

	RV TOOLS							Format No. Revision No./Date 00 Initial Date 01/06/2023			
MOULD PREVENTIVE MAINTENACE CHECK SHEET											
Mould Name		Inj. Molding Machine (tonnage)		Last PM Shots		Mould No			Raw Material		
Part Number		Customer		Current PM Shots		Tool Maker			No. of Cavity		
Cavity half Standard LPM value				Core half Standard LPM value			Cavity Half LPM value after PM			Core Half LPM value after PM	
PM PREPARTION CHECK UP ( TICK ✓ IN FRONT OF AVAILABILITY OF REQUIRED ITEMS)											
Mould Preventive Maintenance Plan		Mould Loading Unloading Checksheet Latest		Last Set-up Part Quality Report		On-Machine Cleaning Checksheet since last PM		All Breakdown Report Slip since last PM		Last Part with runner	
Last PM Checksheet		Spare Parts Availability		Mould History Card		Waste Clothes		Personal Protective Equipments			
A). DEFECTS IN COMPONENT											
B). DEFECTS IN MOULD											
CHECK AREA	CHECK ITEM	IMAGE	CHECK ITEM	STANDARD	CHECKING METHOD	APPLICABLE Put ✓ mark / Not Applicable Put ✕mark	OBSERVATION BEFORE MAINTENANCE ( OK/ NOT OK)	PROBLEM DESCRIPTION	ACTION TAKEN	OBSERVATION AFTER MAINTENANCE	USED SPARE DETAIL
COMMON ITEMS	LIFTING HOLES		LIFTING HOLES	Free from damages in thread, Rust	Visual						
			EYE BOLTS	Eye bolts fully & securely tightened into lifting holes.	Visual / Manual						
	OUTER SURFACE		OUTER SURFACE	Free from rust, damage, bulging, resin sticky	Visual						
	MOLD LEGS / PROTECTION BLOCKS		MOLD LEGS / PROTECTION BLOCKS	Should not be bolt loose or missing	Visual / Manual						
	MOLD LOCK PLATE		LOCK PLATE	Free from damage & missing bolt	Visual						
	CAM/LINK / ROD / LATCHES / LIMIT BOLTS		CAM / LINK / ROD / LATCHES	Should be in working condition, Free from bolt looseness	Visual / Manual						
	CALENDER		CALENDER	Free from movement jam & update	Visual / Manual						
	COOLING SYSTEM		COOLING COUPLERS	Free from damages, Looseness	Visual / Manual						
			PU PIPE FITTINGS / VALVES	Free from damages, Looseness	Visual / Manual						
			MANIFOLD BLOCKs	Free from damages, Looseness blockages & rust, etc	Visual						
COOLING LINES			LPM Value should be same as pre-defined	Coolant Flow Metre							
		COOLING PLUGS	Free from leakage	Visual							
MOULD ID PLATE		MOULD ID PLATE AVAILABILITY IN MOULD	Mould ID Plate should be available and properly fitted in mould	Visual							
POSITIONING PARTS		MOLD POSITIONING PARTS	Free from damages, Looseness	Visual / Manual							
HYDRAULIC SYSTEM		HYD. CYLINDER	Free from leakage, Mounting Looseness	Visual / Manual							
		HYD. OIL HOSES	Free from leakage, Looseness, interfere with Moving parts	Visual / Manual							
		HYD. OIL COUPLERS / FITTINGS	Free from damages, Looseness	Visual / Manual							
		HYD. CORE/SLIDE CONFIRM CONNECTOR	Free from damage, loose wiring, oil, dust & should be in working condition	Visual / Manual							
		LIMIT SWITCH / SENSORS	Free from damage, loose wiring & should be in working condition	Visual / Manual							
CAVITY SIDE	CAVITY TEXTURE		CAVITY TEXTURE	Free from rust, damages	Visual / Manual						
	P.L / P.S		PARTING LINE	Free from damages, rust, buldge, burrs	Visual / Manual						
			PARTING/MATCHING SURFACES	Free from damages, rust, buldge	Visual / Manual						
	CHROME PLATED PARTS		CAVITY SURFACE	Free from Scratches, dents, rust etc.,	Visual						
	TRANSPARENT PARTS		SHOT COUNTER	Ensure for working condition	Visual						
	HRS SYSTEM		HRS SYSTEM	Heaters, Thermocouples in working conditions & note down resistance value	Multimeter / Mobile Temp. controller						
			HRS CONNECTOR	Free from damage	Visual						
			HEAT INSULATOR PLATE	Free from damage, loose mounting	Visual / Manual						
	SEQ. VALVE SYSTEM		SOLENOID VALVE / AIR FITTINGS	Free from damage, loose mounting, loose wiring	Visual / Manual						
	AIR VENTS		AIR VENTS	Free from damages, rust, dust	Visual / Manual						
	GUIDE PILLAR/BUSH		GUIDE PILLAR/BUSH	Free from scoring, bend, damages, looseness/play, tight alignment, lack of grease etc	Visual						
	GAS INJECTION		AIR PIPE FITTINGS	Free from damages, Looseness, dust	Visual/Manual						
	SPRUE BUSH		SPRUE BUSH	Free from scoring, damages, crack, bolt looseness	Visual						
SPRUE BUSH RADIUS			Free from damage, surface roughness	Visual							
