

# General Clamp Set Up

## For All Uniloy IBS Models

### For Multi-Cylinder Injection Clamps

Step 1: Rough adjustment of stack height.

- 1.) Move clamp to closed position.
- 2.) Check stack height with machinist scale. Check at ends of platen.
  - \* Machines for 10" molds = 9-29/32" to 9-15/16"
  - \* Machines for 14" molds = 13-29/32" to 13-15/16"

Step 2: Set side to side parallelism of platen to table.

- 1.) Install gage blocks between the bottom cross arm and the bottom of the table, near the tie bars.
- 2.) Move the clamp open until the gage blocks are held in place.
- 3.) Hold the bottom cross arm in place with a jack or blocks so it does not move.
- 4.) Using a dial indicator setup, determine the high side of the platen.
- 5.) Using the tie bar nuts on the upper cross arm, adjust the high side down to the same height as the low side. Variation of .002" maximum is permissible.  
Gage blocks (or stanchions) are required only on injection clamps with 3 cylinders.

Step 3: Set front to back, platen to table, parallelism with gage blocks still in place.

- 1.) Check the front to back parallelism of the platen to the table with the dial indicator. If it is more than .002", loosen the platen and use a shim to bring it to within .002".  
The shim must be at least 1" wide and be the full length of the platen.
- 2.) Recheck parallelism front to back and side to side.
- 3.) Total indicator variations for all measurements are not to exceed .002".

### For Blow Clamps and Single Cylinder Injection Clamps

Note: Place the clamp in the full down position to perform this procedure.

Step 1: Rough adjustment of stack height.

- 1.) Move clamp to the closed position.
- 2.) Check stack height with machinist scale. Check at ends of platen.
  - \* 5" stroke clamp height = 9-29/32" to 9-15/16"
  - \* 7" stroke clamp height = 13-29/32" to 13-15/16"
  - \* 9" stroke clamp height = 17-29/32" to 17-15/16"

Step 2: Set side to side parallelism of platen to table.

- 1.) Check side to side parallelism of the platen to the table with the dial indicator.  
Determine the high side of the platen.
- 2.) Using the tie bar nuts on the upper cross arm, adjust the high side down to the same height as the low side. Variation of .002" maximum is permissible.
- 3.) Retighten the tie bar nuts.
- 4.) Recheck parallelism side to side.

Step 3: Set front to back, platen to table, parallelism

- 1.) Check the front to back parallelism of the platen to the table with the dial indicator. If it is

more than .002", loosen the platen and use a shim to bring it to within .002".  
The shim must be at least 1" wide and be the full length of the platen.

2.) Recheck parallelism front to back.

3.) Total indicator variations for all measurements are not to exceed .002"