

Mold Plate Index Chart

Young & Associates YAI-26-6 PLC machine mold plate movement is monitored by 600 pulse/rev encoder. The encoder is Zero position is when the mold plate is at fully extended position of the cycle. (See Encoder setup Section of the manual.) **It's important to understand we do not speed compensate for any fill timing. You must set up fill setting based on the speed you will be running the machine at.**

1. 0 counts the mold plate draw bar is at end of dwell. The mold plate motion remains stopped given the knock-out cups can retract and clear the plate before movement is made.
2. 80 counts the mold plate start to retract toward the fill position.
3. 280 counts the mold plate reaches the 1” position inward movement.
4. 360 counts the mold plate reaches the end of lost motion and mold plates starts to advance forward toward the knock-out position
5. 580 counts the forward movement of the mold plate is stopped. The knock-out cups drop thru the plate and knock the patties out of the mold plate.

Pure-Flow (Port-Fill®Formax Inc.) Relief ON

Product: Whole Muscle-Chunk Product

Temperature: 28.5°F – 32.0°F

The pump box has plastic insert that channels the product to each of cavities when the mold plate is in the back fill position. This insures once the product leaves the tube valve it is directed to the cavities of the fill plate and directly to the cavities of the mold plate. The fill slot matches the pump box insert.

Fill Mode Ground Beef- Chicken-Pork	Mold Plate Speed	High Pressure On	High Pressure Off	Stripper Open 74 = Off	Stripper Shut	Relief On 399= Off	Relief Off
Pure-Flow Whole Muscle-Chunk	83-90	163* (150-230)	456* (330-425)	74 (74)	275*	525** (525-550)	575
Pure-Flow Whole Muscle-Chunk	72-82	168* (160-230)	456* (330-425)	74 (74)	280*	525** (525-550)	575
Pure-Flow Whole Muscle-Chunk	62-71	178* (165-230)	456* (330-425)	74 (74)	300*	525** (525-550)	575
Pure-Flow Whole Muscle-Chunk	52-70	182* (175-230)	456* (330-425)	74 (74)	305*	525** (525-550)	575
Pure-Flow Whole Muscle-Chunk	42-51	197* (185-230)	456* (330-425)	74 (74)	310*	525** (525-550)	575
Pure-Flow Whole Muscle-Chunk	32-20	202* (200-250)	456* (330-425)	74 (74)	322*	525** (525-550)	575

*Conversion Formax® Port-Fill ® of Formax Inc. (###-###) YAI-26-PLC Safe Settings Range ** YAI-26-PLC Suggest Settings

Standard Fill Mode No Relief

Product: Ground Beef-Pork-Poultry

Temperature: 28.5°F – 32.0°F

Fill Mode Ground Beef-Chicken-Pork	Mold Plate Speed	High Pressure On	High Pressure Off	Stripper Open 74 = Off	Stripper Shut	Relief On 399= Off	Relief Off
Standard Fill with No Relief Used with Ground Product	20-34	210* (190-230)	330* (300-350)	74	310	399	575
Standard Fill with No Relief Used with Ground Product	35-44	195* (180-230)	330 (300-350)	74	310	399	575
Standard Fill with No Relief Used with Ground Product	45-54	190 (175-230)	330 (300-350)	74	310	399	575
Standard Fill with No Relief Used with Ground Product	55-64	175* (175-230)	330* (300-350)	74	310	399	575
Standard Fill with No Relief Used with Ground Product	65-74	165* (155-230)	330* (300-350)	74	310	399	575
Standard Fill with No Relief Used with Ground Product	75-90	160* (130-230)	330* (300-350)	74	310	399	575
Standard Fill with No Relief Large diameter 4.0/oz	85-95	120** (120-230)	310** (300-350)	74	310	399	575
Standard Fill with No Relief 4.0/oz 5 on Mold Plate	45-54	140** (130-230)	320** (300-350)	74	310	399	575
Standard Fill With No Relief 4.0/oz 5 on Mold Plate	55-65	135** (130-230)	330** (300-350)	74	310	399	575

*Conversion Formax® Setting Fill Mode #1 (###-###) YAI-26-PLC Safe Settings Range ** YAI-26-PLC Suggest Settings