LOCATING RING		LOCATING RING	Free from damage, bolt looseness	Visual / Manual							
SLIDERS	SLIDER PARTS		CAM PINS	Free from scoring, bend, damage.	Visual / Manual						
			WEDGES	Free from damages, scoring, looseness	Visual / Manual						
			WEAR PLATES	Free from damages, scoring, bolt missing.	Visual / Manual						
			SIDE CORE / SLIDER	Free from damages, scoring.	Visual / Manual						
			SIDE CORE INSERT	Free From damages,crack.	Visual / Manual						
			SLIDER SPRINGS	Free from damages, mis-alignment, lack of tension	Visual / Manual						
			STOPPER BOLTS	Free from broken, looseness	Visual / Manual						
			GUIDE RAILS	Free from Scoring, damage, loosen.	Visual / Manual						
	SPRING HOLDING PLATE		SPRING HOLDING PLATE	Free from looseness	Visual / Manual						
	SPRING BOLTS		SPRING BOLTS	Free from looseness, bend	Visual / Manual						
			Rest Button	Free from loosen,crack,damage.	Visual / Manual						
	BALL CATCHERS		BALL CATCHERS	Free from damages, jam etc	Visual / Manual						
	CORE SIDE	CORE SURFACE		CORE SURFACE /	Free from rust, damages, buldging etc., & Level of Ejector Parts found normal from Core surface	Visual					
PARTING LINE		PARTING LINE		Free from damages, rust, buldging etc.	Visual						
AIR VENTS		AIR VENTS		Free from damages, rust, clog	Visual / Manual						
CORE PINS		CORE PINS		Free from scoring, bend, damages, loose fitment etc.,	Visual / Manual						
GUIDE PILLAR/BUSH		GUIDE PILLAR/BUSH		Free from scoring, bend, damages, looseness/play, tight alignment etc	Visual / Manual						
COOLING SYSTEM		COOLING LINES		LPM Value should be same as pre-defined	Coolant Flow Metre						
		COOLING PLUGS	Free from leakage, rust, looseness	Visual							
EJECTOR SYSTEM			EJECTOR SYSTEM MOVEMENT	Free from noise, movement jam etc.,	Visual / Manual						
			EJECTOR PIN / SLEEVE PINS	Free from scoring, dust, bend, tight movement & apply grease	Visual / Manual						
			EJECTOR BLADES	Free from scoring, dust, bend, tight movement & apply grease	Visual / Manual						
			EJECTOR PAD / BLOCKS & SHAFTS	Free from scoring, bend, tight movement & apply grease	Visual / Manual						
			ANGULAR CORE & SHAFTS	Free from scoring, bend, tight movement & apply grease	Visual / Manual						
			RETURN PINS	Free from scoring, bend, tight movement & apply grease	Visual / Manual						
			ALL EJ.PIN / BLADE / SHAFT HOLES	Free from scoring, rust, damages, dust etc.,	Visual / Manual						
			LIFTER'S GUIDE BUSH in CORE BLOCK	Check for its position and lock plate fixed/bolted	Visual / Manual						
			EJECTOR GUIDE PILLAR	Free from scoring, bend, dry surface, tight movement & apply grease	Visual / Manual						
			EJECTOR GUIDE BUSH	Free from scoring, crack, dry surface, tight movement & apply grease	Visual / Manual						
			SUPPORT BLOCKS	Free from damages, scoring, looseness	Visual / Manual						
SLIDE UNITS FOR ANGULAR CORE SHAFT			SLIDE UNITS FOR ANGULAR CORE SHAFT	Free from tight movement, dust, bolt looseness & apply grease	Visual / Manual						
EJECTOR CONFIRMATION			EJ. CONFIRM LIMIT SWITCH	Free from damage, looseness, mis-position & should be in working condition	Visual / Manual						
			EJ. CONFIRMATION CONNECTOR	Check for its working condition, loose wiring	Visual / Manual						
UNSCREWING MECHANISM		UNSCREWING MECHANISM	Check for teeth damage, loose alignment & apply grease	Visual / Manual							
RETURN SPRINGS		RETURN SPRINGS	Free from damages, mis-alignment, tensionless	Visual / Manual							
GAS SPRINGS		GAS SPRINGS	Free from damages, mis-location, bolt looseness & Check for tension	Visual / Manual							
MOULD MATCHING	CORE		BLUE MATCHING	Complete Impression on matching side/New insert fitted if require	Visual / Manual						
	CAVITY		BLUE MATCHING	Complete Impression on matching side/New insert fitted if require	Visual / Manual						
	SLIDER /LIFTER		BLUE MATCHING	Complete Impression on matching side	Visual / Manual						
C). CUSTOMER'S SPECIFIC REQUIREMENTS ( If any )											
TICK (✓) IN FRONT OF THE DOCUMENT UPDATED AFTER PM DONE											
Mould History Card		Monthly PM Plan		Descaling Machine Log sheet		Ultrasonic Machine Log sheet			Spare Parts Register		
Date of Mould PM Start			Date of Mould PM Done		Mould PM Done By			Checked By		Approved By	