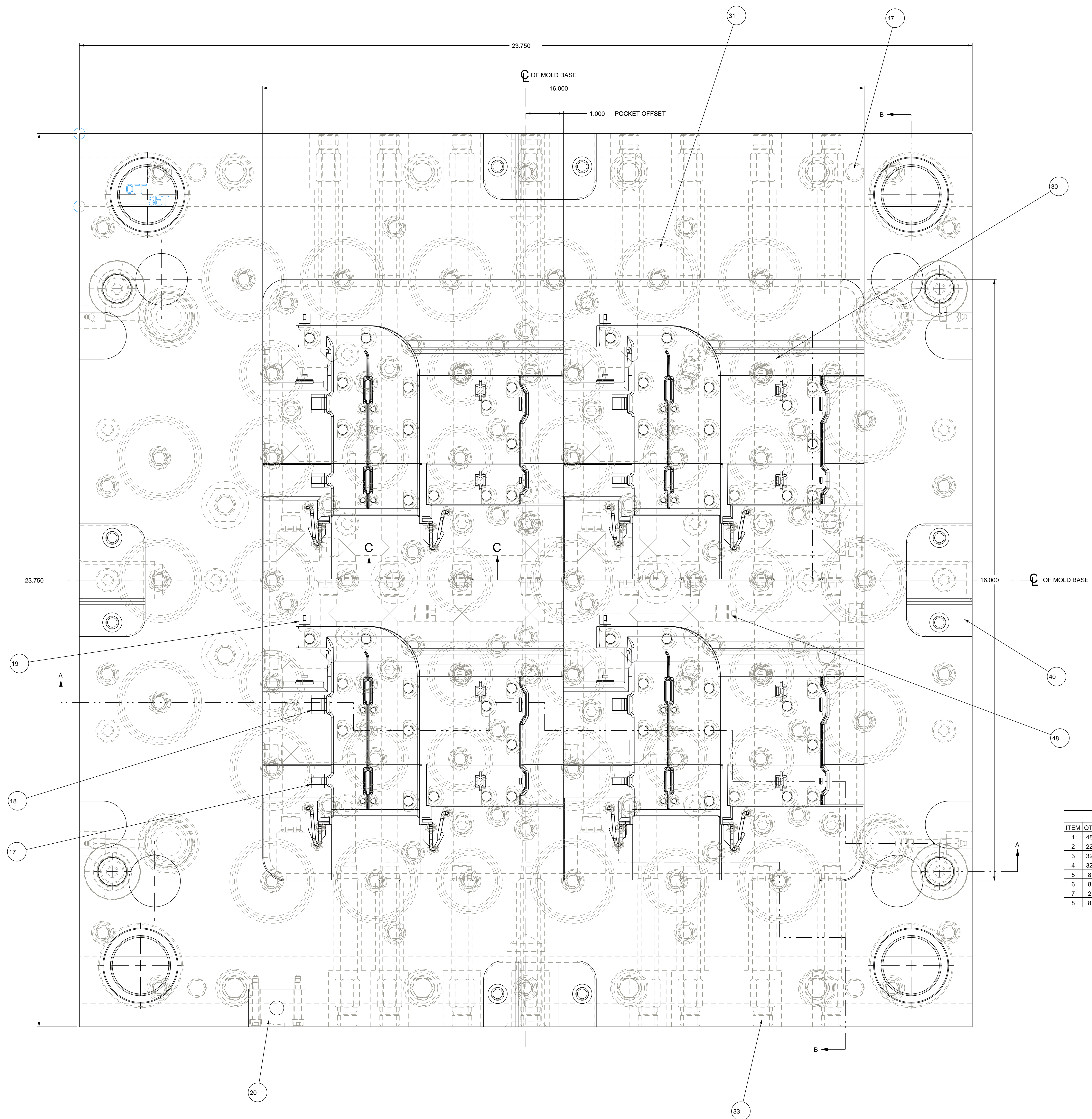


TOP OF MOLD



BOLT CHART

ITEM	QTY	DESCRIPTION
1	48	3/8-16UNC S.H.C.S. X 1.000 LG
2	22	3/8-16UNC S.H.C.S. X 1.250 LG
3	32	3/8-16UNC S.H.C.S. X 1.750 LG
4	32	3/8-16UNC S.H.C.S. X 2.250 LG
5	8	5/8-11UNC S.H.C.S. X 4.500 LG
6	8	5/8-11UNC S.H.C.S. X 5.000 LG
7	2	8-32UNC S.H.C.S. X 1.000 LG
8	8	8-32UNC S.H.C.S. X 1.500 LG

