

# Collapsible Mini-Cores – Features and Benefits

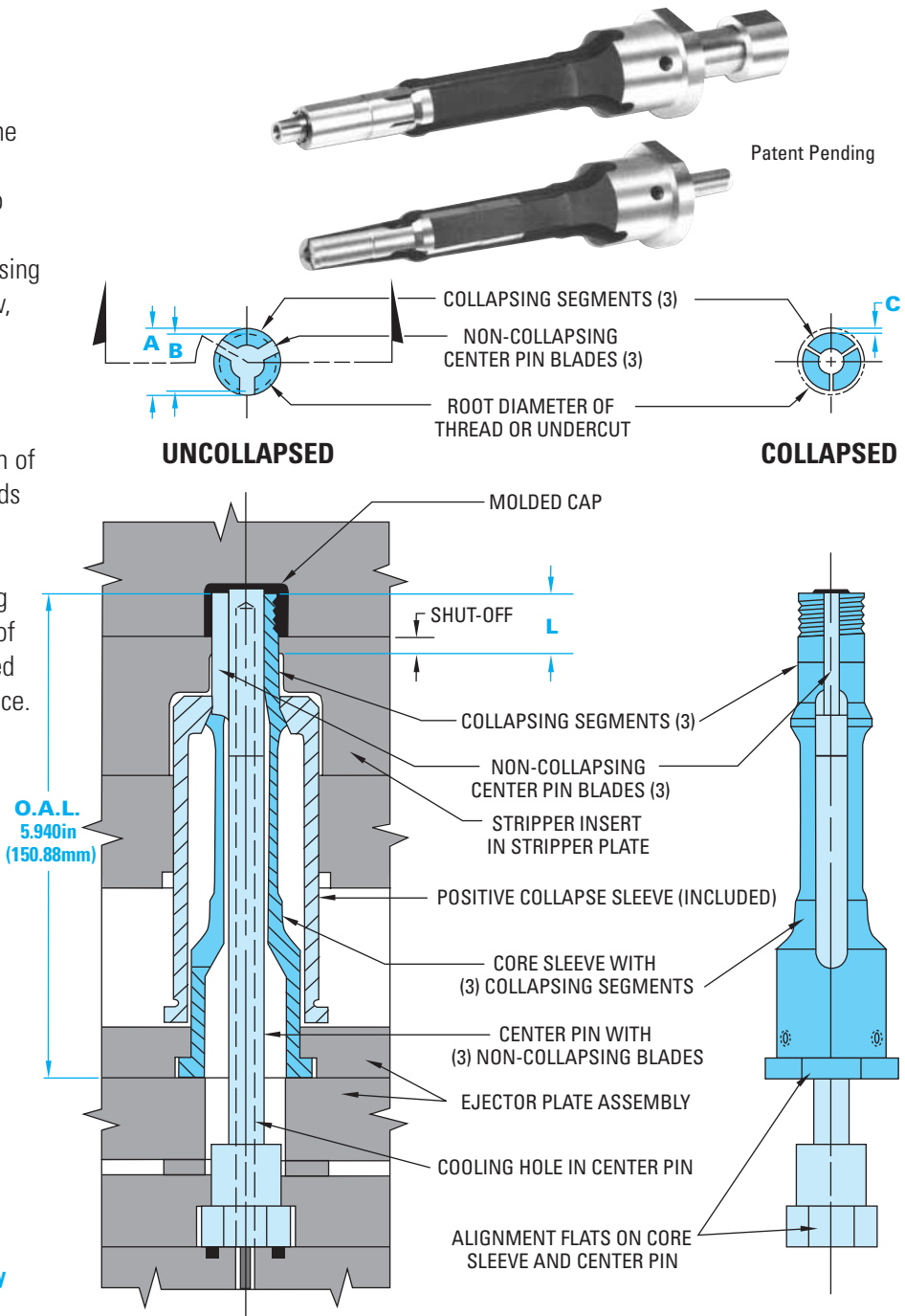
## Easily mold parts with closures as small as 13mm

The Collapsible Mini-Core broadens the applications of collapsible core molds for closures as small as 13mm. Due to the smaller diameters involved, these Mini-Cores employ three larger collapsing segments combined with three narrow, non-collapsing blades, which are an integral part of the center pin.

As a result, up to 80% full threads or undercuts can be molded. The function of the collapsing core also permits threads to stop at any point along the molded length – threads need not run out to the top of the core as with unscrewing molds. If a seal is required in the top of the closure, an undercut can be molded into the part to hold such a seal in place.

The collapsing action also permits a longer threaded area to be formed, without adding to the cycle time or requiring long rack and pinion mechanisms. In addition to threads, other configurations such as dimples, cut-outs or protrusions beyond the capabilities of unscrewing molds can be successfully molded. Three standard sizes of Collapsible Mini-Cores are available, for 13-16, 17-20 and 21-24mm closures.

Full technical details on core grinding and stripper plate mold construction are included in the **Collapsible Core and Collapsible Mini-Core Design & Assembly Guide** – contact D-M-E for a copy.



ITEM NUMBER	FOR CLOSURE DIAMETER RANGE	A MAX O.D. OF THREAD OR CONFIG		B MIN I.D. OF THREAD OR CONFIG		CENTER PIN DIAMETER (AT TOP OF CORE)		WIDTH OF (3) NON-COLLAPSING CENTER OF PIN BLADES (AT TOP OF CORE)		L MAX MOLDED LENGTH (INCL MOLD SHUT-OFF)		C COLLAPSE PER SIDE AT TOP OF CORE*	
	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm
CCM-0001	13-16	.645	16.38	.425	10.80	.300	7.62	.170	4.32	.850	21.59	.052	1.32
CCM-0002	17-20	.805	20.45	.560	14.22	.420	10.67	.190	4.83	.850	21.59	.057	1.45
CCM-0003	21-24	.965	24.51	.710	18.03	.560	14.22	.200	5.08	1.000	25.40	.059	1.50

- NOTES:**
1. Cores listed above include core, center pin, positive collapse sleeve, clamping ring and a special, non-bladed center pin arbor required for proper core grinding.
  2. Collapsible Mini-Cores with longer molding lengths, special diameters, collapse or number of segments will be quoted on request. For larger diameters (up to 3.535"), see Collapsible Cores.

\*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.

View Collapsible Core animation at [www.dme.net/cc](http://www.dme.net/cc)