

Standard & Optional Mold Base Features

CONFIGURE YOUR MOLD BASE
TO YOUR EXACT NEEDS



Standard & Optional Mold Base Features

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UNLIMITED Mold Base Selections

With **D-M-E**, the only limit to your mold base is your imagination. Need guided ejection? Want vented leader pins? Prefer a three-piece ejector housing? D-M-E Custom Mold Bases are available in over 75 trillion possible configurations – one of them is perfect for your specific application.

All this and more, and at a competitive price. And, because it's from D-M-E, you know it'll be done right the first time, on time – *every* time.

A whole new way of ordering

You can choose from an extensive menu of options to configure exactly the mold base you need. What some companies would call "a special" is no problem with D-M-E.

Widest range of features and sizes available

D-M-E's Custom Mold Bases aren't just a limited range of common sizes – no one offers more than D-M-E. More sizes. More high-quality steel types. More plate thicknesses. More value-added features.





Made to order

What you want – not just what's in stock. That's the philosophy of D-M-E. Our leading-edge manufacturing and workflow technologies enable us to build your custom-configured mold base with unparalleled speed. Most configurations can be shipped in only a few days.

Buy only the features you need

D-M-E is driven by a simple premise: Your mold base is made up of only the specific features you want. No paying for "extras" that you didn't need. You can even specify the steel type – at the plate level – to enable customization to meet your objectives.

Why D-M-E?

At D-M-E, we understand the challenges you face. We know that anything that gives you an edge in today's competitive marketplace can enable a business advantage. That's why we work to get you a mold base that's configured exactly the way you need it, as quickly as possible, without price premiums.

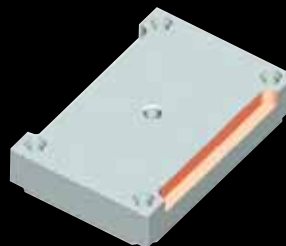
American Mold Base Standard Features



Locating Rings



The Locating Ring aligns the mold base to the stationary platen side of the press and positions the sprue bushing correctly.



Clamp Slots



Clamp Slots facilitate clamping the mold to the platen of the press. D-M-E mold bases offer four slot types to ensure the best fit for the requirements of your application.



Sprue Bushings



The Sprue Bushing provides a seat at the spherical radius for the nozzle of the press. This provides a path for the material from the nozzle to the runner system.



Leader Pins, Vents and Bushings



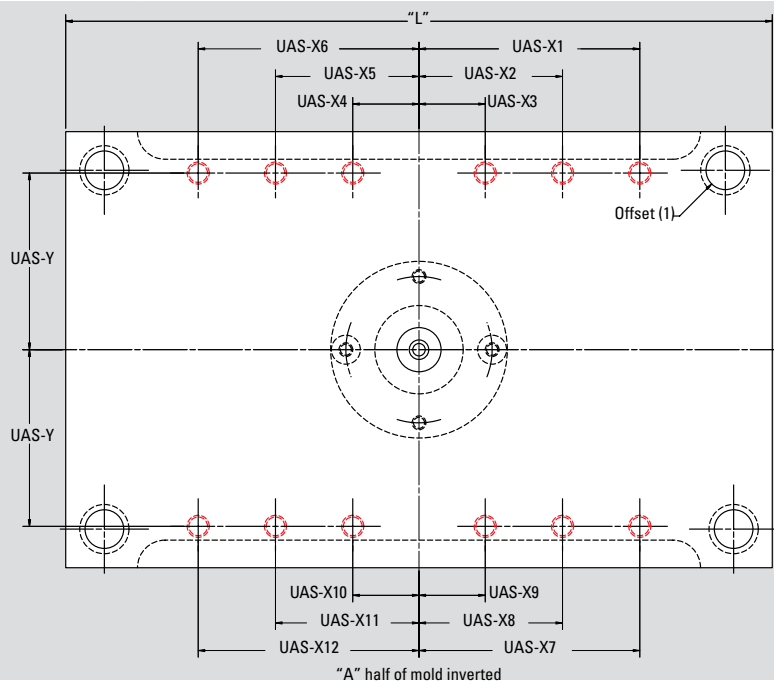
Leader Pins and Bushings align both halves of the mold at the parting line. Leader Pin Vents, which allow trapped air to escape from the mold, are designed into all 15-inch-and-wider series molds. When desired, they can be specified on smaller molds.



Upper and Lower Assembly Screws



Assembly screws are used to hold the plates of the upper and lower halves of the mold together. For simplicity, the upper and lower assembly screws are generally placed in similar positions.



American Mold Base Standard Features



Ejector Housing and Cover



D-M-E offers a selection of housing types to fit application demands. A one-piece welded housing is available for customers requiring maximum rigidity and robust durability. For maximum flexibility of configuration options, a three-piece housing is also available.

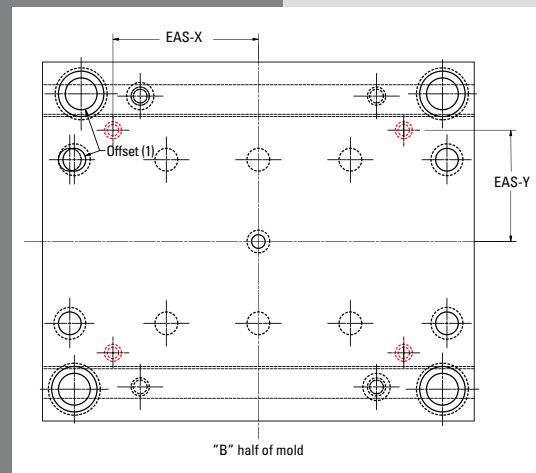
For additional operator safety, D-M-E mold bases include an ejector housing cover, except when a longer length ejector bar is selected. The perforated D-M-E logo helps the operator to visually determine if the ejector plate and ejector retainer plate are in the returned position. The cover is fastened on both sides with 5/16-18 button-head cap screws. Once again, D-M-E is leading the industry into a safer work environment.



Ejector Assembly Screws



Ejector assembly screws are used to hold the plate of the ejector assembly together. Recommended position will be provided but you can specify any different position.



Return Pins, Stop Pins and Sprue Puller Pins



Return Pins are used to ensure correct return of the ejector assembly to the home position. D-M-E return pins are precision-ground from superior quality hotwork die steel. Stop Pins arrest travel – preventing excessive wear and possible housing damage. The Sprue Puller Pin removes material from the Sprue Bushing at the end of the molding cycle.



Self-Lubricating Bushings



Saves design and moldmaking costs for lubrication and fittings. Reduces wear and galling. Lowers maintenance and repair costs. Eliminates contamination... ideal for "clean room" environments.

American Mold Base Optional Features

Guided Ejection Systems



Guided Ejection Systems hold the ejector assembly in alignment and support the weight of the ejector assembly throughout the molding cycle – greatly reducing wear on ejection components and preventing cocking of the ejector assembly.

Pockets and Spring Pockets

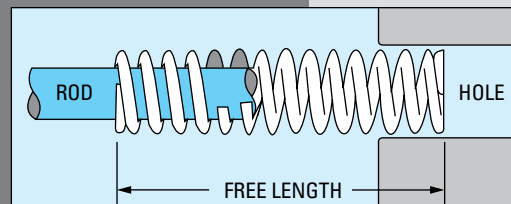
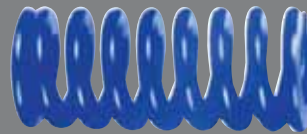


Per customer specifications, D-M-E finishes any type of cavity and core pockets. See the D-M-E Mold Components catalog for spring free lengths and hole dimensions.

Pry Slots



D-M-E mold bases feature Pry Slots, installed in any plate specified, on the parting and/or non-parting line side. This provides handling ease when opening and/or disassembling a mold.



Lifting Holes



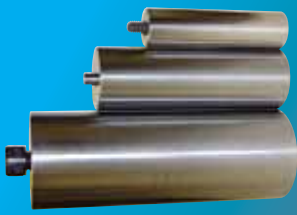
Lifting Holes can be used to install hoist rings for ease of handling. D-M-E mold bases can be configured only with Lifting Holes which are appropriate for the specific mold base size. Refer to D-M-E Mold Components catalog for a comprehensive selection of Hoist Rings.

Mold Strap Holes



Machined holes will be for mounting mold straps. Please provide desired positions and quantity (minimum 2).

American Mold Base Optional Features



Support Pillars



Support pillars should be used liberally since they greatly increase the capacity of the mold to support the projected area of the cavities, runner and sprue. By providing additional support, they prevent deflection of the mold.



Interlocks



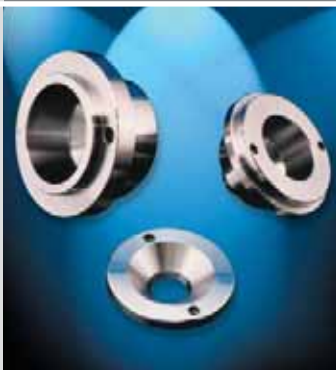
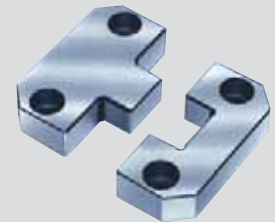
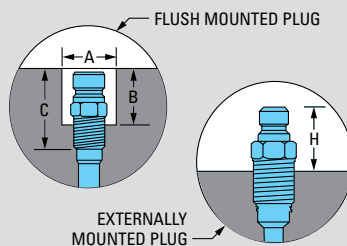
Provides positive alignment between adjacent plates when mold has one or multiple parting line openings. This provides close alignment for interlock cavities and cores in stripper plate type molds.



Waterlines



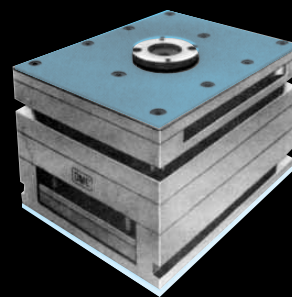
D-M-E will provide waterlines and plugs per customer specifications for optimal cooling efficiency.



3-Plate Extension Bushings



These 3-plate extension bushings can save material, reduce cycle time and help prevent runner hang-ups in 3-plate molds.



Insulator Sheets

These sheets have excellent non-deformation characteristics and a compressive strength which is higher than asbestos and mica materials. Compression molded for high impact strength, they are supplied micro-finished top and bottom, parallel within $\pm.002$.

Locating Rings



Features supplied as standard unless otherwise specified.

The Locating Ring aligns the mold base to the stationary platen side of the press and positions the sprue bushing correctly.

FOR QUOTING OR ORDERING, SPECIFY:

Locating Rings

☐ Standard 6501 D = 3.990

Other _____
(refer to table below and D-M-E Mold Components catalog)

Position/Omission:

Position on center ☐ Center

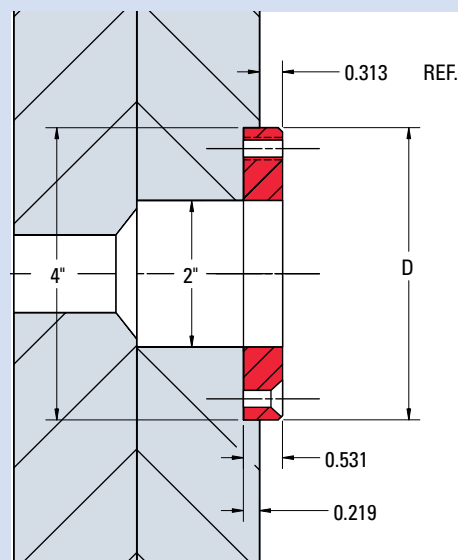
or relocate to

X _____ Y _____

☐ Omit locating ring machining

☐ Omit locating ring

☐ Rotate tapped holes



Locating ring #6501 shown; refer to D-M-E Mold Components catalog for dimensions of other locating rings.

Locating Ring Options

ITEM NUMBER	Ø D	DESCRIPTION
6500	2.615	
6501	3.990	STANDARD SERIES
6501LN	3.990	LN SERIES
6502	4.990	
6503	2.000	
6504	3.990	CLAMP TYPE
6505LN	5.990	LN SERIES
6510	7.995	
6511	2.990	
6520	3.990	EXTENSION NOZZLE TYPE
6521	3.990	STANDARD SERIES
6522	3.990	EXTENSION NOZZLE TYPE
6524	3.990	CLAMP TYPE
6534**	1.574	TOP AND BOTTOM RING
6535	3.541	
6536	4.331	TOP RING
6537	4.331	BOTTOM RING
6541*	3.990	STANDARD SERIES
6544*	3.990	CLAMP TYPE

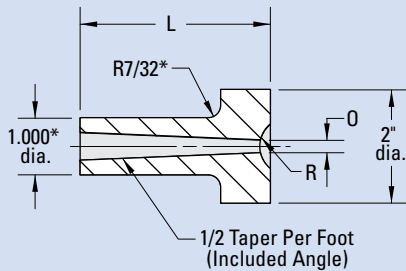
* For use with high-temperature insulator sheets.

