

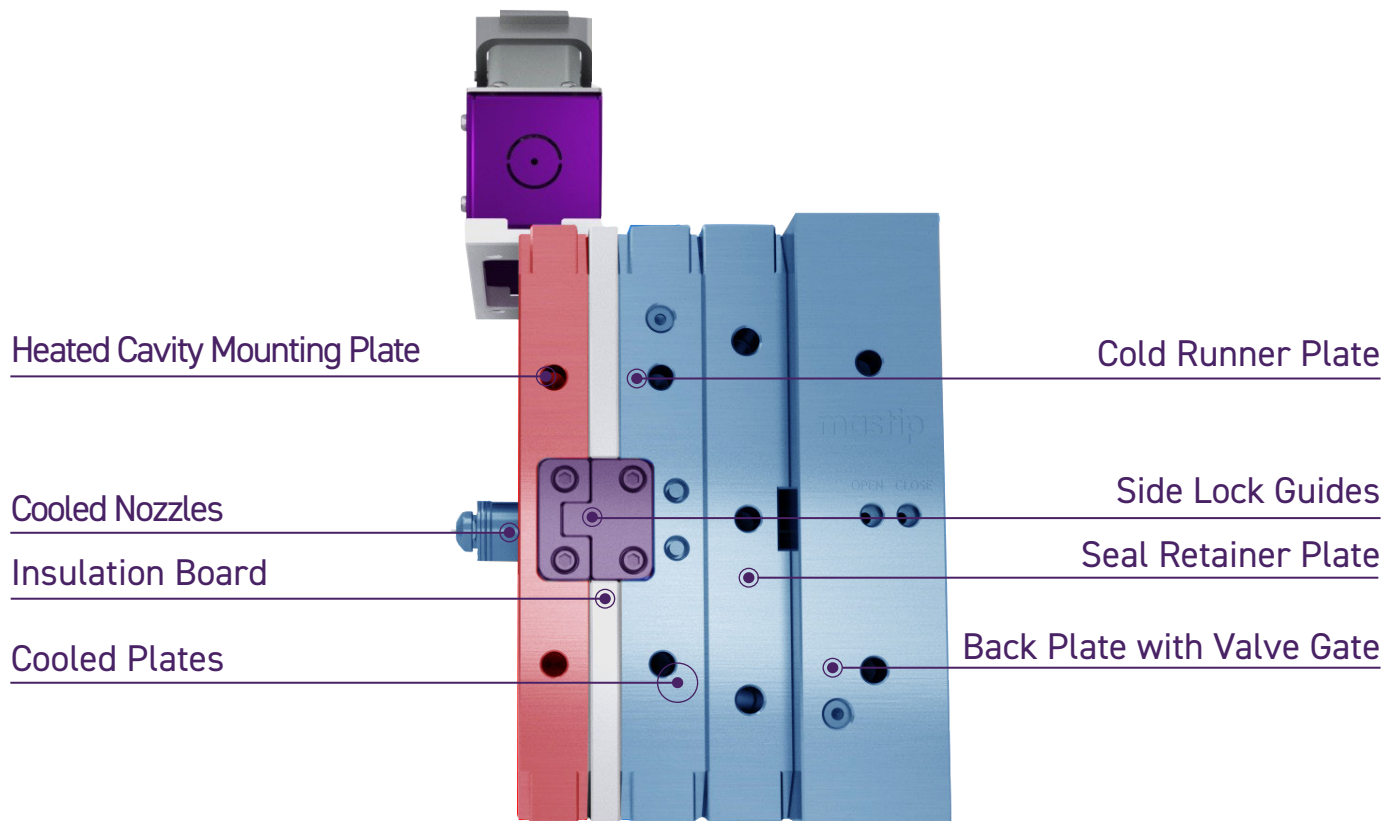
AQUILOTM

LSR Cold Deck

Technical Guide

Assembly Overview

Mastip provides a customised Liquid Silicone Rubber (LSR) cold deck valve gated solution with proven cooling and heating technology. Mastip cold decks are optimised to shorten cycle times while producing high quality parts.

