

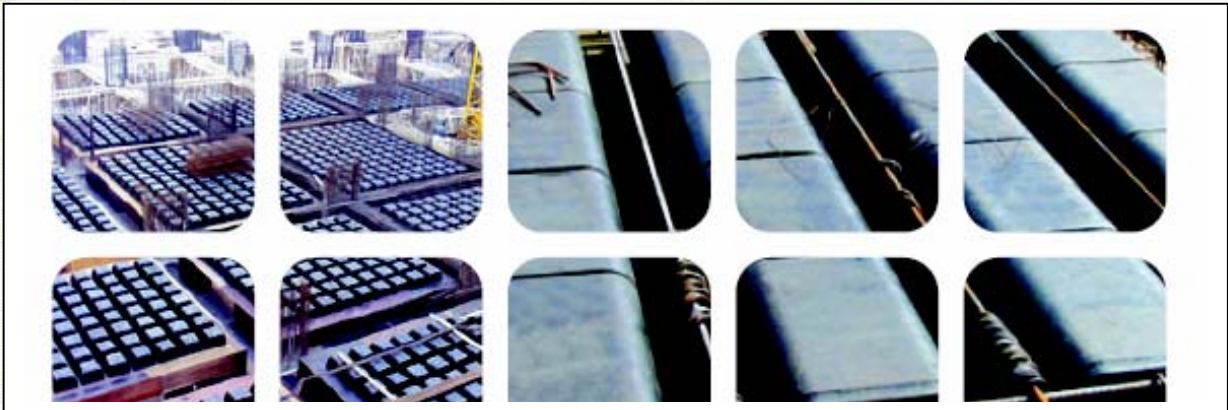
DATA SHEETS

series 12

'M' MOULDS



REPAIR MANUAL



REPAIRS

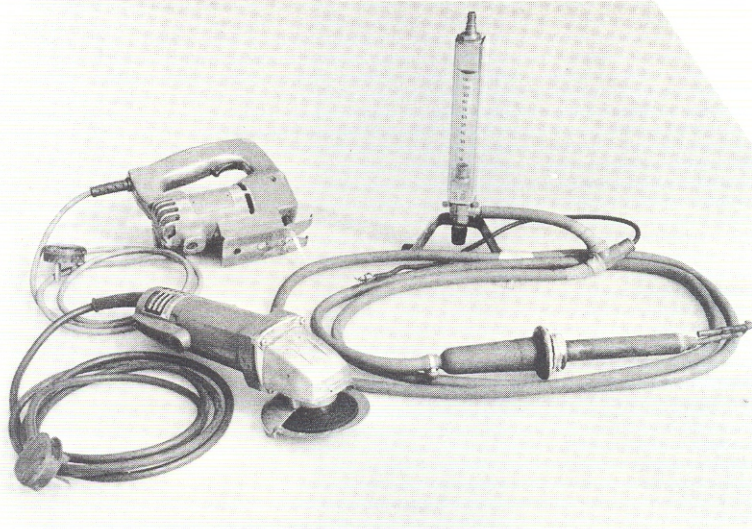


Fig. 1

Equipment Required for Repairing

1. Plastic welding kit, gun, etc. obtainable from :-

Goodburn Plastics Ltd. ,
Arundel Road,
Industrial Estate,
UXBRIDGE, Middx.

Tel: Uxbridge 32256

2. Polisher.
3. Jig-Saw.
4. Polypropylene Sheet.
5. Plastic Welding Rod. (Not shown).
6. Reciprocator/Compressor. (Not shown).