** For use with 3.5 x 3.75 Arburg Mold Bases.

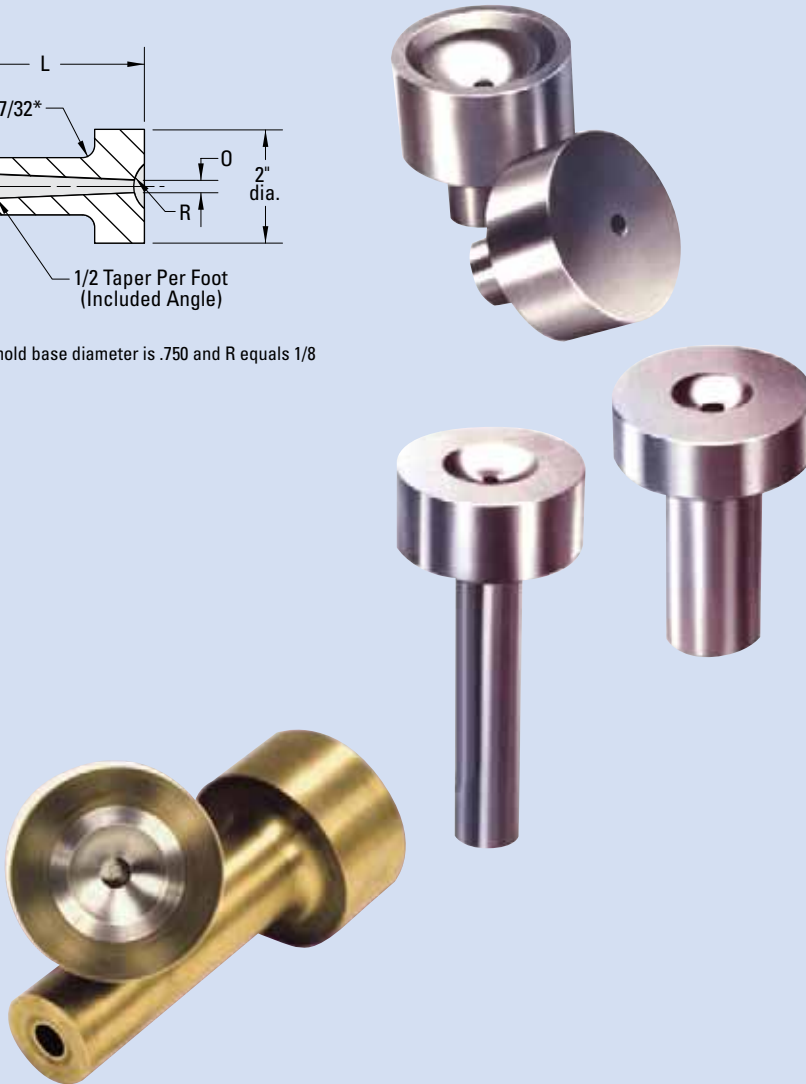
See D-M-E Mold Components catalog for dimensions of other locating rings.

Sprue Bushings

The Sprue Bushing provides a seat at the spherical radius for the nozzle of the press. This provides a path for the material from the nozzle to the runner system.



*For 88 & 812 mold base diameter is .750 and R equals 1/8



Features supplied as standard unless otherwise specified.

FOR QUOTING OR ORDERING, SPECIFY:

Sprue Bushing Series

Standard "B" or "U" (for 88 and 812 mold bases) Series or select any standard D-M-E sprue bushings including D-M-E high-performance sprue bushings.

O (Orifice) _____

R (Radius) _____

NOTE: Refer to D-M-E Mold Components catalog for more information on our complete line of sprue bushings.

Position/Omission:

Position on center ☐ Center

or relocate to

X _____ Y _____

☐ Omit sprue bushing hole

☐ Omit sprue bushing part

Upper and Lower Assembly Screws



Features supplied as standard unless otherwise specified.

FOR QUOTING OR ORDERING, SPECIFY:

Upper Assembly Screws

Recommended position from table (see opposite page) provided standard. If a different position is required, specify below.

Position: ☐ STD ☐ Specify

UASx1 _____
 UASx2 _____
 UASx3 _____
 UASx4 _____
 UASx5 _____
 UASx6 _____
 UASx7 _____
 UASx8 _____
 UASx9 _____
 UASx10 _____
 UASx11 _____
 UASx12 _____
 UASy _____
 Omit hole _____
 Omit part _____

☐ Omit upper assembly holes

☐ Omit upper assembly screws

Lower Assembly Screws

Recommended position from table (see opposite page) provided standard. If a different position is required, specify below.

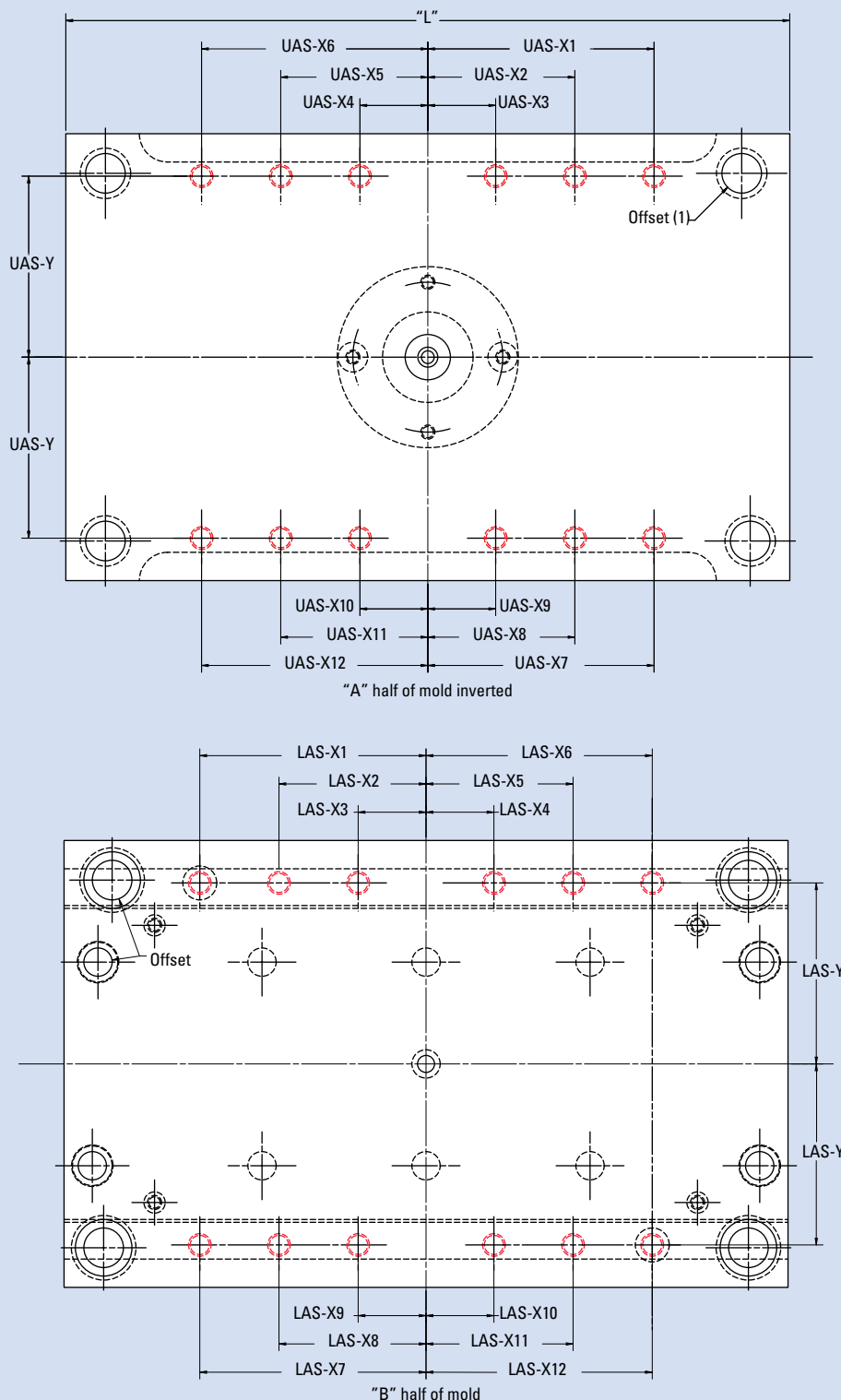
Position: ☐ STD ☐ Specify

LASx1 _____
 LASx2 _____
 LASx3 _____
 LASx4 _____
 LASx5 _____
 LASx6 _____
 LASx7 _____
 LASx8 _____
 LASx9 _____
 LASx10 _____
 LASx11 _____
 LASx12 _____
 LASy _____
 Omit Hole _____
 Omit Part _____

☐ Omit lower assembly holes

☐ Omit lower assembly screws

Assembly screws are used to hold the plates of the upper and lower halves of the mold together. For simplicity, the upper and lower assembly screws are generally placed in similar positions.



Upper and Lower Assembly Screw Positions

BASE SIZE	SCREW SIZE	UASy LASy	UASx1 LASx1	UASx2 LASx2	UASx3 LASx3	UASx4 LASx4	UASx5 LASx5	UASx6 LASx6	UASx7 LASx7	UASx8 LASx8	UASx9 LASx9	UASx10 LASx10	UASx11 LASx11	UASx12 LASx12
88	1/2-13	3.125	1.375	—	—	—	—	1.375	1.375	—	—	—	—	1.375
812	1/2-13	3.125	2.250	—	—	—	—	2.250	2.250	—	—	—	—	2.250
108	1/2-13	4.000	1.875	—	—	—	—	1.875	1.875	—	—	—	—	1.875
1012	1/2-13	4.000	3.250	—	—	—	—	3.250	3.250	—	—	—	—	3.250
1016	1/2-13	4.000	5.000	—	—	—	—	5.000	5.000	—	—	—	—	5.000
1020	1/2-13	4.000	6.500	—	—	1.000	—	6.500	6.500	—	1.000	—	—	6.500
1112	1/2-13	4.469	3.188	—	—	—	—	3.188	3.188	—	—	—	—	3.188
1114	1/2-13	4.469	3.188	—	—	—	—	3.188	3.188	—	—	—	—	3.188
1118	1/2-13	4.469	5.875	—	—	1.000	—	5.875	5.875	—	1.000	—	—	5.875
1123	1/2-13	4.469	8.625	—	3.188	3.188	—	8.625	8.625	—	3.188	3.188	—	8.625
1212	1/2-13	4.469	2.812	—	—	—	—	2.812	2.812	—	—	—	—	2.812
1215	1/2-13	4.469	4.500	—	—	1.000	—	4.500	4.500	—	1.000	—	—	4.500
1220	1/2-13	4.469	6.625	—	—	1.000	—	6.625	6.625	—	1.000	—	—	6.625
1223	1/2-13	4.469	8.625	—	2.812	2.812	—	8.625	8.625	—	2.812	2.812	—	8.625
1315	1/2-13	5.719	4.500	—	—	1.000	—	4.500	4.500	—	1.000	—	—	4.500
1318	1/2-13	5.719	5.438	—	—	1.000	—	5.438	5.438	—	1.000	—	—	5.438
1321	1/2-13	5.719	6.750	—	—	1.000	—	6.750	6.750	—	1.000	—	—	6.750
1323	1/2-13	5.719	8.125	—	2.750	2.750	—	8.125	8.125	—	2.750	2.750	—	8.125
1326	1/2-13	5.719	9.375	—	3.250	3.250	—	9.375	9.375	—	3.250	3.250	—	9.375
1329	1/2-13	5.719	11.125	—	3.250	3.250	—	11.125	11.125	—	3.250	3.250	—	11.125
1518	1/2-13	6.469	5.438	—	—	1.000	—	5.438	5.438	—	1.000	—	—	5.438
1524	1/2-13	6.469	7.750	—	2.750	2.750	—	7.750	7.750	—	2.750	2.750	—	7.750
1529	1/2-13	6.469	10.625	—	3.688	3.688	—	10.625	10.625	—	3.688	3.688	—	10.625
1616	1/2-13	6.969	4.250	—	—	1.000	—	4.250	4.250	—	1.000	—	—	4.250
1620	1/2-13	6.969	6.250	—	—	1.000	—	6.250	6.250	—	1.000	—	—	6.250
1623	1/2-13	6.969	8.000	—	2.750	2.750	—	8.000	8.000	—	2.750	2.750	—	8.000
1626	1/2-13	6.969	9.250	—	3.125	3.125	—	9.250	9.250	—	3.125	3.125	—	9.250
1629	1/2-13	6.969	11.000	—	3.688	3.688	—	11.000	11.000	—	3.688	3.688	—	11.000
1635	1/2-13	6.969	14.000	8.500	2.875	2.875	8.500	14.000	14.000	8.500	2.875	2.875	8.500	14.000
1724	1/2-13	7.281	7.750	—	2.750	2.750	—	7.750	7.750	—	2.750	2.750	—	7.750
1729	1/2-13	7.281	10.625	—	3.688	3.688	—	10.625	10.625	—	3.688	3.688	—	10.625
1818	1/2-13	7.969	5.438	—	—	1.000	—	5.438	5.438	—	1.000	—	—	5.438
1820	1/2-13	7.969	6.438	—	—	1.000	—	6.438	6.438	—	1.000	—	—	6.438
1823	1/2-13	7.969	8.125	—	2.750	2.750	—	8.125	8.125	—	2.750	2.750	—	8.125
1826	1/2-13	7.969	9.375	—	3.125	3.125	—	9.375	9.375	—	3.125	3.125	—	9.375
1829	1/2-13	7.969	11.125	—	3.688	3.688	—	11.125	11.125	—	3.688	3.688	—	11.125
1835	1/2-13	7.969	14.125	8.500	2.875	2.875	8.500	14.125	14.125	8.500	2.875	2.875	8.500	14.125
1924	1/2-13	8.781	7.750	—	2.750	2.750	—	7.750	7.750	—	2.750	2.750	—	7.750
1929	1/2-13	8.781	11.125	—	3.688	3.688	—	11.125	11.125	—	3.688	3.688	—	11.125
1935	1/2-13	8.781	14.125	8.500	2.875	2.875	8.500	14.125	14.125	8.500	2.875	2.875	8.500	14.125
2424	5/8-11	10.844	7.750	—	2.750	2.750	—	7.750	7.750	—	2.750	2.750	—	7.750
2429	5/8-11	10.844	10.625	—	3.688	3.688	—	10.625	10.625	—	3.688	3.688	—	10.625
2435	5/8-11	10.844	13.625	8.500	2.750	2.750	8.500	13.625	13.625	8.500	2.750	2.750	8.500	13.625