PRELIMINARY DESIGN FOR CUSTOMER APPROVAL

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APPROVED WITH CHANGES AS SHOWN

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DATE: _____

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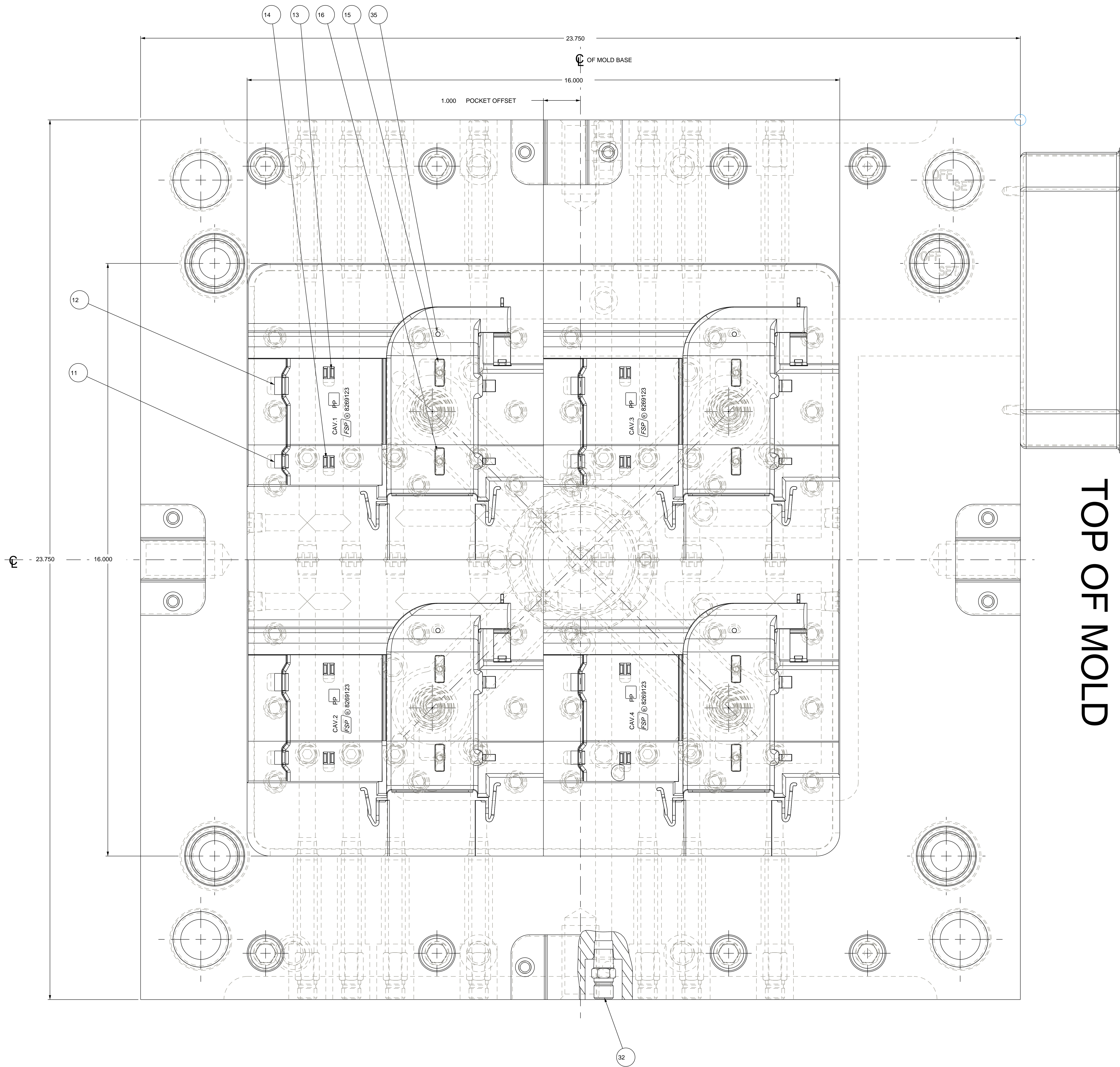
BILL OF MATERIAL

