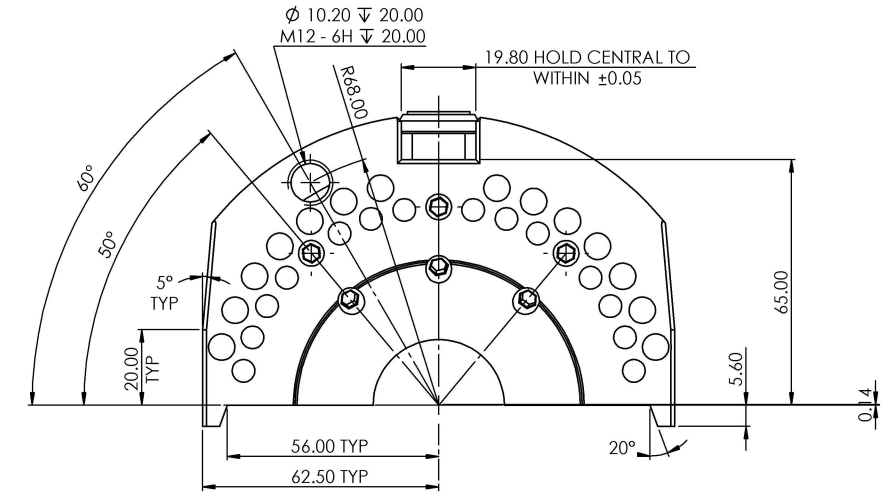
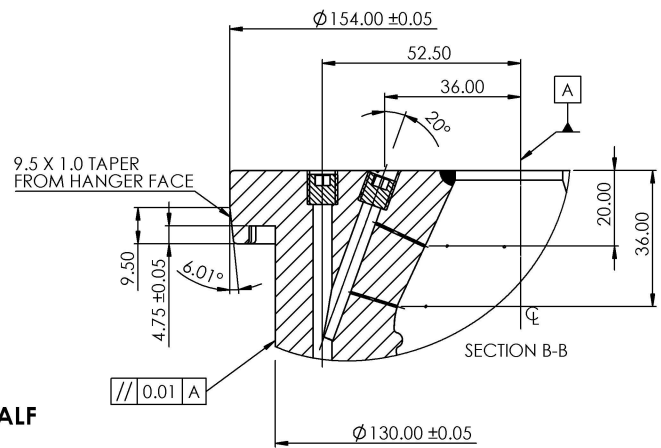
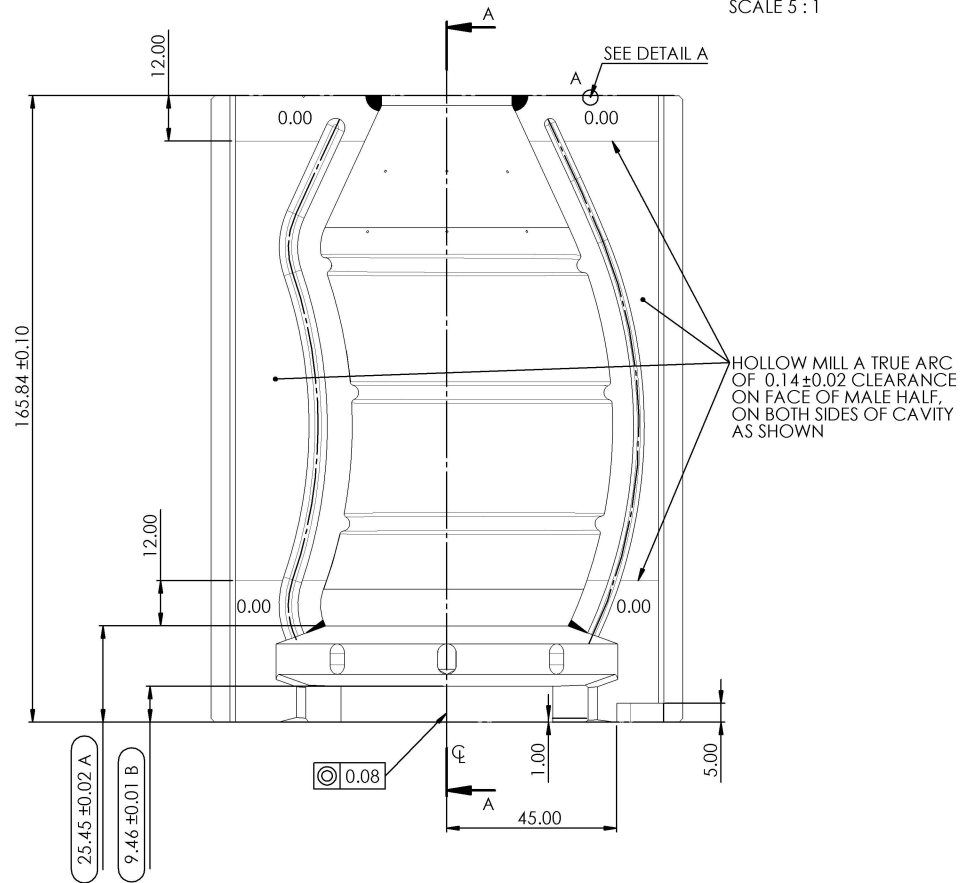


