

"ROUND MATE"® MAINTENANCE PROCEDURES

WE WANT YOUR NEW "ROUND MATE"® SYSTEM TO GIVE YOU THE YEARS OF DEPENDABLE SERVICE FOR WHICH IT WAS DESIGNED. YOU CAN HELP TO MAINTAIN THE LIFE OF YOUR NEW MASTER FRAME BY FOLLOWING THESE SIMPLE PROCEDURES.

AFTER EACH "RUN" OF PLASTIC PARTS, REMOVE THE MOLD INSERT FROM THE MASTER FRAME.

DRY THE STEPPED-BORES OF THE MASTER FRAME AND THE COOLING CHANNELS OF THE INSERTS WITH A CLEAN, DRY CLOTH.

COAT BOTH THE MASTER FRAME AND THE MOLD INSERT SET WITH A LIGHT SPRAY OF MOLD RUST-PROOF.

STORE YOUR MASTER FRAME, WITHOUT THE MOLD INSERT INSTALLED, IN A DRY AREA.

WE STRONGLY ADVISE STORAGE OF YOUR MOLD INSERT SETS IN OUR CUSTOM-MADE STORAGE/CARRYING BOXES FOR YOUR BEST PROTECTION AGAINST RUST AND DAMAGE.

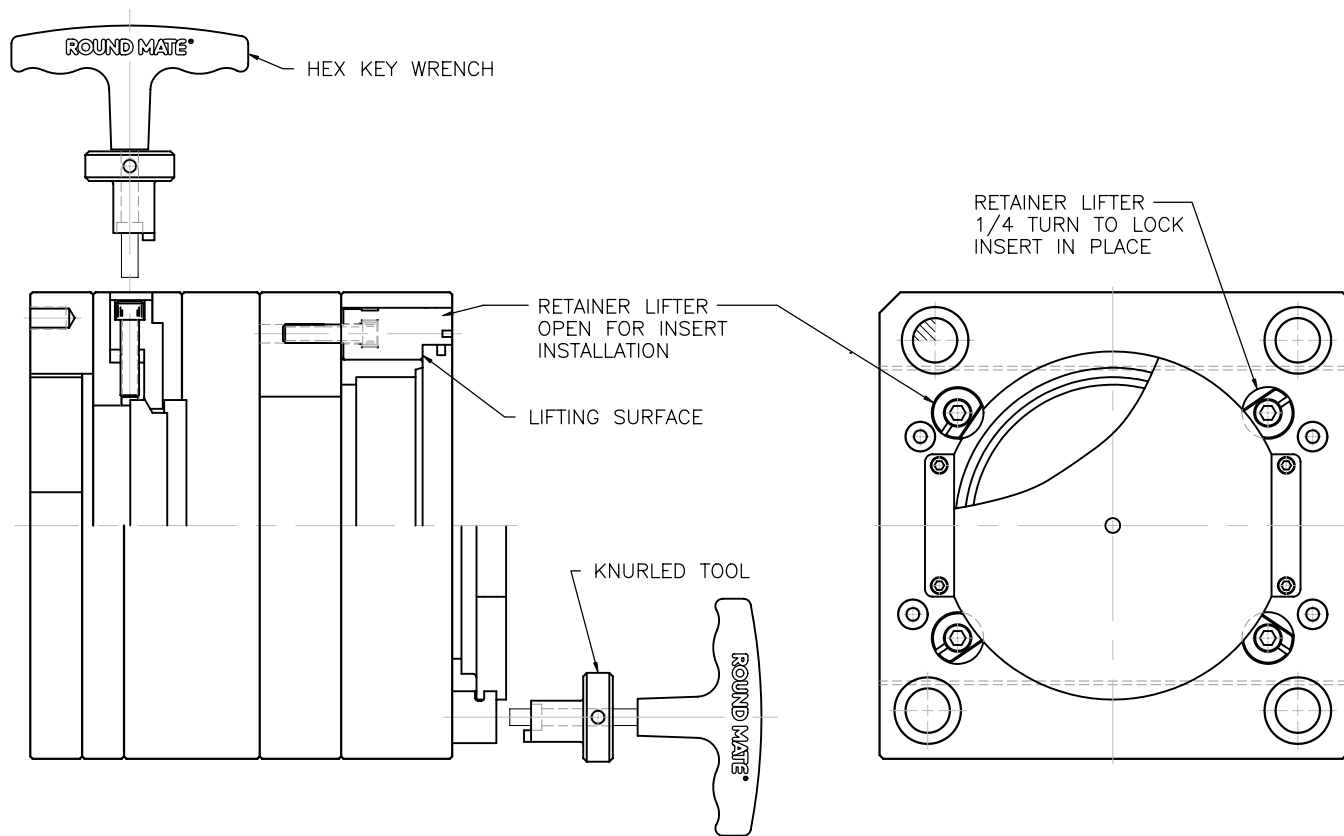
"O" RINGS ARE AN IMPORTANT PART OF THE "ROUND MATE"® SYSTEM AS THEY ARE THE WATER SEALS AND NATURALLY KEEP THE MOLD FROM LEAKING DURING THE MOLDING PROCESS.

