

OPERATION MANUAL

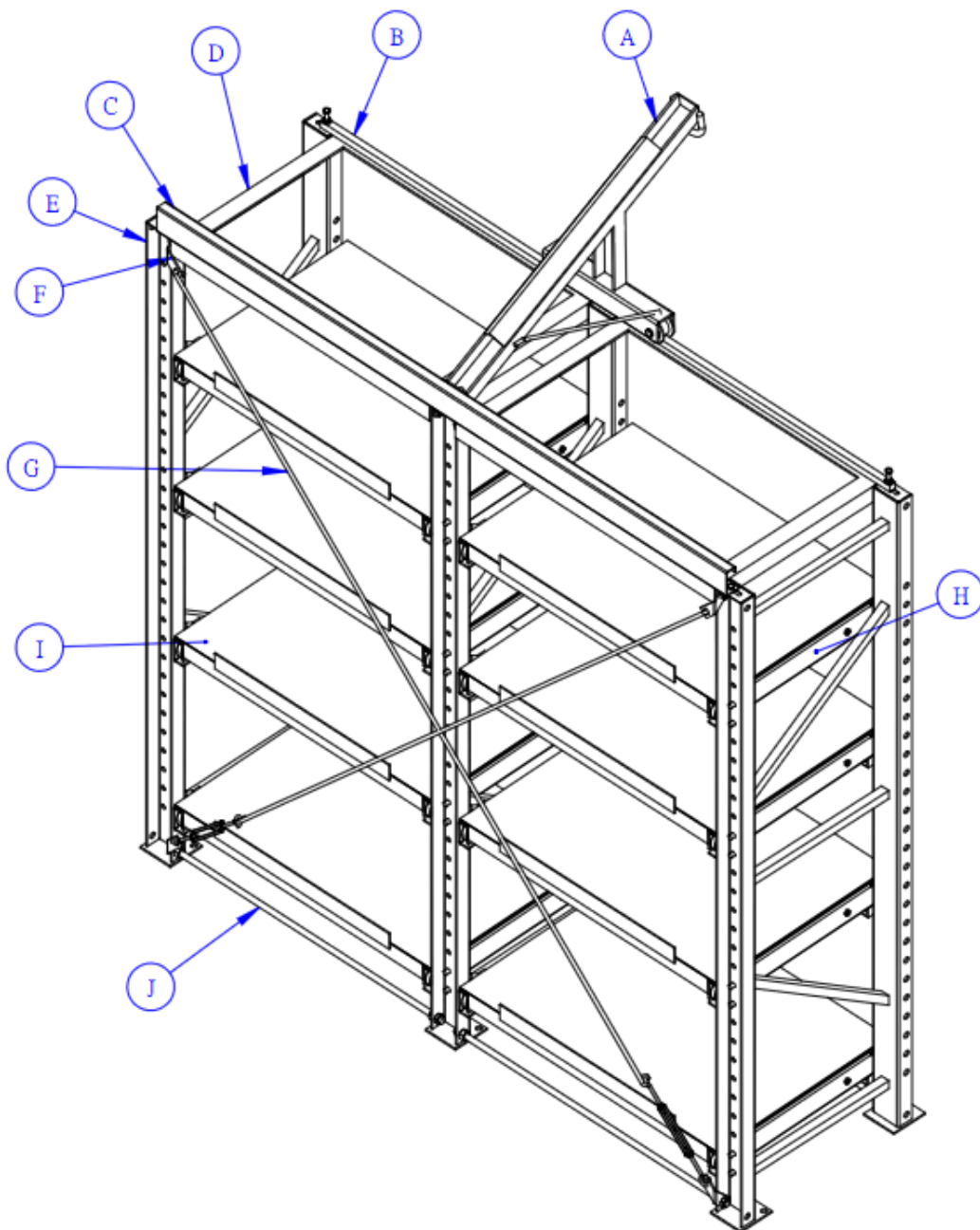


SPRD2-4H1

(1) Model Description: Drawer Type Mold Rack SPRD2-4H1(800/1000KG)

R	D/F	2	4	H1	800/1000KG
Mold Rack	Drawer Type/Fixed Type	Number of Shelf (2 Shelves)	Number of Tier (4 Tiers)	Number of Hoist(1 Set)	Each Tier Load 800/1000KGS