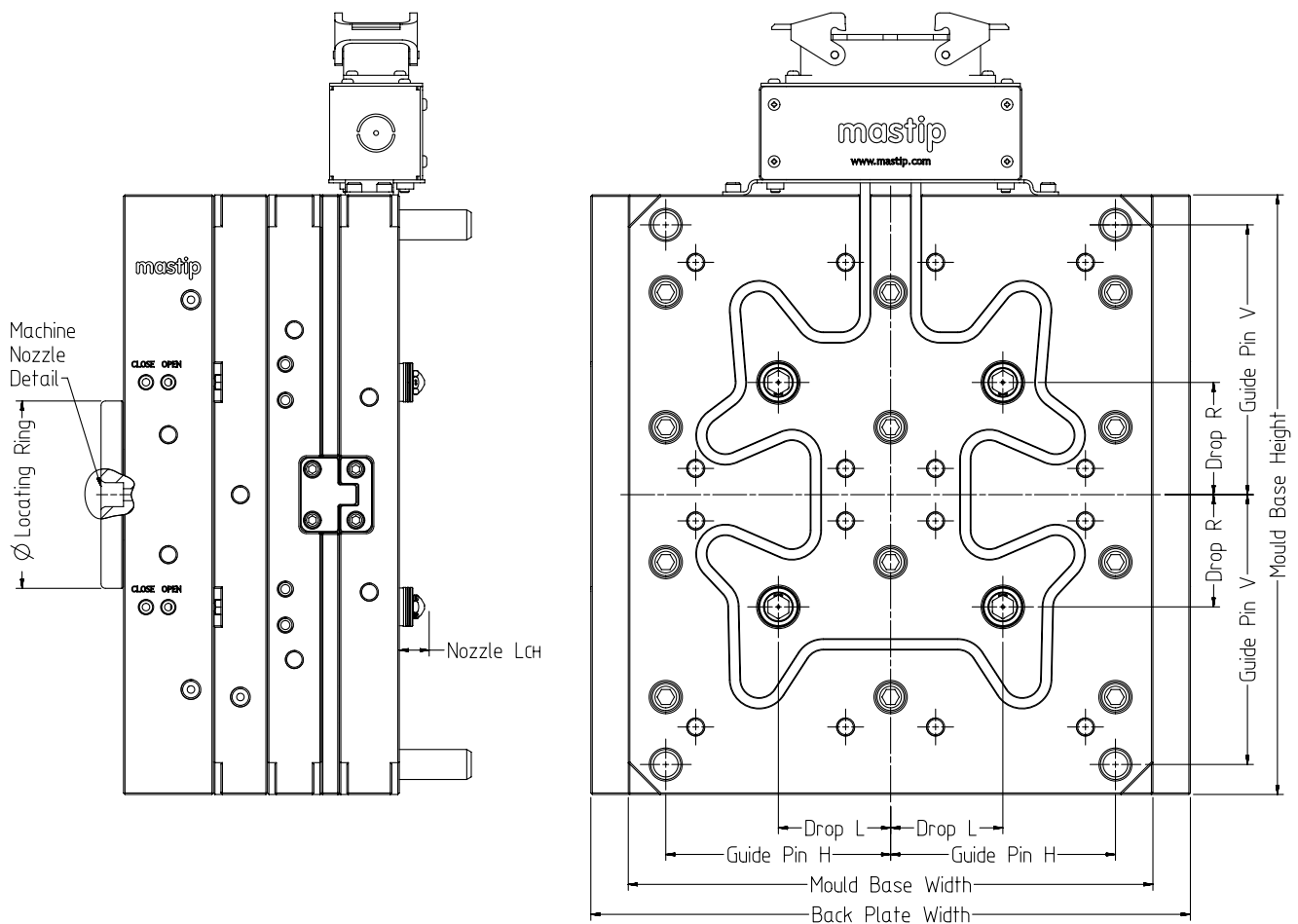


Key Features

- Cooled plates ensure silicone remains liquid
- Cooling channels in the nozzle for delivery of material in optimum condition
- Cavity mounting plate heated with Mastip's proven heater technology
- Insulation board to thermally insulate the cooled plates from heated plates
- Hardened side lock guides to control the thermal expansion between the heated and cooled plates
- Valve gate technology to precisely control the liquid silicone at the gate
- Thermally insulated electrical terminal mounting box for heated plates

AQUILO™ System Ordering Information

Note: To ensure that Mastip are able to supply system approval drawings in a timely and accurate manner, please complete the required AQUILO™ System Ordering Information and supply to Mastip along with the **CAD model with cavity mounting locations**.



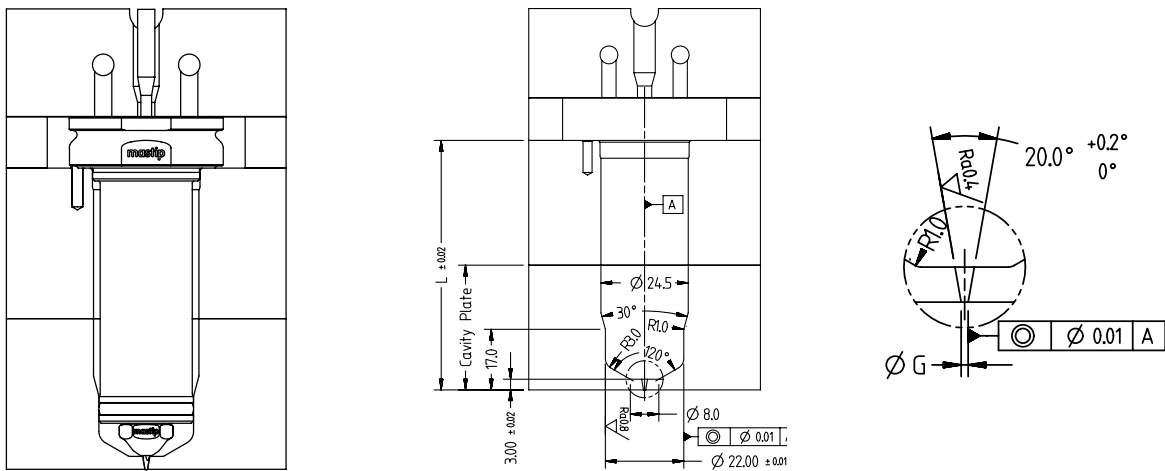
Description	Dimension
Drop L	
Drop R	
Mould Base H	
Mould Base V	
Guide Pin V	
Guide Pin H	
Nozzle LCH	
Ø Locating Ring	
Machine Nozzle Detail	

Cold Deck Nozzle Range Series and Lengths

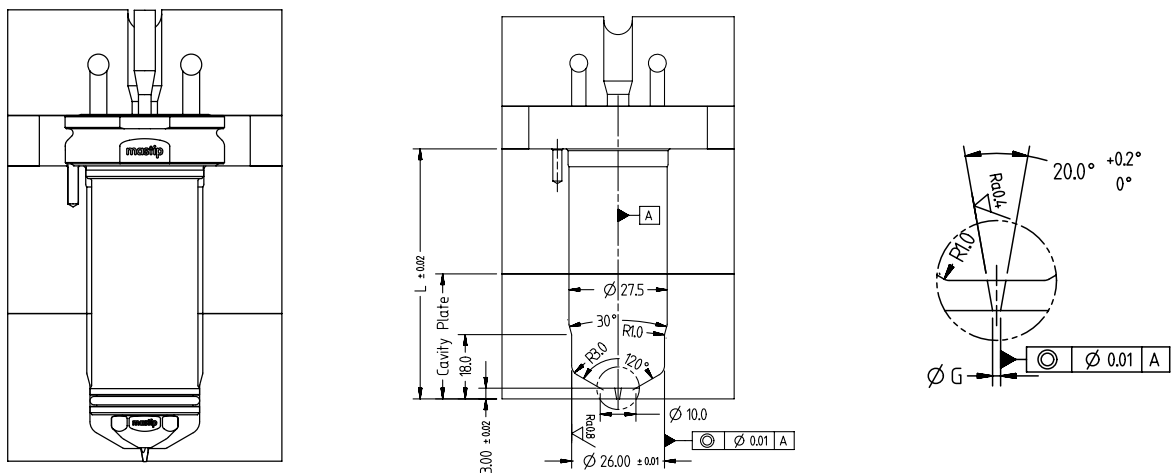
Standard Nozzle Dimensions*			
Series	Flow Bore	Length L	Gate Ø
CR04	Ø4	50, 70, 90	0.4, 0.6, 0.8
CR06	Ø6	50, 70, 90	0.6, 0.8, 1.0

* Custom lengths available on request

CR04



CR06



Cold Deck Requirements

Pneumatic Supply

Air quality: Filtered to 40 µM and lubricated

Minimum air: pressure 4 Bar

Maximum air: pressure 10 Bar

System Cooling

During system start-up, operation and shut-down the cooling water supply to the cold deck must continue flowing to ensure the material does not cure prematurely inside the cold deck.