ITEM	QTY	DESCRIPTION	SIZE / PIN	MATERIAL	SOURCE
1	1	A PLATE	4.750 X 23.750 X 23.750	4140	THYSSEN
2	1	B PLATE	4.875 X 23.750 X 23.750	4140	THYSSEN
3	1	EJ BACKUP PLATE	1.125 X 19.875 X 23.750	4140	THYSSEN
4	1	EJ CLAMP PLATE	.875 X 23.750 X 23.750	4140	THYSSEN
5	2	EJ HOUSING RAIL	1.875 X 3.500 X 23.750	4140	THYSSEN
6	1	EJ RETAINER PLATE	1.125 X 19.875 X 23.750	4140	THYSSEN
7	1	MANIFOLD PLATE	2.886 X 23.750 X 23.750	4140	THYSSEN
8	1	TOP CLAMP PLATE	1.375 X 23.570 X 23.750	4140	THYSSEN
9	4	CAVITY INSERT	4.400 X 8.000 X 8.000	H-13 46-48Rc	THYSSEN
10	4	FORCE INSERT	4.132 X 8.000 X 8.000	H-13 46-48Rc	THYSSEN
11	4	A SIDE SHUTOFF INSERT #1	.364 X .475 X 3.389	S-7 52-54Rc	THYSSEN
12	4	A SIDE SHUTOFF INSERT #2	.472 X .475 X 3.389	S-7 52-54Rc	THYSSEN
13	4	A SIDE SHUTOFF INSERT #3	.302 X .422 X 3.442	S-7 52-54Rc	THYSSEN
14	4	A SIDE SHUTOFF INSERT #4	.301 X .430 X 3.437	S-7 52-54Rc	THYSSEN
15	4	A SIDE SHUTOFF INSERT #5	.260 X .739 X .751	S-7 52-54Rc	THYSSEN
16	4	A SIDE SHUTOFF INSERT #6	.260 X .710 X .739	S-7 52-54Rc	THYSSEN
17	4	B SIDE SHUTOFF INSERT #1	.375 X .450 X 2.937	S-7 52-54Rc	THYSSEN
18	4	B SIDE SHUTOFF INSERT #2	.480 X .500 X 2.867	S-7 52-54Rc	THYSSEN
19	4	B SIDE SHUTOFF INSERT #3	.300 X .350 X 1.863	S-7 52-54Rc	THYSSEN
20	1	COUNTERVIEW	CVPL-100	-	PROG
21	4	GUIDED EJECTOR BUSHING	GEB100	-	PROG
22	4	GUIDED EJECTOR LEADER PIN	LP100L4.25	-	PROG
23	4	LEADER PIN 1.50 DIA.	LP150L8.75	-	PROG
24	4	MANIFOLD LEADER PIN, 1-1/4 DIA.	LP125L8.25	-	PROG
25	4	MEDIUM BLUE DIE SPRING	1.50 DIA. X 5.00	-	PROG
26	4	RETURN PIN	RP750L6.97	-	PROG
27	4	SHOULDER BUSHING	SHB125L4.37	-	PROG
28	4	SHOULDER BUSHING	SHB150L4.87	-	PROG
29	24	STOP PIN	STP-1	-	PROG
30	20	SUPPORT PILLAR	SP150L3.5	-	PROG
31	22	SUPPORT PILLAR	SP200L3.5	-	PROG
32	2	CONNECTOR	352	BRASS	PROG
33	30	EXTENSION CONNECTOR, 1/4 NPT	352 X 5-1/2	BRASS	PROG
34	106	PIPE PLUG	1/4 NPT	BRASS	PROG
35	4	A SIDE CORE PIN, .125 DIA	CPH125L6	HTS	PROG
36	52	EJECTOR PIN, 1/4 DIA.	EP250L10	HTS	PROG
37	16	EJECTOR PIN, 1/8 DIA.	EP125L10	HTS	PROG
38	24	EJECTOR PIN, STEP TYPE, 1/16 DIA.	EPS062X2L10	HTS	PROG
39	6	KNOCKOUT EXTENSION, HEX STYLE	PH50L10	HTS	PROG
40	4	TOP LOCK	TL175	HTS	PROG
41	1	ELECTRICAL BOX	ELB008B-R1	-	MOLDMASTER
42	1	LOCATING RING	LR0051	-	MOLDMASTER
43	4	MANIFOLD DROP	NZDCB2A120	-	MOLDMASTER
44	4	PRESSURE DISK	PD0009	-	MOLDMASTER
45	1	4 DROP MANIFOLD	CUSTOM	STAINLESS	MOLDMASTER
46	4	ZERK GREASE FITTING	6Y867	-	GRAINGER
47	4	DOWEL PIN	.500 DIA. X 1.50	HTS	FASTENAL
48	2	THREADLESS BRASS PLUG	TBP-20	BRASS	DME