(2) Parts Drawing for Drawer Type Mold Rack SPRD2-4H1



(3) Parts List for Drawer Type Mold Rack SPRD2-4H1

Item	Product Name	Spec (mm)	Q' ty
A	Hoist	860Lx420Wx580H	1
B	Hoist Rack Front Rail	20Wx20Hx1990L	1
C	Hoist Rack Rear Rail	45Wx78Hx1990L	1
D	Upper Frame	905Lx604Wx50H	2
E	Prop	91Lx594Wx2004.5H	3
F	Rod Retainer	115Lx30Wx4.5T	4
G	Telescopic Rod	Ø3/8"x2330L	2
H	Slide rail	32.5Wx73Hx600L	16
I	Tier Plate	895Lx604Wx76H	8
J	Screw	Ø 5/8"x950L	4

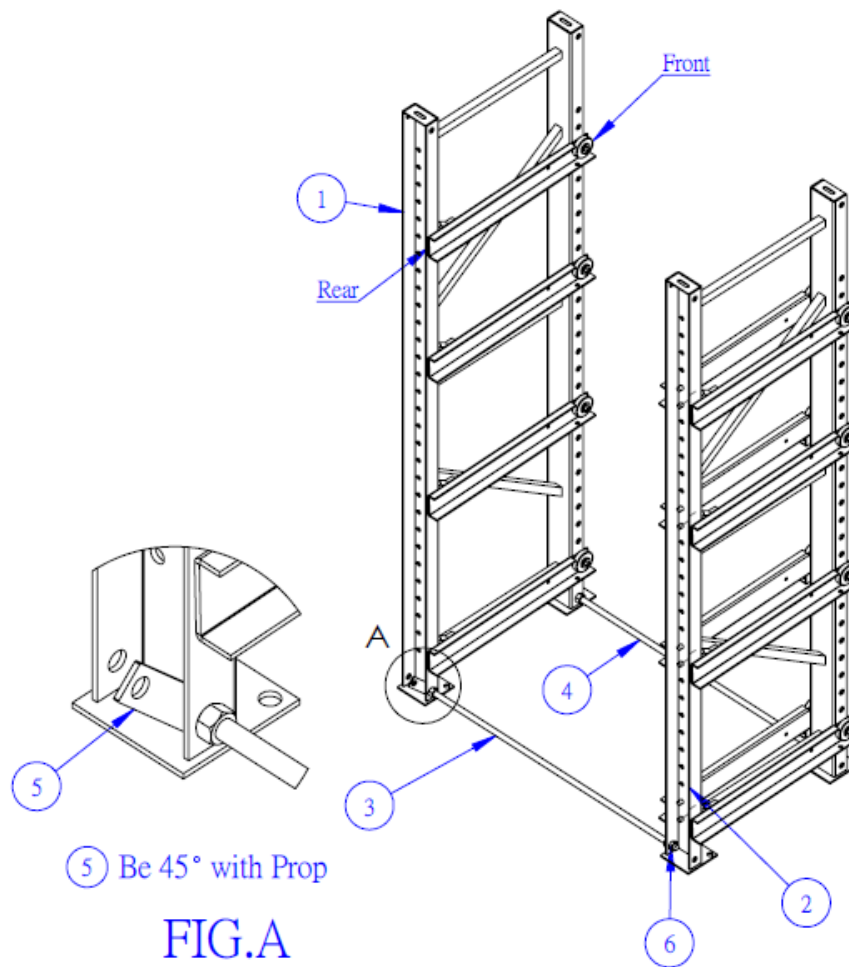
(4) Specification List of Screws for Drawer Type Mold Rack

SPRD2-4H1

Specification List of Screw			
Product Name	Spec	Qty at 1 st Shelf	Qty at 2 nd Shelf
Hex Bolts	3/8"x3"L	2	0
Hex Bolts	3/8"x1"L	11	10
Hex Bolts	5/8"x1"L	4	4
Hex Socket Cap Screws	M8x25Lmm	0	1
Hex Nuts	3/8"	7	2
Hex Nuts	5/8"	8	8
Hex Nuts	M8	0	1
Flat Washer	3/8"	7	2
Flat Washer	5/8"	3	3
Flat Washer	M8	0	1

