

SAFETY INSTRUCTIONS

This safety instruction/declaration of the manufacturer must be kept on file for the whole lifetime of the product and forwarded with the product.



Please read the safety instruction before initial operation with the lifting pin. Make sure that you have comprehend all subjected matters.
Non-observance can lead to serious personal injuries and material damage and eliminates warranty.

PRODUCT DESCRIPTION

PL60T lifting pin is for use exclusively with Liftmould's **ELS60T system**.

Intended use on the lifting of injection moulds only.

Mold rotating operations are not allowed with this accessory.

WLL = 60T

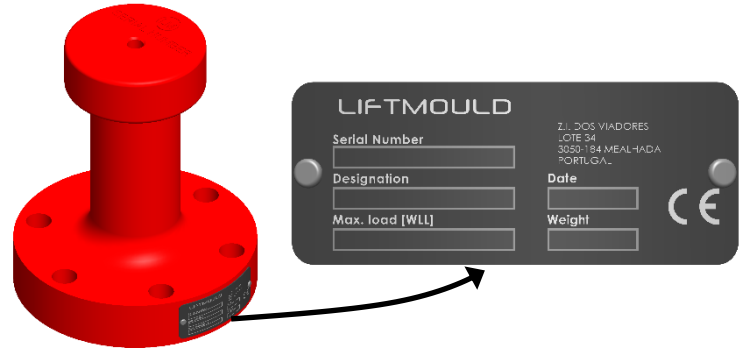
CERTIFICATION-QUALITY

The lifting pins for using with ELS60T system comply with the following:

- Machinery directive 2006/42/EC.
- ASME B30.20 Below-the-Hook Lifting Devices & die
- ASME BTH-1 Design of Below-the-Hook Lifting Devices
- UL/CSA 61010-1

Delivered with EC declaration of conformity.

Certification only valid for equipment produced by LIFTMOULD and compliant. Any modifications performed without written permission of Liftmould make the certification null and void.

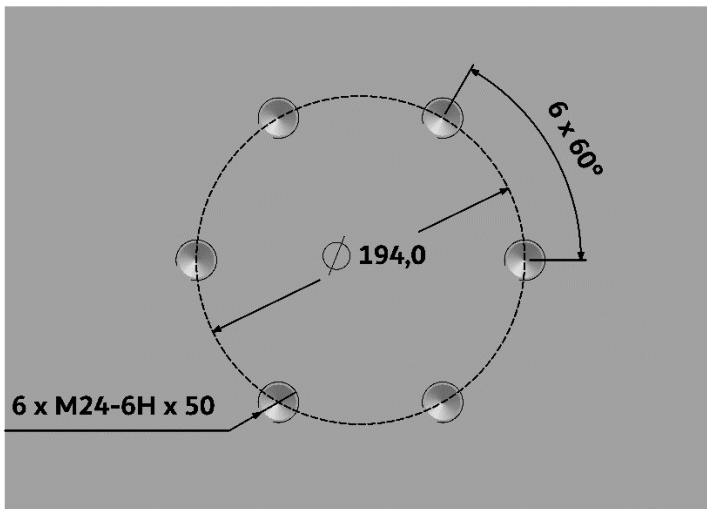


ASSEMBLY



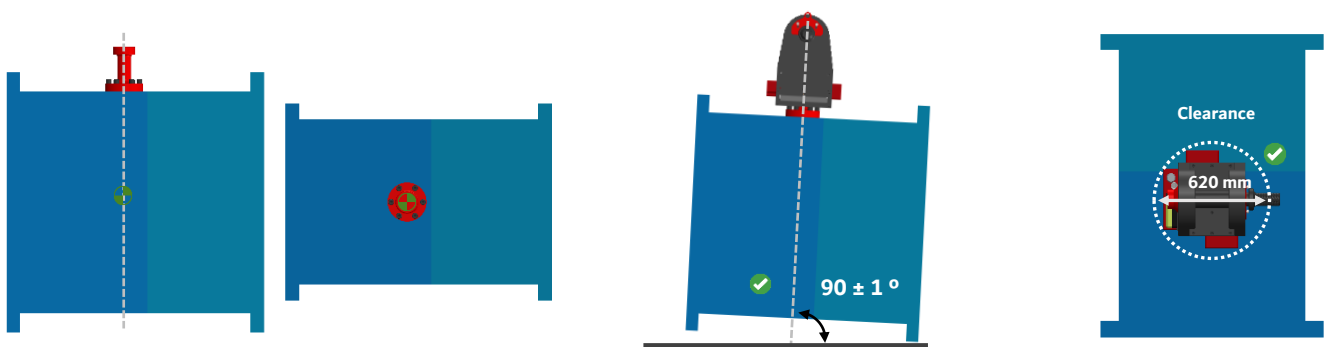
Non-compliance with the following assembly procedures may lead to severe injuries due to mold falling.

