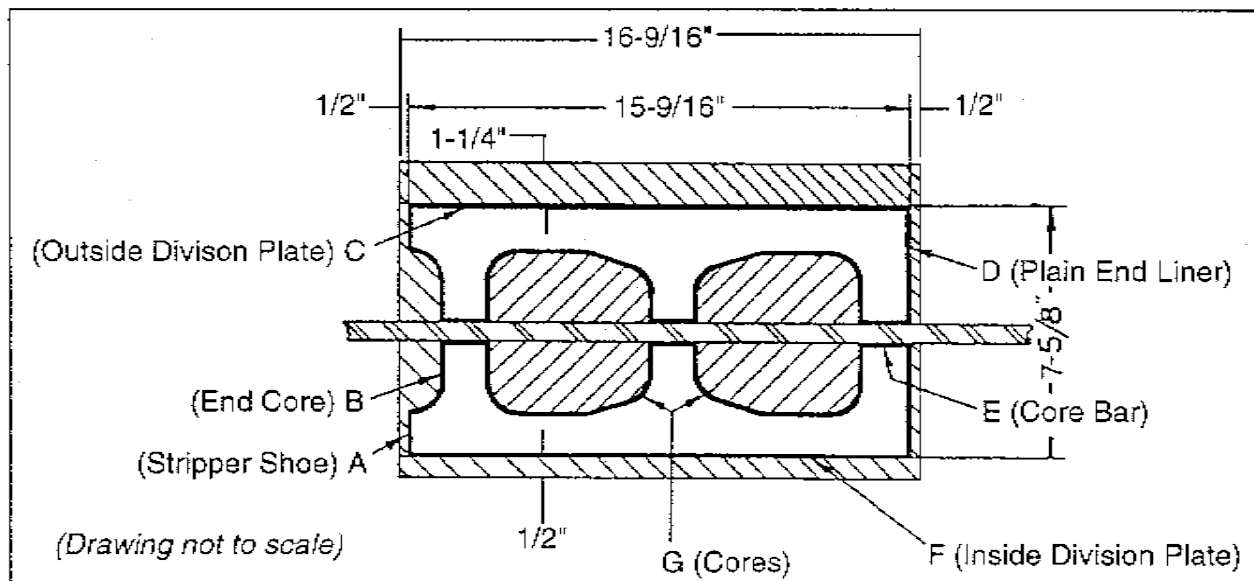


Mold Compartment Clearance Dimensions



This service bulletin is twofold, first to clarify the MOLD DIMENSIONS and secondly to give dimensions of MOLD CLEARANCES in both inch and metric standards.

MOLD DIMENSIONS

All molds are constructed $1/16''$ short of the full modular length of $15-5/8''$; that is molds are constructed with a $15-9/16''$ long cavity, (as compared to a $15-5/8''$ modular length).

The molds are constructed modular in width for example; a NEW standard mold is $7-5/8''$ Wide x $7-5.8''$ High x $15-9/16''$ Long (190 mm x 190 mm x 390 mm).

The $15-9/16''$ dimension is within the accepted tolerance, to give longer mold life. After the initial wear, the mold is the full modular length of $15-5/8''$ long.

MOLD CLEARANCES

All molds including slabs, solids, low height and specials have the clearances as shown in drawing and listed below:

A. Clearance between stripper shoe and end core liner is.....	$1/16''$ (1.5mm).
B. Clearance between stripper shoe and end core is	$1/16''$ (1.5mm).
C. Clearance between stripper shoe and outside division plate is	$1-32''$ (.75mm).
D. Clearance between stripper shoe and plain end liner is	$1/16''$ (1.5mm).
E. Clearance between stripper shoe and core bar is	$1/16''$ (1.5mm).
F. Clearance between stripper shoe and inside division plate is	$1/32''$ (.75mm).
G. Clearance between stripper shoe and cores is.....	$1/16''$ (1.5mm).

Mold Compartment Clearance Dimensions

SAFETY BULLETIN

This notice is issued to advise you that some previously accepted shop practices may not be keeping up with changing Federal and State Safety and Health Standards. Your current shop practices may not emphasize the need for proper precautions to insure safe operation and use of machines, tools, automatic loaders and allied equipment and/or warn against the use of certain solvents or other cleaning substances that are now considered unsafe or prohibited by law. Since many shop practices may not reflect current safety practice and procedures, particularly with regard to the safe operation of equipment, it is important that you review your practices to ensure compliance with Federal and State Safety and Health Standards.

IMPORTANT

The operation of any machine or power-operated device can be extremely hazardous unless proper safety precautions are strictly observed. Observe the following safety precautions:

ALWAYS:

- ✓ Be sure proper guarding is in place for all pinch, catch, shear, crush, and nip points.
- ✓ Be sure that all personnel are clear of the equipment before starting it.
- ✓ Be sure the equipment is properly grounded.
- ✓ Turn the main electrical panel off and lock it out in accordance with published lockout/tagout procedures prior to making adjustments, repairs, and maintenance.
- ✓ Wear appropriate protective equipment such as safety glasses, safety shoes, hearing protection, and hard hats.
- ✓ Keep chemical and flammable material away from electrical or operating equipment.
- ✓ Maintain a safe work area that is free from slipping and tripping hazards.
- ✓ Be sure appropriate safety devices are used when providing maintenance and repairs to all equipment.

Mold Compartment Clearance Dimensions

NEVER:

- ✓ Exceed the rated capacity of a machine or tool.
- ✓ Modify machinery in any way without prior written approval of the Besser Engineering Department.
- ✓ Operate equipment unless proper maintenance has been regularly performed.
- ✓ Operate any equipment if unusual or excessive noise or vibration occurs.
- ✓ Operate any equipment while any part of the body is in the proximity of potentially hazardous areas.
- ✓ Use any toxic flammable substance as a solvent cleaner.
- ✓ Allow the operation or repair of equipment by untrained personnel.
- ✓ Climb or stand on equipment when it is in operation.

It is important that you review Federal and State Safety and Health Standards on a continual basis. All shop supervisors, maintenance personnel, machine operators, tool operators, and any other person involved in the setup, operation, maintenance, repair or adjustment of Besser-built equipment should read and understand this bulletin and Federal and State Safety and Health Standards on which this bulletin is based.