MALE HALF



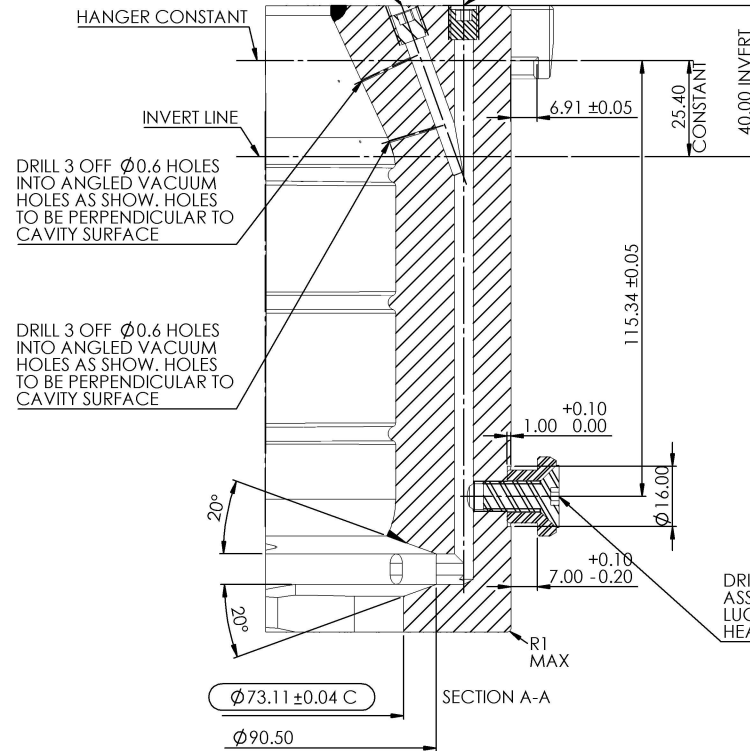
FEMALE HALF

R4.0 NECK MATCH COLMONOY EACH HALF



DRILL 3 OFF Ø5 ANGLED VACUUM HOLES. EACH HOLE TO BE PLUGGED WITH A M8 * 8 GRUB SCREW. GRUB SCREW NOT TO PRETRUDE ABOVE MOULD TOP. SEE SECTION B-B FOR MORE DETAIL

DRILL 3 OFF Ø5 VACUUM HOLES 154MM DEEP. EACH HOLE TO BE PLUGGED WITH A M8 * 8 GRUB SCREW. GRUB SCREW NOT TO PRETRUDE ABOVE MOULD TOP. SEE SECTION B-B FOR MORE DETAIL



PAD AREA BETWEEN CAVITY EDGE AND VACUUM GROOVE TO BE TAPER CUT 0.1+0.03MM DEEP AT BPL END TO 0.2+0.03MM DEEP AT NECK END.

SEE VACUUM GROOVE DETAIL (a) AND (b)

