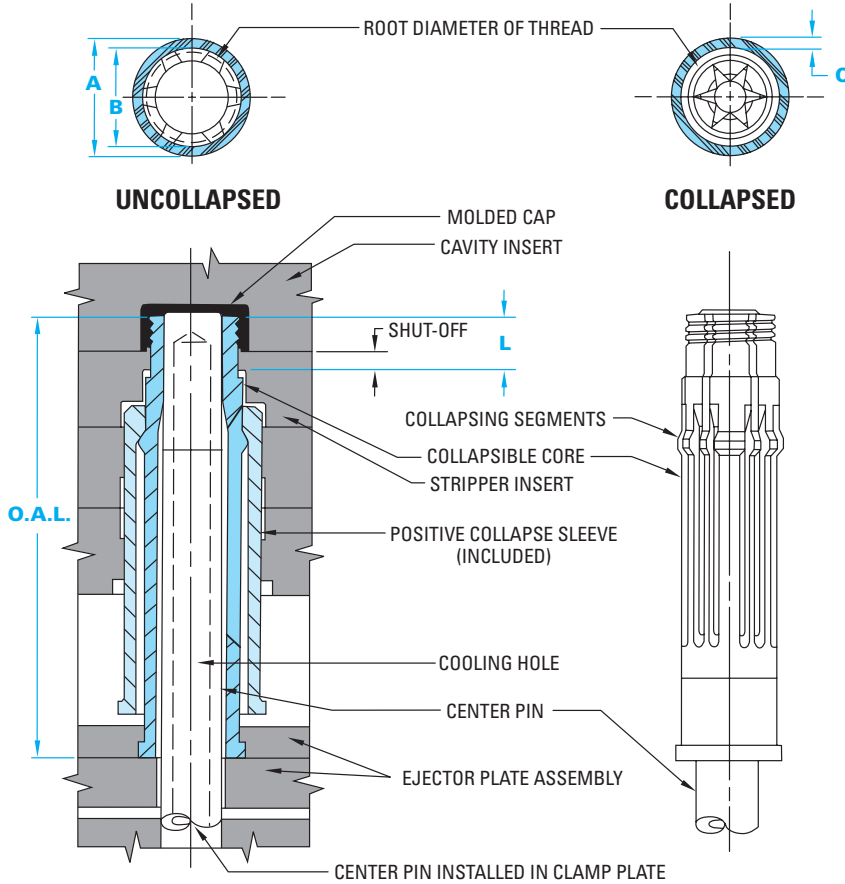


Collapsible Cores – Features and Benefits

U.S. Patent Nos. 3,247,548; 3,660,001
Foreign Patents Issued



Economically produce complex plastic parts

The Collapsible Core is a major breakthrough for molding plastic parts requiring internal threads, undercuts, protrusions or cut-outs. The patented design incorporates only three moving parts, which utilize conventional mold movements.

The Collapsible Core's automatic operation makes it possible for you to produce parts that, previously, had been considered impossible to mold. Parts with internal protrusions, dimples, interrupted threads and cut-outs can now be economically produced on a high- or low-volume basis.

For conventional threaded parts, the Collapsible Core could cut your cycle time up to 30% when compared with unscrewing or other complex actuating mechanisms.

Full technical details, including basic stripper plate mold construction, core grinding instructions, and core and mold machining dimensions are included in the Collapsible Core and Collapsible Mini-Core Design & Assembly Guide – contact D-M-E for a copy.

Collapsible Cores | Features and Benefits

ITEM NUMBER	A MAX O.D. OF THREAD OR CONFIG		B MIN I.D. OF THREAD OR CONFIG		CENTER PIN DIAMETER (AT TOP OF CORE)		L MAX MOLDED LENGTH (INCL MOLD SHUT-OFF)		C COLLAPSE PER SIDE AT TOP OF CORE**				O.A.L. OVERALL LENGTH OF COLLAPSIBLE CORE (ONLY)	
	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	*inch	*mm	inch	mm
CC-125-PC	.720	18.29	.620	15.75	.490	12.45	.800	20.32	.027	.69	.032	.81	5.605	142.37
CC-150-PC	.850	21.59	.700	17.78	.580	14.73	1.000	25.40	.037	.94	.042	1.07	6.615	168.02
CC-175-PC	.970	24.64	.760	19.30	.640	16.26	1.000	25.40	.043	1.09	.048	1.21	6.615	168.02
CC-200-PC	1.270	32.25	.910	23.11	.785	19.93	1.150	29.21	.043	1.09	.048	1.21	7.315	185.80
†CC-250-PC	1.270	32.25	.910	23.11	.785	19.93	1.150	29.21	.043	1.09	.048	1.21	5.440	138.17
CC-202-PC	1.390	35.30	1.010	25.65	.885	22.47	1.150	29.21	.055	1.39	.064	1.62	7.315	185.80
†CC-252-PC	1.390	35.30	1.010	25.65	.885	22.47	1.150	29.21	.055	1.39	.064	1.62	5.440	138.17
CC-302-PC	1.740	44.19	1.270	32.25	1.105	28.06	1.400	35.56	.068	1.72	.083	2.10	7.315	185.80
†CC-352-PC	1.740	44.19	1.270	32.25	1.105	28.06	1.400	35.56	.068	1.72	.083	2.10	6.065	154.05
CC-402-PC	2.182	55.42	1.593	40.46	1.388	35.25	1.700	43.18	.090	2.28	.103	2.61	7.815	198.50
CC-502-PC	2.800	71.12	2.060	52.32	1.750	44.45	1.900	48.26	.115	2.92	.125	3.17	9.625	244.47
CC-602-PC	3.535	89.78	2.610	66.29	2.175	55.24	2.400	60.96	.140	3.55	.148	3.75	11.250	285.75
CC-652-PC	3.800	96.52	2.890	73.41	2.450	62.23	2.400	60.96	.150	3.81	.160	4.06	11.250	285.75
CC-702-PC	4.225	107.31	3.350	85.09	2.875	73.02	2.400	60.96	.165	4.19	.170	4.32	11.250	285.75

† Shorter overall length Collapsible Cores for any application, and particularly where mold shut height is limited.

NOTE: Special Collapsible Cores with molding lengths, special diameters or collapse other than shown in table above will be quoted on request.

* Cores having slightly greater collapse, as shown above, are usually available from stock – contact D-M-E.

** To determine maximum dimension of moldable undercut, reduce the amount of collapse per side shown in the table above by .020 per inch of part height requiring collapse.