

MOUNTING/FRAMING MAINTENANCE

Many mounting and framing repairs can be taken care of with the simple replacement of a part or by making minor adjustments to the mounting system. It is important to check the items referenced in this section after initial break-in of the mold.

Bolt and Receivers

Mounting/Framing Maintenance Problems	Norstar Solutions (as listed below)
1) Cracked receiver	A
2) Stripped or worn out threads	A
3) Bolt set seizing	B

Solutions:

- A) Replace the cracked receiver by pulling the cotter pin and clevis pin, remove the cracked receiver and insert a new receiver. (See Norstar catalog to order replacement parts.)
- B) An appropriate anti-seize lubricant is C5-A by Fel-Pro

See page 13 in this manual for proper bolt stop adjustment pressure.

MOUNTING/FRAMING MAINTENANCE continued

Clamp and “J” Bolt

Clamp and “J” Bolt Problems	Norstar Solution (as listed below)
Excessive flash due to inadequate clamping pressure	A

Solutions:

- A) The “J” bolt can be adjusted up or down by loosening the two ½” – 13 nuts and then moving the “J” bolt to a new position and then tightening the nuts again.

See page 13 of this manual for adjustment to frame.

MOUNTING/FRAME MAINTENANCE continued

K-10 Clamp

Clamp Problems	Norstar Solution (as listed below)
Excessive flash due to inadequate clamping pressure.	A

- A) If you have determined that the parting lines are clean and smooth, but continue to note excessive flash, adjust the draw hook by turning it to tighten. Be careful not to over tighten or you may cause damage to the parting line or clamp. If flash continues to be a problem after you have adjusted the draw hook, contact Norstar for further instructions.

NOTE: The locking nut must be loosened prior to adjustment.

MOUNTING/FRAME MAINTENANCE continued

Springs

Spring Problem	Norstar Solution(as listed below)
Loss of tension	A

A) Tension cannot be regained.

Replace spring by removing the 3/8"-16 mold mounting bolt and insert a new spring. Shims may need to be replaced or added. See drawing on page 13 to reference parts mentioned. (Replacement springs are available in the Norstar Catalog)

NOTE: After numerous runs you may notice a spring moving freely or a space between the spring and the frame (when frame is relaxed).

All springs should have slight tensions between the frame and the mounting post before clamping (springs should barely move with the twist of your hand).

When the spring moves freely or there is a space between the spring and the frame, you will need to re-shim the spring half of the frame only. You should never have to adjust the bottom frame because there is direct pressure from the post to the frame.

See next page for instructions on how to re-shim the spring half of the frame.

MOUNTING/FRAMING MAINTENANCE continued

Re-Shim Frame

- 1) Release all pressure on the mount.
- 2) Loosen all 3/8"-16 mold mounting bolts on the mounting post – BUT DO NOT REMOVE.
- 3) Clamp the parting line together using vise grips or C-Clamps. Clamp at each mounting post if possible.
- 4) Check each spring. If there is a space between the spring and the frame, remove the bolt and shim with a spacer to match the gap between the two. We recommend shim (spacer) sizes .010, .021, .031 and .047. It may be necessary to use several of each, or a combination of sizes.

Continue to shim all posts on all springs that do not touch the frame. When completed, snug up each 3/8"-16 mold mounting bolt to where there is slight tension on the spring. At this point remove the clamping devices from the parting line.

Note: Be sure to check shimming after first few cycles the mold is run.

BOLTS AND RECEIVERS

Back off (loosen) the bolt stops.

Use the bolt and receiver system to tighten the frame together to achieve consistent compression of each spring across the top of the spider. Each spring is to be compressed approximately 1/8" to 3/16" between the bolt head and the frame. At this point the bolt stops can be brought down to their proper adjustment.

CLAMPS

Adjusting the tension of the clamps can also be accomplished by adjusting the "J" hook up or down. This procedure should be used when replacing all springs.

We suggest that all springs be replaced at the same time to maintain uniform tension.