Standard Fill Mode With Relief

Product: Ground Beef-Pork-Poultry

Temperature: 28.5°F – 32.0°F

Fill Mode Ground Beef-Chicken-Pork	Mold Plate Speed	High Pressure On	High Pressure Off	Stripper Open 74 = Off	Stripper Shut	Relief On 399= Off	Relief Off
Standard Fill with No Relief Used with Ground Product	20-34	210* (190-230)	330* (300-350)	74	310	535** (525-550)	575
Standard Fill with No Relief Used with Ground Product	35-44	195* (180-230)	330 (300-350)	74	310	535** (525-550)	575
Standard Fill with No Relief Used with Ground Product	45-54	190 (175-230)	330 (300-350)	74	310	535** (525-550)	575
Standard Fill with No Relief Used with Ground Product	55-64	175* (175-230)	330* (300-350)	74	310	535** (525-550)	575
Standard Fill with No Relief Used with Ground Product	65-74	165* (155-230)	330* (300-350)	74	310	535** (525-550)	575
Standard Fill with No Relief Used with Ground Product	75-90	160* (130-230)	330* (300-350)	74	310	535** (525-550)	575
Standard Fill with No Relief Large diameter 4.0/oz	85-95	120** (120-230)	310** (300-350)	74	310	535** (525-550)	575
Standard Fill with No Relief 4.0/oz 5 on Mold Plate	55-65	135** (130-230)	330** (300-350)	74	310	535** (525-550)	575
Standard Fill With No Relief 4.0/oz 5 on Mold Plate	45-54	140** (130-230)	320** (300-350)	74	310	535** (525-550)	575
Standard Fill With No Relief 8.0/0z -10.0/0z	30-44	160** (155-180)	310**	74	310	535** (525-550)	575

*Conversion Formax® Setting Fill Mode #1 (###-###) YAI-26-PLC Safe Settings Range ** YAI-26-PLC Suggest Settings

Cavity on Cavity Fill (Verti-Form®Formax Inc.)

Product: Whole Muscle Beef-Pork-Poultry

Temperature: 28.5°F – 32.0°F

Fill Slot usually match specific mold Plates. The fill plate and mold plate relationship will allow whole muscle or chunked product to be formed into each cavity when the mold plate stopped over the fill slot.

Fill Mode Ground Beef-Chicken-Pork	Mold Plate Speed	High Pressure On	High Pressure Off	Stripper Open 74 = Off	Stripper Shut	Relief On 399= Off	Relief Off
Cavity on Cavity with No Relief Whole Muscle or Chunk Prod	20-34	240* (230-245)	360* (300-360)	74	310	399 (525-550)	575
Cavity on Cavity with No Relief Whole Muscle or Chunk Prod	35-44	240* (180-230)	360* (300-350)	74	310	399 (525-550)	575
Cavity on Cavity with No Relief Whole Muscle or Chunk Prod	45-54	225* (175-230)	360* (300-350)	74	310	399** (525-550)	575
Cavity on Cavity with No Relief Whole Muscle or Chunk Prod	55-64	221* (175-230)	360* (300-350)	74	310	399** (525-550)	575
Cavity on Cavity with No Relief Whole Muscle or Chunk Prod	65-74	216* (155-230)	360* (300-350)	74	310	399** (525-550)	575
Cavity on Cavity with No Relief Whole Muscle or Chunk Prod	75-90	206* (130-230)	360* (300-350)	74	310	399** (525-550)	575
Cavity on Cavity with No Relief Whole Muscle or Chunk Prod	85-95	200** (190-230)	310** (300-350)	74	310	399** (525-550)	575
Cavity on Cavity with No Relief Whole Muscle or Chunk Prod	65-84	220** (200-230)	320** (300-350)	74	310	399** (525-550)	575
Cavity on Cavity with No Relief Whole Muscle or Chunk Prod	40-64	230** (210-230)	315** (300-350)	74	310	399** (525-550)	575
Cavity on Cavity with No Relief Whole Muscle or Chunk Prod	20-39	250** (230-250)	300** (300-350)	74	310	399** (525-550)	575

*Conversion Formax® Verti_Form® of Formax Inc. (###-###) YAI-26-PLC Safe Settings Range ** YAI-26-PLC Suggest Settings

Cavity on Cavity Fill (Verti-Form®Formax Inc.) With Relief

Product: Whole Muscle Beef-Pork-Poultry

Temperature: 28.5°F – 32.0°F

Fill Mode Ground Beef-Chicken-Pork	Mold Plate Speed	High Pressure On	High Pressure Off	Stripper Open 74 = Off	Stripper Shut	Relief On 399= Off	Relief Off
Cavity on Cavity with Relief Whole Muscle or Chunk Prod	20-34	240* (230-245)	360* (300-360)	74	310	525* (525-550)	575
Cavity on Cavity with Relief Whole Muscle or Chunk Prod	35-44	240* (180-230)	360* (300-350)	74	310	525* (525-550)	575
Cavity on Cavity with Relief Whole Muscle or Chunk Prod	45-54	225* (175-230)	360* (300-350)	74	310	525* (525-550)	575
Cavity on Cavity with Relief Whole Muscle or Chunk Prod	55-64	221* (175-230)	360* (300-350)	74	310	525* (525-550)	575
Cavity on Cavity with Relief Whole Muscle or Chunk Prod	65-74	216* (155-230)	360* (300-350)	74	310	525* (525-550)	575
Cavity on Cavity with Relief Whole Muscle or Chunk Prod	75-90	206* (130-230)	360* (300-350)	74	310	525* (525-550)	575
Cavity on Cavity with Relief Whole Muscle or Chunk Prod	85-95	200** (190-230)	310** (300-350)	74	310	530** (525-550)	575
Cavity on Cavity with Relief Whole Muscle or Chunk Prod	65-84	220** (200-230)	320** (300-350)	74	310	530** (525-550)	575
Cavity on Cavity with Relief Whole Muscle or Chunk Prod	40-64	230** (210-230)	315** (300-350)	74	310	530** (525-550)	575
Cavity on Cavity with Relief Whole Muscle or Chunk Prod	20-39	250** (230-250)	300** (300-350)	74	310	530** (525-550)	575

Large Fill with Strippers (Tender-Form®Formax Inc.)

