

DOVE TAIL COLLAPSIBLE CORES

- Positive mechanically actuated Collapsible Core
- Collapse amount: 5% to 7% per side
- Eliminates costly Rack and Gear Systems
- Enables faster mold cycle times
- Patented Quick Lock helps cut service time
- Built-in center cooling channel
- Standard and custom sizes available



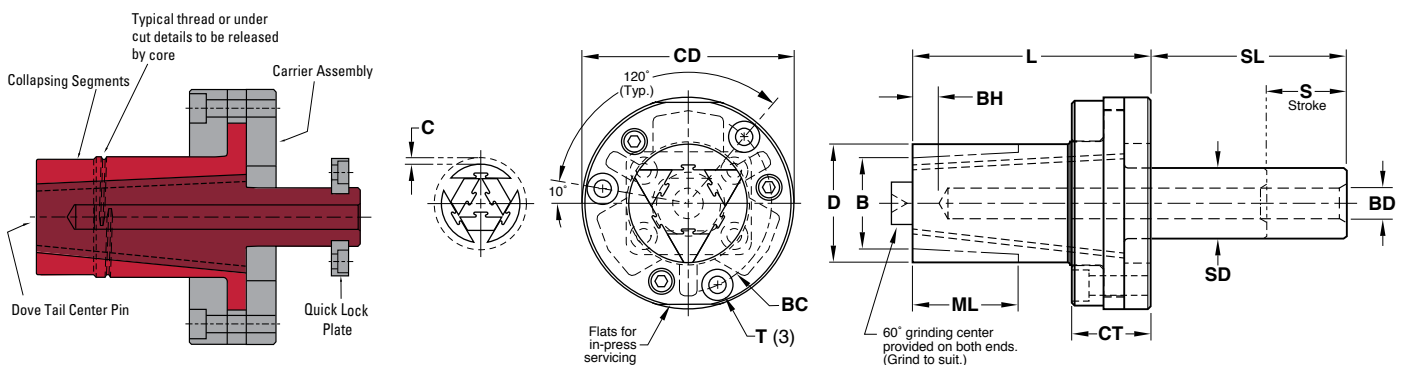
Simplified Mold Design Maximizes Cost Savings

The Collapsible Core DT Series provides a more compact and simplified solution to molding challenging internal undercut features such as o-ring grooves, slots and snap-fit designs. Available in four standard sizes, as well as custom sizes to meet your specific requirements, the DT Collapsible Core Series eliminates the need for unscrewing mechanisms.

Dove Tail Collapsible Cores Enable Application Design Flexibility

- All standard DT Series Collapsible Cores offer 360 degree molding of threads or other undercut features
- Molded parts are not required to be closed at one end; they may be partially or completely open
- DME offers customized DT Cores with pre-machined part detail
- A variety of coatings and treatments are available
- For an engineering review, email your part drawing or application to dme@dme.net

| ITEM NUMBER | D Minimum Outer Diameter | B Minimum Inner Diameter +3'/Side | ML Maximum Molding Length | C Maximum Collapse | CD Carrier Diameter +0.00 - 0.05 | CT Carrier Assembly Thickness ± 0.05 | L Core Length +0.1 - 0.0 | SL Shaft Length | SD Shaft Diameter +0.00 - 0.02 | BD Cooling Hole Diameter | BH Distance to Cooling Hole | BC Mounting Screw Bolt Circle | T Mounting Screws | S Maximum Collapse Stroke |
|-------------|-----------------------------|---|------------------------------|-----------------------|---|--|-----------------------------------|--------------------|---|-----------------------------|--------------------------------|----------------------------------|----------------------|------------------------------|
| DT18 | 21 | 17 | 22 | 1.1 | 53 | 21 | 60 | 60 | 16 | 6 | 6 | 40 | M5 x 25 | 34 |
| DT28 | 33 | 25 | 28 | 1.6 | 60 | 22 | 67 | 60 | 20 | 8 | 8 | 47 | M5 x 25 | 38 |
| DT38 | 42 | 33 | 43 | 2.1 | 76 | 28 | 85 | 60 | 25 | 10 | 10 | 60 | M6 x 35 | 54 |
| DT48 | 54 | 42 | 50 | 2.4 | 98 | 37 | 104 | 70 | 30 | 12 | 12 | 78 | M8 x 40 | 62 |



STANDARD & MINI COLLAPSIBLE CORES

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.

| ITEM NUMBER | A MAX O.D. OF THREAD OR CONFIG | | B MIN I.D. OF THREAD OR CONFIG | | H CENTER PIN DIAMETER (AT TOP OF CORE) | | L MAX WORKING 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 |
| CC125PC | .720 | 18.29 | .620 | 15.75 | .490 | 12.45 | .800 | 20.32 | .027 | .69 | .032 | .81 | 5.605 | 142.37 |
| CC150PC | .850 | 21.59 | .700 | 17.78 | .580 | 14.73 | 1.000 | 25.40 | .037 | .94 | .042 | 1.07 | 6.615 | 168.02 |
| CC175PC | .970 | 24.64 | .760 | 19.30 | .640 | 16.26 | 1.000 | 25.40 | .043 | 1.09 | .048 | 1.21 | 6.615 | 168.02 |
| CC200PC | 1.270 | 32.25 | .910 | 23.11 | .785 | 19.93 | 1.150 | 29.21 | .043 | 1.09 | .048 | 1.21 | 7.315 | 185.80 |
| †CC250PC | 1.270 | 32.25 | .910 | 23.11 | .785 | 19.93 | 1.150 | 29.21 | .043 | 1.09 | .048 | 1.21 | 5.440 | 138.17 |
| CC202PC | 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 |
| †CC252PC | 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 |
| CC302PC | 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 |
| †CC352PC | 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 |
| CC402PC | 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 |
| CC502PC | 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 |
| CC602PC | 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 |
| CC652PC | 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 |
| CC702PC | 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 |

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.

Three standard sizes of Collapsible Mini-Cores are available, for 13-16, 17-20 and 21-24mm closures.

| ITEM NUMBER | FOR CLOSURE DIAMETER RANGE | A MAX O.D. OF THREAD OR CONFIG | | B MIN I.D. OF THREAD OR CONFIG | | H CENTER PIN DIAMETER (AT TOP OF CORE) | | WIDTH OF (3) NON-COLLAPSING CENTER OF PIN BLADES (AT TOP OF CORE) | | L MAX WORKING 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 |
| CCM0001 | 13-16 | .645 | 16.38 | .425 | 10.80 | .300 | 7.62 | .170 | 4.32 | .850 | 21.59 | .052 | 1.32 |
| CCM0002 | 17-20 | .805 | 20.45 | .560 | 14.22 | .420 | 10.67 | .190 | 4.83 | .850 | 21.59 | .057 | 1.45 |
| CCM0003 | 21-24 | .965 | 24.51 | .710 | 18.03 | .560 | 14.22 | .200 | 5.08 | 1.000 | 25.40 | .059 | 1.50 |

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