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MOULD DESIGN ASSLY.

MATERIAL OF THE COMPONENT : PP
SHRINKAGE CONSIDERED : 1.5%
MACHINED SELECTED : SP-180
CALCULATED TONNAGE : 35 Tons
SELECTED MOULD BASE(D-M-E) : N4050 (396X496 mm)
MOULD BASE SPECIFICATION AS PER D-M-E STANDARD : N 4050 SF-106-56/5 106
DISTANCE BETWEEN TIE BARS : 430X430 mm
SHUT HEIGHT OF THE MOULD : 396 mm
NUMBER OF CAVITIES : 4
SHOT WEIGHT (For 4 cavities including sprue & runners) : 56 gm.

DET.NO.	DESCRIPTION	MAT'L.	QTY.	FINISHED SIZE	D-M-E STD. CODE NO.
70					
69					
68					
67	HOSE NIPPLE	STD	08	–	SST-14-1/4 K
66	BRASS EXTENSION PIPE	STD	08	–	BSS-1415

DET.NO.	DESCRIPTION	MAT'L.	QTY.	FINISHED SIZE	HARDNESS
65	COMPRESSION SPRING	STD	08	T4010/32x127(HASCO-STD)	
64	WASHER	STD	04	ø18	–
63	LOCK NUT	STD	04	M16	–
62	NUT	STD	04	M16	–
61	STUD	STD	04	M16X200	–
60	DOWELL PIN	STD	04	ø3X25	–
59	DOWELL PIN	STD	08	ø6X30	–
58	C.S.K.SCREW	STD	08	M4X10	–
57	C.S.K.SCREW	STD	16	M6X15	–
56	S.H.C.SCREW	STD	06	M8X20	–
55	S.H.C.SCREW	STD	08	M8X25	–
54	S.H.C.SCREW	STD	08	M8X30	–
53	S.H.C.SCREW	STD	04	M8X35	–
52	S.H.C.SCREW	STD	02	M8X15	–
51	S.H.C.SCREW	STD	04	M8x20	–
50	S.H.C.SCREW	STD	04	M8x20	–
49	S.H.C.SCREW	STD	04	M10x40	–
48	S.H.C.SCREW	STD	01	M12x40	–
47	S.H.C.SCREW	STD	06	M16X60	–
46	S.H.C.SCREW	STD	06	M16X210	–
45					
44					
43					
42	STOPPER PLATE	MS.	02	254X212X20	40-42 Hrc
41	SUPPORT PILLAR	MS.	04	ø60X106	–
40					
39					
38	STRIPPER PLATE	EN-24	01	254X212X20	40-42 Hrc
37					
36	CAVITY INSERT	STAVAX ESR	04	132X122X76	30-32 Hrc
35					
34					
33					
32	CORE PIN	[illegible]	04	ø10X89	45-50 Hrc
31	CORE INSERT	[illegible]	04	ø66X99	45-50 Hrc
30	CORE PIN-SMALL	[illegible]	04	ø5XX66	45-50 Hrc
29	SIDE CORE	[illegible]	04	69X44X31	45-50 Hrc
28					
27	STRIPPER BOLT	OHNS	04	ø20X160.5	50-52 Hrc
26	EJ.GUIDE BUSH	OHNS	04	ø36X40	50-52 Hrc
25	EJ.GUIDER PILLAR	OHNS	04	ø30X162	50-52 Hrc
24	WEAR PLATE	OHNS	04	85X70X10	50-52 Hrc
23	WEDGE BLOCK	OHNS	02	80X50X25	50-52 Hrc
22	FINGER CAM	OHNS	02	ø34X214	50-52 Hrc
21	SPRUE PULLAR	OHNS	05	ø20X60	50-52 Hrc
20	SLIDER GUIDE	OHNS	04	95X30X20	50-52 Hrc
19	SLIDER	OHNS	02	207X81X67	50-52 Hrc

