FREE VYRCO RESOURCE

After mold maintenance: verification plan

From a documented intervention to an evidence-supported decision

Mold technicians and maintenance, process and quality personnel. Intermediate level.

Define the requirement to evaluate, the evidence to obtain and the authority responsible for results and open items before performing a check.

Use one copy per intervention; repeat the plan and results sheets for each check. Complements VYRCO record 04, which describes the intervention; this resource organizes subsequent evidence. It neither performs tests nor authorizes a return to production.

How to use it

1. Define the change

Identify the mold, revision and work order. Describe what changed and potentially affected interfaces. Separate confirmed information from items requiring assessment; do not declare the rest of the mold acceptable merely because it was not serviced.

2. Obtain the requirement

Link each question to a current drawing, manual or procedure, including revision and section. Record the documented criterion and units. If it is missing, leave the check pending and assign an owner rather than inventing a limit.

3. Define the evidence

The competent responsible person determines the method, equipment, cavity or circuit identification, conditions and sampling scope where applicable. Document how records, photographs and results will be identified. A single photograph does not demonstrate every function.

4. Separate preparation and execution

Identify applicable permissions and procedures before execution. Energizing, moving, pressurizing or heating requires the specific procedure and authorized personnel. This template neither replaces hazardous-energy control nor explains how to remove it. [S2]

5. Record what happened

Preserve original observations, actual conditions, instrument identification and deviations from the plan. Distinguish not performed, incomplete evidence and performed. An absence of failure during an observation is not proof that the root cause has been eliminated.

6. Decide and follow up

The designated authority compares evidence against the criterion, documents the decision and restrictions, and assigns owners to open items. When follow-up is needed, define its scope and timing through the applicable procedure. Do not use a universal cycle count or arbitrary time period.

Sheet A - plan for one check

Use one sheet per check. State pending or not applicable with a reason rather than leaving ambiguous blanks. Attach sheets if more space is needed.

Record ID / mold / revision / work order / date
Change made / component / interfaces to assess
Verification question / cavity, circuit or feature / scope
Requirement and criterion / units / document, revision and section
Authorized method / equipment and ID / applicable conditions and sampling
Required safety procedure and authorizations / responsible persons
Planned evidence / file or record IDs / controlled location
Plan review / responsible person / date / open items before execution

These are documentary status labels proposed by VYRCO. Adapt them to the approved procedure. 'Meets criterion' applies only to the identified check; it does not automatically release the mold or product.

Sheet B - result, decision and follow-up

Use one sheet per check. State pending or not applicable with a reason rather than leaving ambiguous blanks. Attach sheets if more space is needed.

Check and plan ID / performer / date and actual conditions
Execution status: not performed, incomplete evidence or performed / reason
Original results and units / instrument or equipment / evidence ID
Plan deviations / authorization and effect on interpretation
Comparison against criterion / reviewer / conclusion and rationale
Decision: pending, fails criterion, meets criterion or not applicable with reason
Release authority / reference to decision / restrictions and scope
Open item or follow-up / owner / condition or date / closeout evidence

These are documentary status labels proposed by VYRCO. Adapt them to the approved procedure. 'Meets criterion' applies only to the identified check; it does not automatically release the mold or product.

Fictional example: evidence that is not yet sufficient

Context

FICTIONAL: mold DEMO-M14; an intervention involving connection identification on circuit DEMO-C is recorded. This represents no actual plant, customer, equipment or repair procedure.

Plan

Question: does the installed identification match the approved schematic? Fictional reference DEMO-SCH, revision C. Planned evidence: a correspondence record and identified photographs. The responsible person determines how to obtain them with the mold in the authorized safe condition.

Finding

An overall photograph is received, but the labels cannot be read or related to the schematic. Status: incomplete evidence. This does not establish that the connections are incorrect or that the circuit operates correctly.

Decision and closure

Request legible evidence and documented correspondence. Even if that check later meets its criterion, it does not by itself demonstrate flow, leak tightness or part quality. The authority must define other applicable checks and release; this example does not prescribe how to perform them.

Sources, scope and limitations

Sources accessed: 2026-10-13

S1 - JCGM VIM3 2.44 - Verification

Verification links objective evidence to specified requirements. Measurement uncertainty is considered when applicable in metrology. This defines neither mold release nor certification of this template.

Open primary source

S2 - OSHA 29 CFR 1910.147 - Hazardous energy control

Testing that requires temporary energization has specific hazardous-energy control requirements. U.S. reference; no operating sequence is reproduced and no local legal applicability is asserted.

Open primary source

S3 - Husky UltraShot Injection System, v1.1, May 2023

Example of manufacturer documentation referring to assembly drawings for torque and to complementary manuals. No UltraShot values or procedures are transferred to other molds.

Open primary source

Application limits

- Original documentation guidance, not a repair, startup, process-validation or safety procedure.

- Prescribes no universal pressures, temperatures, torques, tolerances, cycles, samples or criteria. These depend on applicable equipment, components and documentation.

- Evidence may support a particular check while leaving other questions unresolved. It is neither certification nor a legal-compliance determination.

- Sources support concepts and limitations. The cited Husky manual is system-specific; its instructions are not requirements for all molds.

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