

# Injection Molder

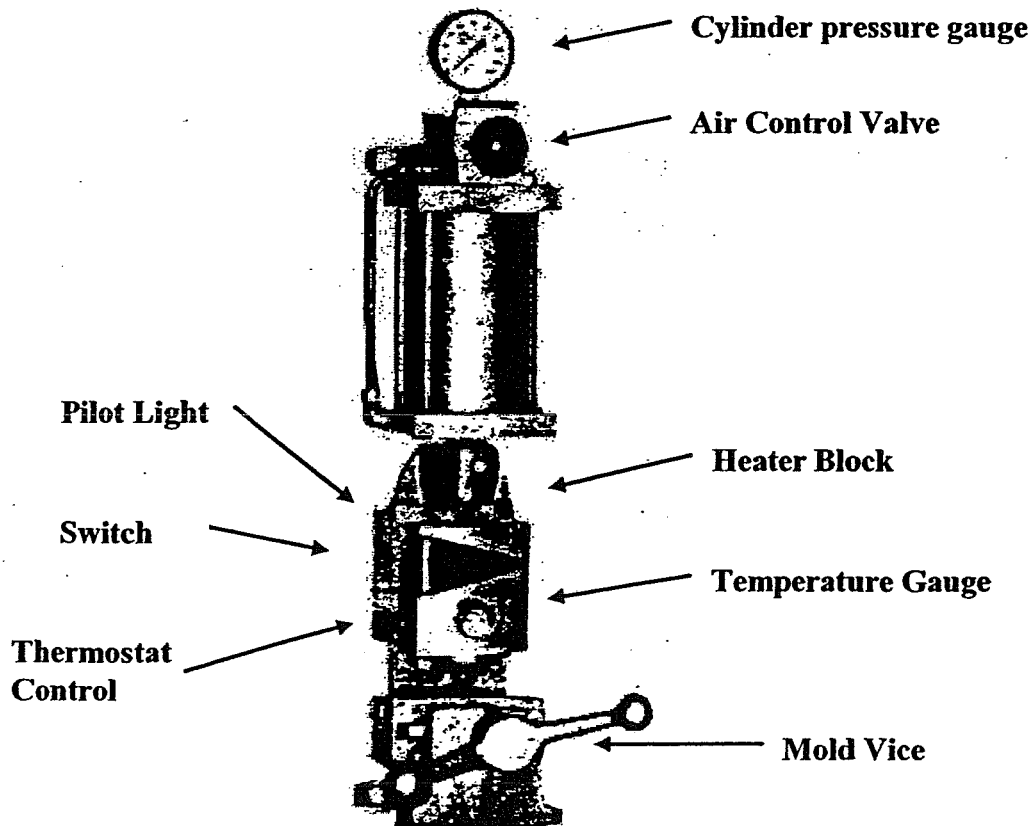
## To certify on the injection molder you will need to know:

1. The safety rules.
2. The parts of the injection molder.
3. How to use the injection molder.
4. How to check out a mold.

## Injection molder safety rules.

1. Wear eye protection
2. Keep hands away from heated cylinder and funnel.
3. Turn off power switch when not in use.
4. Use gloves to remove mold.
5. Do not use metal to pry in or around mold. Doing so will damage mold.

## Parts of the injection molder.



## **How to use the injection molder.**

1. Turn on switch. Pilot light should light.
2. Set the thermostat control at the medium position and allow cylinder to heat. The temperature gauge should reach 275-300 degrees.
3. Install the mold in the mold vice; being sure that the opening at the top of the mold is lined up with the hole of the injection nozzle. Shims (small metal pieces of metal) are needed at times to the hole in the mold into line with the hole in the injection nozzle. These shims are placed, when needed just in back of the mold. Be sure not to over tighten the mold. Just tighten the mold so it is snug.
4. After the mold is in place, fill the heater block with plastic pellets. Let it heat for 3-5 minutes at 275 degrees.
5. Open the valve for the compressed air line. Push in injection molder air control valve. This forces molten plastic into the mold cavity. Wait 30 seconds then release the air control valve.
6. At this time the mold should be full. If it is not there may be several causes for failure:
  - A. The plastic may not have been heated enough.
  - B. The mold may have become clogged.
  - C. Not enough plastic may have been placed in the heating block.
7. At this time your mold is full, loosen the vice and remove the mold. If the mold is hot, use gloves to remove the mold.
8. If the mold will not open or the plastic is stuck in the mold have your instructor assist you. Do not use a metal object to open or free plastic out of the mold.
9. Be sure to refill the heating chamber with plastic.

## **How to check out a mold.**

Ask your instructor to sign out a mold. Remember you're responsible for returning the mold at the end of the period.