DET.NO.	DESCRIPTION	MAT'L.	QTY.	FINISHED SIZE	D-M-E STD. CODE NO.
18-A	INTER LOCK-FEMALE	STD	04	ø25X31	FT25-31
18	INTER LOCK-MALE	STD	04	ø25X31	MT25-31
17	STOP BUTTON	STD	08	ø26X4	–
16	PARALLEL BLOCKS	STD	02	496X56X106	N30-106-4050/5
15	KNOCKOUT ROD	STD	01	ø60X63	–
14	EJECTOR PIN	STD	04	ø2X212	EC2-250
13	EJECTOR PIN	STD	12	ø4X216	AH4-250
12	LOCATING RING	STD	01	ø175X15	–
11	SPRUE BUSH	STD	01	ø25X136	–
10	RETURN PIN	STD	04	ø18X192	–
09	GUIDE BUSH	STD	04	ø42X56	FBN-34-56
08	GUIDE PILLAR	STD	04	ø34X252	FSN 34-106-146
07	EJECTOR BACK PLATE	STD	01	496X280X26	N50-26-4050/5
06	EJECTOR PLATE	STD	01	496X280X16	N40-16-4050/5
05	CORE BACK PLATE	STD	01	496X396X56	N20-4050-56/5
04	CORE BLOCK	STD	01	496X396X56	N10-4050-56/5
03	CAVITY BLOCK	STD	01	496x396x106	N10-4050-106/5
02	BOTTOM PLATE	STD	01	496x396x36	N01-4050-36/5
01	TOP PLATE	STD	01	496x396x36	N02-4050-36/5

CO-ORDINATE TABLE FOR CORE BLOCK

SL.NO:	'X'-Ref.	'Y'-Ref.	DESCRIPTION
1	-170.0	220.0	ø42H7 Thru hole &ø48 X 6mm deep from bottom. (GB-GUIDE BUSH)
2	170.0	220.0	
3	170.0	-220.0	
4	-170.0	-220.0	
5	-125.0	230.0	ø18H7 Thru hole. (RP-RETURN PIN)
6	125.0	230.0	
7	125.0	-230.0	
8	-125.0	-230.0	
9	-114.0	208.0	ø6H7 X 16mm deep from top. (DP-DOWELL PIN)
10	114.0	208.0	
11	114.0	132.0	
12	-114.0	132.0	
13	-114.0	-132.0	
14	114.0	-132.0	
15	114.0	-208.0	
16	-114.0	-208.0	
17	-112.0	91.0	ø20H7 Thru hole. (SB-STRIPPER BOLT)
18	112.0	91.0	
19	112.0	-91.0	
20	-112.0	-91.0	
21	-71.0	66.0	ø60H7 Thru & ø67 X 6mm deep from bottom. (CI-CORE INSERT)
22	71.0	66.0	
23	71.0	-66.0	
24	-71.0	-66.0	
25	-71.0	21.0	ø12H7 Thru hole &ø20 X 7mm deep from bottom. (SP-SPRUE PULLER)
26	71.0	21.0	
27	0.0	0.0	
28	-71.0	-21.0	
29	71.0	-21.0	
30	-170.0	166.0	M16 Tap X 30mm deep from bootom.
31	170.0	166.0	
32	170.0	0.0	
33	-170.0	0.0	
34	-170.0	-166.0	
35	170.0	-166.0	
60	-179.0	126.0	ø8 Thru hole,ø25 X 31.5mm deep from top&ø12 X 8mm deep from bottom. (IL-INTER LOCK)
61	179.0	126.0	
62	179.0	-126.0	
63	-179.0	-126.0	

SCALE : | PREPARED BY | PROJECTION : | DATE | CHECKED | APPROVED
SHT. No. | No. OFF SHEETS
TITLE AEROSOL CAP – 52.0 DIA
REF. MEMO No. & DATE of
DRG. No. ––

