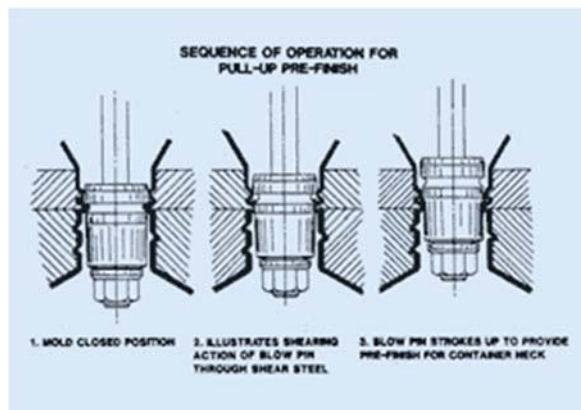


Procedure for Installing Pull-Up Style Pre-Finish Blow Pins and Shear Steels

NOTE: For accurate setting, machine must be up to operating temperature.

1. With molds in open position, turn hydraulic pump off, and remove platen guards.
2. Remove old blow pin heads from blow pin stems and install new blow pin heads. Secure locking nuts tightly. Rotate blow pin stems to be sure they are not bent.
3. Remove old shear steels and install new shear steels. The 10-32 SHCS holding the shear steels should only be finger tight for now. Be sure the shear steels you are putting in are a matched set.
4. With molds open, check blow pin height while blow pins are in the down position. Adjust height so that the cutting surface of the shear steel is in the center of the blow groove in the blow pin.
5. Re-install platen guards, close operators safety doors and start hydraulic pump. Open and close the molds manually around the blow pin head and check for proper front to back and side to side alignment by watching for blow pin movement as the molds open and close around it. Adjust the blow pin cylinder until there is no visible blow pin head movement.
6. With the molds open, raise the blow pins manually.
7. Hold the mold close button and lower the blow pins down to seat the shear steels in the mold top blocks.
8. Manually open the molds, raise the blow pins, and repeat step # 7, two or three times. Do not raise the blow pins with the molds closed until after Step #9 is completed.
9. Manually open the molds and tighten the 10-32 SHCS holding the shear steels in place. Your blow pins and shear steels should now be properly aligned.



NOTE: Periodically check the cutting diameters of your shear steels and blow pins for uneven wear marks. If uneven wear marks are visible and your parts have been installed properly, you should look for sideways movement in your mold pins or your clamp assembly.

CAUTION: IF BLOW PIN IS SET TOO LOW, DAMAGE TO SHEAR STEELS, BLOW PINS, OR BOTH WILL OCCUR. IF SET TOO HIGH, NO SHEARING ACTION WILL OCCUR AND NECK FINISH WILL NOT BE COMPLETE