1. Water quality and PH levels must be maintained to ensure it is clean and free of particulates and biological growth
2. Cooling water temperature must not exceed the material manufacturers recommendation, typically less than 25°C
3. Cooling water pressure should not exceed 8 bar
4. Cooling water flow rate should be a minimum of 15 l /min
5. All cooling circuits should be independently supplied by separate cooling feeds

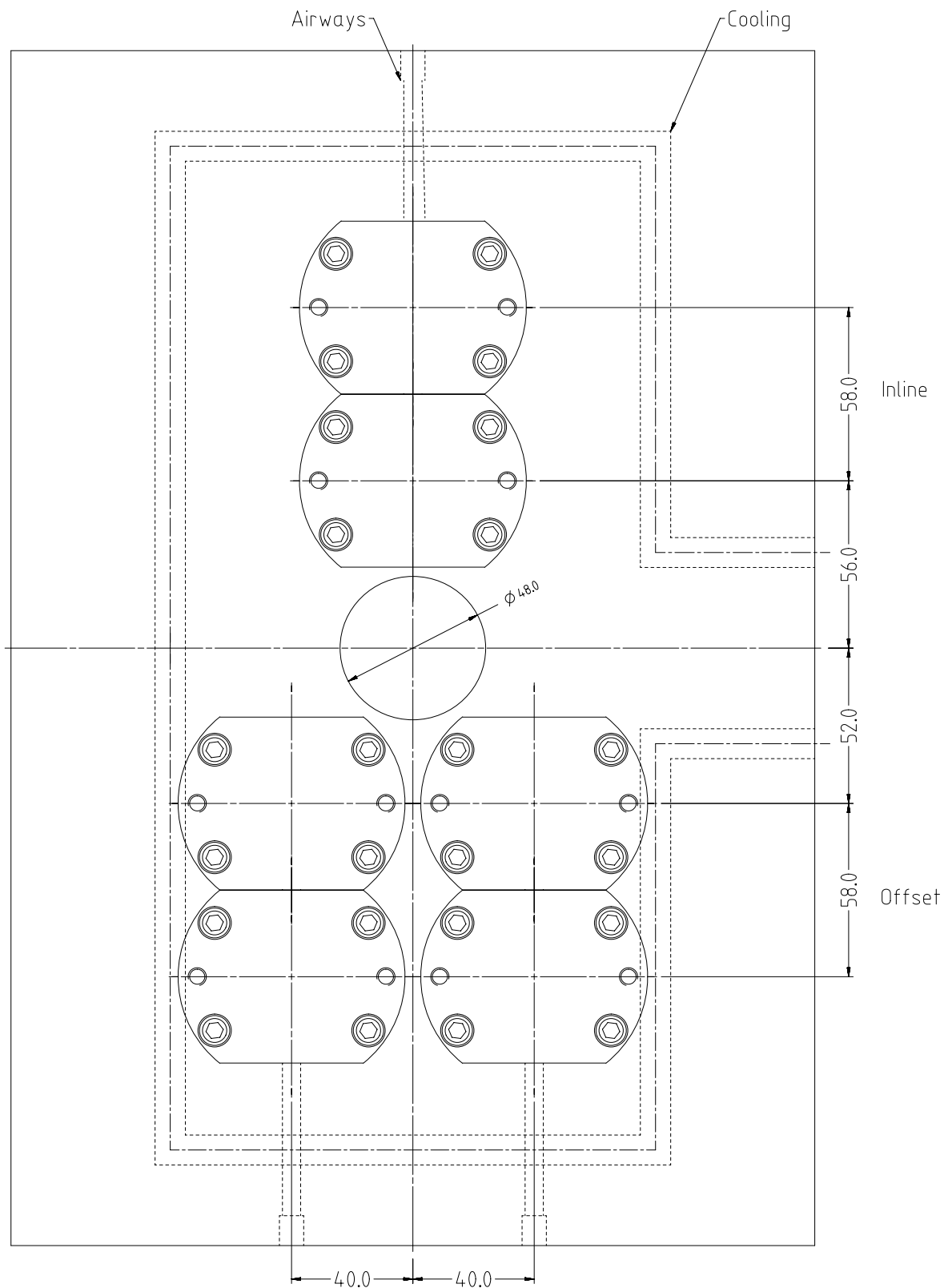
Start-up Procedure

1. Turn on all water chillers/cooling and ensure temperatures are at or below the conditions mentioned above
2. Turn on water cooling connections to the cold deck and check cooling flow is operating correctly
3. Continue with normal cavity heating start-up procedure

Shut-down Procedure

Switch off all mould heaters, ensuring all water cooling continues flowing to the cold deck until the heated plates are at room temperature

