

D-M-E Small and Shuttle Mold Bases

HIGH-QUALITY, ECONOMICAL
MOLD BASE ASSEMBLIES
FOR PROTOTYPE OR
PRODUCTION RUNS

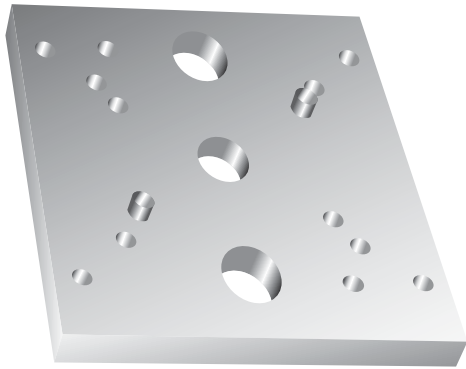
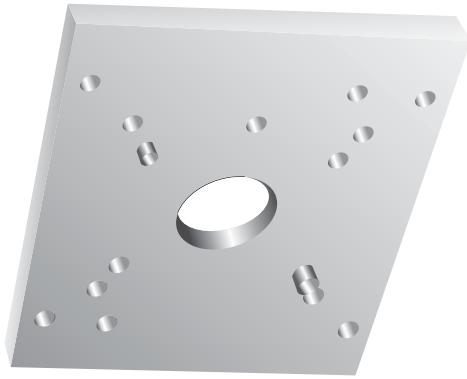


Small and Shuttle Mold Bases

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Small Mold Base Adapter Plates



D-M-E No. 2 Steel

With D-M-E Small Mold Base Adapter Plates You Can.....

Lower your mold costs

Only one set of low cost Adapter Plates is required for each injection molding machine. The Adapter Plates can become a permanent part of your press platen...or can easily be removed to allow installation of larger mold bases. The Adapter Plates can also be moved to another press to meet your production requirements. D-M-E Small Mold Bases provide the highest quality, most economical mold base assemblies for either short runs or production runs. Cavity and support plates are made from D-M-E No. 3 cavity steel.

Change mold bases in minutes

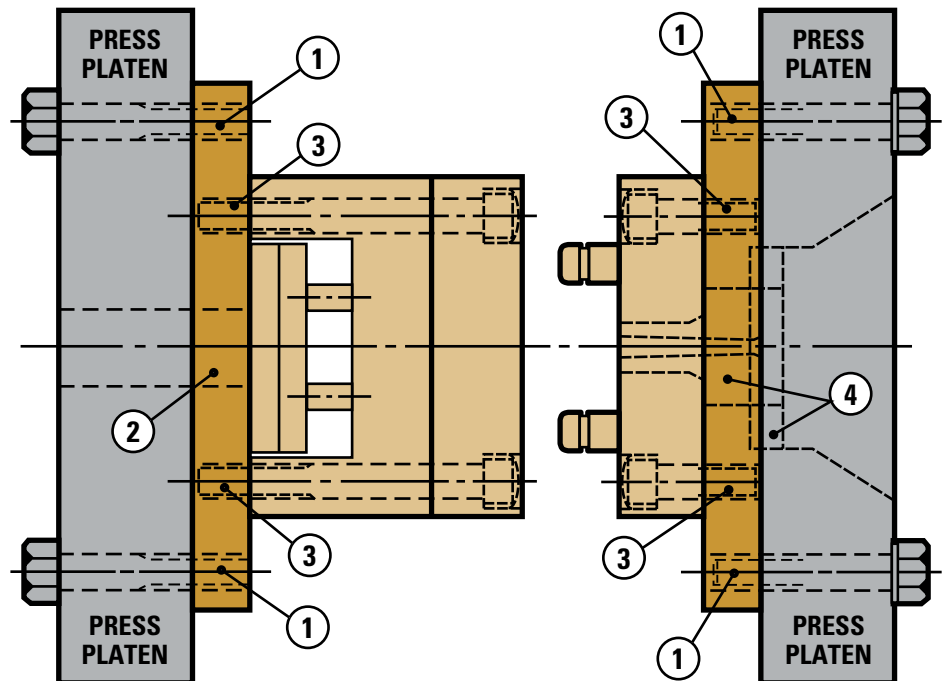
With D-M-E's exclusive Adapter Plate System, standard 5"x 6" U and 5"x 8" U Series Mold Bases can be easily changed in 10 minutes or less. Costly machine downtime is reduced to a minimum.

Increase your profits

The D-M-E's Adapter Plate System provides economic manufacturing for greater profitability. The unique system lends itself to minimum cavity, high-speed cycle operations. Fast interchangeability of mold bases makes short runs just as profitable as long runs... no costly fill-ins!