TOLERANCES UNLESS OTHERWISE SPECIFIED
 2 PLACE ±.01
 3 PLACE ±.002
 4 PLACE ±.0005
 UNSPECIFIED R
 UNSPECIFIED DRIFT
 STAMP STEEL TYPE AND HARDNESS ON PART
 THIS - INDICATES DWG. NOT TO SCALE
 ROUND ALL UNNECESSARY SHARP CORNERS

ITEM	QTY	DESCRIPTION	FINISHED SIZE	MATL	HEAT TREAT	SHT
4 CAVITY INJECTION MOLD MOLD LAYOUT PLAN VIEWS						
DRAWN BY		SCALE		JOB NUMBER		SHEET
S. ALEXANDER		1.000		XXXXXX		1
DATE DRAWN		SHRINKAGE		XXXXXX		4
xx/xx/xx		.014 IN/IN		XXXXXX		4
DELIVERY DATE						

XXXXXX						



TOP OF MOLD

PRELIMINARY DESIGN
FOR
CUSTOMER APPROVAL

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AS SHOWN

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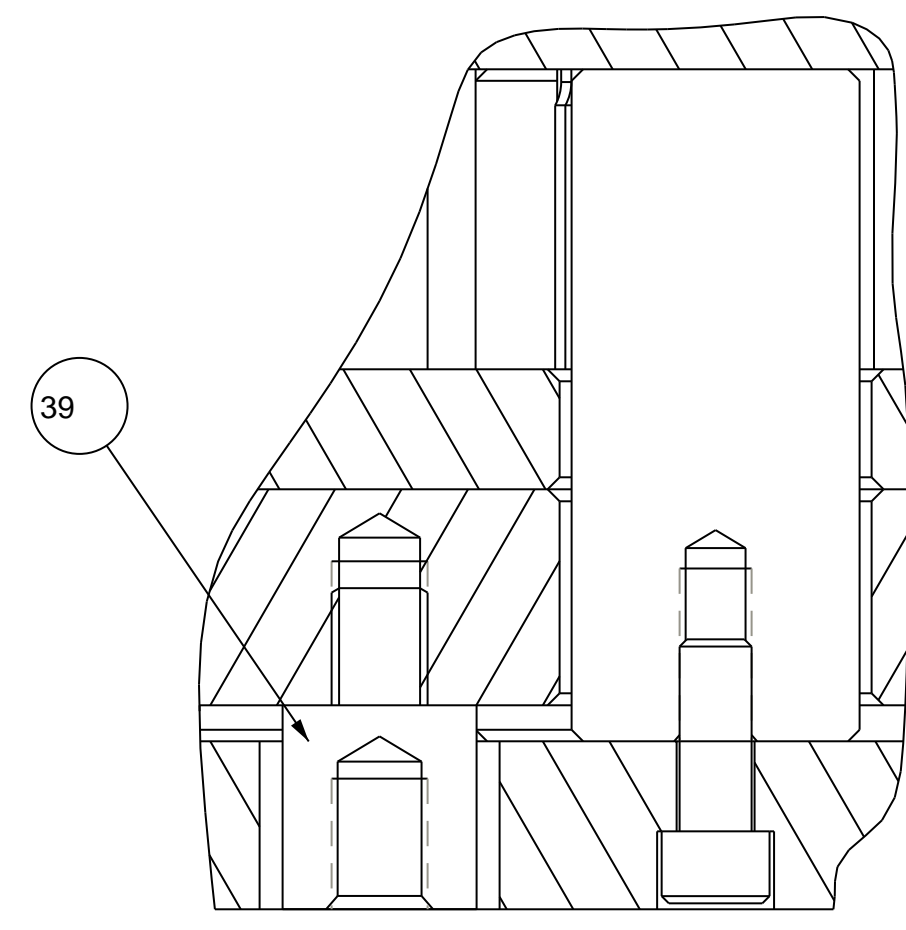
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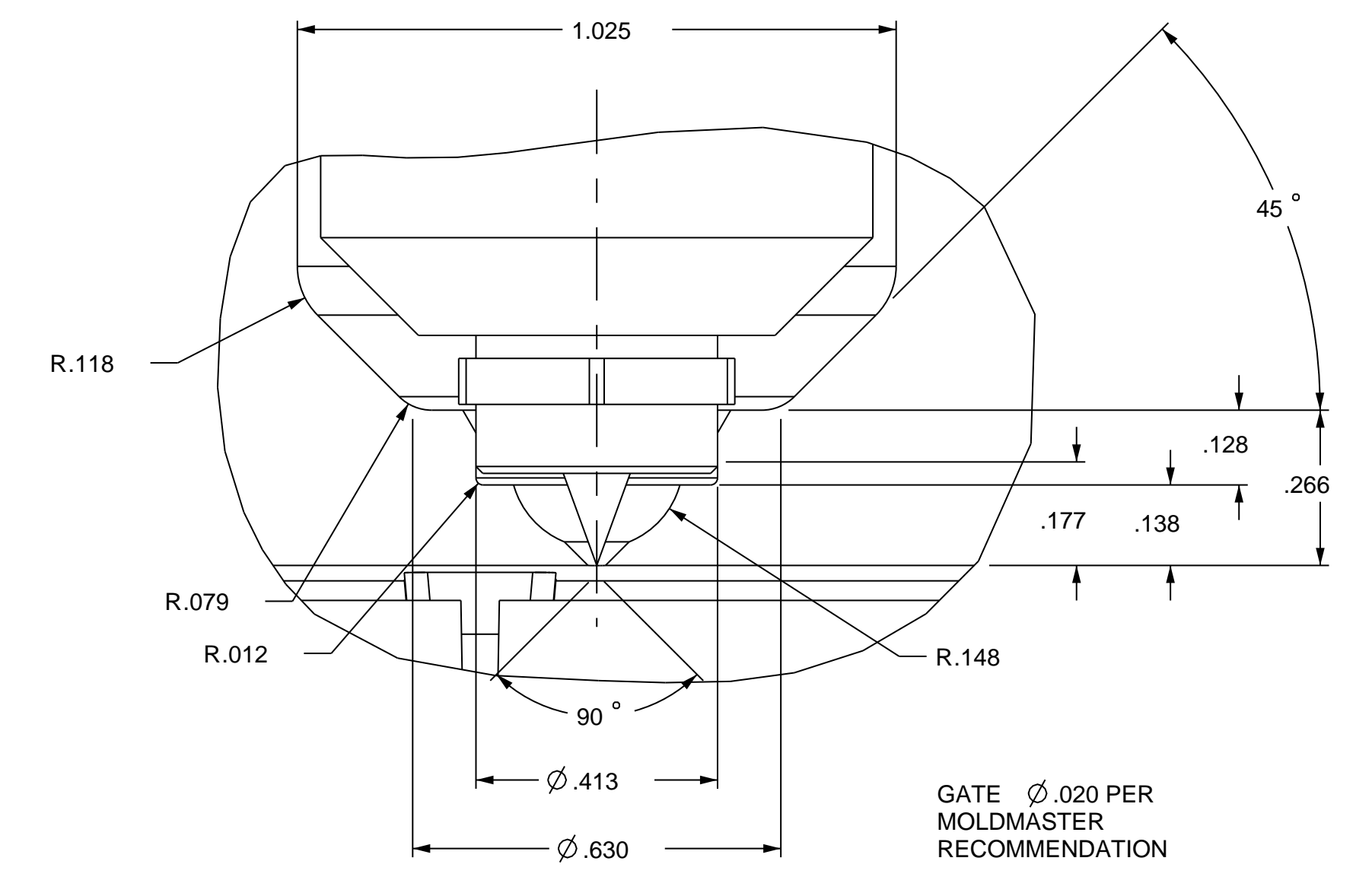
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4 PLACE ±.0005
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STAMP STEEL TYPE AND
HARDNESS ON PART
THIS - INDICATES DWG.
NOT TO SCALE
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SHARP CORNERS

ITEM	QTY	DESCRIPTION	FINISHED SIZE	MATL	HEAT TREAT	SHT	DELIVERY DATE
4 CAVITY INJECTION MOLD MOLD LAYOUT PLAN VIEWS							***
DRAWN BY	SCALE	JOB NUMBER	SHEET				
S. ALEXANDER	1.000	XXXXXX	2				
DATE DRAWN	SHRINKAGE	OF	4				
xx/xx/xx	.014 IN/IN						