Clamp Slots



Features supplied as standard unless otherwise specified.

FOR QUOTING OR ORDERING, SPECIFY:

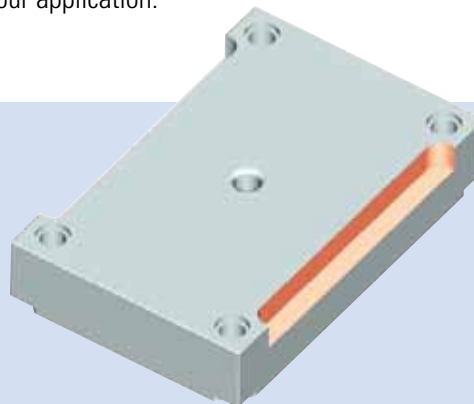
Clamp Slot Type

- ☐ **Type A** - Machined when Top Clamping Plate is 0.875 or 1.375
- ☐ **Type B** - Machined in plates that are 2.375 or thicker
- ☐ **Type C** - Machined only when specified by a customer and top clamp plate is 1.375
- ☐ **Type D** - Machined plates that are 1.875 thick

Other options include:

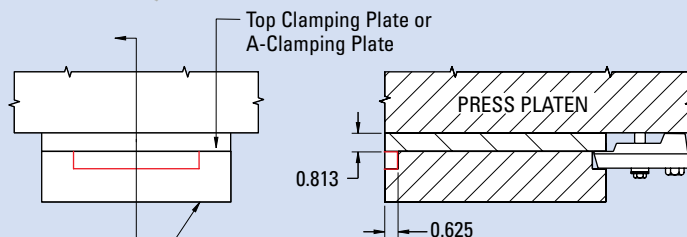
- ☐ Omit upper clamp slot
- ☐ Omit lower clamp slot (3-piece housing supplied)
- ☐ Machine entire length
- ☐ Machine all four sides

Clamp Slots facilitate clamping the mold to the platen of the press. D-M-E American Standard Mold Base offers four slot types (shown below) to ensure the best fit for the requirements of your application.



Type A

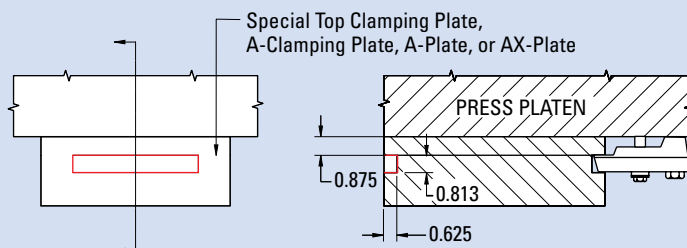
Machined when Top Clamping Plate is 0.875 or 1.375



NOTE: When this plate is 0.875 thick, the slots will be machined through the thickness.

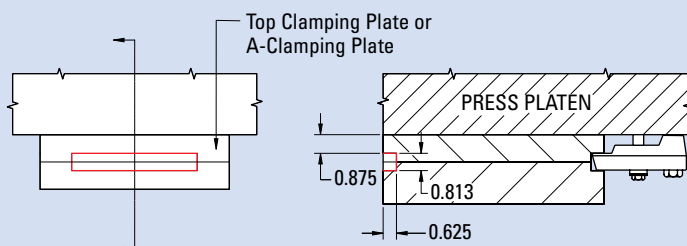
Type B

Machined in plates that are 2.375 or thicker



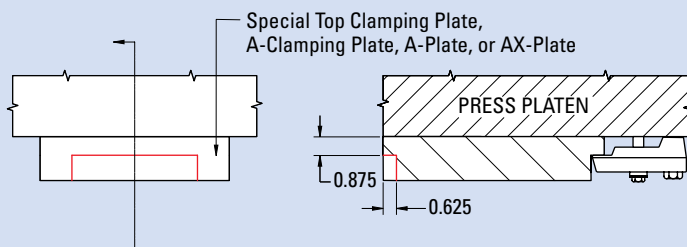
Type C

Machined only when specified by a customer



Type D

Machined plates that are 1.875 thick

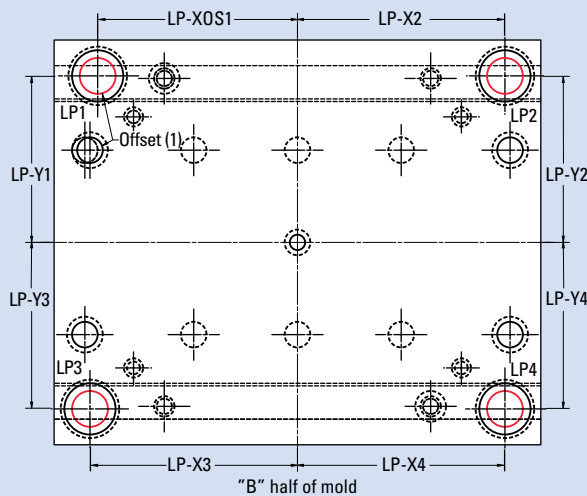


Guide Pins and Bushings

Guide Pins and Bushings align both halves of the mold at the parting line.



Features supplied as standard unless otherwise specified.



Guide Pin Positions

SIZE	DIA	LPxos	LPx	LPy
88	0.750	3.000	3.125	3.125
812	0.750	5.000	5.125	3.125
108	0.750	2.938	3.125	4.062
1012	0.875	4.875	5.062	4.062
1016	0.875	6.938	7.125	4.062
1020	0.875	8.938	9.125	4.062
1112	0.875	4.938	5.125	4.562
1114	0.875	5.938	6.125	4.562
1118	0.875	7.938	8.125	4.562
1123	0.875	10.688	10.875	4.562
1212	1.000	4.625	4.812	5.000
1215	1.000	6.125	6.312	5.000
1220	1.000	8.625	8.812	5.000
1223	1.000	10.375	10.562	5.000
1315	1.000	6.125	6.312	5.688
1318	1.000	7.375	7.562	5.688
1321	1.000	8.750	8.938	5.688
1323	1.000	10.125	10.312	5.688
1326	1.000	11.375	11.562	5.688
1329	1.000	13.125	13.312	5.688
1518	1.250	7.375	7.562	6.062
1524	1.250	10.250	10.438	6.062
1529	1.250	13.125	13.312	6.062
1616	1.250	6.375	6.562	6.562
1620	1.250	8.375	8.562	6.562
1623	1.250	10.125	10.312	6.562
1626	1.250	11.375	11.562	6.562
1629	1.250	13.125	13.312	6.562
1635	1.250	16.125	16.312	6.562
1724	1.250	10.250	10.438	6.812
1729	1.250	13.125	13.312	6.812
1818	1.250	7.375	7.562	7.562
1820	1.250	8.375	8.562	7.562
1823	1.250	10.125	10.312	7.562
1826	1.250	11.375	11.562	7.562
1829	1.250	13.125	13.312	7.562
1835	1.250	16.125	16.312	7.562
1924	1.250	10.250	10.438	8.312
1929	1.250	13.125	13.312	8.312
1935	1.250	16.125	16.312	8.312
2424	1.500	10.062	10.250	10.250
2429	1.500	12.938	13.125	10.250
2435	1.500	15.938	16.125	10.250

FOR QUOTING OR ORDERING, SPECIFY:

Guide Pins

Diameter: ☐ STD ☐ Specify

Recommended diameter from table provided standard. If a different diameter is required, specify below.

Diameter Options:

- ☐ 0.750 ☐ 2.000
☐ 0.875 ☐ 2.500
☐ 1.000 ☐ 3.000
☐ 1.500

Length: ☐ STD ☐ Specify

Recommended pin length for A-Series mold base (A Plate Thickness + B Plate Thickness + 1/2) provided standard. If a different pin length is required, specify below.

Specify Pin Length: _____

Position: ☐ STD ☐ Specify

Recommended position from table provided standard (bushing location will correspond). If a different position is required, specify below.

LPxos1 _____ LPy1 _____
 LPx2 _____ LPy2 _____
 LPx3 _____ LPy3 _____
 LPx4 _____ LPy4 _____

Guide Pin Bushings

Type/Omission:

- ☐ Steel
☐ Bronze
☐ Self-Lubricating
☐ Omit Machining for Leader Pin and Bushings
☐ Omit Guide Pin and Bushing

Return Pins, Stop Pins and Sprue Puller Pins



Features supplied as
standard unless
otherwise specified.

FOR QUOTING OR ORDERING, SPECIFY:

Return Pins

Position: ☐ STD ☐ Specify
Recommended position from table provided standard. If a different position is required, specify below.

☐ Position 1

Standard outboard position for maximum space.

☐ Position 2

Inboard position to allow for spring pockets.

Position/Omission:

RPxos1 _____ RPy1 _____

RPx2 _____ RPy2 _____

RPx3 _____ RPy3 _____

RPx4 _____ RPy4 _____

☐ Omit machining
for return pins

☐ Omit return pins

Length: ☐ STD ☐ Specify _____

Diameter: ☐ STD ☐ Specify _____

Sprue Puller Pins

Diameter: ☐ STD ☐ Specify
Recommended diameter provided standard (.375 diameter, except 88 and 812 are .250 diameter). If a different diameter is required, specify below.