THE "ROUND MATE"® MASTER FRAME AND INSERTS HAVE BEEN CAREFULLY DESIGNED TO ELIMINATE "PINCHING" OR "NICKING" AN "O" RING BY USING A "STEPPED BORE" CONSTRUCTION AND A GROOVE IN WHICH THE "O" RING RESTS. THIS DESIGN VIRTUALLY ELIMINATES THE DANGER OF DAMAGING AN "O" RING DURING THE NORMAL CHANGING OF INSERTS. HOWEVER, WORKING WITH AN INSERT ON THE BENCH COULD EASILY SCUFF AN "O" RING, AND WE SUGGEST A VISUAL INSPECTION EACH TIME YOU LOAD AN INSERT INTO THE MASTER FRAME.

IN SPECIAL APPLICATIONS, "HOT OIL" HAS BEEN USED TO HEAT THE INSERT FOR THERMOSET MOLDING. TEMPERATURES REACH 350 DEGREES AND UP. WE DO NOT RECOMMEND THIS PROCEDURE. PIPES AND HOSES CAN RUPTURE AND CONNECTIONS MAY "POP-OFF". WE HAVE DEVELOPED AN ELECTRICALLY HEATED "ROUND MATE"® TO HANDLE THERMOSET AND HIGH HEAT MATERIALS HOWEVER, IF YOU CHOOSE TO USE THE "HOT OIL" SYSTEM IN THE "ROUND MATE"®, PLEASE REMEMBER TO ORDER THE INSERTS WITH HIGH TEMPERATURE VITON "O" RINGS IN PLACE OF OUR STANDARD "O" RINGS. EACH TIME "HOT OIL" IS USED IN THE "ROUND MATE"® WE RECOMMEND CHANGING THE VITON "O" RINGS.

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ROUND MATE®
MAINTENANCE
PROCEDURES



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STEP BY STEP
INSERT INSTALLATION

INSTALLING INSERTS INTO THE "MASTER FRAME"

ONE OF THE REAL ADVANTAGES OF THE "ROUND MATE"[®] SYSTEM IS ITS SIMPLE "QUICK CHANGE" FEATURE. BY FOLLOWING THIS STEP-BY-STEP PROCEDURE, YOU WILL VERY SOON BECOME ADEPT AT CHANGING INSERTS EASILY AND EFFICIENTLY. WE SUGGEST YOU PRACTICE A COUPLE OF TIMES WITH THE INSERTS AND MASTER FRAME ON THE BENCH BEFORE INSTALLING THE MASTER FRAME IN YOUR PRESS. WE WILL CONCENTRATE HERE ON THE "B" OR EJECTOR HALF.

SINGLE POSITION MASTER FRAME

STEP 1: LOCATE THE TWO EJECTOR PLATE LOCKS ON OPPOSITE SIDES OF THE EJECTOR PLATE OF THE MASTER FRAME. USING THE HEX KEY WRENCH, BACK OUT EACH LOCK UNTIL IT STOPS.

STEP 2: LOCATE THE RETAINER/LIFTERS ON THE FACE OF THE MASTER FRAME. YOU WILL NOTE THAT THESE ARE A "HALF MOON" OR "CAM" WITH A FLAT SIDE. THE RETAINER/LIFTERS SHOULD BE SEATED INTO THE MASTER FRAME, BUT NOT SNUGLY. THE FLAT SIDE OF THE CAM MUST BE IN ALIGNMENT WITH THE BORE OF THE MASTER FRAME AND THE LIFTING SURFACE SHOULD BE FLUSH WITH THE BOTTOM OF THE LARGE BORE TO ALLOW INSERTION OF THE MOLD. CHECK THIS WITH YOUR FINGERS TO MAKE SURE YOU HAVE A SMOOTH BORE AT EACH OF THE FOUR RETAINER/LIFTER POINTS YOU ARE NOW READY TO LOAD THE INSERT.

