

instructions

20-2117 TETRAMET® MOLD CLOSURE

*U.S. Patent No. 3,999,916

The TETRAMET® is a totally new design offering four distinct advantages over previous compression mold closures.

ASSEMBLY:

Refer to Figure 5 for the correct assembly sequence. To attach the upper mold ram to the TETRAMET® Mold Closure, hold the assembly in one hand. While supporting the stem with one finger, compress the spring and slide the ram onto the ball end of the stem. Secure ram to stem by pressing the "U" spring into the recessed mounting holes.

MAKING CLOSURE:

Grip closure with the finger tips as shown in Figure 1 and lower upper ram face into the cylinder cavity. As the threads of the closure first contact the cylinder threads (Figure 2), rotate the closure counterclockwise 1/8 turn to gain a thread start; then finger tighten in clockwise direction until threads are fully engaged—**avoid excessive force**.

RELEASING CLOSURE:

Grasp the two handles firmly and jerk slightly in the counterclockwise direction; continue rotation until the threads disengage. Remove closure by pulling up on handles and/or activating the bottom ram upward. **On PNEUMET® Presses the air pressure must be totally released before TETRAMET® removal.**

HEATER AND COOLER:

May be removed or replaced while the press is under pressure by lifting the handles (Figure 3) and sliding the heater or cooler over the mold and closure (Figure 4).

CAUTION:

Over tightening or attempted closure removal while under pressure can cause breakage of the insulated handles.

The 20-2117 TETRAMET® closure and mold assembly parts must be kept free of accumulated mounting material. The frequency of cleaning will depend upon usage but failure to clean periodically may result in a reduction of the closing force. This could cause the TETRAMET® to "blow-out" of the mold, possibly causing severe injury.

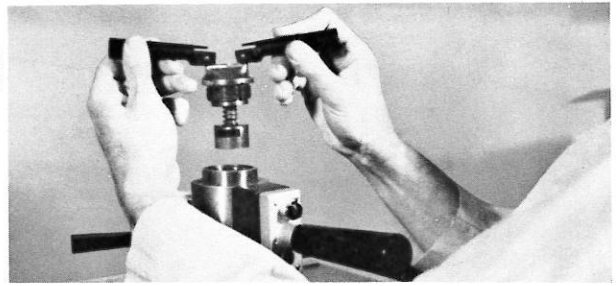


FIGURE 1



FIGURE 2



FIGURE 3

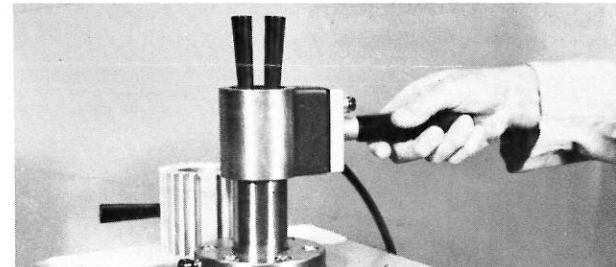


FIGURE 4

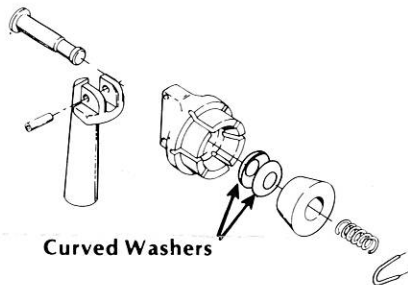
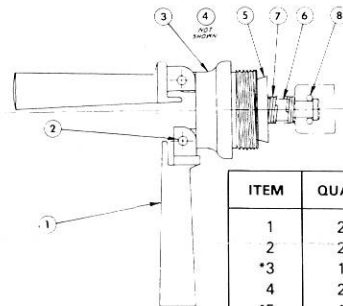


FIGURE 5

NOTE: Successful operation of the TETRAMET® closure (Figure 5) automatic release feature depends upon the positioning of the two curved washers. If the closure is disassembled or if it fails to release and requires replacement washers, they must be assembled with the concave surfaces facing each other.



PARTS LIST

ITEM	QUAN.	PART NO.	DESCRIPTION
1	2	2117-S004	Handle
2	2	R-7088	Roll Pin
*3	1	2117-S001	Cap
4	2	R-2976	Washer
*5	1	2117-S002	Cone
*6	1	2117-S003	Stem
7	1	3115-S3	Spring
8	1	1303-5-S2A	"U" Spring