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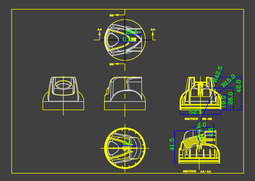
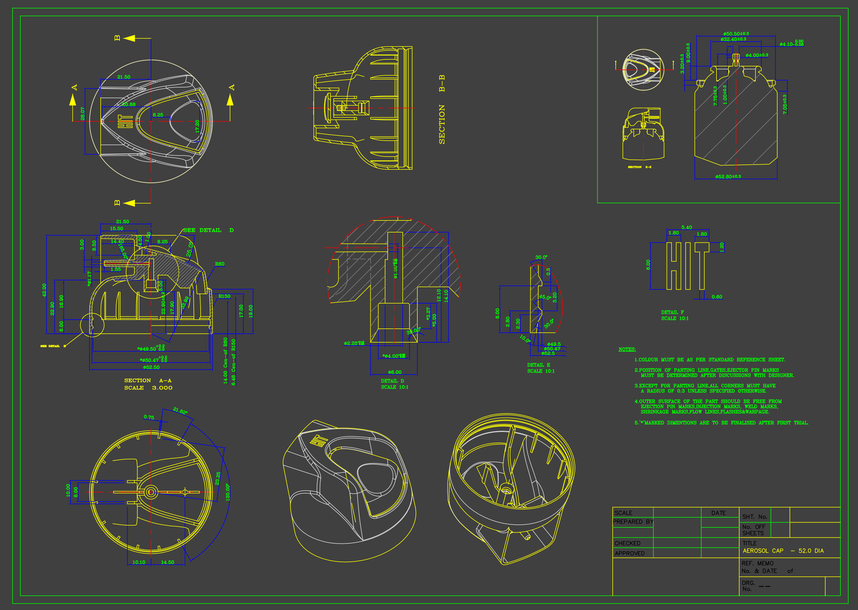
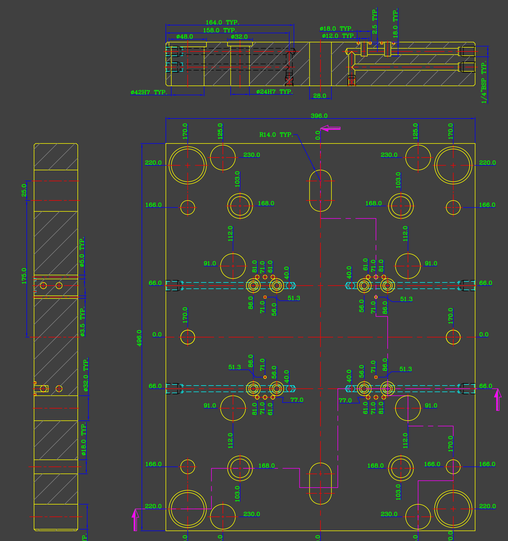
COMPONENT DRAWING



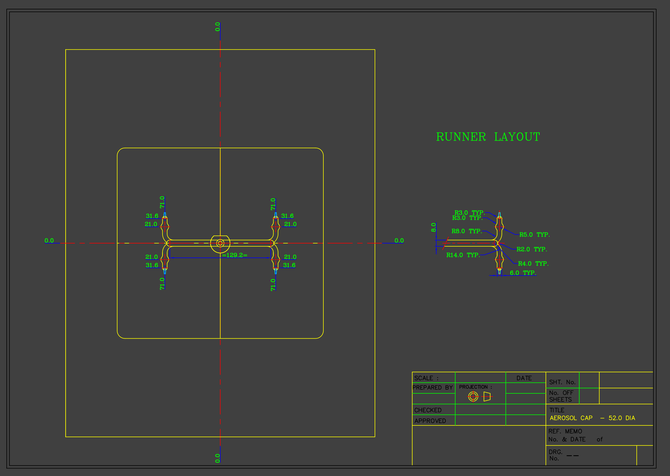


SCALE :		DATE :	SHT. No.
PREPARED BY :			No. OFF SHEETS :
CHECKED :			TITLE : AEROSOL CAP – 52.0 DIA
APPROVED :			REF. MEMO No. & DATE of
			DRG. No. – –



SR.	CORE BACK PLATE	QTY.	01	MOULD MATERIAL
DWT.NO.	DESCRIPTION	MAT'L QTY.	D-M-E STD.CODE NO.	

SCALE :		DATE :	SHT. No.
PREPARED BY :	PROJECTION		No. OFF SHEETS :
CHECKED :			TITLE : AEROSOL CAP – 52.0 DIA
APPROVED :			REF. MEMO No. & DATE of
			DRG. No. – –



SCALE :		DATE :	SHT. No.
PREPARED BY :	PROJECTION		No. OFF SHEETS :
CHECKED :			TITLE : AEROSOL CAP – 52.0 DIA
APPROVED :			REF. MEMO No. & DATE of
			DRG. No. – –