

## Checking to see if My Cylinder Mold is Bad

If your cylinder mold is bad, it will first have some symptoms:

- 1) The cylinder mold will not heat up as hot as it is supposed to. The temperature reading of the cylinder mold on the Time vs. Temperature graph will read lower than the reference temperature.
- 2) The mold is reading a consistent temperature under or over the reference temperature.

### Checking the Thermocouple on the Mold

- a) The first thing to do is take off the bottom insulation of the cylinder mold.
- b) Make sure the thermocouple wire is pushed all the way down into the hole (If the wire is not all the way down in the hole, the thermocouple will be reading a colder temperature than what it should be.
- c) Undo the top cover on the inside of the Circular panel jack. Make sure that the constantan wire is going to the constantan screw and the copper wire is going to the copper screw.
- d) Find a volt meter and turn it on to resistance ( $\Omega$ ).
- e) Touch one prong into either of the jack inlets and touch the other prong to the metallic part of the mold.
- f) If there is any reading, the thermocouple is grounding to the mold and needs to be replaced.

If the mold is still not heating up like it should be then try checking the heaters on the cylinder mold.

### Checking the Heaters on the Cylinder Mold

- a) First, find a volt meter.
- b) Turn the volt meter on and to resistance ( $\Omega$ ).
- c) Place one probe on the Gold colored prong in the Hubbel inlet (make sure the probe is not placed on the 'L' shaped prong in the inlet)
- d) Place the other probe on the silver colored prong in the Hubbel inlet.
- e) The reading on the volt meter should be around  $120\Omega (\pm 15\Omega)$
- f) If the heater is bad, the most common reading is going to be off by  $120\Omega$ .
- g) If the heater(s) do(es) test out bad, they need to be replaced.
- h) More heaters can be purchased through Products Engineering.