☐ .250

☐ .3125

☐ .375

Length: ☐ STD ☐ Specify _____

Position/Omission:

Position on center ☐ Center

or relocate to

X _____ Y _____

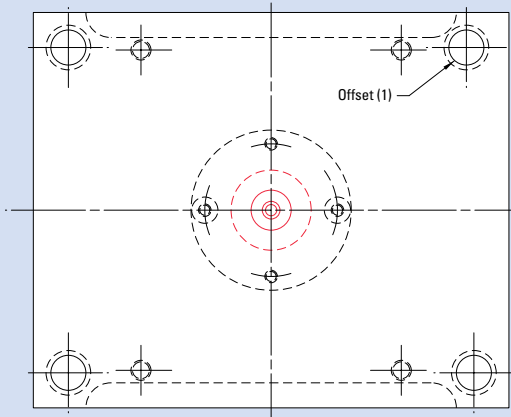
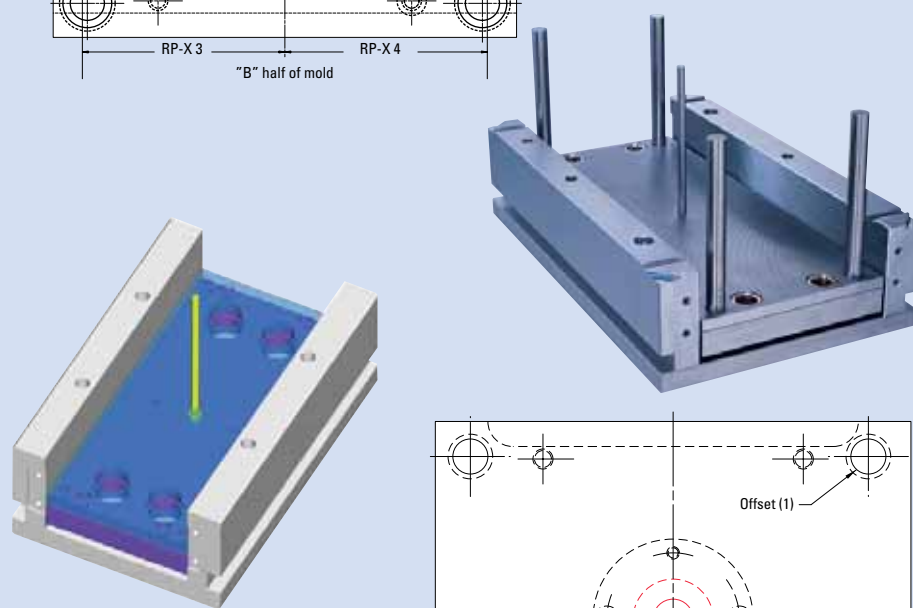
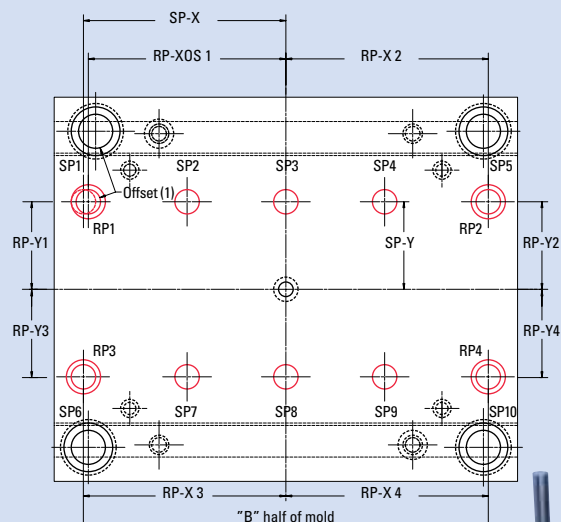
☐ Omit machining for sprue
puller pin

☐ Omit sprue puller pin

Return Pins are used to ensure correct return of the ejector assembly to the home position. D-M-E return pins are precision-ground from superior quality hotwork die steel.

Stop Pins arrest travel — preventing excessive wear and possible housing damage.

The Sprue Puller Pin removes material from the Sprue Bushing at the end of the molding cycle. It's positioned directly below the Sprue Bushing and is retained between the ejector bar and ejector retainer.



Return Pins, Stop Pins and Sprue Puller Pins

Mold Base Return Pin and Stop Pin Positions

BASE SIZE	RP DIAMETER (RECOMMENDED)	RP-y SP-y	POSITION 1		POSITION 2		SP-x1 SP-x6	SP-x2 SP-x7	SP-x3 SP-x8	SP-x4 SP-x9	SP-x5 SP-x10
			RP-xos	RP-x	RP-xos	RP-x					
88	0.500	1.500	3.250	3.375	3.188	3.312	3.375				3.375
812	0.500	1.500	5.250	5.375	5.188	5.312	5.375		On Center		5.375
108	0.625	2.250	3.250	3.375	3.125	3.250	3.375				3.375
1012	0.625	2.250	5.188	5.312	5.063	5.188	5.312		On Center		5.312
1016	0.625	2.250	7.250	7.375	7.125	7.250	7.375	2.500		2.500	7.375
1020	0.625	2.250	9.250	9.375	9.125	9.250	9.375	3.125		3.125	9.375
1112	0.625	2.812	5.250	5.375	5.125	5.250	5.375		On Center		5.375
1114	0.625	2.812	6.250	6.375	6.125	6.250	6.375		On Center		6.375
1118	0.625	2.812	8.250	8.375	8.125	8.250	8.375		On Center		8.375
1123	0.625	2.812	11.000	11.125	10.875	11.000	11.125	3.750		3.750	11.125
1212	0.750	3.188	5.250	5.375	5.000	5.125	5.375		On Center		5.375
1215	0.750	3.188	6.750	6.875	6.500	6.625	6.875	2.250		2.250	6.875
1220	0.750	3.188	9.250	9.375	9.000	9.125	9.375	3.094		3.094	9.375
1223	0.750	3.188	11.000	11.125	10.750	10.875	11.125	3.750		3.750	11.125
1315	0.750	3.812	6.750	6.875	6.500	6.625	6.875	2.250		2.250	6.875
1318	0.750	3.812	8.250	8.375	8.000	8.125	8.375	2.750		2.750	8.375
1321	0.750	3.812	9.500	9.625	9.375	9.500	9.625	4.000		4.000	9.625
1323	0.750	3.812	10.875	11.000	10.750	10.875	11.000	4.000		4.000	11.000
1326	0.750	3.812	12.125	12.250	12.000	12.125	12.250	4.000		4.000	12.250
1329	0.750	3.812	13.875	14.000	13.750	13.875	14.000	5.000		5.000	14.000
1518	0.750	3.875	8.125	8.250	7.938	8.062	8.250	2.750		2.750	8.250
1524	0.750	3.875	11.000	11.125	10.875	11.000	11.125	3.750		3.750	11.125
1529	0.750	3.875	13.875	14.000	13.750	13.875	14.000	4.688		4.688	14.000
1616	0.750	4.375	7.125	7.250	7.000	7.125	7.250	2.375		2.375	7.250
1620	0.750	4.375	9.125	9.250	9.000	9.125	9.250	3.062		3.062	9.250
1623	0.750	4.375	10.875	11.000	10.750	10.875	11.000	4.000		4.000	11.000
1626	0.750	4.375	12.125	12.250	12.000	12.125	12.250	4.000		4.000	12.250
1629	0.750	4.375	13.875	14.000	13.750	13.875	14.000	4.688		4.688	14.000
1635	0.750	4.375	16.875	17.000	16.750	16.875	17.000	8.500	On Center	8.500	17.000
1724	0.750	4.625	11.000	11.125	10.875	11.000	11.125	3.750		3.750	11.125
1729	0.750	4.625	13.875	14.000	13.750	13.875	14.000	4.688		4.688	14.000
1818	0.750	5.375	8.125	8.250	8.000	8.125	8.250	2.750		2.750	8.250
1820	0.750	5.375	9.125	9.250	9.000	9.125	9.250	3.062		3.062	9.250
1823	0.750	5.375	10.875	11.000	10.750	10.875	11.000	4.000		4.000	11.000
1826	0.750	5.375	12.125	12.250	12.000	12.125	12.250	4.000		4.000	12.250
1829	0.750	5.375	13.875	14.000	13.750	13.875	14.000	4.688		4.688	14.000
1835	0.750	5.375	16.875	17.000	16.750	16.875	17.000	8.500	On Center	8.500	17.000
1924	0.750	6.125	11.000	11.125	10.875	11.000	11.125	3.750		3.750	11.125
1929	0.750	6.125	13.875	14.000	13.750	13.875	14.000	4.688		4.688	14.000
1935	0.750	6.125	16.875	17.000	16.750	16.875	17.000	8.500	On Center	8.500	17.000
2424	0.750	7.750	11.000	11.125	10.875	11.000	11.125	3.750		3.750	11.125
2429	0.750	7.750	13.875	14.000	13.750	13.875	14.000	4.688		4.688	14.000
2435	0.750	7.750	16.875	17.000	16.750	16.875	17.000	8.500	On Center	8.500	17.000

Ejector Housing and Cover



Features supplied as standard unless otherwise specified.

FOR QUOTING OR ORDERING, SPECIFY:

Ejector Housing Type

☐ Welded Housing

Available in #1 steel

☐ 3-Piece Housing

☐ D-M-E #1 steel

☐ D-M-E #7 steel

Riser Height:

☐ 2.500

☐ 4.500

☐ 3.000

☐ 5.000*

☐ 3.500

☐ 5.500*

☐ 4.000

☐ 6.000*

☐ Other _____

*Available in 3-Piece only

Bottom Clamp Plate

Thickness for

3-Piece Housing

☐ 0.875

☐ 3.375

☐ 1.375

☐ 3.875

☐ 1.875

☐ 4.875

☐ 2.375

☐ 5.875

☐ 2.875

☐ Other _____

Ejector Housing Cover

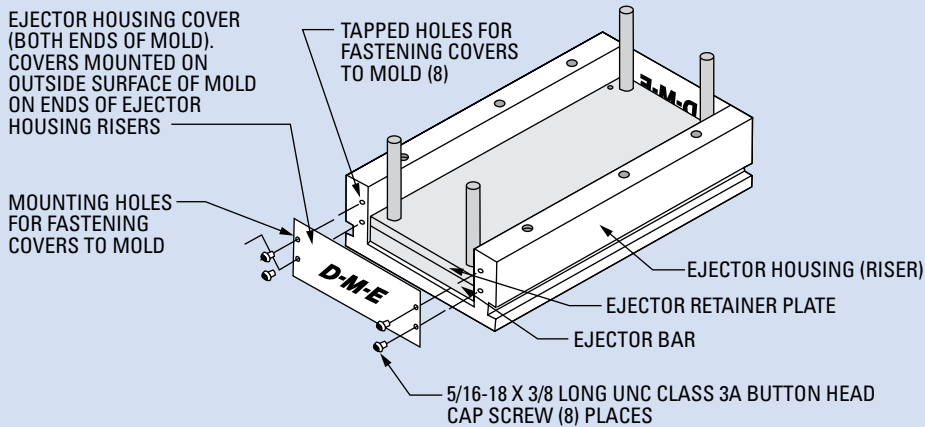
For additional operator safety, D-M-E Standard Mold Bases include an ejector housing cover, except when a longer length ejector bar is selected. The perforated D-M-E logo helps the operator to visually determine if the ejector plate and ejector retainer plate are in the returned position. The cover is fastened on both sides with 5/16-18 button-head cap screws. Once again, D-M-E is leading the industry into a safer work environment.

Ejector Housing

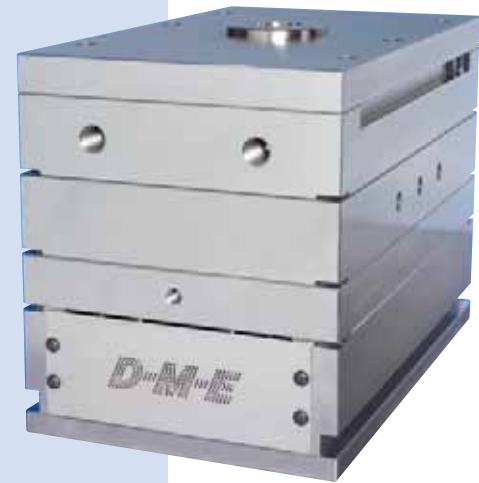
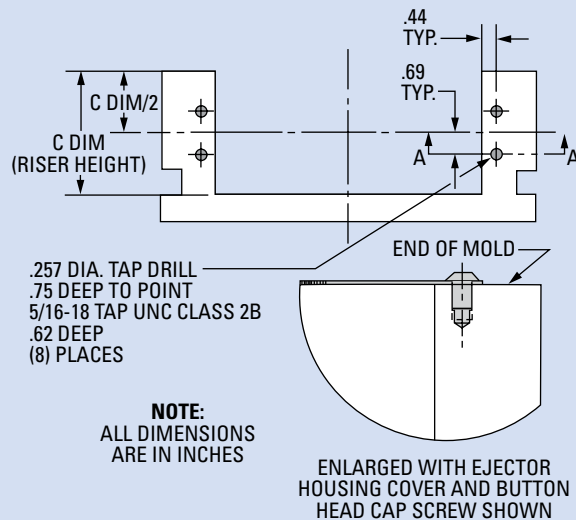
D-M-E offers a selection of housing types to fit application demands. A one-piece welded housing is available for customers requiring maximum rigidity and robust durability. For maximum flexibility of configuration options, a three-piece housing is also available.



