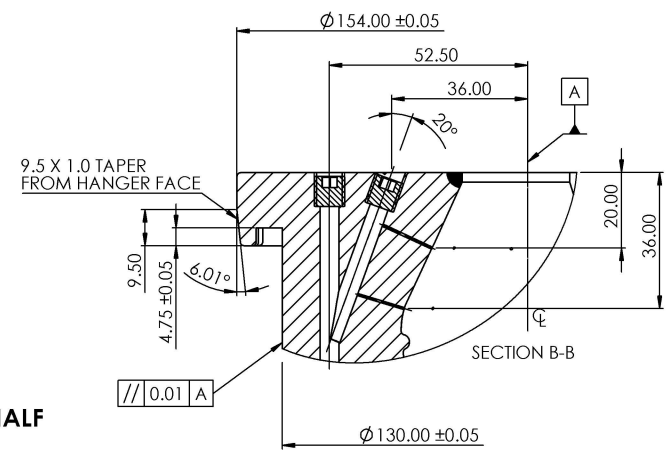
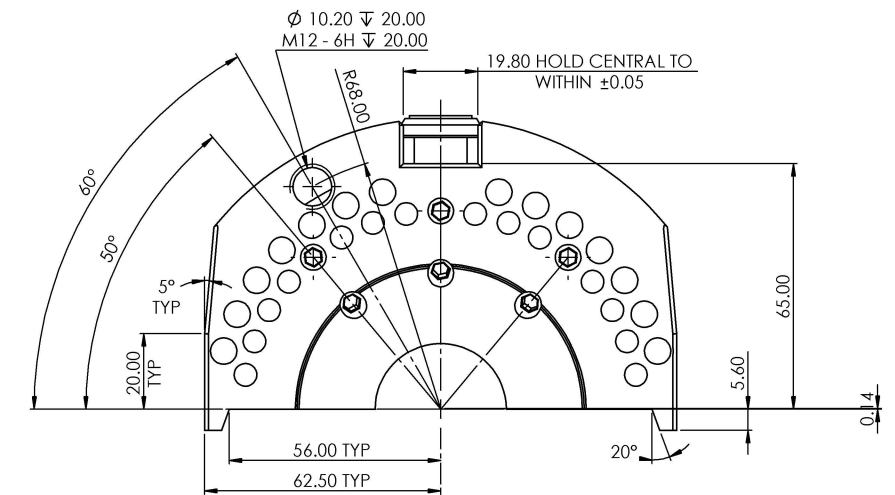


**MALE HALF**



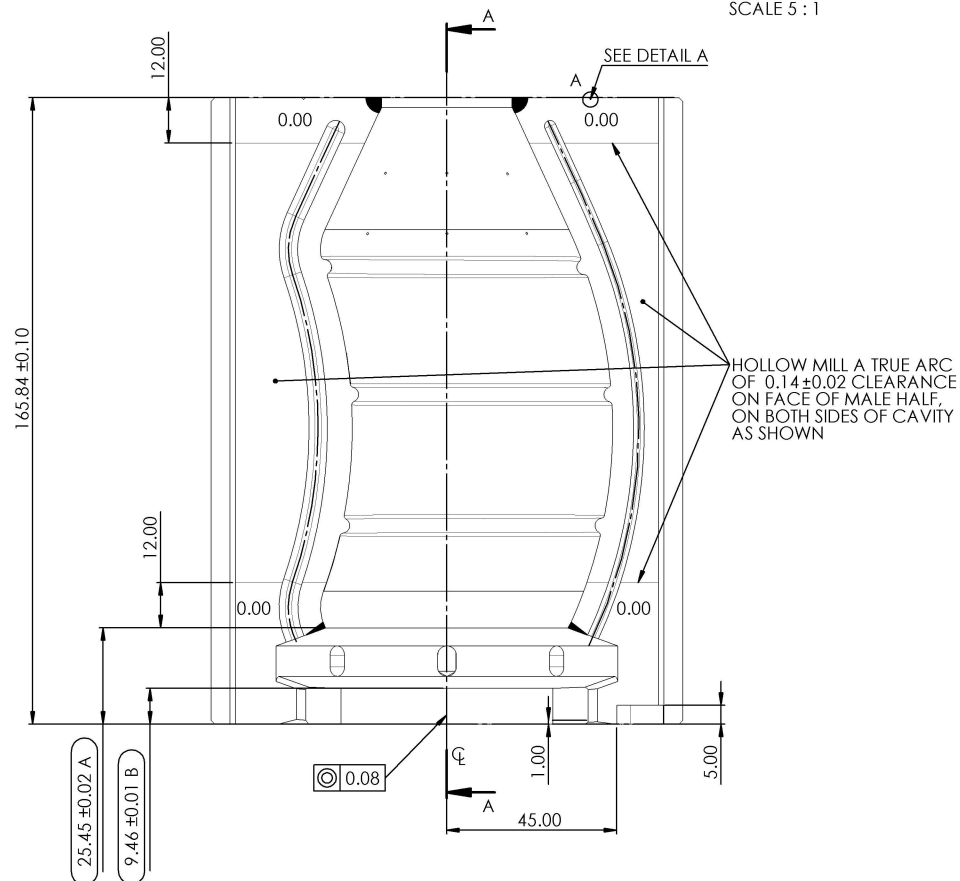
DRILL 3 OFF Ø5 ANGLED VACUUM HOLES. EACH HOLE TO BE PLUGGED WITH A M8 \* 8 GRUB SCREW. GRUB SCREW NOT TO PRETRUDE ABOVE MOULD TOP. SEE SECTION B-B FOR MORE DETAIL