- Adequate resistance steel must be used on the parts where the pin will be assembled. The drilling pattern below must be done in the mold to fix the pin:



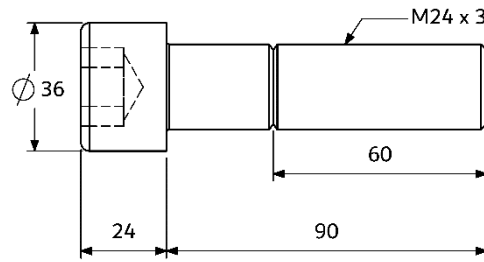
- It must be dully verified that the material where the lifting pin will be secured has adequate strength.
- The M24 hole on the mold must be located at least 60 mm away from a free edge to ensure proper resistance.
- Not respecting the specified **thread tolerances (6H)** may lead to mold fall. The threads must be checked before assembling the lifting pin.

- The pin must be placed in line with the center of gravity of the mold, and in a surface perpendicular to the lifting direction. Before first commissioning, it must be verified that the mold inclination does not exceed 1° in any direction when the mold is in the air. Also, it must be ensured that there are no obstacles around the lifting pin in a diameter of 620 mm.

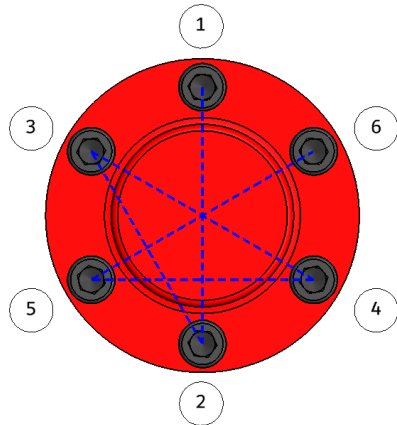


- The lifting pin is fixed to the mould with 6 hexagon head socket cap **M24 DIN912** screws length **90mm**.

DIN 912 CLASS 12.9



- The bolts must be class 12.9. The bolts must be tightened in a criss-cross pattern (figure below), increasing progressively the tightening torque. The final torque must be 380 N.m per bolt using a calibrated torque wrench.



Torque / bolt = **380 N.m**



- Not respecting the bolts resistance class is totally forbidden. Mold fall may occur.
- Not respecting the tightening torque may lead to untightening overtime resulting in dangerous situations.

CONDITIONS OF USE

General requirements

- All the assembly instructions are dully fulfilled by qualified person;
- The qualified person in charge of assembling the lifting pin fills and stores the provided document **Mod 164**;
- All elements connected with the lifting pin must be in properly dimensioned to the loads being lifted
- The material where the lifting pin will be bolted to must be of adequate strength to withstand the forces during lifting without any permanent deformation.

OPERATING INSTRUCTIONS

The intended use of the pin is strictly with the below the hook lifting device ELS60T. Detailed operating instructions are supplied with this system .
Beware of effects of temperatures: **The lifting pin can be operated from -20°C to 100°C.**

CONTROL AND MAINTENANCE

Control should always be carried out by qualified personnel in accordance with standards currently in effect on the place of use. A visual control prior to each use is necessary. The following points must always be checked, prior to any lifting operation:

- Wear, bending, abnormal corrosion.
- Bolt markings
- Nicks, deformation, cracks
- EC mark and engraving (WLL, traceability, manufacturer)

If one of these criteria is considered nonconform, the material must be subject to a more thorough examination. The manufacturer must be contacted before any actions.

Liftmould lifting pins are provided with an Assembly and Maintenance booklet (Mod 164) that must be kept on file for the whole lifetime of the product and forwarded with the product.

The continuing suitability of the lifting pin assembly must be thoroughly checked by an expert at least 1x year. For frequent usage, the period in between inspections must be smaller.