D-M-E Adapter Plates are:

- ① Pre-drilled and tapped to match platen holes
- ② Pre-machined with clearance holes for knockout rods
- ③ Pre-drilled and tapped to match mounting holes on D-M-E 5"x 6" U series mold bases... with precision dowels for fast, accurate alignment. (One dowel is off-set to prevent improper installation.)
- ④ Completely machined to accommodate your choice of sprue bushing and locating ring.



5" x 8" U 2-Plate Mold Bases - 58U2

These 2 & 3 Plate Assemblies are designed for use with D-M-E Universal Adapter Plates

General Dimensions

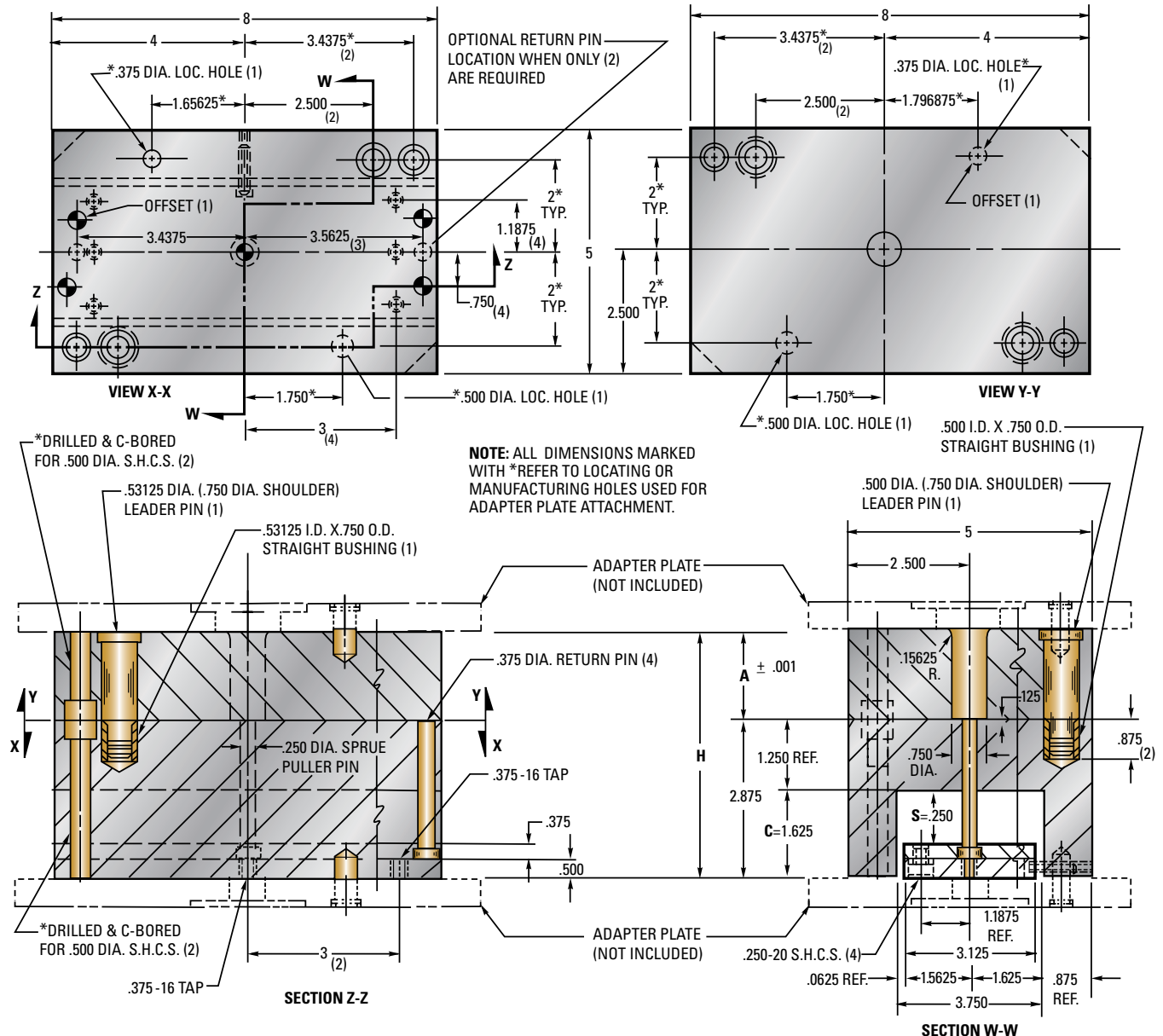
O = Small Dia. of Sprue Bushing
Orifice .15625, .21875 or .28125