*Sold only as part of 20-2117



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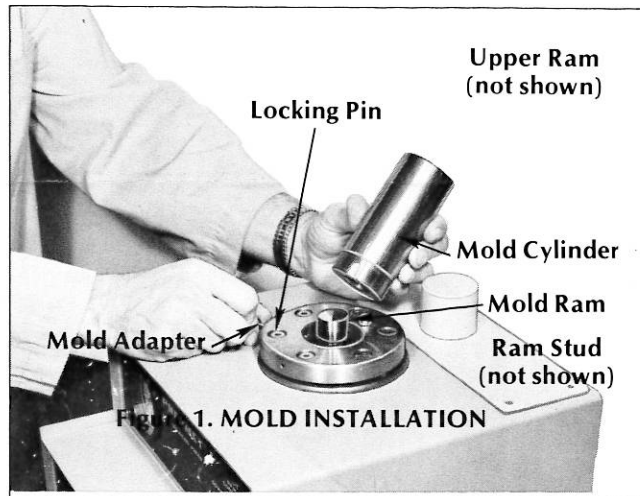
APPARATUS FOR MICROSTRUCTURAL ANALYSIS

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instructions

THREADED BASE MOLD ASSEMBLIES

No. 20-2104, 20-2105, 20-2106, 20-2107, 20-2109 and 20-2125
(No. 20-2106 and 20-2107 cannot be used with PNEUMET® I Press)



UNPACKING:

Carefully unpack so that Rams do not slip out of Mold Cylinder. If any components are missing or damaged, save the packing list and material and advise the carrier and Buehler Ltd. of the discrepancy.

ASSEMBLY:

To assemble any BUEHLER® Mounting Press Mold Assembly having a threaded base, use the following procedure in the order indicated:

- Screw the Mold Ram on the Ram Stud.
- Pull out the Locking Pin on the Mold Adapter (See your Instruction Manual) and turn 1/4 turn until it catches in the out position.
- Screw the Mold Cylinder clockwise into the Mold Adapter as far as it will go.
- Turn the Locking Pin until it releases.
- Turn the Mold Cylinder counterclockwise until the Locking Pin drops into the Mold Cylinder detent. Check for locking by trying to unscrew the Mold Cylinder.

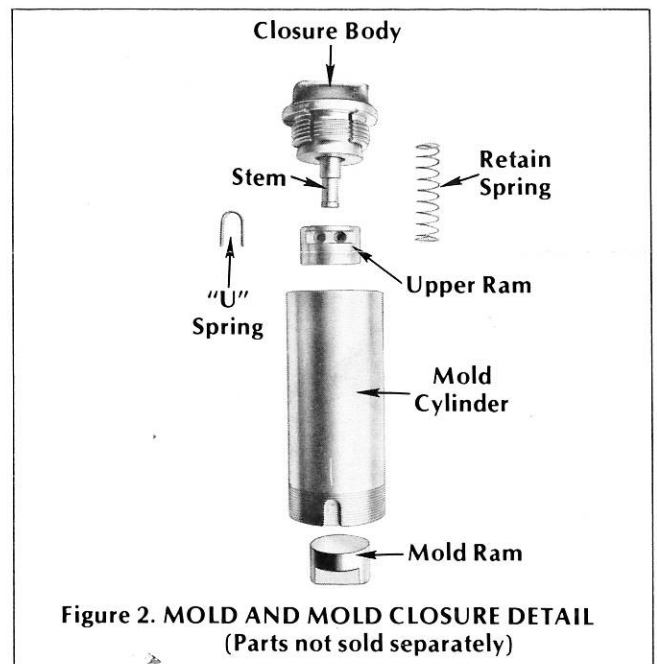
NOTE: Before using this new mold assembly, coat the heated upper and lower rams and the cylinder walls with No. 20-3048 powdered mold release or No. 20-3046 silicone mold release.

This will insure smooth operation of your press and will prevent molding flash from adhering to mold components.

SERVICE AND MAINTENANCE:

To keep your Mold Assembly operating efficiently, routine cleaning is advised. Compression molding produces some flash on the Mold Rams and Cylinder. Failure to remove this accumulation may restrict or prevent the Ram movement within the Cylinder. Use the scraper provided with your Press to remove any flash from the working surfaces as it forms. Occasional addition of BUEHLER® Mold Release to the operating surfaces of the hot Mold Assembly will help keep the Mold working freely.

Over a longer period of time, e.g., 6 months or 1 year, remove the Mold Cylinder and clean out any flash or powder that has accumulated within the Mold Adapter. A good time to perform this cleaning is when Mold Cylinders are changed.



WARRANTY:

This unit is guaranteed against defective material and workmanship for a period of two (2) years from date of receipt by customer. Warranty is void if inspection shows evidence of abuse, misuse or unauthorized repair. Warranty covers only replacement of defective materials.

If, for any reason, this unit must be returned to our plant for warranty service, please apply for prior authorization with shipping instructions, and include the following information: Customer Purchase Order Number; Buehler Ltd. Invoice Number and Date; and reason for return.



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