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

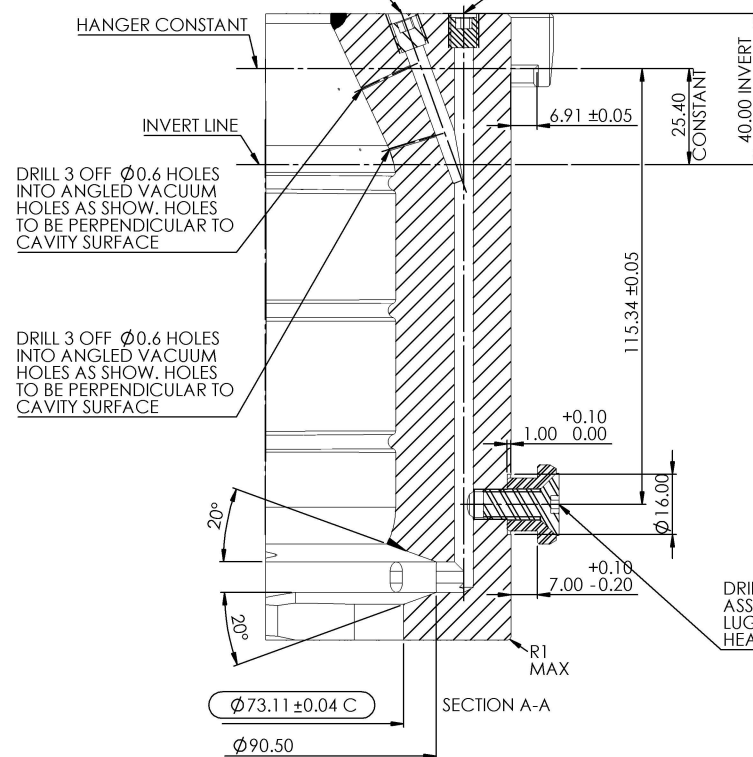


**FEMALE HALF**

R4.0 NECK MATCH  
COLMONOY EACH  
HALF



**FOR CAVITY DETAIL SEE CAVITY DRAWING**

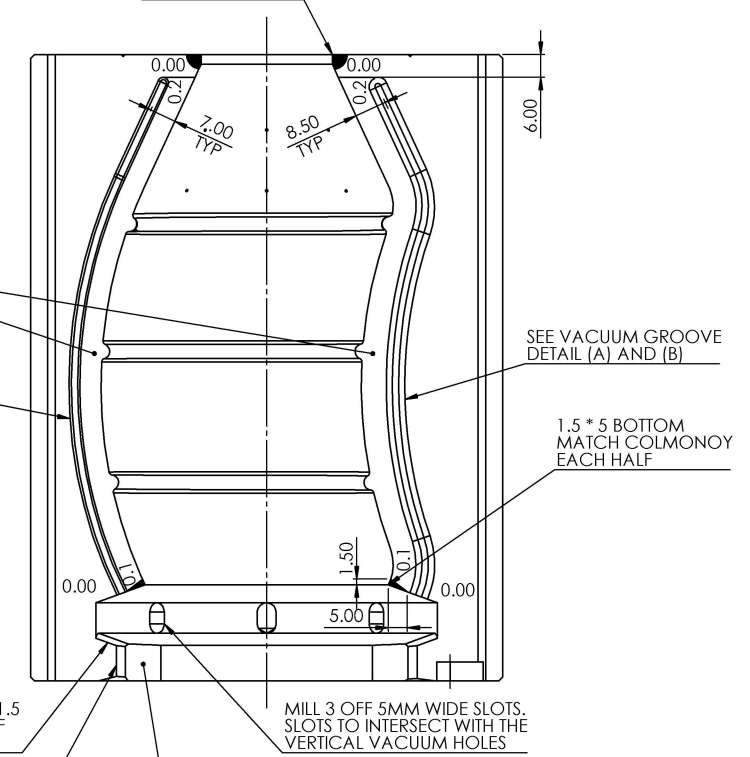


PAD AREA BETWEEN CAVITY  
EDGE AND VACUUM GROOVE  
TO BE TAPER CUT  $0.1+0.03\text{MM}$   
DEEP AT BPL END TO  $0.2+0.03\text{MM}$   
DEEP AT NECK END.

SEE VACUUM GROOVE  
DETAIL (a) AND (b)

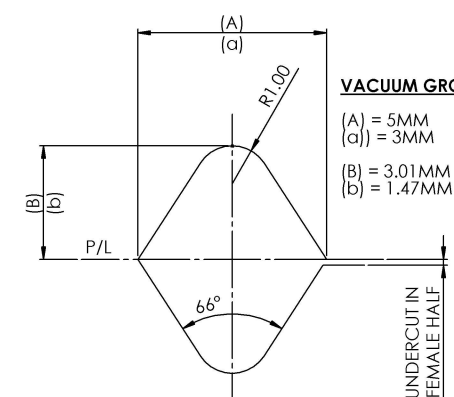
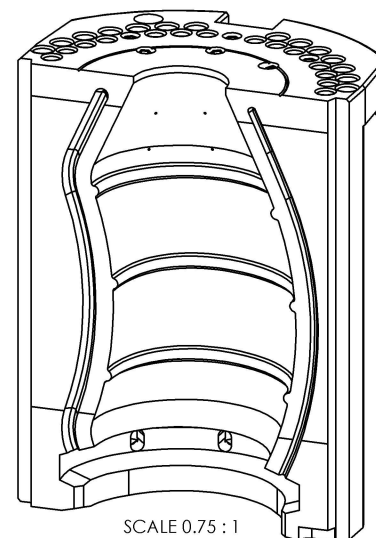
SEE VACUUM GROOVE  
DETAIL (A) AND (B)

1.5 \* 5 BOTTOM  
MATCH COLMONOY  
EACH HALF



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



VACUUM GROOVE DETAIL

$$\begin{aligned} (A) &= 5\text{MM} \\ (a) &= 3\text{MM} \\ (B) &= 3.01\text{MM} \\ (b) &= 1.47\text{MM} \end{aligned}$$

## UNDERCUT IN

## 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:										FINISH		DEBURR AND BREAK SHARP EDGES		DO NOT SCALE DRAWING		REVISION	
NAME		SIGNATURE		DATE								TITLE:  MOULD TOOL					
TS				24/09/22													
CHK'D TS																	
APP'CD																	
MTC																	
Q.A.																	
MATERIAL:								DWG NO.				Mid		A1			
WEIGHT:								SCALE 1:1				SHEET 1 OF 1					