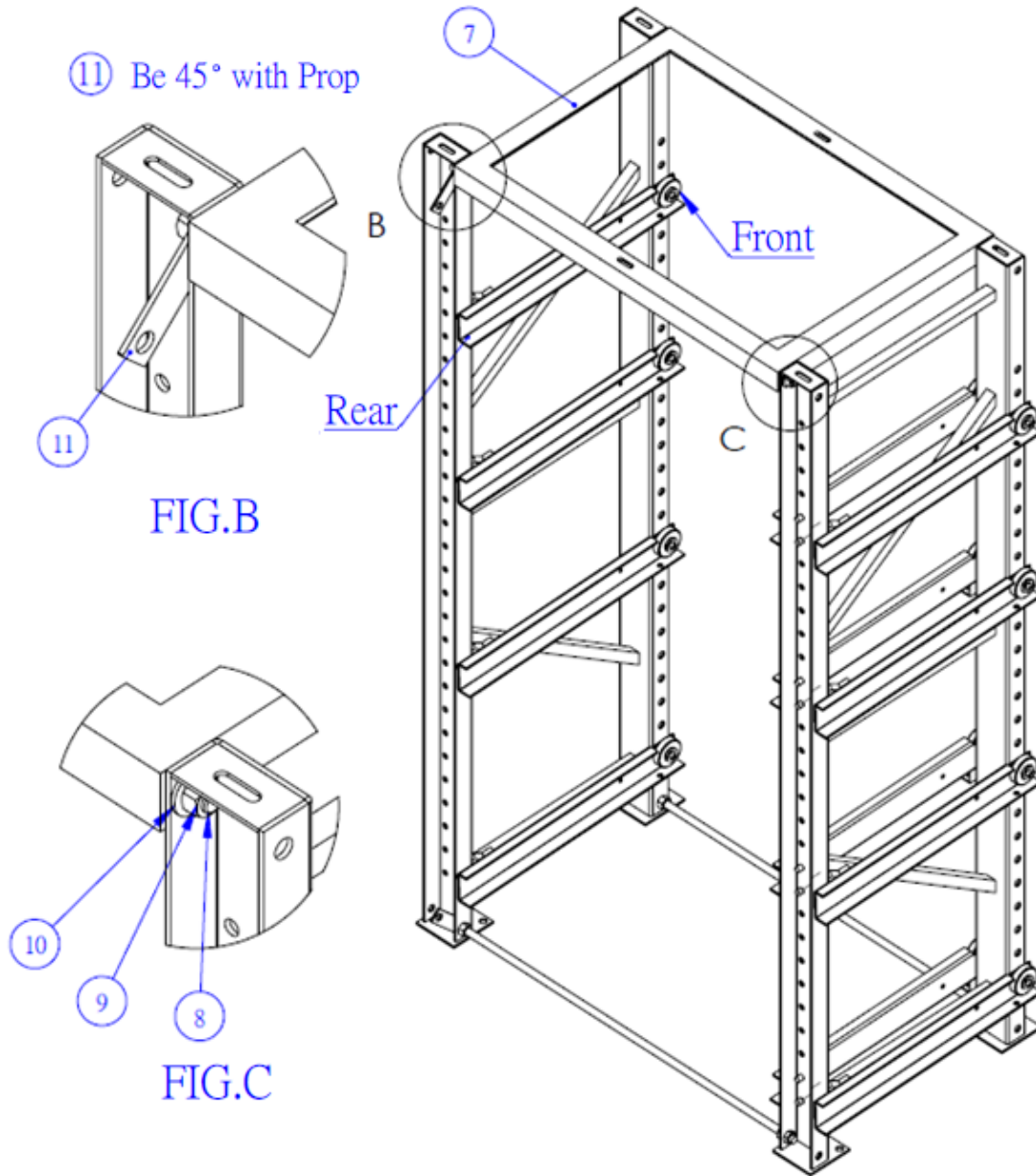
(5) Assembly Steps for Drawer Type Mold Rack

- 1) Stay up ① Prop & ② Prop and then fix ③④ Screw at the bottom with ⑥ Hex Nuts. Put ⑤ Rod Retainer lower behind ① Prop. Lock with ⑥ Hex Nuts to make Prop be 45°. (as FIG. A)