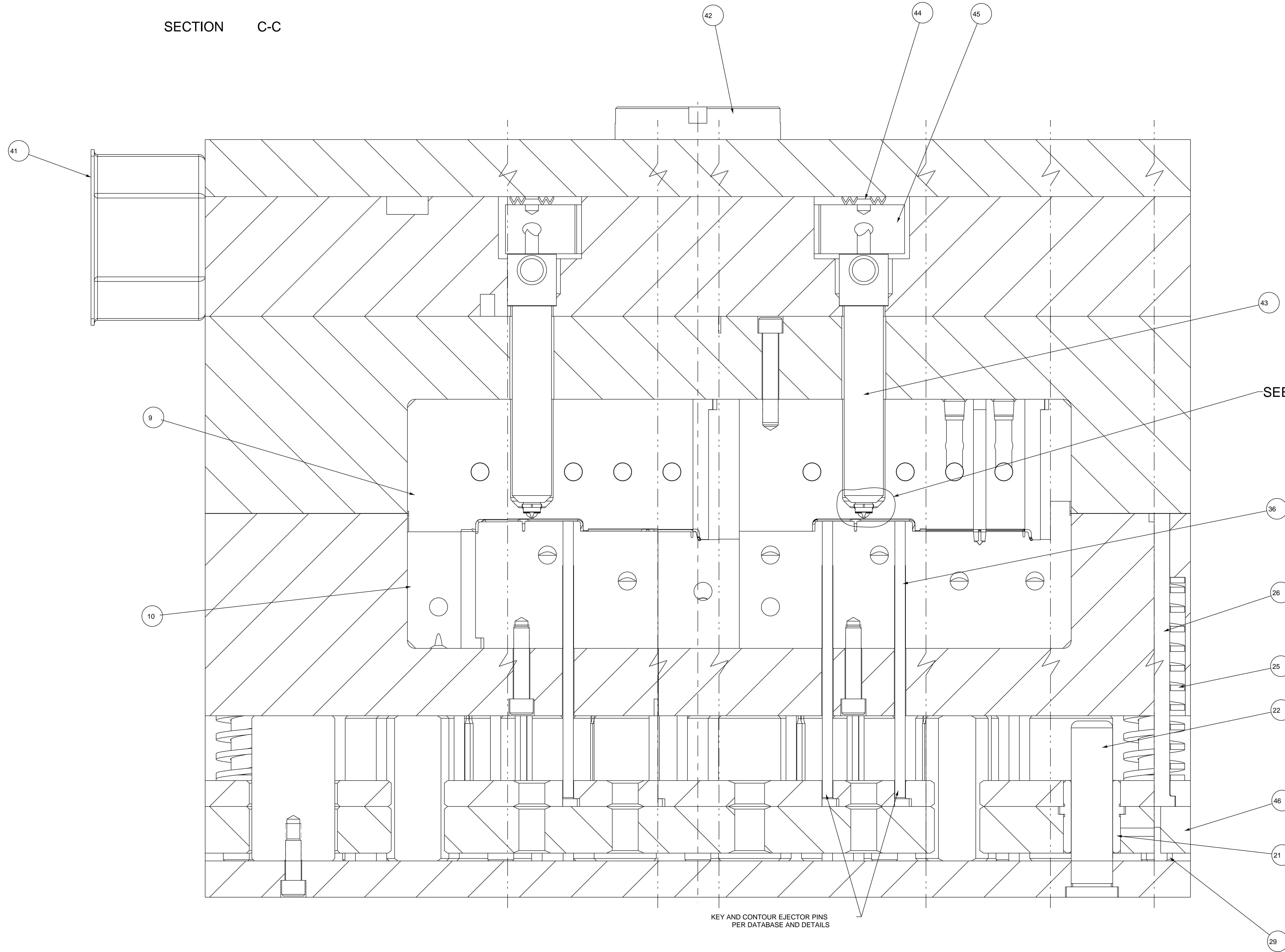
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SECTION C-C