Ejector Housing and Cover



Recommended Dimensions for Drilling and Tapping



Ejector Housing Cover Item Numbers

HOUSING WIDTH CODE	RISER HEIGHT CODE							
	25	30	35	40	45	50	55	60
08	EHCS0825	EHCS0830	EHCS0835	EHCS0840	EHCS0845	EHCS0850	EHCS0855	EHCS0860
10	EHCS1025	EHCS1030	EHCS1035	EHCS1040	EHCS1045	EHCS1050	EHCS1055	EHCS1060
11	EHCS1125	EHCS1130	EHCS1135	EHCS1140	EHCS1145	EHCS1150	EHCS1155	EHCS1160
12	EHCS1225	EHCS1230	EHCS1235	EHCS1240	EHCS1245	EHCS1250	EHCS1255	EHCS1260
13	EHCS1325	EHCS1330	EHCS1335	EHCS1340	EHCS1345	EHCS1350	EHCS1355	EHCS1360
15	EHCS1525	EHCS1530	EHCS1535	EHCS1540	EHCS1545	EHCS1550	EHCS1555	EHCS1560
16	EHCS1625	EHCS1630	EHCS1635	EHCS1640	EHCS1645	EHCS1650	EHCS1655	EHCS1660
17	EHCS1725	EHCS1730	EHCS1735	EHCS1740	EHCS1745	EHCS1750	EHCS1755	EHCS1760
18	EHCS1825	EHCS1830	EHCS1835	EHCS1840	EHCS1845	EHCS1850	EHCS1855	EHCS1860
19	EHCS1925	EHCS1930	EHCS1935	EHCS1940	EHCS1945	EHCS1950	EHCS1955	EHCS1960
24	EHCS2425	EHCS2430	EHCS2435	EHCS2440	EHCS2445	EHCS2450	EHCS2455	EHCS2460

NOTE: EHC item numbers are assembled from the prefix EHCS plus the width code and thickness code.
Example: EHCS0825 would be the cover for an 88 or 812 with a riser of 2.5".

Ejector Assembly Screws



Features supplied as standard unless otherwise specified.

FOR QUOTING OR ORDERING, SPECIFY:

Ejector Assembly Screws

Position: ☐ STD ☐ Specify

Recommended position from table provided standard. If a different position is required, specify below.

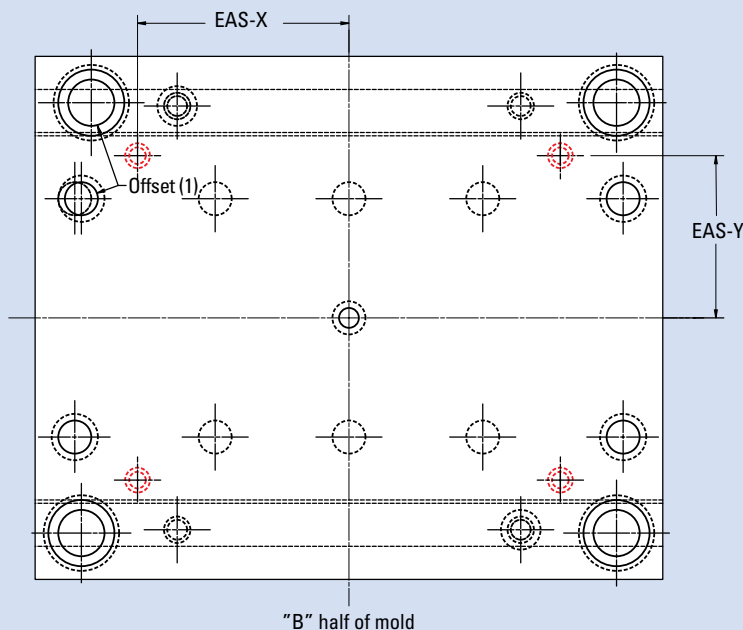
EASx _____

EASy _____

☐ Omit upper assembly holes

☐ Omit upper assembly screws

Ejector Assembly Screws are used to hold the plates of the ejector assembly together (including the ejector bar and retainer).



Ejector Assembly Screw Positions

BASE SIZE	SCREW SIZE	EASx	EASy	BASE SIZE	SCREW SIZE	EASx	EASy
88	5/16-18	3.375	2.250	1518	3/8-16	8.312	5.000
812	5/16-18	5.375	2.250	1524	3/8-16	11.250	5.000
108	5/16-18	3.375	3.062	1529	3/8-16	14.125	5.000
1012	5/16-18	5.312	3.062	1616	3/8-16	7.375	5.438
1016	5/16-18	7.375	3.062	1620	3/8-16	9.375	5.438
1020	5/16-18	9.375	3.062	1623	3/8-16	11.125	5.438
1112	5/16-18	4.562	3.312	1626	3/8-16	12.375	5.438
1114	5/16-18	5.562	3.312	1629	3/8-16	14.125	5.438
1118	5/16-18	7.562	3.312	1635	3/8-16	17.125	5.438
1123	5/16-18	10.312	3.312	1724	3/8-16	11.250	5.750
1212	5/16-18	4.500	3.812	1729	3/8-16	14.125	5.750
1215	5/16-18	6.000	3.812	1818	3/8-16	8.375	6.438
1220	5/16-18	8.500	3.812	1820	3/8-16	9.375	6.438
1223	5/16-18	10.250	3.812	1823	3/8-16	11.125	6.438
*1315	3/8-16	5.812	4.250	1826	3/8-16	12.375	6.438
*1318	3/8-16	7.312	4.250	1829	3/8-16	14.125	6.438
1321	3/8-16	8.688	4.250	1835	3/8-16	17.125	6.438
1323	3/8-16	10.062	4.250	1924	1/2-13	11.250	7.250
1326	3/8-16	11.312	4.250	1929	1/2-13	14.125	7.250
1329	3/8-16	13.062	4.250	1935	1/2-13	17.125	7.250
				2424	1/2-13	11.250	8.875
				2429	1/2-13	14.125	8.875
				2435	1/2-13	17.125	8.875

*New X dimension effective 10/02.

Minimum Recommended Additional Assembly SHCS

MOLD BASE SIZE	A PLATE THICKNESS	EXISTING TOTAL NUMBER OF SHCS	MOLDING MACHINE FORCE (TONS) / MOLD OPENING FORCE (LBS.)											
			15 THROUGH 400 3000 THROUGH 80,000	425 85,000	450 90,000	475 95,000	500 100,000	525 105,000	550 110,000	575 115,000	600 120,000	625 125,000	650 130,000	
88	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
812	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
108	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1012	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1016	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1020	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1112	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1114	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1118	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1123	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1212	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1215	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1220	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1223	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1315	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1318	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1321	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1323	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1326	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1329	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1518	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1524	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1529	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1616	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1620	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1623	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1626	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1629	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1635	.875	12	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	
1724	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1729	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1818	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1820	.875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2	
	1.375 TO 5.875	4	0	0	0	0	0	+1	+1	+1	+1	+1	+2	
1823	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1826	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1829	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1835	.875	12	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	
1924	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1929	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
1935	.875	12	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	
2424	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
2429	.875	8	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	
2435	.875	12	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	

NOTES:

1. Blue color configurations require additional assembly screws.
2. Numbers of additional assembly screws suggested are minimum required.
3. No safety factor considered. The moldmaker is entirely responsible for the chosen configuration.

KEY:

- = No additional assembly screws required
- = Add screws as noted (+)
- = Not available/not recommended

Minimum Recommended Additional Assembly SHCS

MOLD BASE SIZE	A PLATE THICKNESS	EXISTING TOTAL NUMBER OF SHCS	MOLDING MACHINE FORCE (TONS) / MOLD OPENING FORCE (LBS.)													
			675 135,000	700 140,000	725 145,000	750 150,000	775 155,000	800 160,000	825 165,000	850 170,000	875 175,000	900 180,000	925 185,000	950 190,000	975 195,000	1000 200,000
88	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
812	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
108	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1012	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1016	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1020	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1112	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1114	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1118	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1123	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1212	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1215	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1220	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1223	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1315	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1318	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1321	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1323	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1326	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1329	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1518	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1524	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1529	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1616	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1620	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1623	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1626	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1629	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1635	.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1724	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1729	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1818	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1820	.875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6
	1.375 TO 5.875	4	+2	+2	+2	+2	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4
1823	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1826	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1829	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1835	.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1924	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1929	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
1935	.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0
2424	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
2429	.875	8	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0
2435	.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0

NOTES:

1. Blue color configurations require additional assembly screws.
2. Numbers of additional assembly screws suggested are minimum required.
3. No safety factor considered. The moldmaker is entirely responsible for the chosen configuration.

KEY:

- = No additional assembly screws required
- = Add screws as noted (+)
- N/A = Not available/not recommended

American Mold Base Features and Delivery Time



Special Mold Bases Shipping in FIVE Working Days

Includes all D-M-E Standard Mold Bases #1, #2 and #3 steel ($7/8"$ to $57/8"$ thick) and #7 steel ($7/8"$ to $27/8"$ thick); and all "no charge" items, plus:

- Machine for and install guided ejection – 2 or 4 places
- Machine for and install support pillars
- Machine for and install additional stop pins
- Machine press knock-out in bottom clamp plate (tap in ejector bar, if required)
- Machine pry bar slots
- Machine leader pin vent slots in rails
- Machine for spring holes
- Drill and tap lifting holes
- Drill and tap mold strap holes (location $\pm 1/32"$)
- Machine for and install extra assembly screws in top and/or bottom
- Machine for and install extra assembly screws in ejector assembly
- Machine for and install added return pins
- Rough mill/bore cavity and core pocket; blind or through (NOTE: $1/2"$ minimum radius required)



Special Mold Bases Shipping in SEVEN Working Days

Includes all features specified in FIVE working days, plus:

- Machine for D-M-E three-piece extension bushings
- Drill and tap horizontal water lines
- Drill water pipe clearance holes
- Drill vertical water lines (excluding o-ring machining)
- Machine for D-M-E angle pin inserts
- Finish mill/bore cavity and core pocket; blind or through (NOTE: $1/2"$ minimum radius required)



Special Mold Bases Shipping in ELEVEN Working Days

Includes all features specified in SEVEN working days, plus:

- Machine for D-M-E parting line interlocks
- Provide special thickness plates (maximum plate thickness of $57/8"$ in D-M-E #1, #2 and #3 steels, and $27/8"$ in D-M-E #7 steel)

Self-Lubricating Bushings



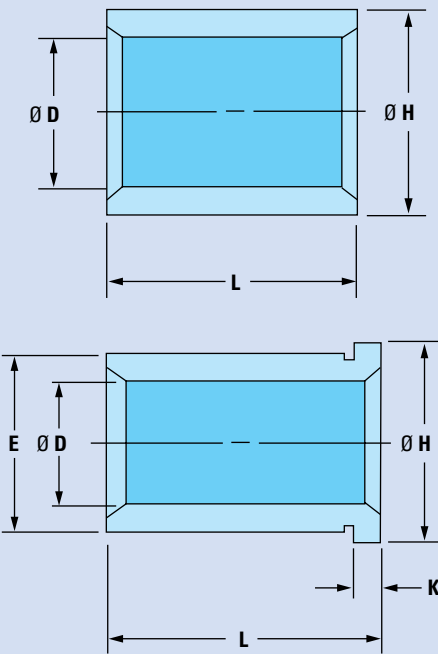
D-M-E Self-Lubricating Bushings save time and money in the design, construction and operation of injection molds. Their built-in lubrication capability also makes them a good choice for fast cycling, high-production molds.