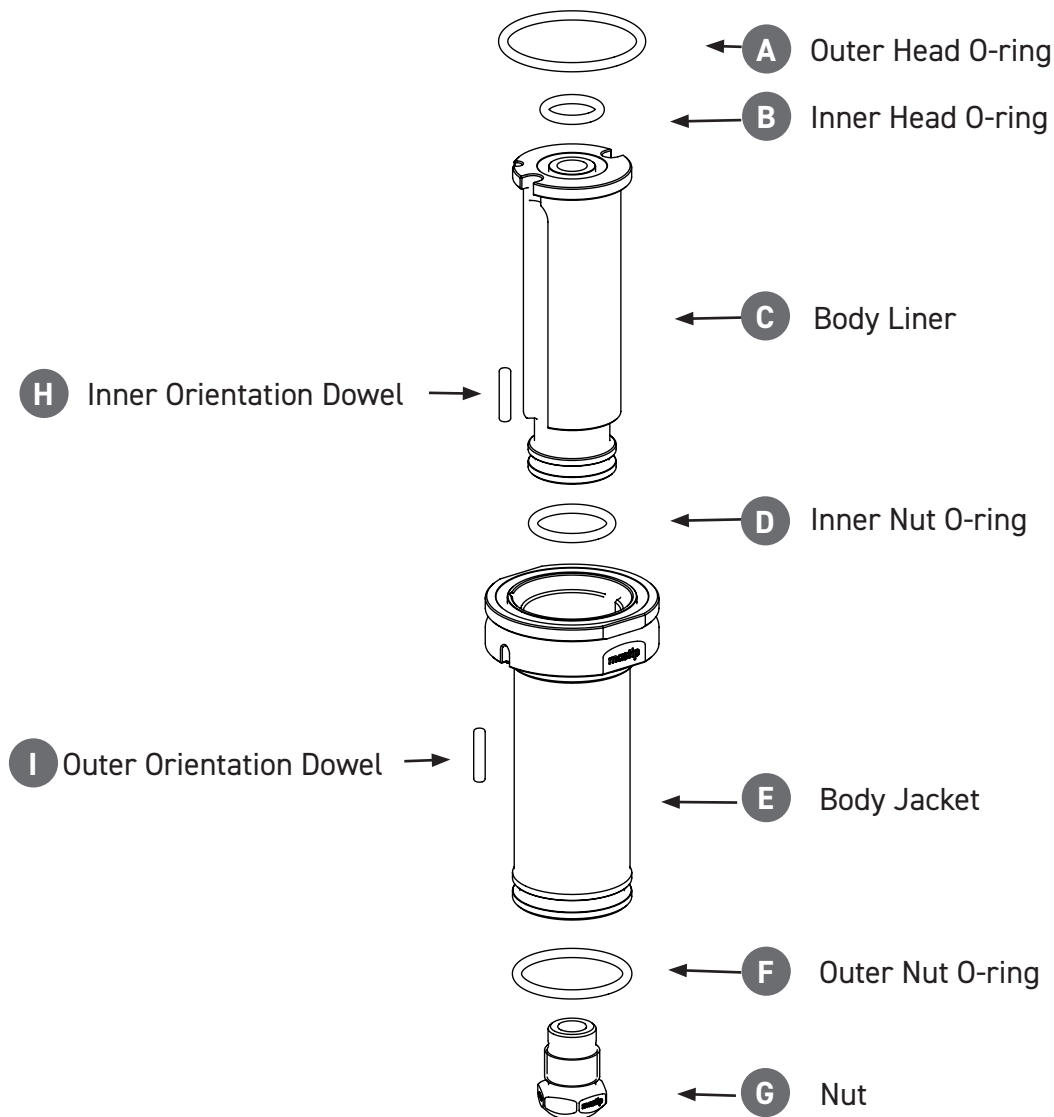
Spacing Layout



Maintenance Reassembly Procedure

INSTALLATION

ONE

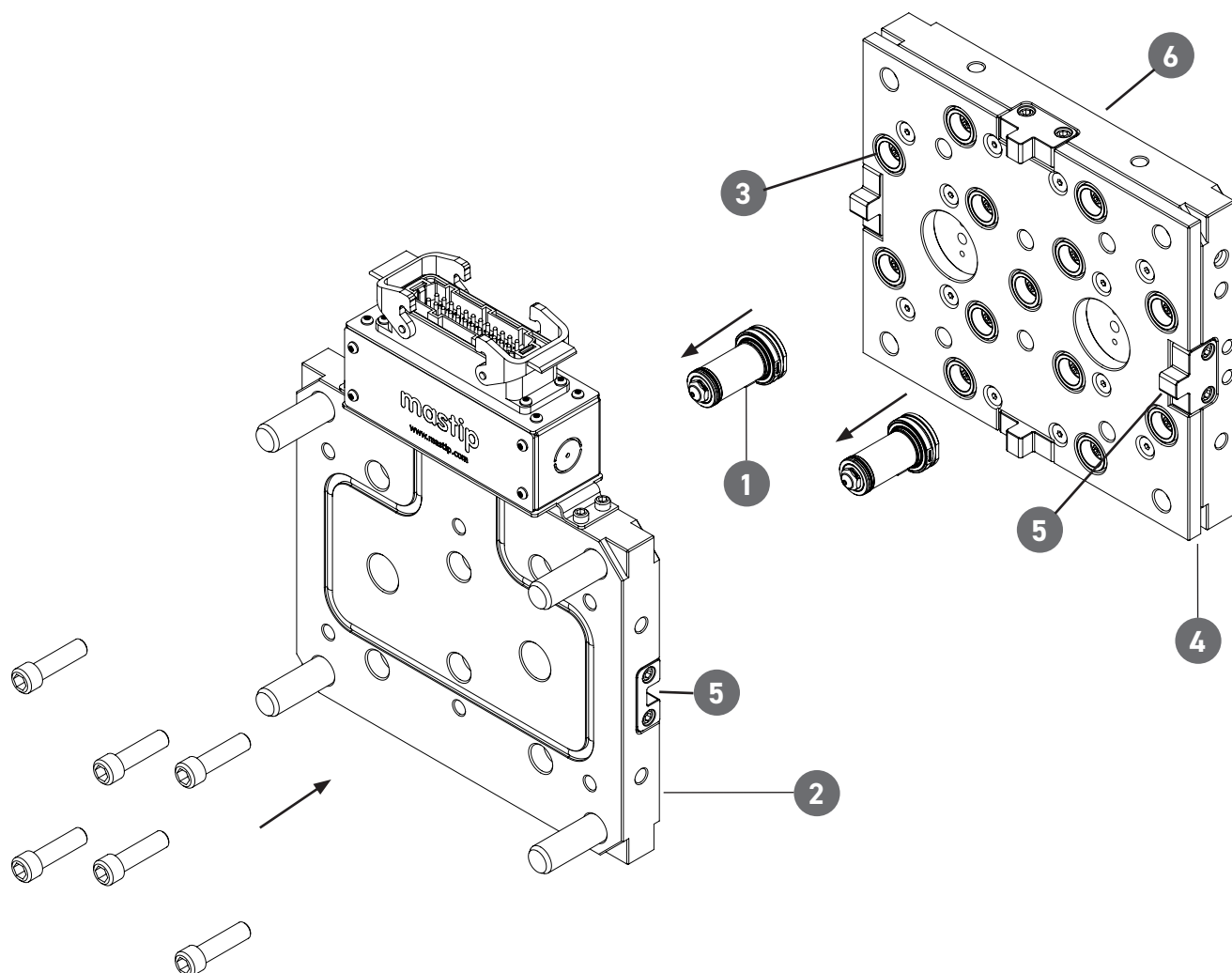


Fit Nut **G** to Body Liner **C** and tighten to 25Nm. Fit Inner Nut O-ring **D** to Body Liner **C** and add silicon grease. Fit Inner Orientation Dowel **H** to Body Jacket **E** and slide Body Liner **C** inside Body Jacket **E** ensuring the orientation dowel is aligned with slot.

Fit Outer Nut O-ring **F**, Outer Head O-ring **A** and Inner Head O-ring **B** to nozzle assembly. Fit Outer Orientation Dowel **I** to Cavity Mounting Plate **2**.

INSTALLATION CONT.....