DETAIL GATE
SCALE 4.000



SECTION A-A

SEE DETAIL GATE

KEY AND CONTOUR EJECTOR PINS
PER DATABASE AND DETAILS

**PRELIMINARY DESIGN
FOR
CUSTOMER APPROVAL**

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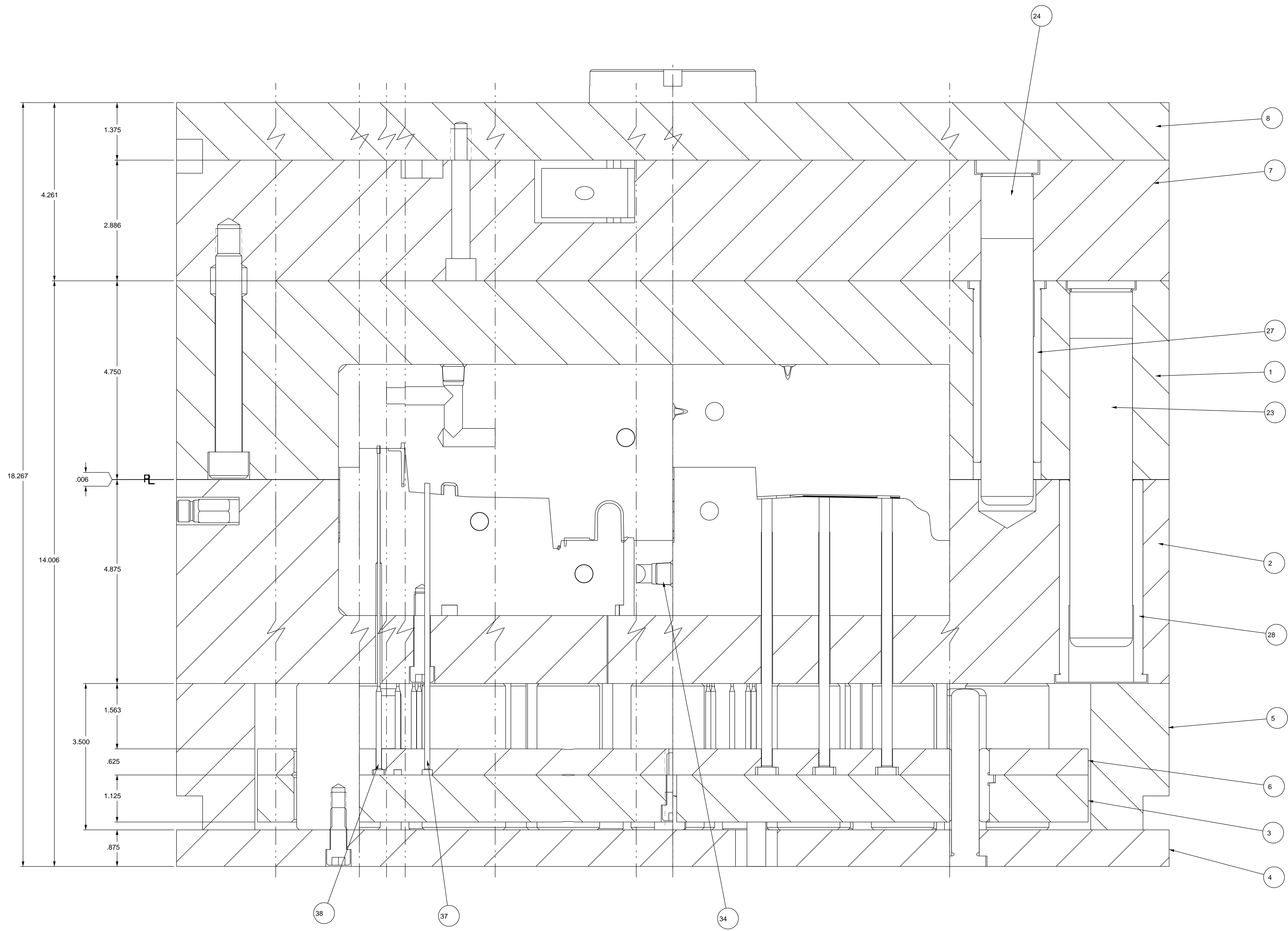
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ITEM	QTY	DESCRIPTION	FINISHED SIZE	MATL	HEAT TREAT	SHT	DELIVERY DATE
4 CAVITY INJECTION MOLD MOLD LAYOUT PLAN VIEWS							***
DRAWN BY S. ALEXANDER		SCALE 1.000	JOB NUMBER XXXXXX	SHEET 3	XXXXXX		
DATE DRAWN xx/xx/xx		SHRINKAGE .014 IN/IN	OF 4				