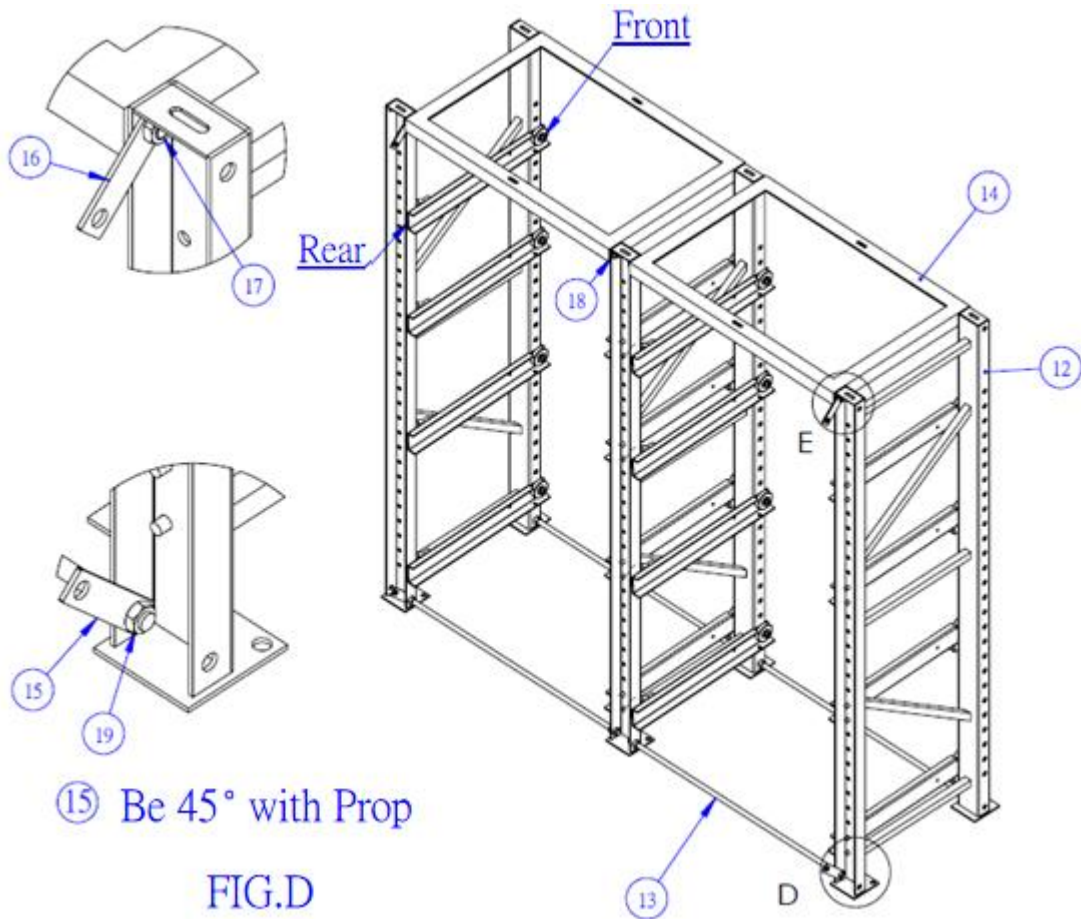
Item	Product Name	Spec (mm)	Qty
1	Prop	91Lx594Wx2004.5H	1
2	Prop	91Lx594Wx2004.5H	1
3	Screw	Ø 5/8"x950L	1
4	Screw	Ø 5/8"x950L	1
5	Rod Retainer	115Lx30Wx4.5T	1
6	Hex Nuts	5/8"	4

2) Place ⑦Upper Frame on the top between ①Prop and ②Prop. Fix ① Prop with ⑧Hex Bolts +⑪Rod Retainer +⑨Hex Nuts. Rod Retainer will be 45° with Prop (as Fig. B) and the other 3 corners shall be fixed with ⑧Hex Bolts + ⑩Flat Washer +⑨Hex Nuts. (as FIG. C)