DRILL AND TAP M8 * ASSEMBLY IS-625-2-300 LUG WITH M8 * 20 FLAT HEAD SOCKET CAP SCREW

BREAK FACE OF REGISTER DIAMETER WITH 4.3 * 3.3 CHAMFER ON BOTH SIDES IN EACH HALF

MACHINE CLEARANCE ON EACH SIDE OF REGISTER DIAMETER. TAPER 1.0 AT FACE TO 0.0 AT 45° BACK IN EACH HALF

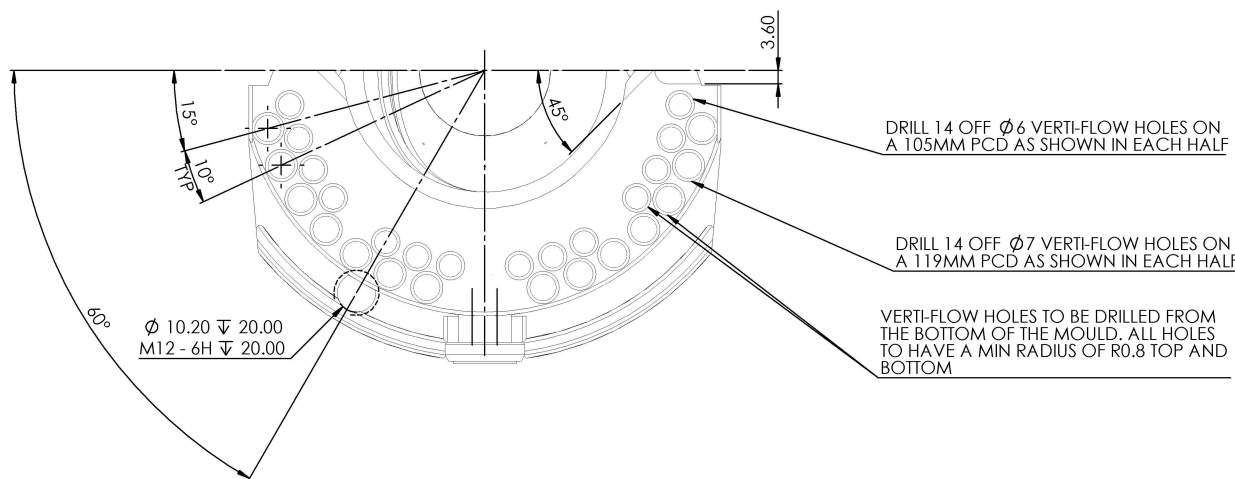
BEVEL DOVETAIL TAPER 8.0 * 1.5 ON BOTH SIDES IN EACH HALF TOWARD FACE

MILL 3 OFF 5MM WIDE SLOTS. SLOTS TO INTERSECT WITH THE VERTICAL VACUUM HOLES

SEE VACUUM GROOVE DETAIL (A) AND (B)

1.5 * 5 BOTTOM MATCH COLMONOY EACH HALF

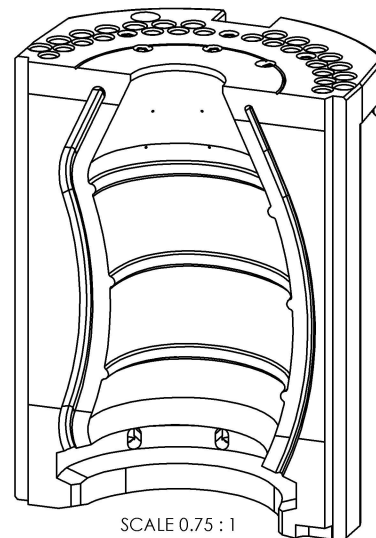
FOR CAVITY DETAIL SEE CAVITY DRAWING



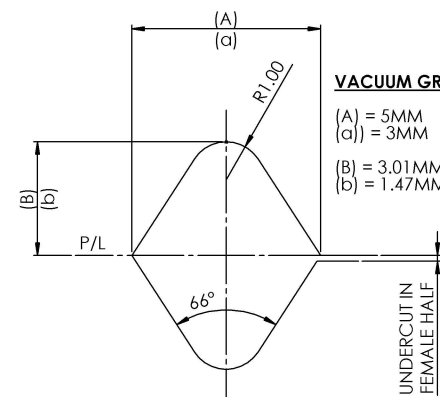
DRILL 14 OFF Ø6 VERTI-FLOW HOLES ON A 105MM PCD AS SHOWN IN EACH HALF

DRILL 14 OFF Ø7 VERTI-FLOW HOLES ON A 119MM PCD AS SHOWN IN EACH HALF

VERTI-FLOW HOLES TO BE DRILLED FROM THE BOTTOM OF THE MOULD. ALL HOLES TO HAVE A MIN RADIUS OF R0.8 TOP AND BOTTOM



SCALE 0.75 : 1



VACUUM GROOVE DETAIL

(A) = 5MM
(a) = 3MM
(B) = 3.01MM
(b) = 1.47MM

HEAT TREATING EQUIPMENT

NOTE: EQUIPMENT IS TO BE HEAT TREATED TO RELIEVE STRESS AFTER COLMONOY APPLICATION AND BEFORE TURNING CASTINGS, CAVITY OR T & G. THE PROCEDURE IS AS FOLLOWS:

- RAISE FROM ROOM TEMPERATURE TO 621°C FOR FOUR HOURS
- HOLD AT 621°C FOR FOUR HOURS
- COOL AT 52°C PER HOUR TO 371°C AND THEN GRADUALLY COOL TO ROOM TEMPERATURE

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS SURFACE FINISH: TOLERANCES: LINEAR: ANGULAR:				DO NOT SCALE DRAWING		REVISION	
DESIGN	12	SIGNATURE	DATE	TITLE: MOULD TOOL		DWG NO. Mld	
CHECK	12						
APPROV							
DATE							
Q.A.							
MATERIAL:				WEIGHT:		SCALE: 1:1	
						SHEET 1 OF 1	