Product: Ground product not greater than 9/32” Final Grind.

Temperature: 28.5°F – 32.0°F

- ☞ Using ¼” Seal-off tooling or ¼” taper tooling.
- ☞ Product must be free flowing.
- ☞ Avoid product with a lot connective tissues.
- ☞ Forming pressure should never exceed 175 PSI.
- ☞ Large fill with Stripper breather plate must be used.
- ☞ Use of .28 stroke cylinders should only be used.
- ☞ Insure correct length of stripper pins are being used.
- ☞ Clean stripper plate if your product pressure should exceed more than 50/PSI from its pressure it started out producing with clean stripper plate.

Fill Mode Ground Beef- Chicken-Pork	Mold Plate Speed	High Pressure On	High Pressure Off	Stripper Open 74 = Off	Stripper Shut	Relief On 399= Off	Relief Off
Large Fill/Strippers Ground Beef-Pork- Poultry	83-90	240* (230-245)	360* (300-360)	80* (110)	275*	399 (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	72-82	240* (180-230)	360* (300-350)	90* (110)	280*	399 (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	62-71	225* (175-230)	360* (300-350)	95* (110)	300*	399** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	52-70	221* (175-230)	360* (300-350)	98* (110)	305*	399** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	42-51	216* (155-230)	360* (300-350)	110* (110)	310*	399** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	32-20	206* (130-230)	360* (300-350)	130* (110)	322*	399** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	83-90	140* (140-245)	330** (300-360)	110** (290-330)	320** (-10 HP Off)	399 (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	72-82	150* (150-230)	330** (300-350)	110** (290-330)	320** (-10 HP Off)	399 (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	62-71	175* (175-230)	330** (300-350)	110** (290-330)	320** (-10 HP Off)	399** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	52-70	185** (175-230)	330** (300-350)	110** (290-330)	320** (-10 HP Off)	399** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	42-51	200** (195-230)	330** (300-350)	110* (290-330)	320** (-10 HP Off)	399** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	32-20	210** (200-230)	330* (300-350)	110* (290-330)	320** (-10 HP Off)	399** (525-550)	575

*Conversion Formax® Tender-Form® A of Formax Inc. (###-###) YAI-26-PLC Safe Settings Range ** YAI-26-PLC Suggest Settings

Large Fill with Strippers (Tender-Form®Formax Inc.) Relief ON

Product: Ground product not greater than 9/32” Final Grind.

Temperature: 28.5°F – 32.0°F

- ☞ Using ¼” Seal-off tooling or ¼” taper tooling.
- ☞ Product must be free flowing.
- ☞ Avoid product with a lot connective tissues.
- ☞ Forming pressure should never exceed 175 PSI.
- ☞ Large fill with Stripper breather plate must be used.
- ☞ Use of .28 stroke cylinders should only be used.
- ☞ Insure correct length of stripper pins are being used.
- ☞ Clean stripper plate if your product pressure should exceed more than 50/PSI from its pressure it started out producing with clean stripper plate.

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Large Fill/Strippers Ground Beef-Pork- Poultry	83-90	240* (230-245)	360* (300-360)	80* (110)	275*	525** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	72-82	240* (180-230)	360* (300-350)	90* (110)	280*	525** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	62-71	225* (175-230)	360* (300-350)	95* (110)	300*	525** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	52-70	221* (175-230)	360* (300-350)	98* (110)	305*	525** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	42-51	216* (155-230)	360* (300-350)	110* (110)	310*	525** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	32-20	206* (130-230)	360* (300-350)	130* (110)	322*	525** (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	83-90	140* (140-245)	330** (300-360)	110** (290-330)	320** (-10 HP Off)	530 (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	72-82	150* (150-230)	330** (300-350)	110** (290-330)	320** (-10 HP Off)	530 (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	62-71	175* (175-230)	330** (300-350)	110** (290-330)	320** (-10 HP Off)	530 (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	52-70	185** (175-230)	330** (300-350)	110** (290-330)	320** (-10 HP Off)	530 (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	42-51	200** (195-230)	330** (300-350)	110* (290-330)	320** (-10 HP Off)	530 (525-550)	575
Large Fill/Strippers Ground Beef-Pork- Poultry	32-20	210** (200-230)	330* (300-350)	110* (290-330)	320** (-10 HP Off)	530 (525-550)	575

*Conversion Formax® Tender-Form® A of Formax Inc. (###-###) YAI-26-PLC Safe Settings Range ** YAI-26-PLC Suggest Settings

YAI-26-6 PLC Mold Plate Travel