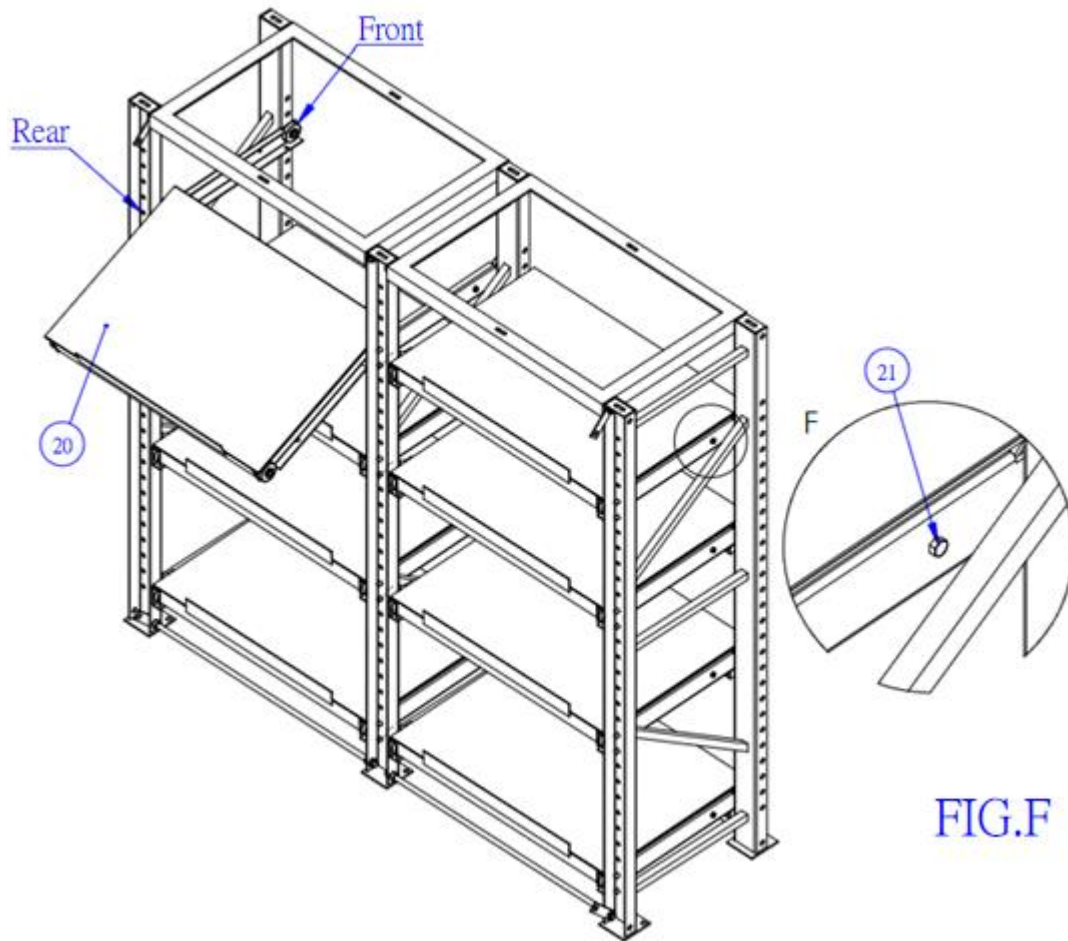
Item	Product Name	Spec (mm)	Qty
7	Upper Frame	905Lx604Wx50H	1
8	Hex Bolts	5/8"x1"L	4
9	Hex Nuts	5/8"	4
10	Flat Washer	5/8"	3
11	Rod Retainer	115Lx30Wx4.5T	1

3) Repeat Step (1) and Step (2). Build up ⑫ Prop, ⑬ Screw, ⑭ Upper Frame and ⑮⑯ Rod Retainers. (as FIG. D & FIG. E)



