

TOOLING APPROVAL CHECK LIST FOR PLASTIC MOULDS

Part Name:	Mould maker's Mould no.:
Customer Part No.:	Your Company's mould no.:
Your Company's Part No.:	Mould drawing No.:
Customer drawing No.:	Revision level:
Revision:	Hot runner details:
	Mould Size:
Date of Review:	Mould Weight:
	No. of cavities:

S.No	Check points	OK/ NOK/ NA	Remark / Deviation
1	All the Notes written on part drawing are accomplished		
2	Core and Cavity material test certificate is ready		
3	Final mould inspection report		
4	Blue matching of cavity, core, side core and other matching areas		
5	Flash observed on the part		
6	Is there buckling on core, cavity and ejector plates		
7	No. of fasteners is sufficient for core and cavity inserts		
8	Lifting holes provided for heavier core and cavity inserts		
9	Dismantling and assembly of moulds is easy		
10	All parts of the mould are identified for easy assembly		
11	All necessary parts are heat treated		
12	Is the core surface		
	Free from polishing line		
	Free from EDM or milling marks		
	Free from waviness		
13	Draft angle is sufficient		
14	Mould dimensions produce components within component tolerances		
15	Mouldings remain on ejector side when the mould opens		
16	Ejector stroke clears components		
17	Component is free from catching, cracking and warpage		
18	Is the texture according to standard and is uniform		
19	Free movement of ejector system		
20	Adopter is suitable to the machine selected		
21	Ejector return mechanism is acceptable		
22	Main guide pillars enter before any other part of the mould		
23	Is there scoring on any parts		
24	Cavity and Core inserts properly located		
25	Electrical wires on the mould is properly clamped		
26	All electrical connections, wiring are checked		
27	Water channel inlet and outlet are according to drawings and stamped for IN , OUT and thread size		
28	Water lines are completely checked for leaks at 5 bar pressure		
29	Are Water and hydraulic hoses, connectors interfering during mould loading and during moulding		
30	Locating ring is matching to the machine selected		
31	Sprue bush nozzle seating radius matching with planned machine		
32	Is Sprue bush draft sufficient and polished		
33	Is Sprue puller proper		
34	Runners are of sufficient size		
35	Runners are polished and free from burrs		
36	Gate to be checked for size and burrs		
37	Mould is sufficiently vented		
38	Opening and closing is acceptable		
39	Mould lifting eye bolts are sufficient		
40	Eye bolt size, mould weight, mould no. and part no. punched		
41	Lifting Strap, if any does not project beyond plates and foul with other parts		
42	Special instructions are punched on the mould		
43	Check for doweling of all guide rails		
44	Check for cracks on mould parts		
45	Circuit diagram for heaters to be provided on the mould towards the operator side		
46	All catalogues in original		
47	Process sheet for Mould Setting		
48	Side cores are removable while the mould is in the machine		
49	All cavities are numbered		
50	Check for split line burrs		
51	Moulds to be provided with Hasco water nipples		
52	The mould should not have any brazed part		
53	Mould part drawings		
54	Critical spares are identified and provided		
55	Side core movement controlled by Ball catch or stopper plates		
56	Top plate cooling on hot runner mould		
	Tool Approved	YES / NO	

Other Comments

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Signature and Name of the Tool maker with Seal	Signatute and Name of Your Company representatives (Production, Quality, Engineering)
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