R = Spherical Radius of Sprue Bushing .500 or .750 (see item 3 to the right)



WHEN ORDERING PLEASE SPECIFY:

- Quantity & Item Number
- Type of Sprue Bushing ("U", "UV" or "UR" Series) see D-M-E Sprue Bushings
- O & R Dimensions
O = .15625, .21875 or .28125
R = .500 or .750 ("U" Series)
500 ("UV" Series Standard) or .750 ("UV" Series Special)
No spherical radius on "UR" Series
- Method of Shipment



2-Plate Assembly

A	ITEM NUMBER	H	OVERALL ASSEMBLY HEIGHT INCLUDING ADAPTER PLATES	NET WT.
7/8	58U2-7	3 3/4	5 1/2	37
1 3/8	58U2-13	4 1/4	6	43
1 7/8	58U2-17	4 3/4	6 1/2	49

All 2 & 3-Plate assemblies listed are supplied complete with mounting and locating holes to match D-M-E Universal Adapter Plates, and Standard Sprue Bushing specified. Cavity plates are made from D-M-E No. 3 Steel.

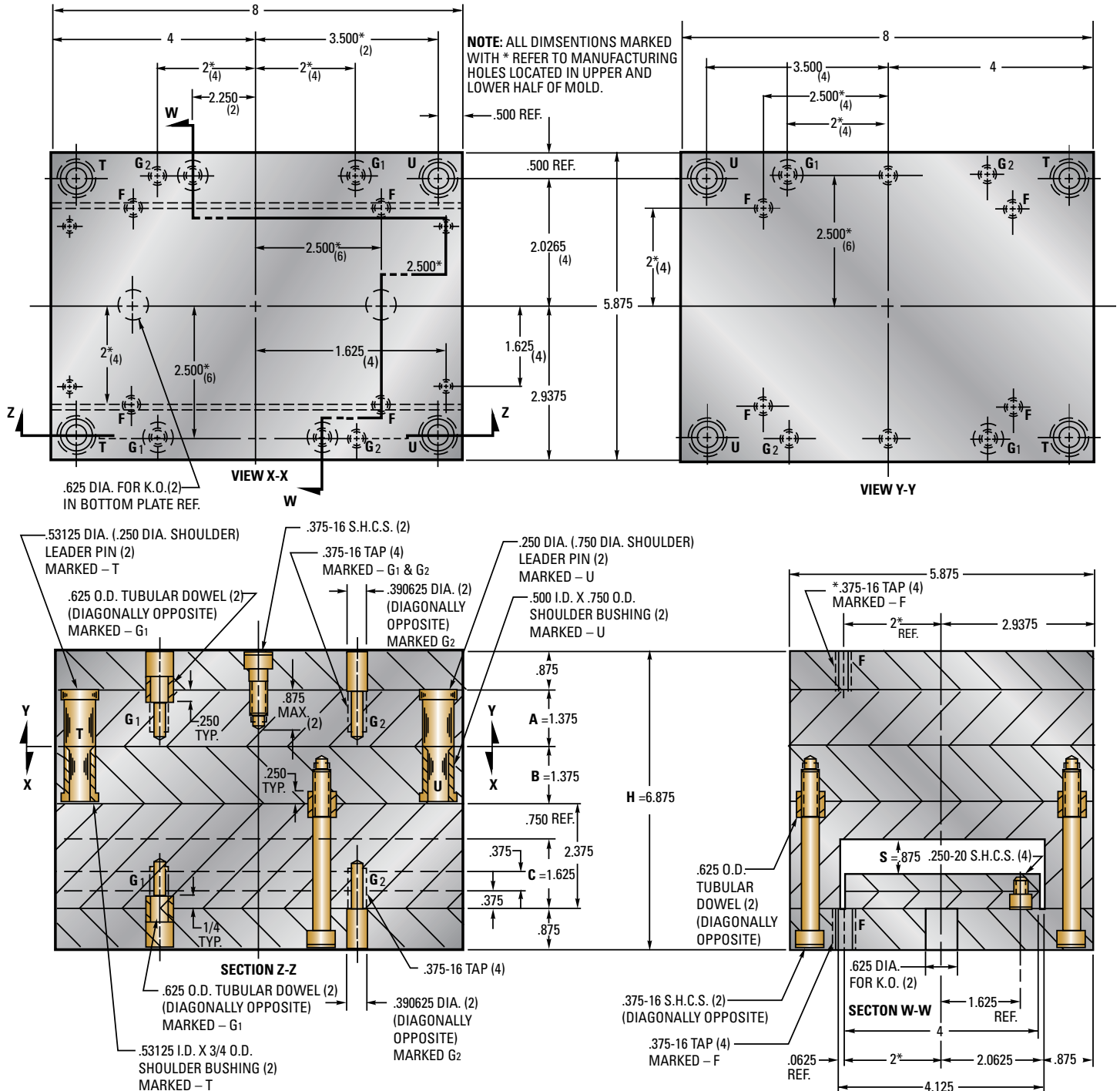
NOTE: For 58U Plates and housings, see Mold Plates section.