FOR QUOTING OR ORDERING, SPECIFY:

Self-Lubricating Bushings

Item Number: _____

Quantity: _____



General Dimensions

NOMINAL I.D.	Ø E ^{+0.005} _{-0.000}	H ^{+0.000} _{-0.030}	K
3/4	1.1255	1.302	3/16
7/8	1.2505	1.427	
1"	1.3755	1.552	
1 1/4	1.6255	1.802	
1 1/2	2.0005	2.177	
2"	2.5005	2.677	
2 1/2	3.2505	3.427	1/2
3"	3.7505	3.990	

Self-Lubricating Straight Bushings

NOMINAL I.D.	Ø D ^{+0.005} _{-0.000}	L ^{+0.00} _{-0.06} LENGTH	H ^{+0.005} _{-0.000}	ITEM NUMBER
3/4	.7505	7/8	1.1255	GBS-06-07
		1 3/8	1.1255	GBS-06-13
7/8	.8755	1 3/8	1.2505	GBS-07-13
1"	1.0005	1 3/8	1.3755	GBS-08-13
1 1/4	1.2505	1 3/8	1.6255	GBS-10-13
		1 7/8	1.6255	GBS-10-17
1 1/2	1.5005	1 3/8	2.0005	GBS-12-13
		1 7/8	2.0005	GBS-12-17
2"	2.0005	3 7/8	2.5005	GBS-16-37
2 1/2	2.5005	4 7/8	3.2505	GBS-20-47
3"	3.0005	4 7/8	3.7505	GBS-24-47

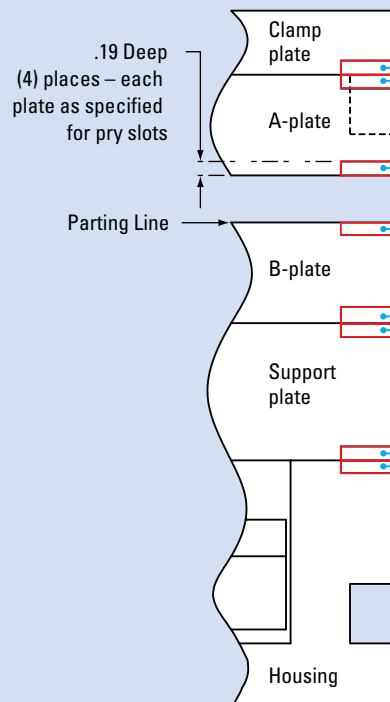
Pry Slots

Mold base features Pry Slots, installed in any plate specified, on the parting and/or non-parting line side. This provides handling ease when opening and/or disassembling a mold.



Pry Slot Options

BASE SIZE	SLOT LENGTH Z
88-1123	.56 x 45°
1212-1315	.88 x 45°
1318-2435	1.00 x 45°

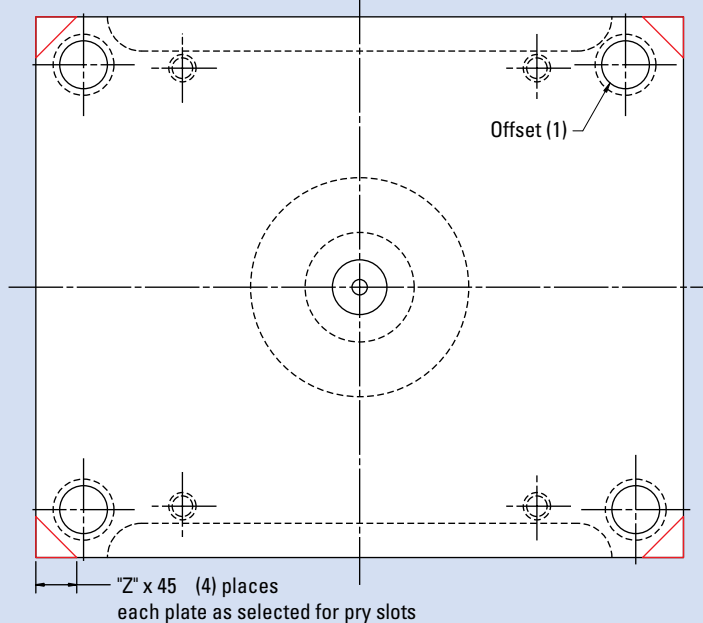


FOR QUOTING OR ORDERING, SPECIFY:

Pry Slot options:

- ☐ Clamp Plate – parting line
- ☐ A Plate – non-parting line
- ☐ A Plate – parting line
- ☐ B Plate – parting line
- ☐ B Plate – non-parting line
- ☐ Support Plate – parting line
- ☐ Support Plate – non-parting line
- ☐ Housing – parting line

"A" half of mold inverted



Guided Ejection Systems



Guided Ejection Systems hold the ejector assembly in alignment and support the weight of the ejector assembly throughout the molding cycle – greatly reducing wear on ejection components and preventing cocking of the ejector assembly.

FOR QUOTING OR ORDERING, SPECIFY:

Guided Ejection System Type

- ☐ System 1
☐ System 2

Quantity (2 or 4): _____

Guided Ejection Bushing Type

- ☐ Bronze-Plated Steel Bushings
☐ Self-Lubricating Bushings

Guided Ejection

Position:

- ☐ STD ☐ Specify

Recommended position from table provided standard (see opposite page). If a different position is required, specify below.

GEx _____

GEy _____

Diameter:

- ☐ STD ☐ Specify

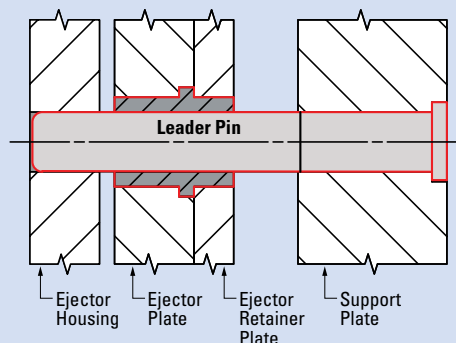
Recommended diameter from table provided standard. If a different diameter is required, it will require a positioning change; specify below.

Available diameters:

- ☐ 0.750
☐ 0.875
☐ 1.000
☐ 1.250

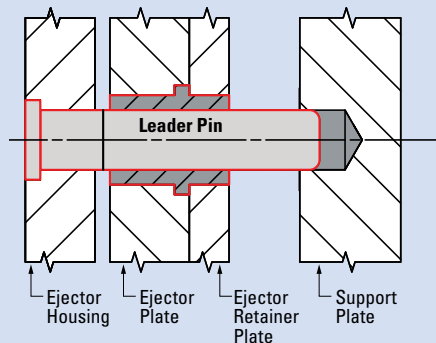
SYSTEM 1

When pins are installed in the support plate, the ejector housing can be removed from the mold without removing ejector plates. This permits easy access to service the ejector system.

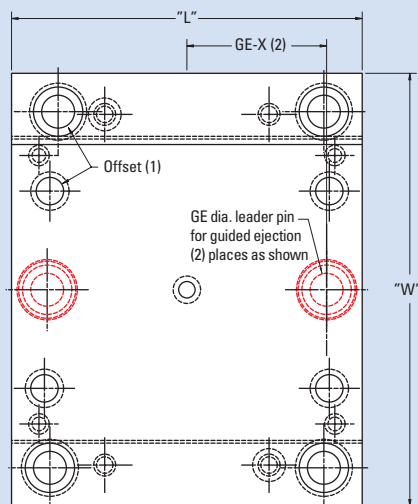
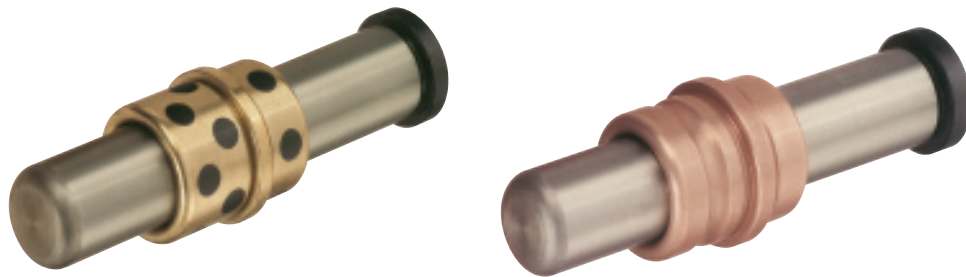


SYSTEM 2

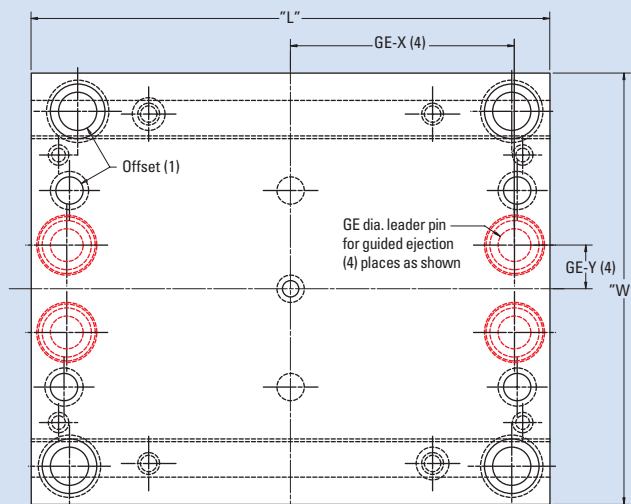
Pins installed in the ejector housing permit fast installation. When the ejector housing is removed from the mold base, the complete ejector assembly is removed.



Guided Ejection Systems



**"B" HALF OF MOLD
FOR 88, 812 & 108 MOLD BASE
SIZE ONLY**



**"B" HALF OF MOLD
FOR 1012 - 2435 BASES**

Guided Ejection Positions

PIN DIAMETER (RECOMMENDED)	BASE SIZE	GE _x	GE _y
0.750	88	3.000	Center
	812	5.000	Center
	108	3.062	Center
	1012	5.000	1.000
	1016	7.062	1.000
	1020	9.062	1.000
	1112	5.062	1.625
	1114	6.062	1.625
	1118	8.062	1.625
	1123	10.812	1.625
0.875	1212	5.000	1.750
	1215	6.500	1.750
	1220	9.000	1.750
	1223	10.750	1.750
	1315	6.500	2.375
	1318	8.000	2.375
	1321	9.375	2.375
	1323	10.750	2.375
	1326	12.000	2.375
	1329	13.750	2.375

PIN DIAMETER (RECOMMENDED)	BASE SIZE	GE _x	GE _y
1.000	1518	7.875	2.375
	1524	10.812	2.375
	1529	13.688	2.375
	1616	6.938	2.875
	1620	8.938	2.875
	1623	10.688	2.875
	1626	11.938	2.875
	1629	13.688	2.875
	1635	16.688	2.875
	1724	10.812	3.125
	1729	13.688	3.125
	1818	7.938	3.875
	1820	8.938	3.875
	1823	10.688	3.875
	1826	11.938	3.875
	1829	13.688	3.875
	1835	16.688	3.875
	1924	10.812	4.625
	1929	13.688	4.625
	1935	16.688	4.625
1.250	2424	10.688	6.125
	2429	13.562	6.125
	2435	16.562	6.125

Lifting Holes



FOR QUOTING OR ORDERING, SPECIFY:

Lifting Holes

Lifting holes can be selected up to three per plate edge. They are available in top clamp plate, A-plate, B-plate, support plate, and bottom clamp plate.

Note that for safety reasons, only the recommended hole diameters (or larger) shown in the table are offered.