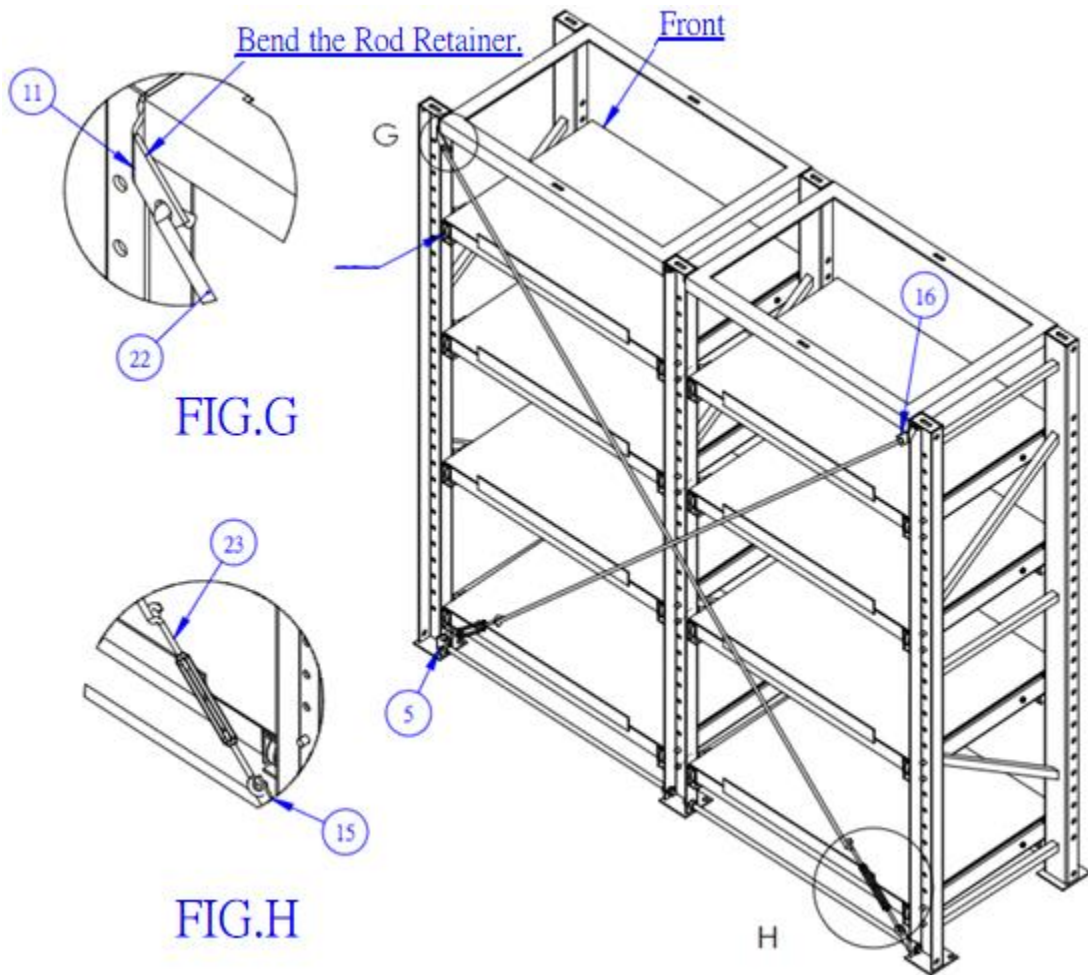
Item	Product Name	Spec. (mm)	Q' ty
12	Prop	91Lx594Wx2004.5H	1
13	Screw	Ø 5/8"x950L	2
14	Upper Frame	905Lx604Wx50H	1
15	Rod Retainer	115Lx30Wx4.5T	1
16	Rod Retainer	115Lx30Wx4.5T	2
17	Hex Bolts	5/8"x1"L	1
18	Flat Washer	5/8"	3
19	Hex Nuts	5/8"	8

4) Push forward all ⑳ Tier Plates by 45° (as following figure). After push forward, lock both sides of Slide Rail on each Tier Plate with 2 pcs of ㉑ Hex Bolts (as FIG. F) to avoid coming off when pull out Tier Plate.