5 7/8" x 8" J Mold Bases - 68J

Ejector stroke data

C = (height of riser) = 1 5/8

S = (max stroke of ejector bar) = 7/8



ITEM NUMBER	A	B	C	NET WT.
68J-13-13	1 3/8	1 3/8	1 5/8	84

WHEN ORDERING, PLEASE SPECIFY:

- Quantity
- Item Number
- Method of Shipment

Small and Shuttle Mold Bases | 5 7/8" x 8" J Mold Bases

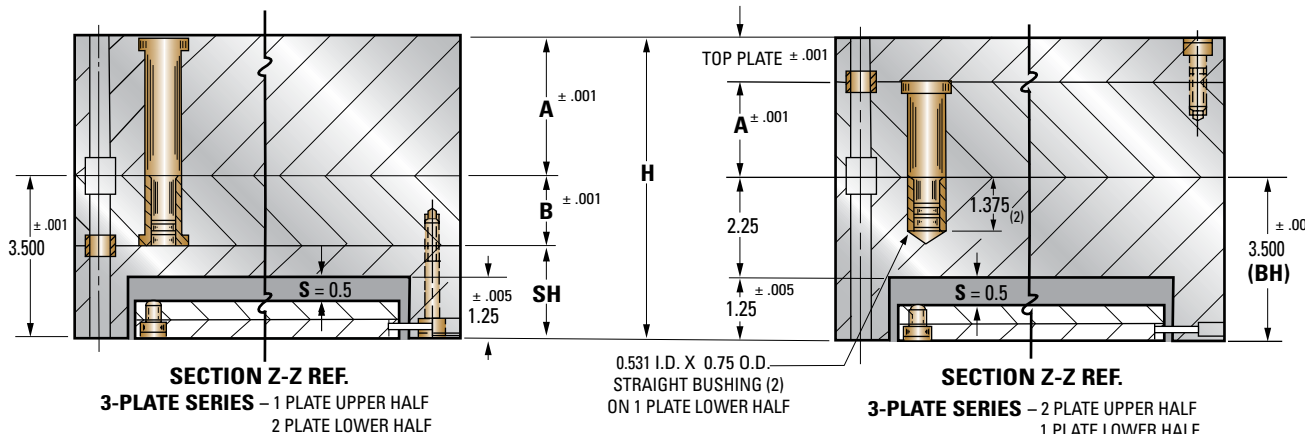
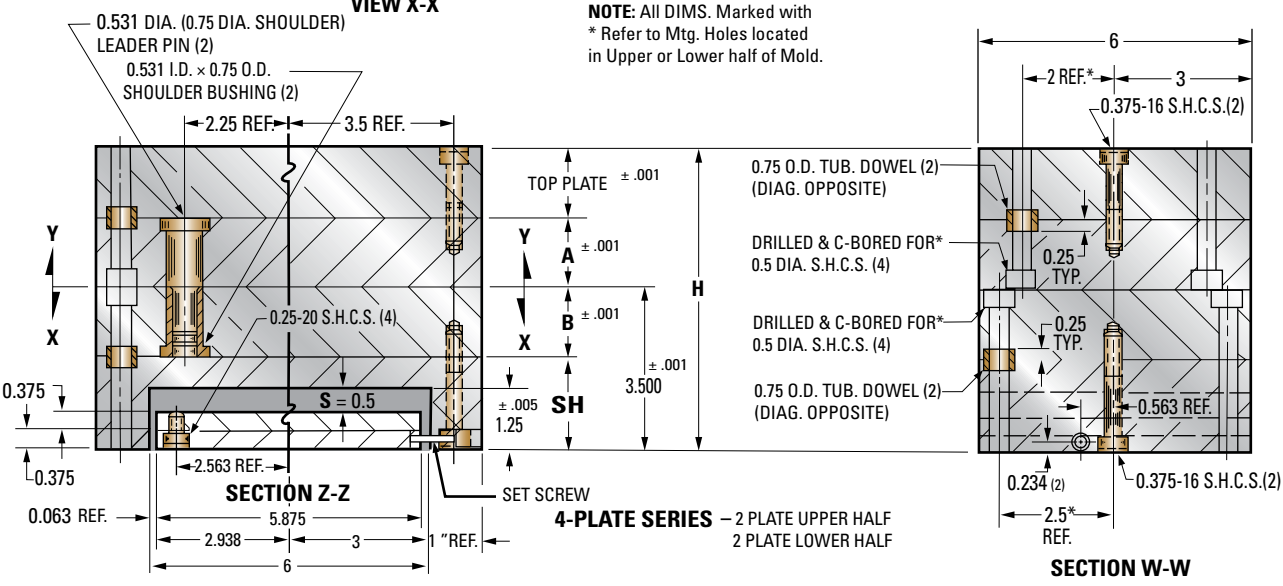
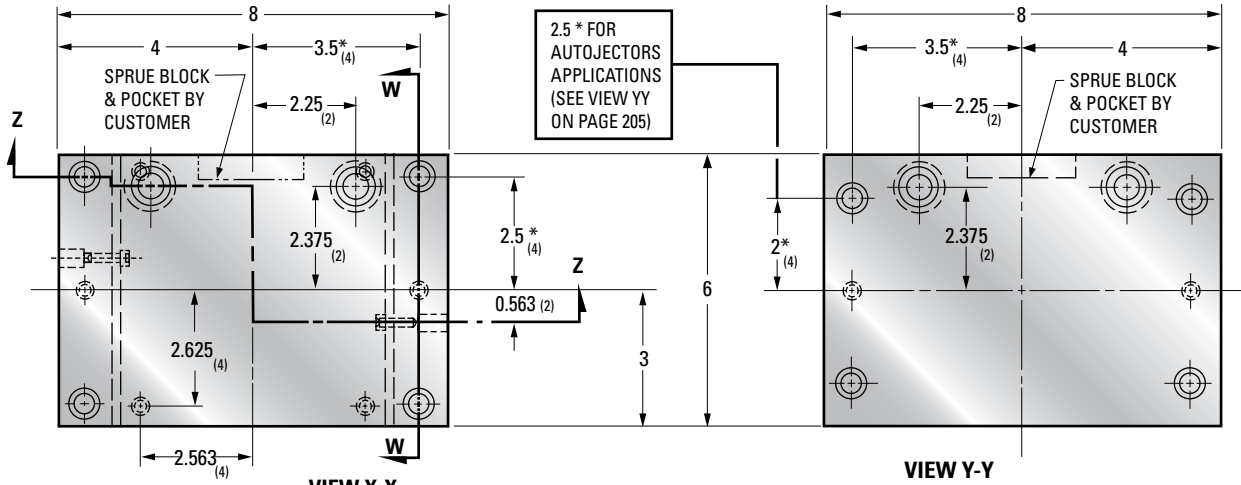
6" x 8" SH Shuttle Mold Bases - 68SH