Diameter _____

Quantity in each plate _____

Plates with lift holes _____

(Prints required if not on center)

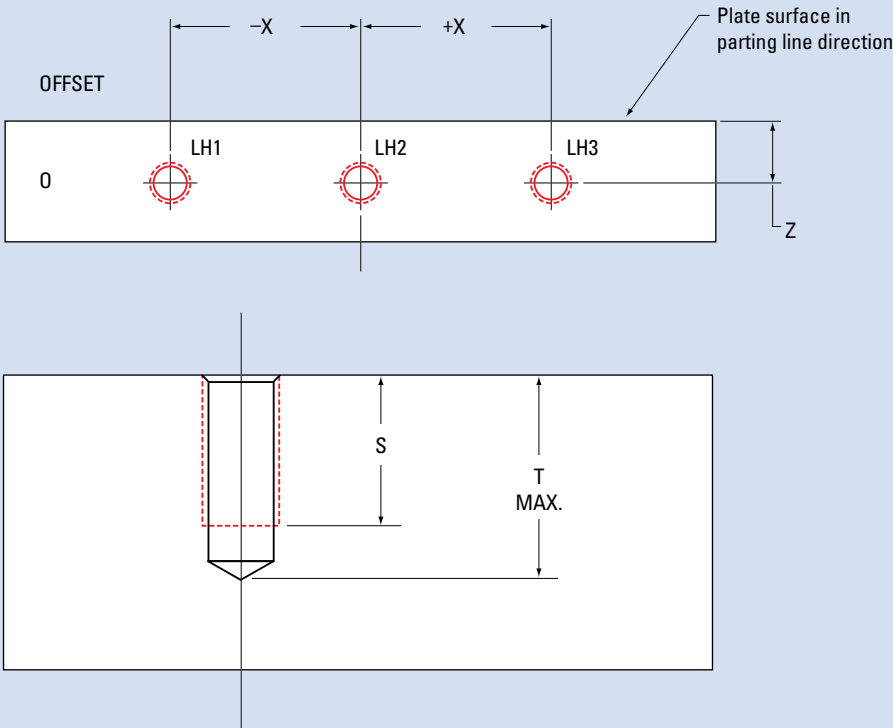
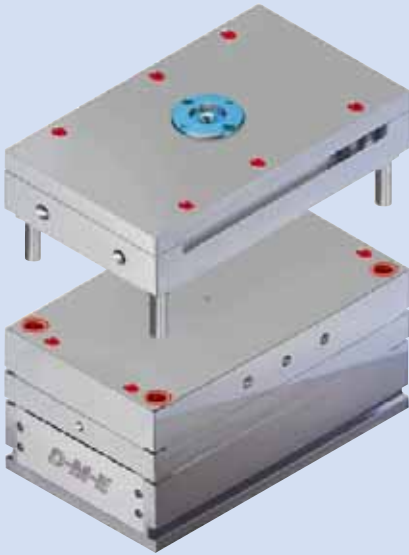
Lifting Holes can be used to install hoist rings for ease of handling. Mold base can be configured only with Lifting Holes which are appropriate for the specific mold base size. Refer to the D-M-E Mold Components catalog for a comprehensive selection of hoist rings.

Lifting Hole Diameters

BASE SIZE	PLATE THICKNESS	
	0.875	1.375
88-1118	1/2-13 UNC	1/2-13 UNC
1123-1524	5/8-11 UNC	5/8-11 UNC
1529-1829	5/8-11 UNC	3/4-10 UNC
1835-2429	5/8-11 UNC	1"-8 UNC
2435	N/A	1"-8 UNC

Lifting Holes

THREAD SIZE	S	T MAX.
1/2-13	1.00	1.38
5/8-11	1.25	1.75
3/4-10	1.50	2.00
1"-8	2.00	2.62



Pockets

Per customer specifications, D-M-E finishes any type of cavity and core pockets.
See D-M-E Mold Components catalog for spring free lengths and hole dimensions.



**Quick delivery on any type
of cavity or core pockets**



FOR QUOTING OR ORDERING, SPECIFY:

Rectangular Pockets

- ☐ Rough rectangular pockets: 5 days
- ☐ Finished rectangular pockets: 7 days

Length _____

Width _____

- ☐ Through
- ☐ Blind _____
(specify depth)

Corner Radius _____
(.50 min/1.00 max)

NOTE: Rough pocket tolerance
-.062 per side; finished
pocket tolerance $\pm .001$

Support Pillars



Support Pillars greatly increase the capacity of the mold to support the projected area of the cavities, runner and sprue. By providing additional support, they prevent deflection of the mold. Support Pillars are universally adaptable for cap screw, threaded locating pin, or socket set screw application.

FOR QUOTING OR ORDERING, SPECIFY:

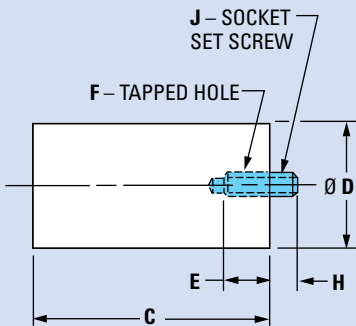
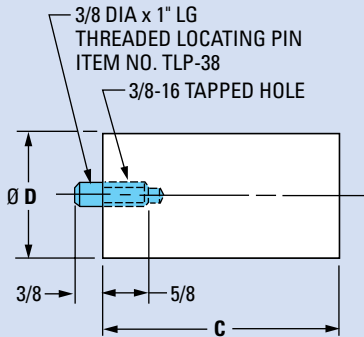
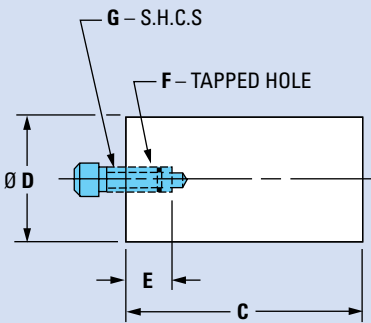
Support Pillars

Quantity: _____

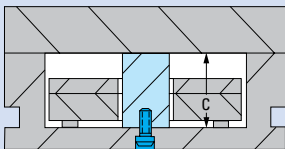
Diameter: _____

Style:

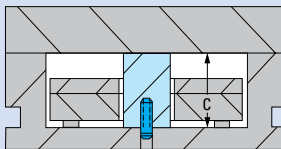
- ☐ Cap screw
- ☐ Threaded locating pin
- ☐ Socket set screw



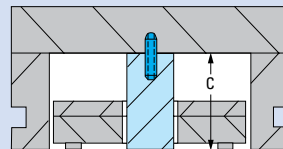
Cap Screw Application



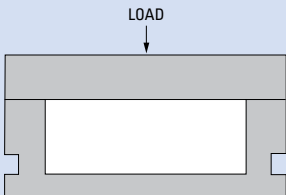
Threaded Locating Pin Application



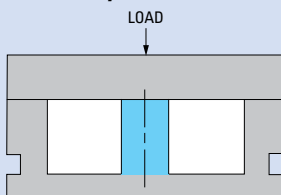
Socket Set Screw Application



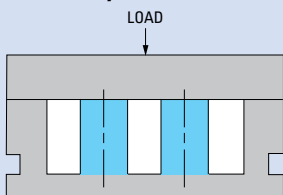
No support pillars



One row of support pillars increases the permissible cavity area 4 times



Two rows of support pillars increase the permissible cavity area 9 times



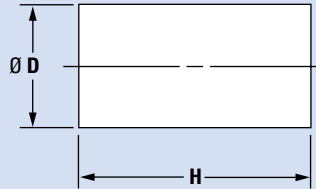
Ø D	E	F	H (APPROX)	J SOCKET SET SCREW
1", 1 1/4", 1 1/2", 2"	5/8	3/8 - 16	1/2	ITEM NO. SSS-38114
3", 4"	1 1/4	5/8 - 11	3/8	ITEM NO. SSS-582

NOTE: Order SHCS separately.

Support Pillars

Support Pillars

$\emptyset D$ ^{+0.000} -0.060	H ^{+0.001} -0.000 HEIGHT	ITEM NUMBER
1"	2.500	6090
	3.000	6091
	3.500	6092
	4.000	6093
	4.500	6094
1 1/4"	2.500	6130
	3.000	6131
	3.500	6132
	4.000	6133
	4.500	6134
	5.000	6135
1 1/2"	2.500	6140
	3.000	6141
	3.500	6142
	4.000	6143
	4.500	6144
	5.000	6145
2"	2.500	6150
	3.000	6151
	3.500	6152
	4.000	6153
	4.500	6154
	5.000	6155
3"	6.000	6156
	5.000	6235
	6.000	6236
4"	8.000	6238
	5.000	6245
	6.000	6246
	8.000	6248



Support pillars are universally adaptable for cap screw, threaded locating pin, or socket set screw applications.

Order pillars from chart at left and required "fasteners" as listed below.

Cap Screw (S.H.C.S.) Applications

3/8-16 or 5/8-11 socket head cap screws can be ordered in length required, see D-M-E Mold Components Catalog.

Threaded Locating Pin Applications

Locating pins unavailable for 3" and 4" diameter pillars.

$\emptyset D$ PILLAR	ITEM NUMBER
1" TO 2"	TLP-38

Socket Set Screw Applications

Order pins and screws in package lots only.

$\emptyset D$ PILLAR	ITEM NUMBER	QTY PER PACKAGE
1" TO 2"	SSS-38114	10
3" AND 4"	SSS-582	5

Leader Pin Vents, Spring Pockets & Mold Strap Holes

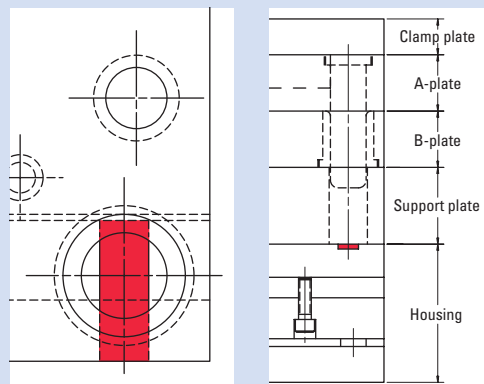


FOR QUOTING OR ORDERING, SPECIFY:

☐ Leader Pin Vents

Leader Pin Vents (0.50 wide x 0.12 deep) can be machined in the housing under the bushing location.

Leader Pin Vents, which allow trapped air to escape from the mold, are designed into all 15-inch-and-wider series molds. When desired, they can be specified on smaller molds.

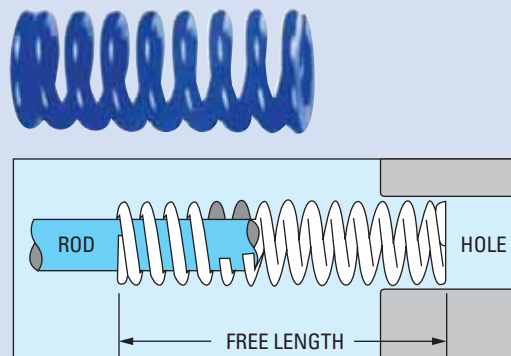


☐ Spring Pockets

Quantity: _____

Plate(s) with pockets: _____

Per customer specifications, D-M-E finishes any type of cavity and core pockets. See D-M-E Mold Components catalog for spring free lengths and hole dimensions.



☐ Mold Strap Holes

Provide desired positions and quantity (minimum 2).

Quantity: _____

Positions: _____

Machined holes will be for mounting mold straps. Please provide desired positions and quantity (minimum 2).



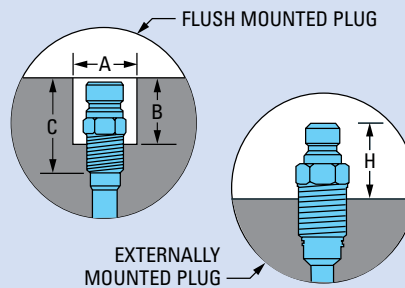
Waterlines

D-M-E will provide waterlines and plugs per customer specifications.