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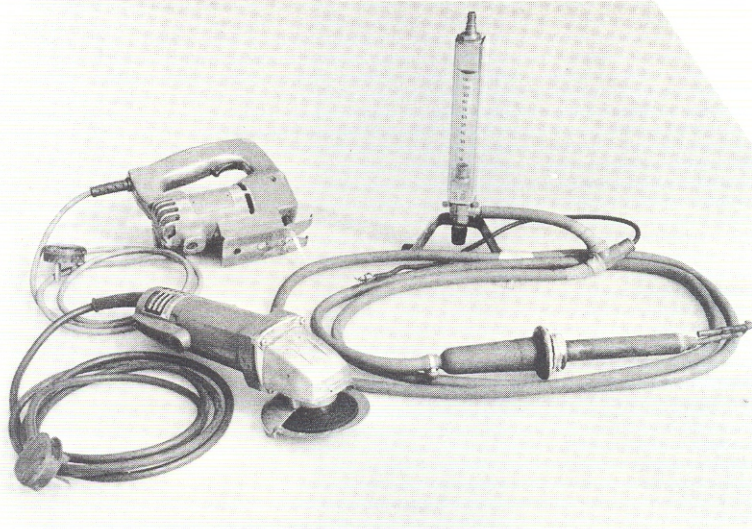


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METHOD OF REPAIR

Repairs are carried out by low temperature plastic welding.

The workshop in which repairs are carried out should be at a constant warm temperature. Moulds to be repaired (and the materials being used for the repairs) should be kept in this workshop for a few hours before repair.

In cases where the mould is cracked but no material has been lost, the two edges of the crack are welded together with the welding rod from both inside and outside the mould. The crack is then rubbed off clean on the outside with the polisher.

If however, a piece of material has been broken from the mould, then a full patching process must be used.

First a piece of material is cut from the polypropylene sheet to approximately the same shape as the missing section. This should be slightly smaller than the hole itself to allow for the weld. The replacement piece of material is inserted and held in position with a clamp from the inside. The welding process is then carried out as in Fig. 2. (The welding rod used can be seen being fed into the welding gun.)



Fig. 2



Fig. 3

The polisher is then used from the outside to smooth the repair to the same plane as the mould, (see Fig. 3) and the excess patch removed from the inside.

The result is as seen in Fig. 4.

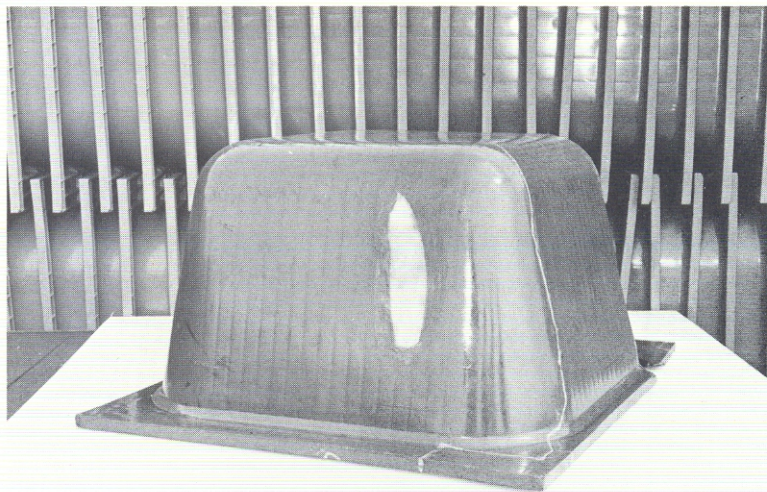


Fig. 4

The completed repair showing the position of the splints is illustrated in Fig. 7.

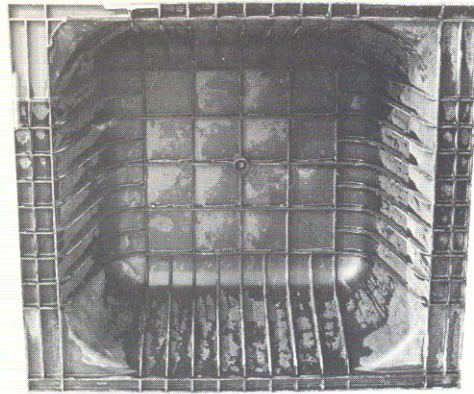


Fig. 7

After some practice, it will be possible to determine whether a damaged mould is capable of being repaired or whether the cost would be uneconomic. In practice, very few moulds are totally scrapped since even those very badly damaged can be cannibalised to provide parts for other less damaged moulds.