

Besser Mold Assembly and Torque Requirements

Longer mold life can be achieved by following a few basic rules. Be sure to clean all parts and mating surfaces thoroughly before assembly. Always be sure parts are properly aligned and use proper torque requirements. To assure that parts are square, start with a good working surface (Besser portable mold jig). A visual inspection is suggested to make sure parts are not burred or scored.

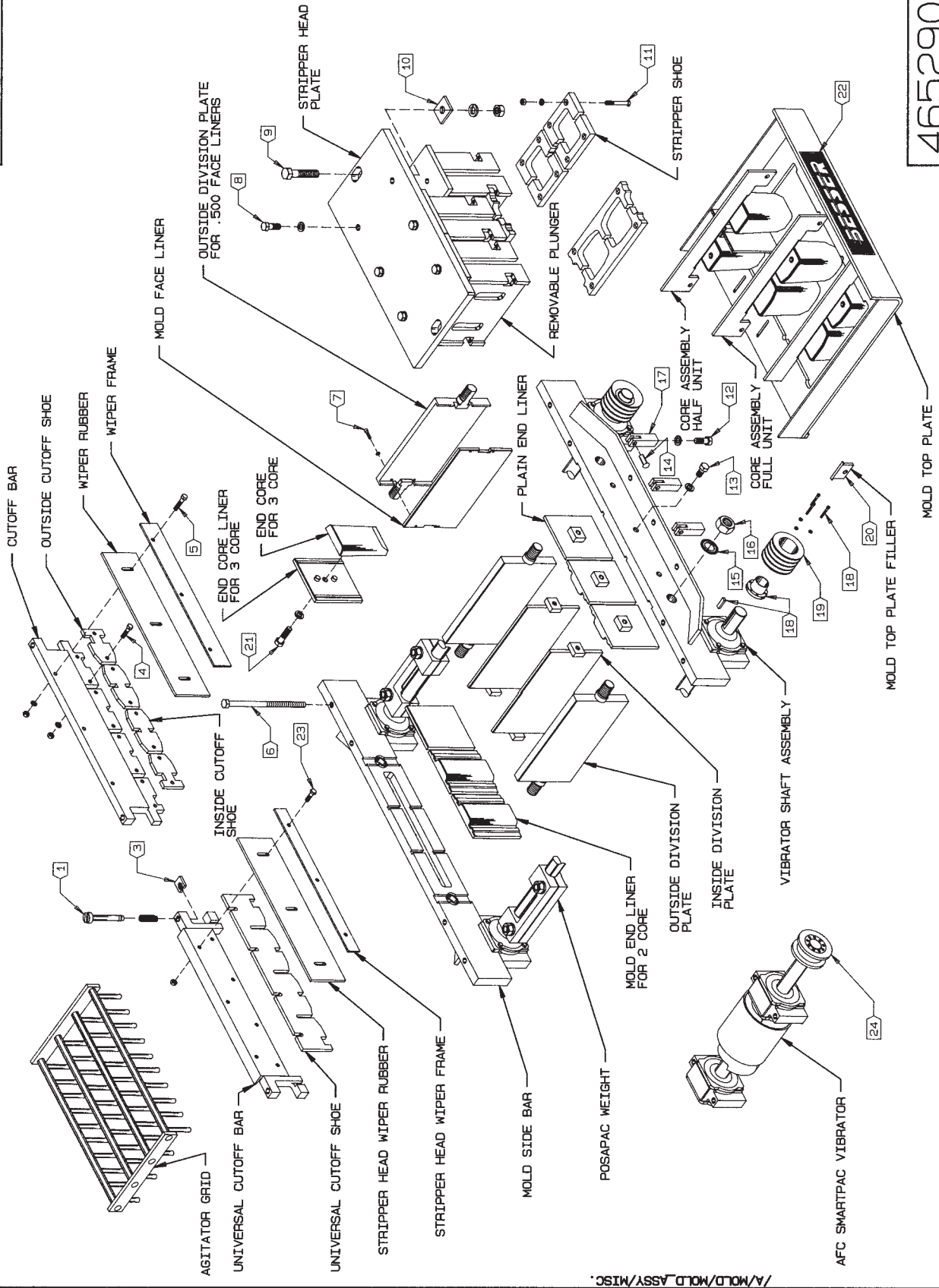
NOTE: Always start with new lock washers and only use a brass hammer.

1. Outside division plates should be torqued to 625 - 675 Ft. Lbs., (930 - 1005 Newton-Meters). Outside division plates with cutouts for face liners should be torqued to 175 - 195 Ft. Lbs. (260 - 290 Newton-Meters).
2. Vibrator bolts should be torqued to 220 - 300 Ft. Lbs., (330 - 450 Newton-Meters).
3. Core bars should first be snugged initially front and back.
4. Then core bars should be torqued to 70 - 90 Ft. Lbs., (105 - 135 Newton-Meters). Align front and back as uniform as possible to the mold side bars. Check cores for center between division plates to assure uniform block dimensions. (A wire can be secured through the hold down bolt heads as a safety to prevent the bolts from coming loose during constant vibration.)
5. Secure plungers to stripper head plate - 100 - 140 Ft. Lbs., (150 - 210 Newton Meters).
6. Align the stripper shoes.
7. Threaded inside division plates should be torqued to 40 - 50 Ft. Lbs., (60 - 70
8. Newton-Meters). Tanged inside division plates should be torqued to 100 - 120 Ft. Lbs., (150 - 180 Newton-Meters).
9. End liners should be torqued to 100 - 140 Ft. Lbs., (150 - 210 Newton-Meters).
10. Stripper shoes should be torqued to 65 - 75 Ft. Lbs., (100 - 110 Newton-Meters).
11. Center Posapac Vibrator Weights as close as possible to assure uniform vibration and that the nuts face the outside of the mold.

Besser Mold Parts illustrated on page 2.

BESSER MOLD PARTS

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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.

Besser Mold Assembly and Torque Requirements

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.