STEP 3: TAKE THE INSERT IN YOUR HANDS AND PREPARE TO LOAD IT IN THE MASTER FRAME. LOCATE THE NOTCH IN THE OUTSIDE DIAMETER OF THE FACE OF THE INSERT AND NOTE THE SHORT DOWEL IN THE BORE OF THE MASTER FRAME. THESE ARE FOR ALIGNMENT PURPOSES. THEY PREVENT YOU FROM LOADING THE INSERT 180 DEGREES OUT OF ROTATION. (OPPOSITE EACH OTHER)

STEP 4: SLIDE THE INSERT INTO THE MASTER FRAME. THE INSERT SHOULD SLIDE IN UNTIL IT IS ALMOST FLUSH WITH THE FACE OF THE MASTER FRAME. IF IT HANGS-UP, CHECK YOUR RETAINER/LIFTERS TO ASSURE THEY ARE NOT PROTRUDING INTO THE BORE OR THE LIFTING SURFACE IS NOT STANDING ABOVE THE BOTTOM OF THE LARGE BORE.

STEP 5: THE INSERT SHOULD NOW BE IN PLACE. ENGAGE THE RETAINER/LIFTERS BY INSERTING THE HEX KEY WRENCH AND SLIDING THE KNURLED TOOL DOWN THE WRENCH UNTIL THE PROTRUDING TIP IS ENGAGED IN THE SLOT OF THE RETAINER/LIFTER. WHILE HOLDING THE HEX KEY WRENCH IN ONE HAND, TURN THE KNURLED TOOL WITH THE OTHER HAND 1/4 TURN UNTIL THE CAM LOCK IS ENGAGED. (NOTE: THIS WILL TAKE SOME PRACTICE AS YOU WILL BE ADJUSTING THE HEX WRENCH LEFT TO RIGHT AND BACK WHILE YOU TURN THE KNURLED TOOL UNTIL YOU FEEL IT MAKE THE 1/4 TURN AND LOCK INTO POSITION) AFTER REPEATING THIS STEP ON ALL FOUR RETAINER/LIFTERS, PULL THE KNURLED TOOL BACK UP THE HEX WRENCH AND FIRMLY TIGHTEN ALL FOUR RETAINER/LIFTERS WITH THE HEX WRENCH. (DO NOT OVER TIGHTEN) A PAIR OF WRENCHES USED TOGETHER, ON OPPOSITE RETAINER/LIFTERS, WILL MORE EVENLY MOVE THE INSERTS INTO, OR OUT OF, THE MASTER FRAME. REPEAT THIS PROCESS ON THE "A" SIDE.

STEP 6: USING THE HEX WRENCH, ENGAGE AND TIGHTEN THE EJECTOR PLATE LOCKS ON THE MASTER FRAME. THE MASTER INSTALLATION PROCESS IS NOW COMPLETE.

MULTI POSITION MASTER FRAME

STEP 6A: THE BASIC PROCEDURE FOR INSTALLING THE INSERTS IS THE SAME WITH THE EXCEPTION OF LOCKING THE EJECTOR SET IN THE MASTER FRAME. IN A MULTI POSITION "ROUND MATE"[®], YOU MUST ENGAGE THE EJECTOR PLATE LOCKS FROM THE PARTING LINE. THESE LOCKS ARE LOCATED IN TWO PLACES FOR EACH INSERT, NEAR THE RETAINER LIFTERS ON THE FACE OF THE MASTER FRAME, AND MARKED "LOCK E.J.". USING THE LONG T-HANDLE WRENCH, ENGAGE THE GEAR DRIVEN LOCKS IN A CLOCKWISE MOTION. CONVERSELY, TO DISENGAGE THE LOCKS, TURN YOUR T-HANDLE WRENCH COUNTERCLOCKWISE.

CHANGING OR ELIMINATING THE SPRUE DISC

SINGLE POSITION MASTER FRAME

IN CERTAIN AND VARIOUS MOLDING SITUATIONS, THE NEED MAY ARISE TO CHANGE, OR ELIMINATE ALTOGETHER, THE SPRUE DISC, WHICH THEN ADDS GREATER FLEXIBILITY TO MOLD DESIGN. THIS IS A SIMPLE PROCESS, AND MAY BE DONE OUT OF THE FACE OF THE MASTER FRAME USING YOUR HEX KEY WRENCH. STANDARD AND EXTENDED NOZZLE SPRUE BUSHINGS DISCS CAN BE ORDERED FROM YOUR "ROUND MATE"[®] CATALOG.

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INSTALLING INSERTS INTO
THE MASTER FRAME