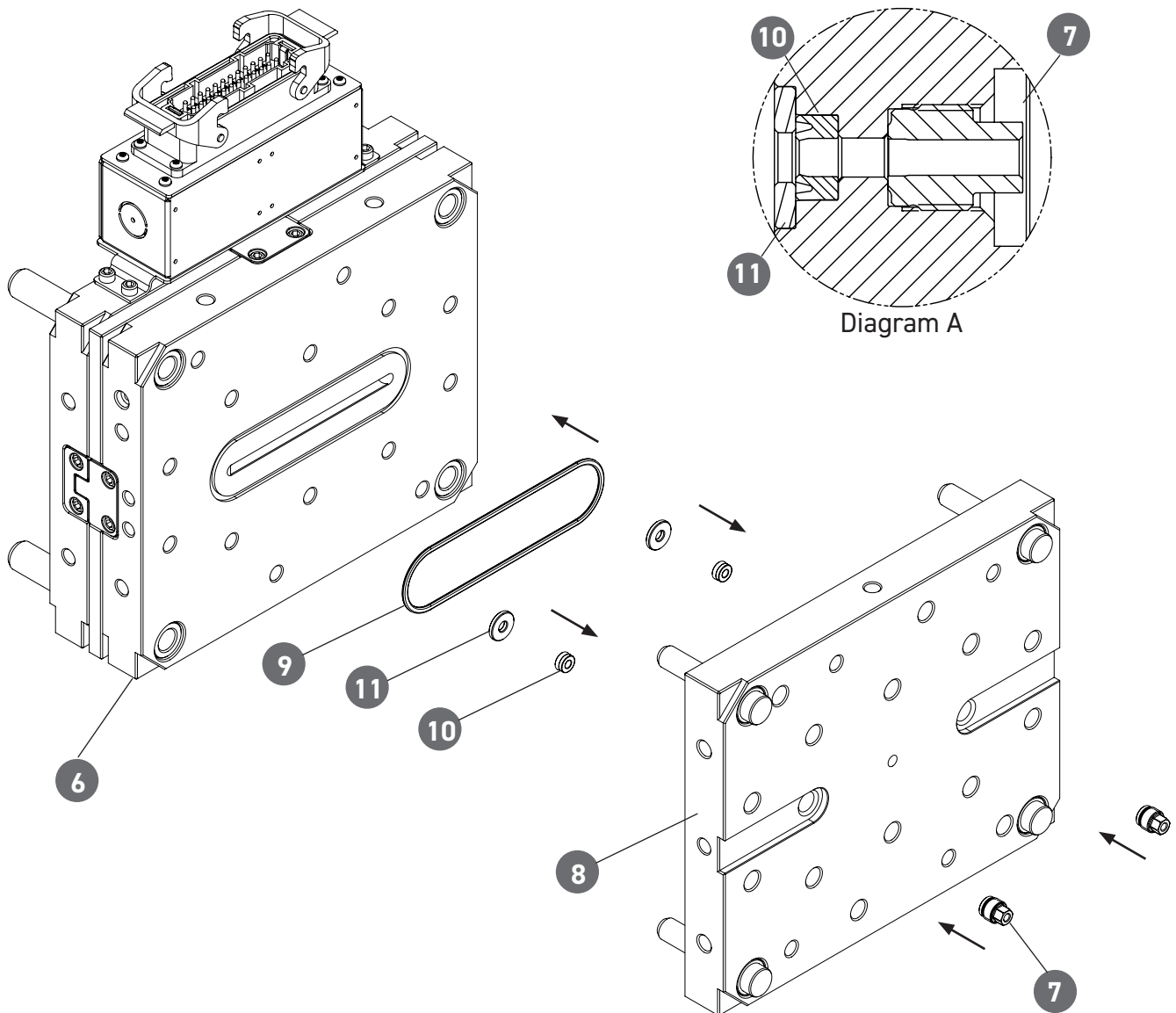
TWO



Fit Nozzles **1** to Cavity Mounting Plate **2** and fit Spacers **3**, Insulation Board **4**, Side Locks **5** to the Manifold Plate **6**. Fasten together with supplied cap head screws (M12: 130Nm, M16: 240Nm)

INSTALLATION CONT.....