DESCRIPTION	PART/ASSY FILE NAME	QTY
3/8-16UNC S.H.C.S. X 1.000 LG	5553_DES2	1
3/8-16UNC S.H.C.S. X 1.250 LG	3_8-16X1000	48
3/8-16UNC S.H.C.S. X 1.750 LG	3_8-16X1250	22
3/8-16UNC S.H.C.S. X 2.250 LG	3_8-16X1750	32
4 DROP MANIFOLD	5553_HOT_RUNNER	1
5/8-11UNC S.H.C.S. X 4.500 LG	5_8-11X4500	8
5/8-11UNC S.H.C.S. X 5.000 LG	5_8-11X5000	8
8-32UNC S.H.C.S. X 1.000 LG	8-32X1000	2
8-32UNC S.H.C.S. X 1.500 LG	8-32X1500	8
A PLATE	5553_A_PLATE	1
A SIDE CORE PIN, .125 DIA	5553_A_CORE_PIN	4
A SIDE SHUTOFF INSERT #1	5553_A_INSERT_1	4
A SIDE SHUTOFF INSERT #2	5553_A_INSERT_2	4
A SIDE SHUTOFF INSERT #3	5553_A_INSERT_3	4
A SIDE SHUTOFF INSERT #4	5553_A_INSERT_4	4
A SIDE SHUTOFF INSERT #5	5553_A_INSERT_5	4
A SIDE SHUTOFF INSERT #6	5553_A_INSERT_6	4
B PLATE	5553_B_PLATE	1
B SIDE SHUTOFF INSERT #1	5553_B_INSERT_1	4
B SIDE SHUTOFF INSERT #2	5553_B_INSERT_2	4
B SIDE SHUTOFF INSERT #3	5553_B_INSERT_3	4
CAVITY INSERT	5553_CAVITY_1	1
CAVITY INSERT	5553_CAVITY_2	1
CAVITY INSERT	5553_CAVITY_3	1
CAVITY INSERT	5553_CAVITY_4	1
CONNECTOR	352	2
COUNTERVIEW	COUNTERVIEW	1
DOWEL PIN	500	4
EJ BACKUP PLATE	5553_EJ_BACKUP	1
EJ CLAMP PLATE	5553_EJ_CLAMP	1
EJ HOUSING RAIL	5553_EJ_RAIL	2
EJ RETAINER PLATE	5553_EJ_RETAINER	1
EJECTOR PIN, 1/4 DIA.	EJ_PIN_250	52
EJECTOR PIN, 1/8 DIA.	EJ_PIN_125	16
EJECTOR PIN, STEP TYPE, 1/16 DIA.	EJ_STEP_062	24
ELECTRICAL BOX	ELECTRICAL_COVER	1
EXTENSION CONNECTOR, 1/4 NPT	352X55	30
FORCE INSERT	5553_FORCE_1	1
FORCE INSERT	5553_FORCE_2	1
FORCE INSERT	5553_FORCE_3	1
FORCE INSERT	5553_FORCE_4	1
GUIDED EJECTOR BUSHING	100	4
GUIDED EJECTOR LEADER PIN	100X425	4
KNOCKOUT EXTENSION, HEX STYLE	PKO_HEX	6
LEADER PIN 1.50 DIA.	LEADER_PIN	4
LOCATING RING	LR0051	1
MANIFOLD DROP	DC_E-TYPE	4
MANIFOLD LEADER PIN, 1-1/4 DIA.	LP125X675	4
MANIFOLD PLATE	5553_MANIFOLD_PLATE	1
MEDIUM BLUE DIE SPRING	SPRING	4
PIPE PLUG	250PP	106
PRESSURE DISK	MM_DROP_BACKUP	4
RETURN PIN	RETURN_PIN	4
SHOULDER BUSHING	SHOULDER_BUSHING	4
SHOULDER BUSHING	SHOULDER_BUSHING_M	4
STOP PIN	STOP_PIN	24
SUPPORT PILLAR	150X350	20
SUPPORT PILLAR	200X350	22
THREADLESS BRASS PLUG	TBP-20	2
TOP CLAMP PLATE	5553_TOP_CLAMP_PLATE	1
TOP LOCK	TL175	4
ZERK GREASE FITTING	ZERK_STRT	4
	5553_CAV_WATER_1	1
	5553_CAV_WATER_2	1
	5553_CAV_WATER_3	1
	5553_CAV_WATER_4	1
	5553_FORCE_WATER_1	1
	5553_FORCE_WATER_2	1
	5553_FORCE_WATER_3	1
	5553_FORCE_WATER_4	1
	5553_MANIFOLD	1
	5553_MM_MANIFOLD	1
	5553_MOLDBASE	1
	TIE_BARS	1
	TL175_F	4
	TL175_M	4



SECTION B-B

PRELIMINARY DESIGN FOR CUSTOMER APPROVAL

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ITEM	QTY	DESCRIPTION	FINISHED SIZE	MATL	HEAT TREAT	SHT
4 CAVITY INJECTION MOLD MOLD LAYOUT PLAN VIEWS						
DRAWN BY	SCALE	JOB NUMBER	SHEET			
S. ALEXANDER	1.000	XXXXXX	4			
DATE DRAWN	SHRINKAGE	XXXXXX	OF			
xx/xx/xx	.014 IN/IN	XXXXXX	4			
DELIVERY DATE						

XXXXXX						