Engineered and designed for various models of Autojectors, Moslo and Newbury vertical injection presses with shuttle tables.

EJECTOR STROKE DATA

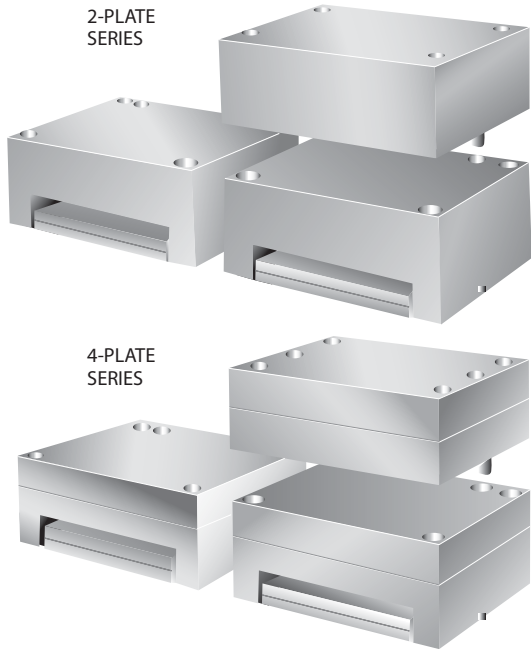
C = (Height of Riser) = 1.25

S = (Max. Stroke of Ejector Bar) = 0.5



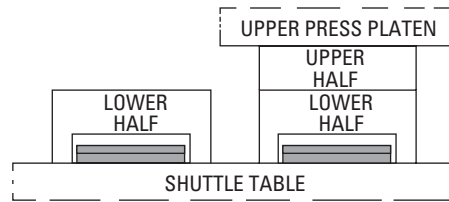
Small and Shuttle Mold Bases | 6" x 8" SH Shuttle Mold Bases

6" x 8" SH Shuttle Mold Bases – 68SH



Shuttle Mold Bases listed below are supplied complete with one upper and two lower sub-assemblies. Upper and lower sub-assemblies are pre-drilled to match platen holes of presses listed in chart. The one piece ejector housings include set screws to securely hold the ejector plates in place during installation or removal.