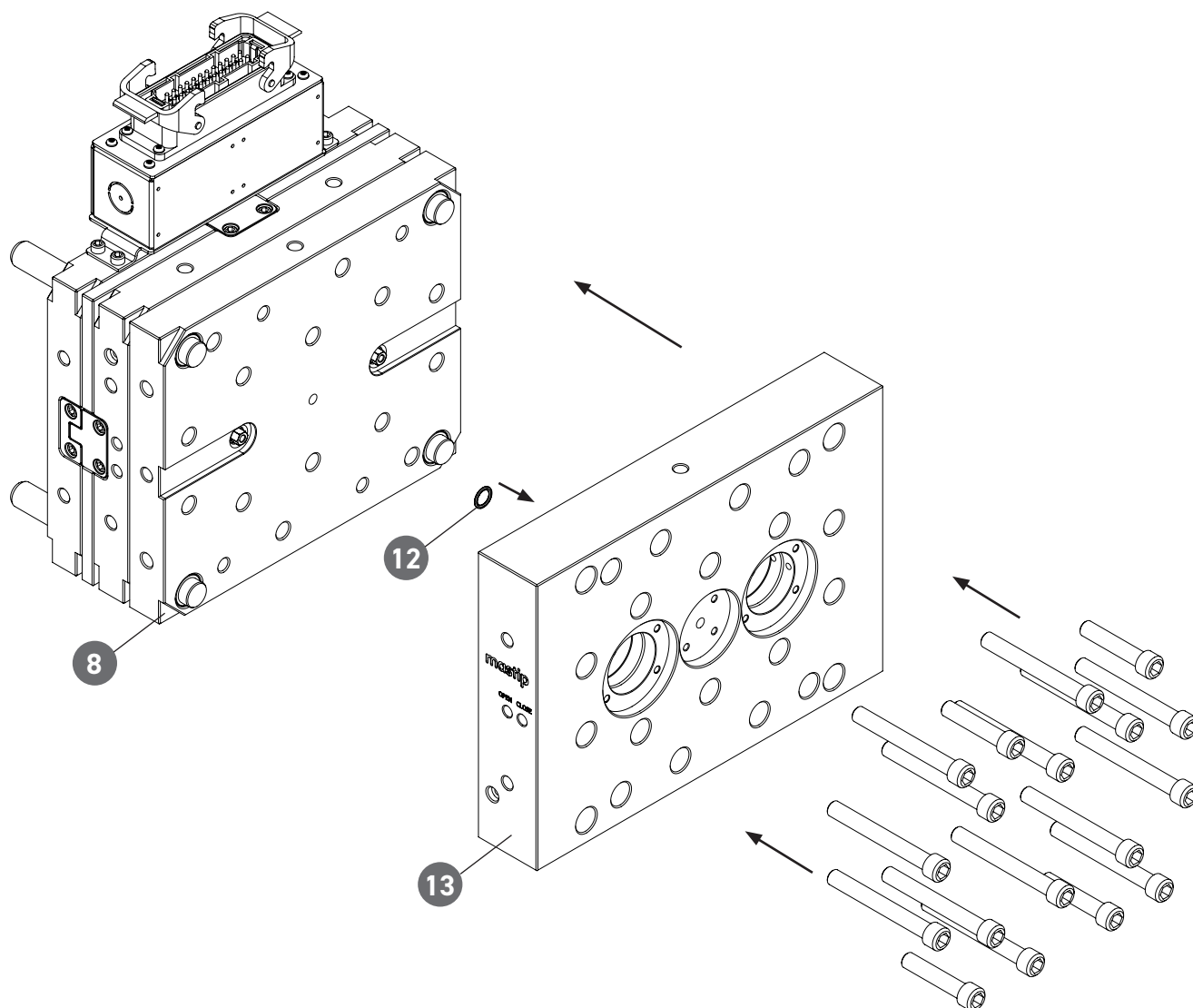
THREE



Fit the **Valve Pin Guides** **7** to the **Seal Plate** **8**, and tighten to 20Nm. Fit the **Manifold O-Ring** **9** to the **Manifold Plate** **6**. Fit the **Valve Pin Seals** **10** to the **Seal Plate** **8** with the groove facing out (Refer to **Diagram A**), and fit the **Seal Retaining Disks** **11** over the top of the seal. Assemble the **Seal Plate** **8** to the **Manifold Plate** **6**, taking care not to damage the **O-Ring** **9** or **Valve Pin Seals** **10**.

INSTALLATION CONT.....

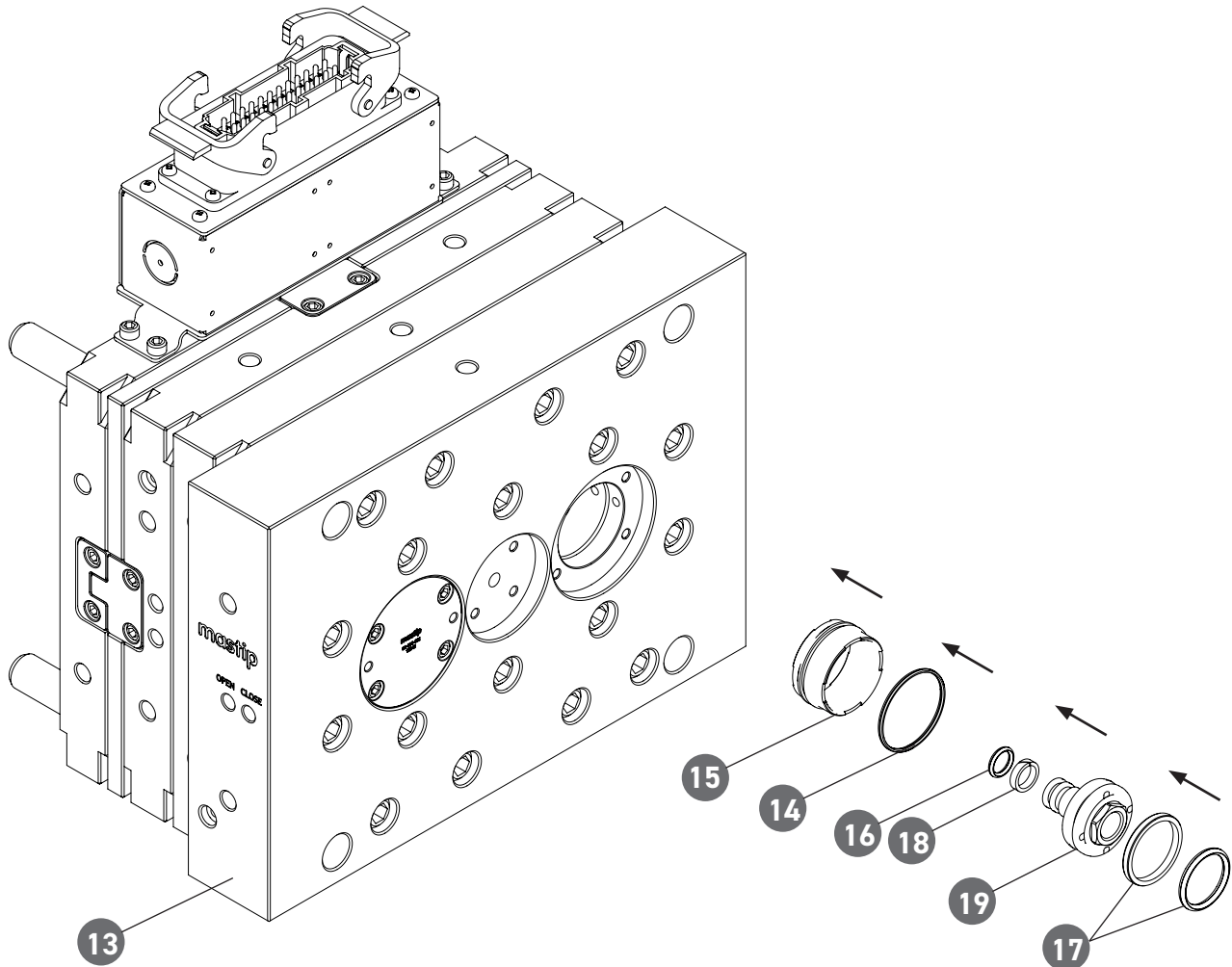
FOUR



Fit the Back Plate Sprue O-ring **12** to the Back Plate **13** and fit the Back Plate **13** to the Seal Plate **8**. Fasten with supplied Cap Head Screws (M12: 130Nm, M16: 240Nm)

INSTALLATION CONT.....

