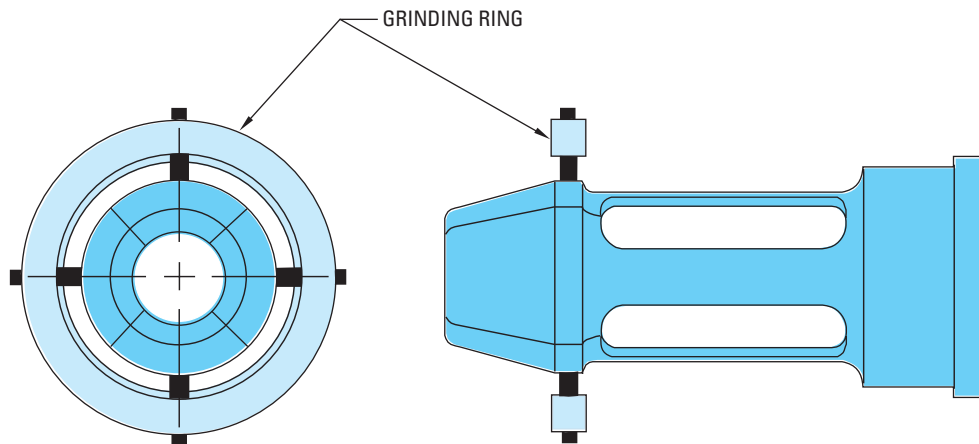


Application Guidelines



The possibilities are almost limitless

- Size Range: The Expandable Cavity is typically designed for parts with outside dimensions of 1/32 to 3 inches, but more custom designs are also available to suit your overall part size or undercut requirements
- Can be designed for retrofit to existing molds
- Can be designed for use in combination with D-M-E Collapsible Cores, Collapsible Mini-Cores, unscrewing cores or straight pull outs for interior of part
- Can be designed in inch or metric sizes

Detailing

Most Expandable Cavity details are usually ground or EDM'd. It is important when grinding to flood tool with suitable coolant for hardened tool steels. Do not grind with a loaded wheel (dress wheel frequently). The wheel must be of a soft grade (60J, 46J, etc.). When grinding make sure the Expandable Cavity is completely closed in a true circle by using the grinding ring supplied, as shown here.

After all finish grinding, polishing and EDM'ing work, be sure to demagnetize the Expandable Cavity to prevent adhesion of any metal particles that might find their way into the cavity during molding.

NOTE: D-M-E does not provide the part configuration detailing or machining. We can direct you to an appropriate source for this service if required.

How to order

The Expandable Cavity is designed and constructed based on part configuration and mold design requirements. For a quotation, copy and fill out the Quote Request Form on the facing page and mail or fax to the address or fax number shown on the form. If you also include a part print and/or mold design, D-M-E can assist you in determining the feasibility of molding with the Expandable Cavity and review your overall mold design.

The Expandable Cavity System may be subject to restrictions in its use for the molding of plastic tamper-indication closures in threaded caps under U.S. Patent No. 5,281,385 of Sunbeam Plastics Corporation. Roehr Tool disclaims any damages or responsibility for the use of its core when used in the method of such patent.