

MID-AMERICA MACHINING, INC
11530 BROOKLYN ROAD
BROOKLYN, MI 49230
TEL.: 517-592-8988 ♦ FAX: 517-592-8991

15 STEP STANDARD MOLD REPAIR AND RECONDITIONING PROCEDURES

- Ø DISASSEMBLE AND CLEAN MOLDS: Allows for detailed inspection and evaluation of molds prior to repair.
- Ø INSPECT NECK RINGS: Check shut height, pinch-off, sandblast, zero shear steels, inserts, etc.
- Ø REPLACE PINS AND BUSHINGS: Ensure bushing snugness, proper mold alignment.
- Ø CLEAN WATER LINES: Remove water line corrosion, replace worn freeze plugs, enlarge damaged "O" ring counter bores, etc.
- Ø REPAIR PINCH-OFF: Insert, peen, or weld beryllium-copper or aluminum pinch-offs as necessary to insure proper trimming.
- Ø GRIND PARTING FACE AND BACK OF MOLD: (.003" / .004" normal), removes damaged material, allows molds to be re-matched, pinch-off to be re-sharpened.
- Ø RE-MATCH CAVITIES: Improves container appearance and ensures proper trimming.
- Ø RE-BORE MATCH DIAMETER: Ensures correct mounting of neck rings/top blocks.
- Ø RE-CUT VENTS/FLASH POCKETS: Ensures proper gram weight and proper venting per print specification.
- Ø SHARPEN PINCH-OFF ANGLES: Ensures proper trimming.
- Ø SANDBLAST/CLEAN VENTS: Improves container finish, better air venting.
- Ø MAINTAIN SHUT HEIGHT: Molds can be reworked one at a time, so a set of molds can be matched to other sets.
- Ø STEP BACK PLATES: Necessary to ensure correct mounting of neck rings.
- Ø WATER TEST: Check for leaks, damaged freeze plugs, "O" rings, cracked water lines, etc., maintain proper water flow.

Ø REASSEMBLY: Reassemble with protection between mold halves, and tape securely to prevent damage to parting faces and pinch-off edges during transportation.