DME STANDARD TOLERANCES

DME Standard Tolerances are stated below. For any special tolerances, please send your requests for review. Unless otherwise requested these Standard Tolerances will apply.

All dimensions are in Inches.

MOLD PLATES

1) FINISH GROUND MOLD PLATE
   Length and Width = -0.000 / +0.005
   Thickness = -0.001 / +0.001
   Flatness = 0.0007/ ft
   Parallelism = 0.0005
   Chamfer = 0.060 X45* TYP / 0.100X45* TYP

2) RGM MOLD PLATE
   Length and Width = -0.000 / +0.005
   Thickness = +0.015 / +0.020 (PLATES SIZES 88-812; 108-1016; 1112-1118; 1212-1215; 1315-1318;1518)
   Thickness = +0.023 / +0.031 (ALL OTHER STD. SIZES)
   Flatness = 0.002/ ft
   Parallelism = 0.003
   Chamfer = 0.095 X45* TYP / 0.125X45* TYP

3) LARGE MOLD PLATE
   Length and Width = -0.000 / +0.020
   Thickness = 0.000 / +0.010 (RGM CONDITION)

4) EJECTOR PLATE
   Length= -0.030 / -0.045
   Width = -0.010 / 0.000
   Thickness= -0.001/ +0.001
   Flatness= 0.001/ ft
   Parallelism= 0.001
   Chamfer = 0.050X45* TYP Minimum

5) EJECTOR RETAINER PLATE
   Length= -0.030 / -0.045
   Width = -0.010 / 0.000
   Thickness= 0.000/ +0.015 (RGM CONDITION)
   Flatness= 0.005/ ft
   Parallelism= 0.005
   Chamfer = 0.050X45* TYP Minimum

6) SPACER BLOCK
   Length = -0.000 / +0.005
   C (Riser Height) = -0.001 / +0.001 (FINISH GROUND)
   P (Width) = -0.000 / +0.015

7) DIE BLOCK
   Thickness, Width and Length = +0.050 / 0.060

MOLD BASE FEATURE

1) LEADER PIN
   Diameter = (Nominal) +0.0006/ +0.0011
   Depth= +0.005/ +0.030
   Alignment= -0.001 /+0.001
   Location= -0.001 /+0.001

2) BUSHINGS
   Diameter = (Nominal) +0.0004/ +0.0008
   Depth= +0.005/ +0.030
   Alignment= -0.001 /+0.001
   Location= -0.001 /+0.001

3) LOCATING RING
   Diameter = (Nominal) -0.006/ +0.004
   Depth= -0.000/ +0.015
   Alignment= -0.002 /+0.002
   Location= -0.002 /+0.002

4) SPRUE BUSHING
   Diameter = (Nominal) +0.0003/ +0.0011
   Depth= -0.000/ +0.010
   Alignment= -0.002 /+0.002
   Location= -0.002 /+0.002

5) SPRUE PULLER PIN
   Diameter = (Nominal) +0.001/ +0.002
   Depth= (Nominal +0.001) +0.005/-0.000
   Alignment= -0.002 /+0.002
   Location= -0.002 /+0.002

6) ASSEMBLY BOLT
   Diameter = (Nominal +1/32) -0.020 /+0.020
   Depth= (Nominal) -0.000/+0.030
   Alignment= -0.003 /+0.003
   Location= -0.003 /+0.003

7) TUBULAR DOWEL
   Diameter = +0.0008/ +0.0030
   Depth= -0.000/+0.025
   Alignment= -0.001 /+0.001
   Location= -0.003 /+0.003

8) SOLID DOWEL
   Diameter = +0.0008/ +0.0030
   Depth= -0.000/+0.030
   Alignment= -0.001 /+0.001
   Location= -0.003 /+0.003

9) SHOULDER BOLT
   Diameter = -0.000/ +0.001
   Depth= -0.000/+0.030
   Alignment= -0.001 /+0.001
   Location= -0.003 /+0.003

10) RETURN PIN
   Diameter = +0.002/ +0.004
   Depth= -0.000/+0.005
   Alignment= -0.001 /+0.001
   Location= -0.001 /+0.001

11) RETURN PIN / CLEARANCE
Diameter = (Nominal +0.015) -0.004/+0.010
Alignment= -0.001 /+0.001
Location= -0.001 /+0.001

12) STOP BUTTON
Diameter = -0.0001/ +0.0005
Location= -0.015 /+0.015

13) GUIDED EJECTION
Diameter = +0.0003/+0.0011
Depth= CB DEPTH +0.005/+0.030
Location= -0.001 /+0.001

14) EJECTOR PIN MACHINING TOLERANCE (CLEARANCE, REAM, COUNTER BORE)
Diameter = +0.0005/+0.001
Location= -0.001 /+0.001

15) CORE PIN MACHINING TOLERANCE (CLEARANCE, REAM, COUNTER BORE)
Diameter = +0.0005/+0.001
Location= -0.001 /+0.001

16) SLEEVE PIN MACHINING TOLERANCE (CLEARANCE, REAM, COUNTER BORE)
Diameter = +0.0005/+0.001
Location= -0.001 /+0.001

17) EYE BOLT HOLES (TAP DRILL SIZE, DIAMETER AND DEPTH)
Diameter = -0.00/+0.06
Location= -0.001 /+0.001

18) FINISH POCKET

Length and Width = -0.001 /+0.001
Depth = -0.001 /+0.001
Angle= -0.001 /+0.001
Alignment = -0.0005 /+0.0005
Location= -0.0005 /+0.0005

19) FINISH BORE

Diameter = -0.001/ +0.001
Depth= -0.001/+0.001
Angle= -0.001/+0.001
Alignment= -0.0005 /+0.0005
Location= -0.0005 /+0.0005

20) ANGLE HORN PIN

Diameter = -0.0005/ +0.0005
Depth= -0.005/+0.005
Angle= -15'/+ 15'
Alignment= -0.0005 /+0.0005
Location= -0.003 /+0.003

21) NOZZLE DROP

Diameter = -0.0005/ +0.0005
Depth= -0.0005/+0.0005
Alignment= -0.0005 /+0.0005
Location= -0.0005 /+0.0005

22) WATERLINE / PIPE TAP
Diameter = -0.005/ +0.005
Depth= -0.005/ +0.005
Angle= -1 deg /+ 1 deg
Alignment= -0.005/ +0.005
Location= -0.005/ +0.005

23) PIPE CLEARANCE / COUNTERBORE
Diameter = -0.005/ +0.005
Depth= -0.005/ +0.005
Angle= -0.005/ +0.005
Alignment= -0.005/ +0.005
Location= -0.005/ +0.005

24) SUPPORT PILLAR
Length= -0.000/+0.001
Diameter=-0.060/+0.000
CLEARANCE = NOMINAL DIAMETER +0.06/+0.12 OR PRINT SPECIFICATION

For all DME Mold Components tolerances, please see DME Catalog and / or Installation Sheet.