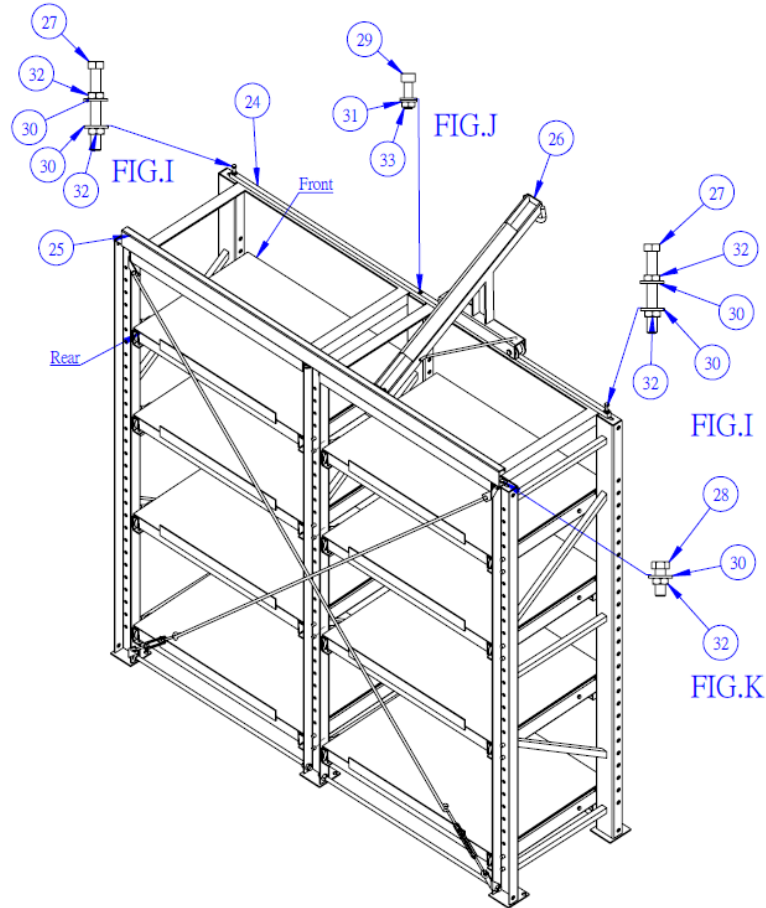
Item	Product Name	Spec. (mm)	Q' ty
20	Tier Plate	895Lx 604Wx76H	8
21	Hex Bolts	3/8"x1"L	16

- 5) After bend all the 4 pcs of ⑤①⑬⑯ Rod Retainers, hood ⑪ Rod Retainer with ⑳ Telescopic Rod (FIG. G). Take ㉓ Telescopic Hood to hook ㉒ Telescopic Rod at one end, and hook ⑮ Rod Retainer at the other end (FIG. H). After assemble, fasten them tightly. Repeat the above step to build up another ㉒ Telescopic Rod + ㉓ Telescopic Hook and ⑯⑤ Rod Retainers. (as following figure.)



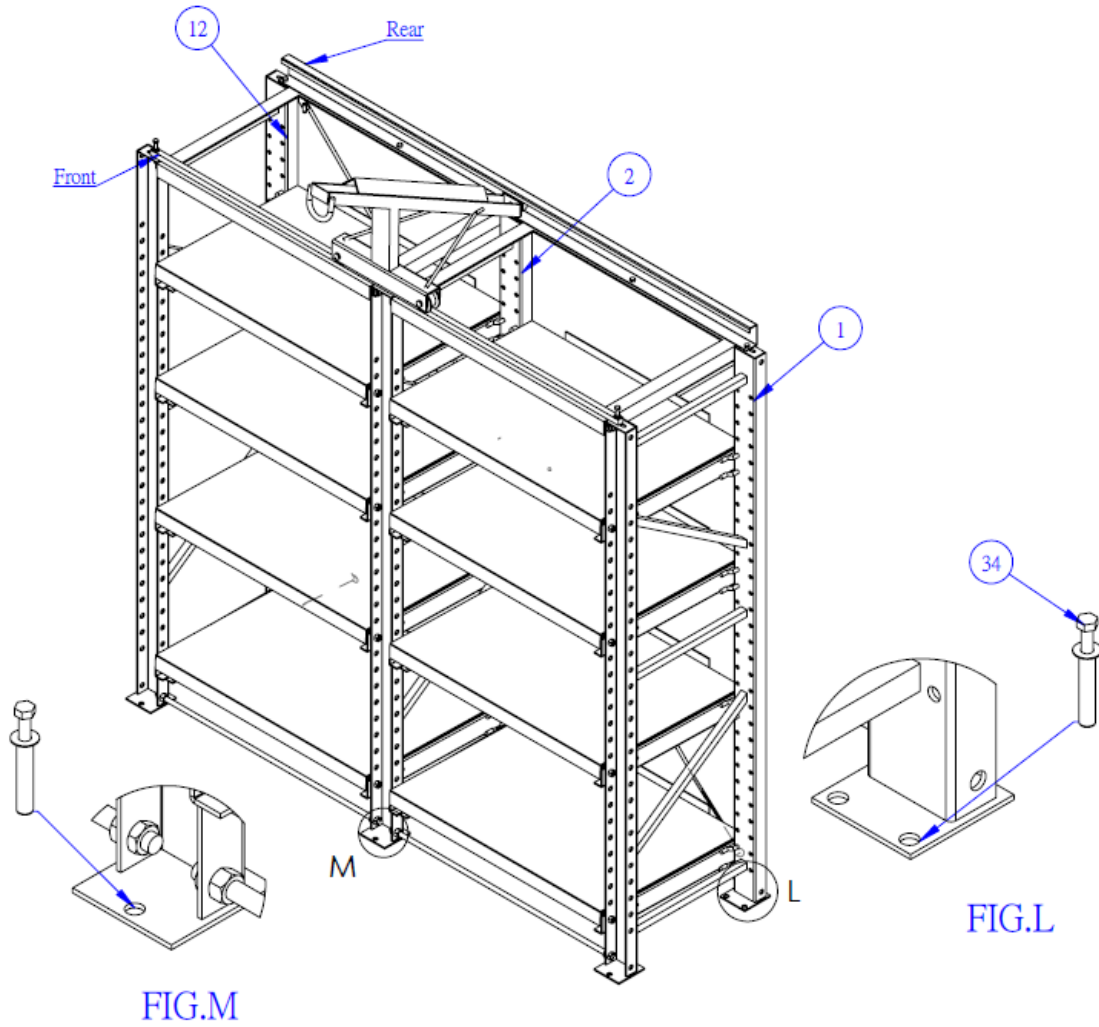
Item	Product Name	Spec.	Q' ty
22	Telescopic Rod	3/8"	2
23	Telescopic Hook	3/8"	2