All plates and housings are made from D-M-E No. 3 Steel (see page 8), except for the ejector and ejector retainer plates.

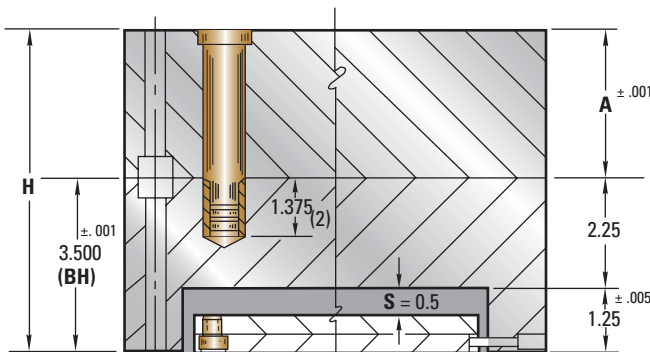


SERIES	TOP PLATE	A	B	BH	SH	H	S	FITS PRESS*	ITEM NUMBER	NET WT.	
2 PLATE	–	2.875	–	3.5	–	6.375	0.5	**AJ-M-N	68SH2-0-27-22-0	124	
3 PLATE	1	1.875	–	3.5	–	6.375	0.5	**AJ-M-N	68SH3-10-17-22-0	124	
	–	2.875	1.375	–	2.125			**AJ-M-N	68SH3-0-27-13-7	124	
4 PLATE	–	1.875	0.875	0.875	–	6.25	0.5	N	68SH4-17-7-7-13	123	
	–	1.875	0.875	1.375	–			N	68SH4-17-7-13-7	123	
	–	1.375	1.375	0.875	–			N	68SH4-13-13-7-13	123	
	–	1.375	1.375	1.375	–	2.125	6.375	0.5	N	68SH4-13-13-13-7	123
	1	1.875	0.875	–	2.625	**AJ-M-N			68SH4-10-17-7-13	124	
	1	1.875	1.375	–	2.125	**AJ-M-N			68SH4-10-17-13-7	124	
	1	2	1.375	–	2.125	AJ-N			68SH4-10-20-13-7	126	

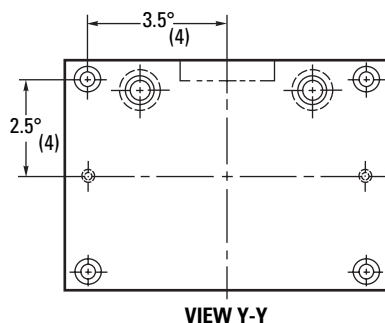
*AJ = Autojectors M = Moslo N = Newbury

NOTE: For 68SH Components, see D-M-E's Mold Components catalog.

**NOTE: Autojector applications with 6.375 H dimension require a 0.125" thick spacer for upper half (check with molder; machine may be equipped with required spacer).



SECTION Z-Z REF.
2-PLATE SERIES – 1 PLATE UPPER HALF
1 PLATE LOWER HALF



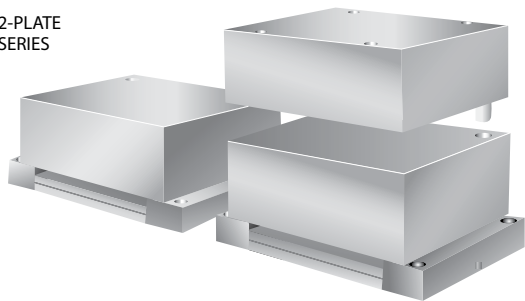
ALTERNATIVE UPPER HALF MOUNTING HOLES PROVIDED ONLY WHEN AUTOJECTORS APPLICATION IS SPECIFIED (SEE ITEM 3 BELOW).