Jiffy-Tite® Plugs (JP)

Male Plug Mounting Information



ITEM NUMBER	NPT	HEX SIZE	A	B	C	H
JP-250	1/16	7/16	11/16	11/16	1"	5/8
JP-251	1/8	7/16	11/16	11/16	1"	5/8
JP-252-(SV)	1/4	9/16	27/32	15/16	1 3/16	7/8
JP-253-(SV)	3/8	1 1/16	1.000	1 5/16	1 1/4	2 9/32
JP-351	1/8	9/16	1.000	1 5/16	1 1/4	7/8
JP-352-(SV)	1/4	9/16	1.000	1 3/32	1 7/16	1 1/32
JP-353-(SV)	3/8	1 1/16	1.000	1 1/8	1 7/16	1 1/16
JP-354-(SV)	1/2	7/8	1 3/16	1 1/4	1 9/16	1 3/16
JP-553	3/8	7/8	1 1/4	1 3/16	1 5/8	1 1/8
JP-554	1/2	7/8	1 1/4	1 1/2	1 13/16	1 7/16
JP-556	3/4	1 1/8	1 1/2	1 9/16	1 7/8	1 1/2

FOR QUOTING OR ORDERING, SPECIFY:

Waterlines

Diameter: _____

Specify plates with waterlines:

Total length (in inches) of waterlines in each plate:

3-Plate Extension Bushings



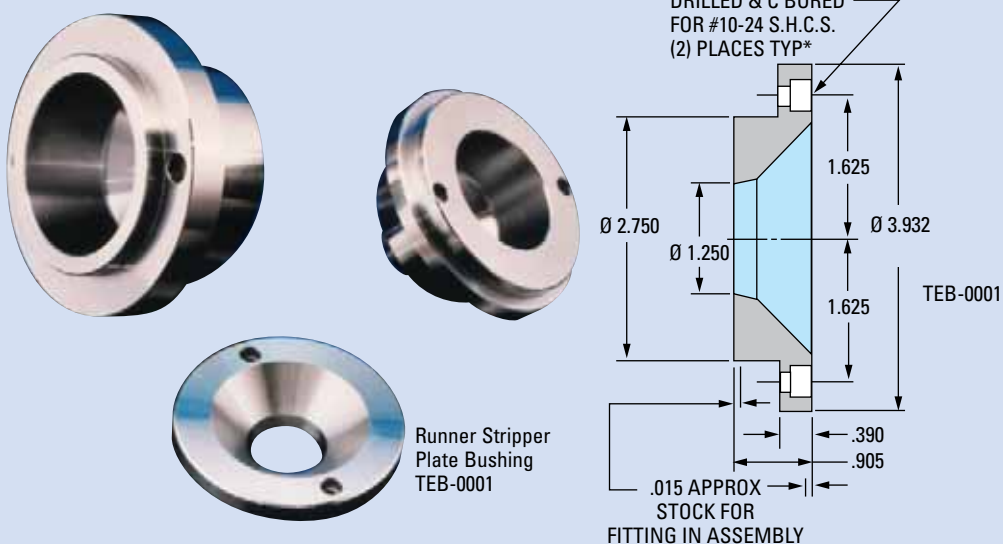
FOR QUOTING OR ORDERING, SPECIFY:

Extension Bushings

Item Number: _____

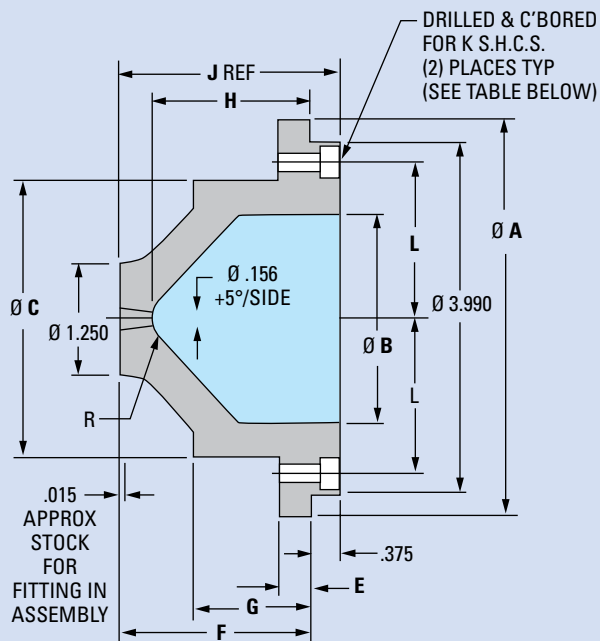
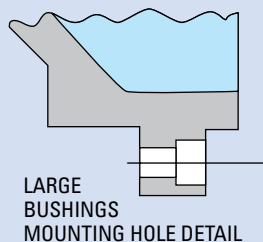
Quantity: _____

Three-Plate Extension Bushings can save material, reduce cycle time and help prevent runner hang-ups in 3-plate molds.



NOTES:

1. Stripper plate bushing TEB-0001 is used with all small and large extension nozzle bushings.
2. Appropriate S.H.C.S. are included with all bushings (TEB-0001 thru TEB-0009).
3. Select small or large bushing based on "A" clamping plate (A.C.P.) thickness, X-1 stripper plate thickness, machine nozzle spherical radius and machine nozzle clearance requirements.



ITEM NUMBER	R SPH. RAD	Ø A	Ø B	Ø C	E	F	G	H	J	K	L
TEB-0002	1/2	4.490	2.375	3.120	.375	2.265	1.377	1.875	2.640	#10-24 x 7/8 LONG (2) INCLUDED	1.781
TEB-0003	3/4							1.812			
TEB-0004	1/2							2.375			
TEB-0005	3/4							2.312			
TEB-0006	1/2	5.490	3.250	3.932	.750	2.765	1.877	2.375	3.140	5/16-18 x 7/8 LONG (2) INCLUDED	2.312
TEB-0007	3/4							2.312			
TEB-0008	1/2							2.875			
TEB-0009	3/4							2.812			

Interlocks

D-M-E Interlocks are precision tolerated and precision manufactured to provide off-the-shelf interchangeability and accurate alignment of mold halves.



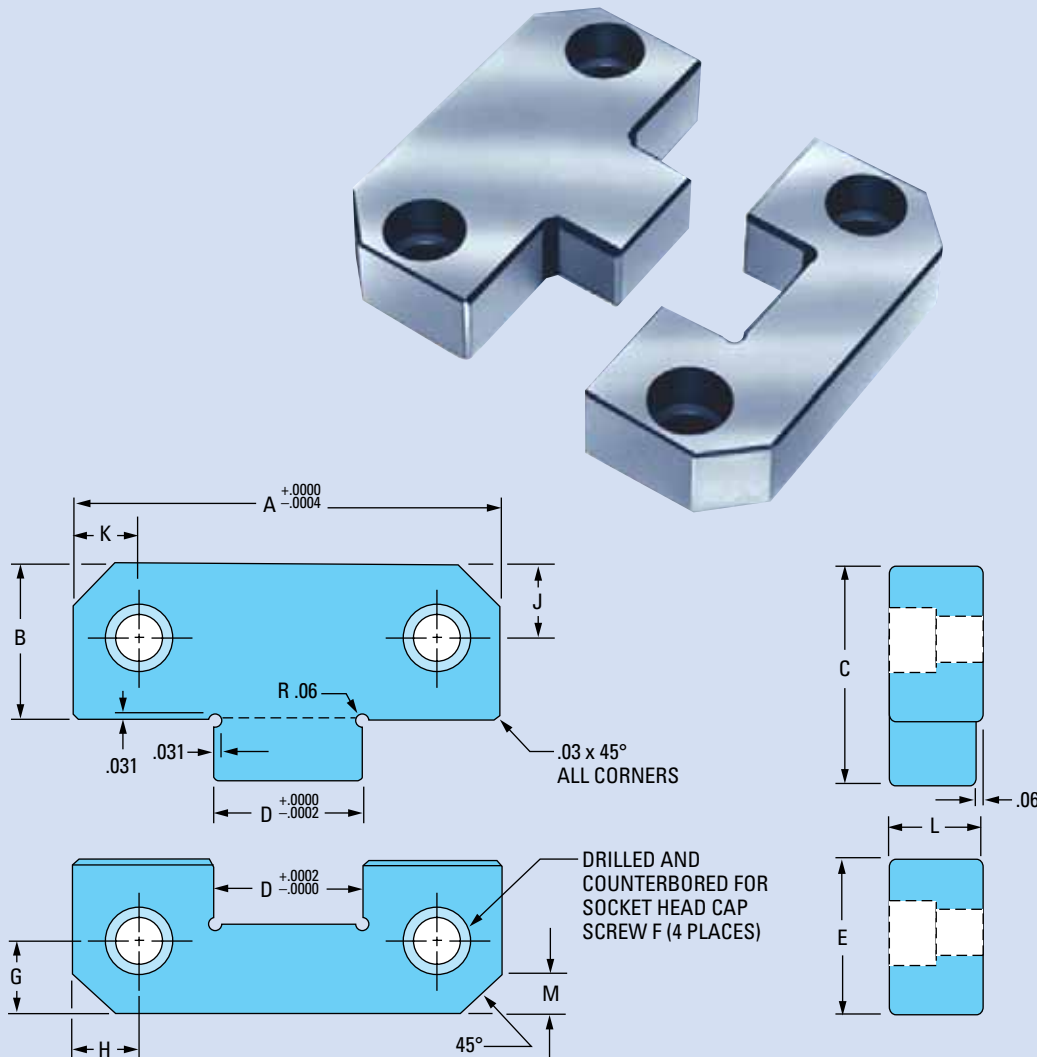
FOR QUOTING OR ORDERING, SPECIFY:

Interlocks

Quantity: _____

Item Number: _____

NOTE: See D-M-E Mold Components catalog for additional interlock options.



ITEM NUMBER	A NOMINAL	B	C	D NOMINAL	E	F*	G	H	J	K	L	M
PLM-0001	1.5000	.870	1.18	.5000	.870	1/4-20 X 3/4	.281	.281	.437	.281	.620	.19
PLF-0001												
PLM-0002	2.0000	.870	1.18	.6800	.870	1/4-20 X 3/4	.375	.375	.437	.375	.620	.19
PLF-0002												
PLM-0003	3.0000	1.360	1.910	1.0000	1.370	3/8-16 X 1	.688	.375	.688	.375	.745	.19
PLF-0003												
PLM-0004	4.0000	1.870	2.640	1.3750	1.870	3/8-16 X 1	.875	.625	.875	.625	.745	.50
PLF-0004												
PLM-0005	5.0000	1.870	2.640	1.7500	1.870	1/2-13 X 1 1/4	.875	.750	.875	.750	1.120	.50
PLF-0005												

*(2) F size SHCS included with each interlock.

Insulator Sheets

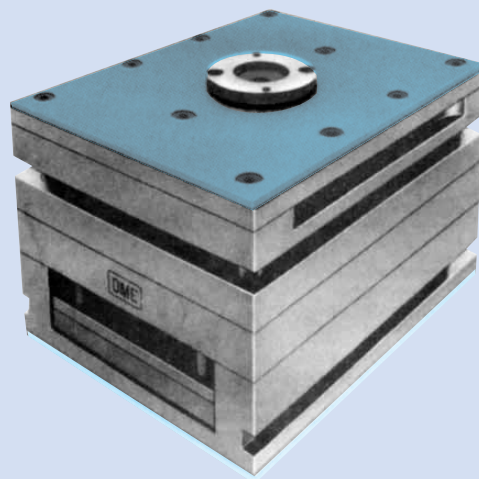
D-M-E High Temperature Insulator Sheets are used on molds and dies between the top clamping plate and the stationary platen, and between the bottom of the ejector housing and the movable platen.

- Asbestos-free material
- High compression strength
- Machinable with high-speed cutting tools

ENERGY SAVINGS

$\frac{1}{4}$ THICK = 27,508 BTU/HR

$\frac{1}{2}$ THICK = 31,004 BTU/HR



General Data

COMPRESSIVE STRENGTH	(ASTM D-229)	49,400 PSI AT 75°F 27,200 PSI AT 300°F 18,000 PSI AT 400°F 17,100 PSI AT 500°F 15,000 PSI AT 550°F
MODULUS OF ELASTICITY IN COMPRESSION	(ASTM D-229)	1.8 x 10 ⁶ PSI AT 75°F 2.9 x 10 ⁶ PSI AT 425°F
WATER ABSORPTION	(ASTM D-229)	0.2%
THERMAL CONDUCTIVITY (K FACTOR), (BTU/HR/FT ² /IN/°F)	(ASTM C-177)	1.9 AT 75°F 2.1 AT 425°F
FLAME RESISTANCE	(UL SUBJECT 94)	94V-0
EXPANSION ACROSS THICKNESS EXPANSION ACROSS SURFACE		6.43 x 10 ⁻⁵ IN/IN/°F 1.24 x 10 ⁻⁵ IN/IN/°F
MAXIMUM RECOMMENDED SERVICE TEMPERATURE		550°F

High Temperature Insulator Sheets

THICKNESS	LENGTH	WIDTH	ITEM NUMBER	NET WEIGHT
$\frac{1}{4}$	36"	18"	HTIS-1836-2	12
		24"	HTIS-2436-2	16
		36"	HTIS-3636-2	24
$\frac{1}{4}$	96"	48"	HTIS-4896-2	105
$\frac{1}{2}$	36"	18"	HTIS-1836-4	24
		24"	HTIS-2436-4	32
		36"	HTIS-3636-4	48

NOTE: Special sizes available on special order: Max. length = 96",
Max thickness = 1", Max. width = 48", Min. thickness = $\frac{1}{8}$
Installation: Use $\frac{1}{4}$ -20 flat head screws. Drill and tap base to suit.