- 6) Fix ②④ Hoist Rack Front Rail at both ends of Front Rail with ②⑦ Hex Bolts x 2pcs + ③① Flat Washer x 4 pcs + ③② Hex Nuts x 4 pcs (as FIG.I) to avoid ②⑥ Hoist coming out of the rail. And then fix between Front Rail with ②⑨ Hex Socket Cap Screws x 1 pc + ③① Flat Washer x 1 pc + ③③ Hex Nuts x 1pc (as FIG. J). Fix ②⑤ Hoist Rack Rear Rail behind Mold Rack with ②⑧ Hex Bolts x 5pcs + ③① Flat Washer x 5pcs + ③② Hex Nuts x 5pcs (as FIG. K) and then put up ②⑥ Hoist (as following figure) to finish the assembly of Mold Rack.



Item	Product Name	Spec. (mm)	Q' ty
24	Hoist Front Rail	20Wx20Hx1990L	1
25	Hoist Rear Rail	45Wx78Hx1990L	1
26	Hoist	860Lx420Wx580H	1
27	Hex Bolts	3/8"x3"L	2
28	Hex Bolts	3/8"x1"L	5
29	Hex Socket Cap Screws	M8x25L	1
30	Flat Washer	3/8"	9
31	Flat Washer	M8	1
32	Hex Nuts	3/8"	9
33	Hex Nuts	M8	1

- 7) After finish the assembly, pull it to proper place. Fix it with 2 pcs of ③④ Anchor Bolt at Rear Foot Plate of ①⑫ Prop. (as FIG. L), and then fix it with 1 pcs of ③④ Anchor Bolt at Front Foot Plate of ② Prop. (as FIG. M)



Item	Product Name	Spec	Q' ty
34	Anchor Bolt	3/8"x2.5"L	3

(5) Caution:

1. In the beginning of empty storage rack, please place the large mold on the bottom plate and small mold on the top plate.
2. To pull down the safety pin, then to pull out the plate and unloose the safety pin immediately. As the plate is pulled out entirely, the safety pin will spring automatically into the pin bore of plate. Please confirm that the plate is locked by safety pin to avoid dangerous condition “the plate would back to original place while pick & place mold.”
3. Please do not pull out two or more plates at the same time in order to avoid causing the mold rack to topple forward.
4. Please do not make any traverse movement on the rail when using the hoist to lift the mold up.
5. Make use of hoist to pick and place the mold on the pulled plate, and please set carefully.
6. After placing the mold, to pull down the safety pin, then to push the plate inside and unloose the safety pin immediately. As the plate is push inside entirely to the end, the safety pin will spring automatically into the pin bore of plate. Please confirm that the plate is locked by safety pin to avoid causing the mold to slide out.
7. When lifting a large number of molds, please first pick up the top of mold. It is to avoid causing the mold rack to topple forward because of bottom plate empty.
8. Please make regularly scheduled time to check settled screws on the mold rack and to lubricate bearings.