WHEN ORDERING, PLEASE SPECIFY:

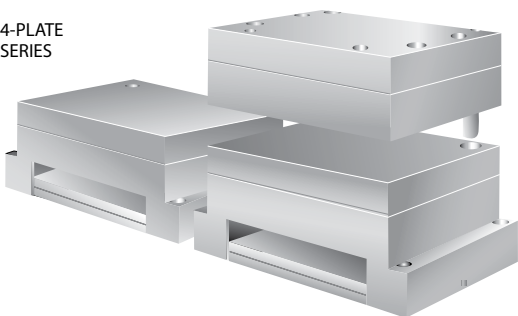
1. Quantity
2. Item Number
3. Mounting Hole Requirement: Standard or Autojectors
4. Method of Shipment

8" x 9 7/8" SH Shuttle Mold Bases – 810SH

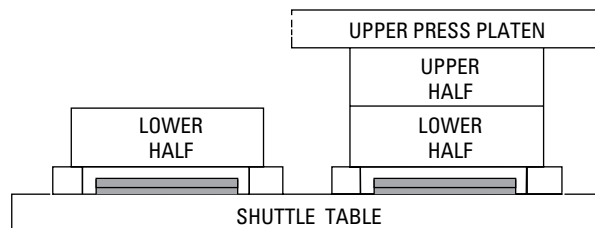
2-PLATE SERIES



4-PLATE SERIES



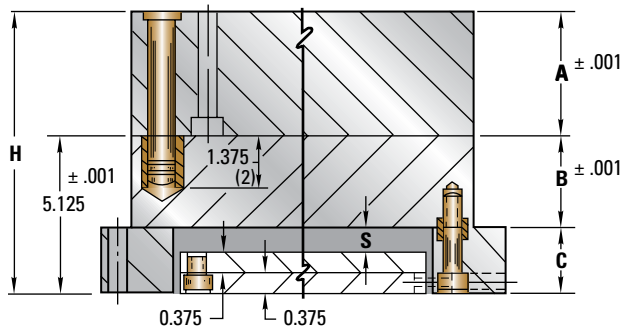
Shuttle Mold Bases listed below are supplied complete with one upper and two lower sub-assemblies. Upper and lower sub-assemblies are pre-drilled to match platen holes of presses listed in chart. Solid rails (spacer blocks) extend beyond support or cavity plate for ease of installation in press.



SERIES	TOP PLATE	A	B	SUPP. PLATE	C	H	S	FITS PRESS*	ITEM NUMBER	NET WT.
2 PLATE	–	3.375	3.875	–	1.25	8.5	0.5	** AJ-M-N RD-V	810SH2-0-33-37-0	298
	1	2.375	3.875	–	1.25		0.5		810SH3-10-23-37-0	298
3 PLATE	–	3.375	1.375	1.875	1.875	8.5	1	** AJ-M-N RD-V	810SH3-0-33-13-17	286
	–	3.375	1.875	1.375					810SH3-0-33-17-13	286
	–	3.375	2.375	0.875					810SH3-0-33-23-7	286
	–	3.375	0.875	2.375					810SH4-23-7-7-23	284
4 PLATE	2.375	0.875	1.375	1.875	1.875	8.375	1	N-RD-V	810SH4-23-7-13-17	284
	2.375	0.875	1.375	1.875				N-RD-V	810SH4-17-13-13-17	284
	1.875	1.375	1.375	1.875				N-RD-V	810SH4-17-13-17-13	284
	1.875	1.375	1.875	1.375				N-RD-V	810SH4-17-13-23-7	284
	1.875	1.375	1.875	1.375				N-RD-V	810SH4-13-17-17-13	284
	1.375	1.875	1.875	1.375				N-RD-V	810SH4-10-23-13-17	286
	1	2.375	1.875	1.375		8.5	1	** AJ-M N-RD-V	810SH4-10-23-17-13	286
	1	2.375	1.875	1.375				810SH4-10-23-23-7	286	
	1	2.375	2.375	0.875						
	1	2.375	2.375	0.875						

*AJ = Autojectors M = Moslo N = Newbury RD = Reed V = Van Dorn

** NOTE: All Autojector applications require a 0.5" thick spacer for upper half (check with molder; machine may be equipped with required spacer).



SECTION Z-Z REF.
2-PLATE SERIES – 1 PLATE UPPER HALF
1 PLATE LOWER HALF

AVAILABLE IN:

- D-M-E No. 1 or No. 3 Steel

NO. 3 STEEL ASSEMBLY

- "A" and "B" Plate - No. 3 Steel
- Top & Support Plates - No. 2 Steel

WHEN ORDERING, PLEASE SPECIFY:

1. Quantity & Item Number
2. No. 1 or No. 3 Steel
3. Method of Shipment

Metric Equivalents and Conversions

Equivalents: Inch, fraction, decimal, millimeter

INCHES	MILLIMETERS	INCHES	MILLIMETERS
1	25.4	34	863.6
2	50.8	35	889.0
3	76.2	36	914.4
4	101.6	37	939.8
5	127.0	38	965.2
6	152.4	39	990.6
7	177.8	40	1016.0
8	203.2	41	1041.4
9	228.6	42	1066.8
10	254.0	43	1092.2
11	279.4	44	1117.6
12	304.8	45	1143.0
13	330.2	46	1168.4
14	355.6	47	1193.8
15	381.0	48	1219.2
16	406.4	49	1244.6
17	431.8	50	1270.0
18	457.2	51	1295.4
19	482.6	52	1320.8
20	508.0	53	1346.2
21	533.4	54	1371.6
22	558.8	55	1397.0
23	584.2	56	1422.4
24	609.6	57	1447.8
25	635.0	58	1473.2
26	660.4	59	1498.6
27	685.8	60	1524.0
28	711.2	61	1549.4
29	736.6	62	1574.8
30	762.0	63	1600.2
31	787.4	64	1625.6
32	812.8	65	1651.0
33	838.2	66	1676.4

INCHES		MILLIMETERS	INCHES		MILLIMETERS
1/64	0.015625	0.396875	33/64	0.515625	13.096875
1/32	0.031250	0.793750	17/32	0.531250	13.493750
3/64	0.046875	1.190625	35/64	0.546875	13.890625
1/16	0.062500	1.587500	9/16	0.562500	14.287500
5/64	0.078125	1.984375	37/64	0.578125	14.684375
3/32	0.093750	2.381250	19/32	0.593750	15.081250
7/64	0.109375	2.778125	39/64	0.609375	15.478125
1/8	0.125000	3.175000	5/8	0.625000	15.875000
9/64	0.140625	3.571875	41/64	0.640625	16.271875
5/32	0.156250	3.968750	21/32	0.656250	16.668750
11/64	0.171875	4.365625	43/64	0.671875	17.065625
3/16	0.187500	4.762500	11/16	0.687500	17.462500
13/64	0.203125	5.159375	45/64	0.703125	17.859375
7/32	0.218750	5.556250	23/32	0.718750	18.256250
15/64	0.234375	5.953125	47/64	0.734375	18.653125
1/4	0.250000	6.350000	3/4	0.750000	19.050000
17/64	0.265625	6.746875	49/64	0.765625	19.446875
9/32	0.281250	7.143750	25/32	0.781250	19.843750
19/64	0.296875	7.540625	51/64	0.796875	20.240625
5/16	0.312500	7.937500	13/16	0.812500	20.637500
21/64	0.328125	8.334375	53/64	0.828125	21.034375
11/32	0.343750	8.731250	27/32	0.843750	21.431250
23/64	0.359375	9.128125	55/64	0.859375	21.828125
3/8	0.375000	9.525000	7/8	0.875000	22.225000
25/64	0.390625	9.921875	57/64	0.890625	22.621875
13/32	0.406250	10.318750	29/32	0.906250	23.018750
27/64	0.421875	10.715625	59/64	0.921875	23.415625
7/16	0.437500	11.112500	15/16	0.937500	23.812500
29/64	0.453125	11.509375	61/64	0.953125	24.209375
15/32	0.468750	11.906250	31/32	0.968750	24.606250
31/64	0.484375	12.303125	63/64	0.984375	25.003125
1/2	0.500000	12.700000	1	1.000000	25.400000

Equivalents: Decimal, millimeter

INCHES	MILLIMETERS	INCHES	MILLIMETERS	INCHES	MILLIMETERS
0.001	0.0254	0.01	0.254	0.1	2.54
0.002	0.0508	0.02	0.508	0.2	5.08
0.003	0.0762	0.03	0.762	0.3	7.62
0.004	0.1016	0.04	1.016	0.4	10.16
0.005	0.1270	0.05	1.270	0.5	12.70
0.006	0.1524	0.06	1.524	0.6	15.24
0.007	0.1778	0.07	1.778	0.7	17.78
0.008	0.2032	0.08	2.032	0.8	20.32
0.009	0.2286	0.09	2.286	0.9	22.86

Measurement conversions

MULTIPLY BY	FROM	TO	MULTIPLY BY
	← TO	← FROM	
0.03937	inch	millimeter	25.4
0.0016	inch ²	millimeter ²	645.16
0.061	inch ³	centimeter ³	16.3871
0.2642	gallon (U.S.)	liter	3.7854
0.03527	oz. (avdp.)	gram	28.3495
2.2044	pound	kilogram	0.4536
62.43	lbs/ft ³	g/cm ³	0.0160
0.145	psi	kPa	6.8948
14.2247	psi	kg/cm ²	0.0703
1.8°C + 32	°F	°C	(°F-32)/1.8