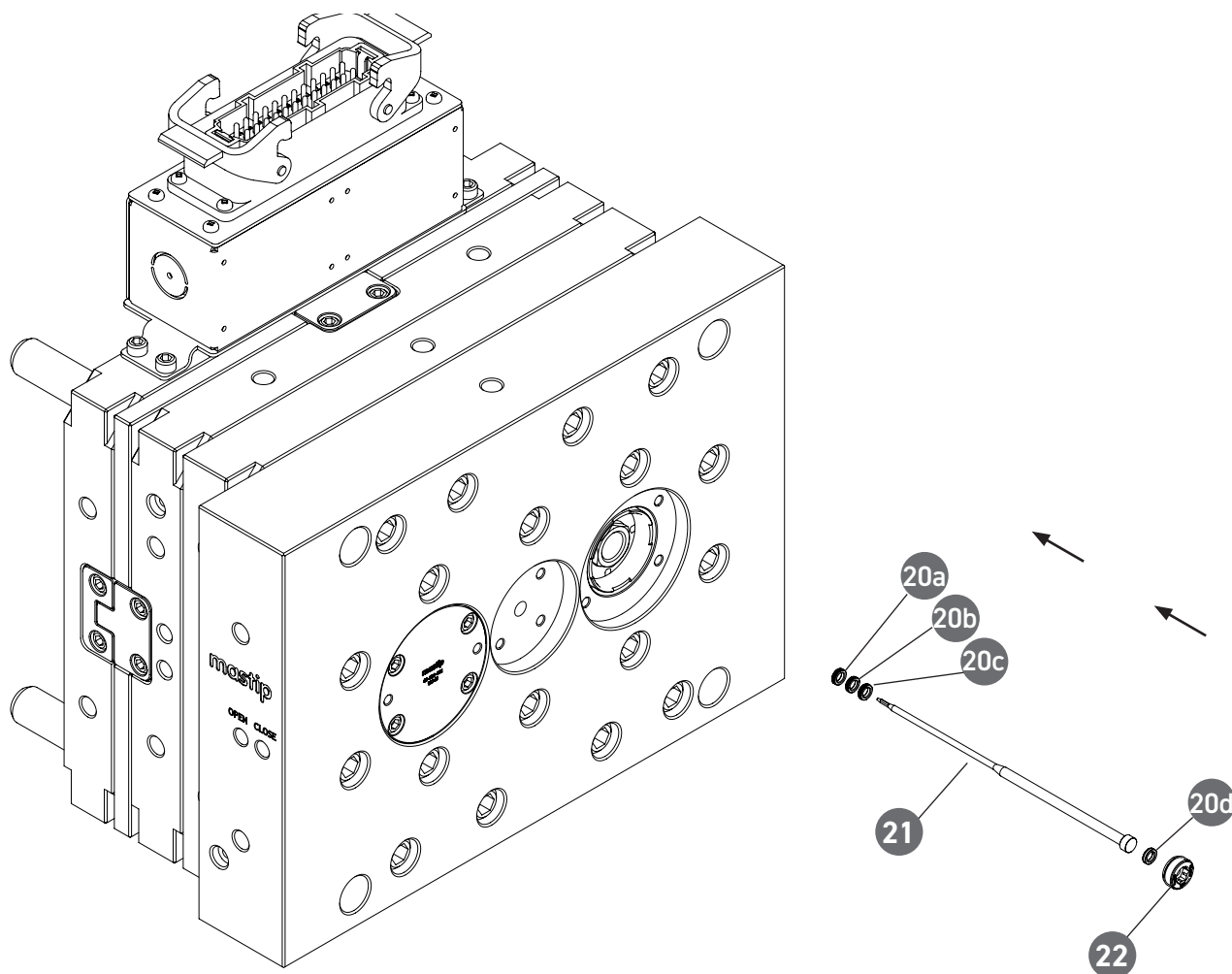
FIVE



Assemble the **Cylinder O-ring 14** to the **Valve Cylinder 15**, apply silicon grease to the O-ring **14** and fit to the cold deck **Back Plate 13**. Fit the **Piston Seals 17**, **Bearing Strip 18** and **Rod Seal 16** to the **Piston 19**. Apply high temperature silicon grease to the cylinder bore, **Piston Seals 17**, **Bearing Strip 18** and **Rod Seal 16**. Fit the **Piston 19** to the **Cylinder 15**.

INSTALLATION CONT.....

SIX



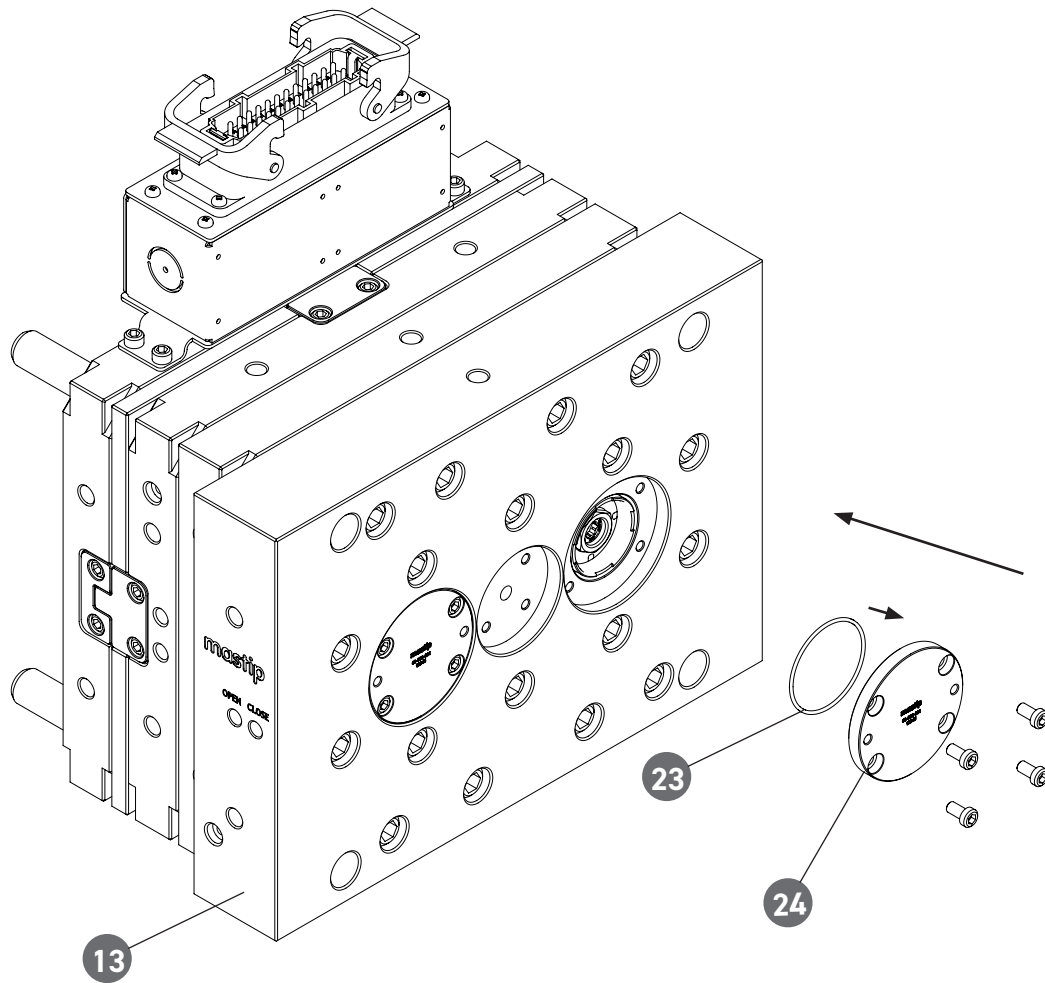
Insert the **Valve Pin Adjustment Packs** 20a, 20b, 20c onto the **Valve Pin** 21. Ensure the correct packer thickness is in the correct position. (Recommend starting with the thinnest packer above the pin head, then adjust to suit if necessary). Fit the **Valve Pin** 21 to the **Piston** 19.

Fit the remaining **Valve Pin Adjustment Spacer** 20d, above the Valve Pin head. Fit the **Pin Locking Screw** 22 to the **Piston** 19 and tighten to 40Nm.

Refer to Page LSR-14 for **Pin Height Adjustment** information.

INSTALLATION CONT.....

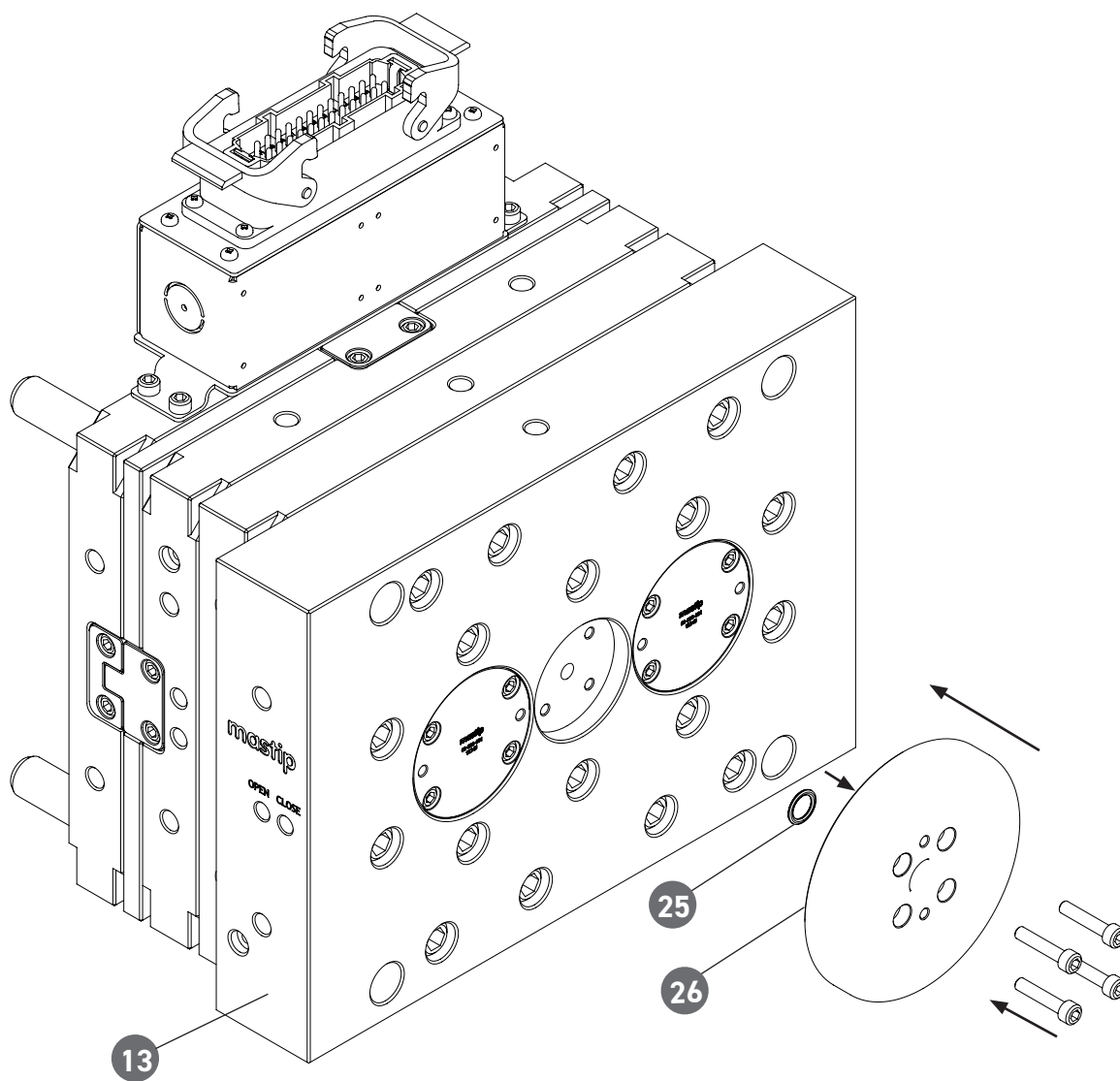
SEVEN



Fit Blanking Plate Seal 23 to Blanking Plate 24. Fit Blanking Plate 24 to the Backplate 13 and fasten using blanking plate screws

INSTALLATION CONT.....

EIGHT



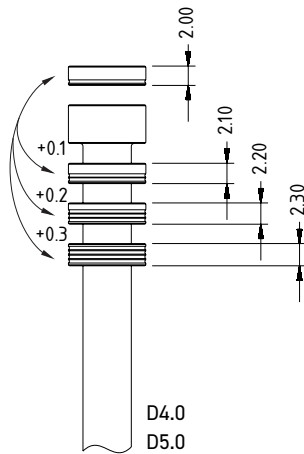
Fit Locating Ring O-ring **25** to Locating Ring **26**. Fit Locating Ring **26** to Backplate **13** and fasten with supplied Caphead Screws.

Note: Disassembly is the opposite of the above assembly procedure

PIN HEIGHT ADJUSTMENT

ONE

Minor Adjustment

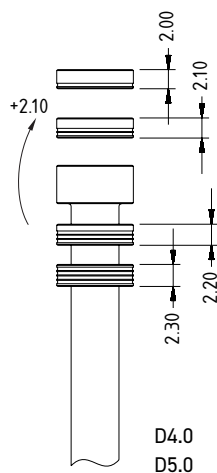


Swap Valve Pin Adjustment

Packers 20a, 20b, 20c & 20d to achieve small pin adjustments (different packer = different height)

TWO

Major Adjustment



Move one or more Valve Pin

Adjustment Packers 20a, 20b, 20c & 20d from below the pin head to above the pin head to achieve large pin adjustment

Notes

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Mastip Head Office New Zealand

Physical Address

558 Rosebank Road, Avondale
Auckland 1026, New Zealand

Postal Address

PO Box 90651, Victoria St West
Auckland 1142, New Zealand

Phone: +64 9 970 2100

Email: mastip@mastip.com

Mastip Regional Office Europe

Phone: +33 0 809 400 076

Email: europe@mastip.com

Mastip Regional Office North America

Phone: +1 262 644 9400

Email: northamerica@mastip.com

Mastip Regional Office China

Phone: : +86 755 84193188

Email: china@mastip.com

Mastip Regional Office Vietnam

Phone: +84 93 8877488

Email: quang.pham@mastip.com

For a full list of Distributors,
please visit www.mastip.com