

SPECIAL MOLD BASE MACHINING

CAPABILITIES & GUIDELINES

PCS Company machines to 3D CAD files and follow Quality ISO9001:2015 guideline. CMM Reports included with each Mold Base.



POCKET WORK

Rough or Finished · Blind & Through · Milled or Wire EDM Machining

TOLERANCES

DESIGN GUIDELINES

CAVITY & CORE INSERT POCKETS

MILLED
Length & Width:
(+0.002"/-0.000")

MILLED
Depth:
(+0.000"/-0.002")
Measured from Parting Line

WIRE EDM
Length & Width:
(+0.001"/-0.000")

MILLED
Pocket Depths:
<3.000" will have a min.
.312" Corner Radii
with .030" Radii at the floor.

MILLED
Pocket Depths:
>3.000" will have a min.
.500" Corner Radii with
.030" Radii at the floor.

Insert pockets are left sharp at Parting Line unless showing in CAD model and/or requested in writing.

BORED
Diameter:
(+0.0008"/-0.0000")

BORED
Diameter Range:
2.000" - 8.000"
Max Depth: 8.000"

SLIDE & HEEL BLOCK POCKETS

MILLED
Length & Width
(+0.002"/-0.000")
Depth:
(+0.000"/-0.002")
Measured from parting line

MILLED
Length & Width:
Nominal
Depth: Nominal

SPRING POCKETS

MILLED
General Fit

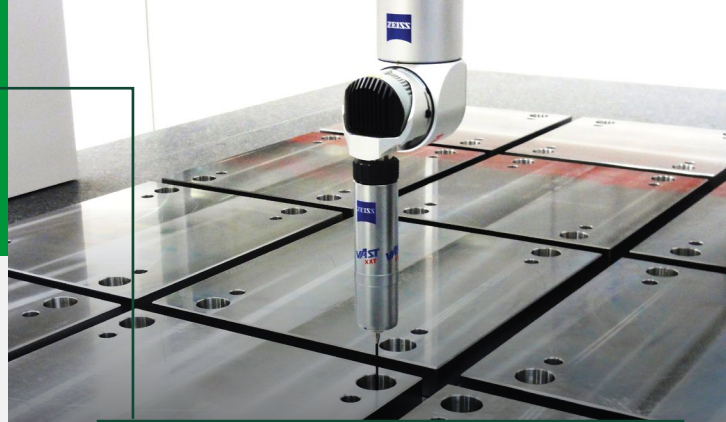
MILLED
Length & Width:
Nominal

Depth: Nominal

All feature edges will be broken and or chamfered

ALIGNMENT LOCK POCKETS

Machined to Fit & Install



MACHINE ALL COMMON MOLD FEATURES INCLUDING, BUT NOT LIMITED TO:



DRILLING

- Angle Pin Holes
- Ejector & Core Pin Holes
- Hoist Ring / Eyebolt Holes
- Guided Ejection
- Knockout Holes
- Leader Pin Holes
- Return Pin Holes
- Spring Return Holes
- Stripper Bolts
- Support Pillar Clearance
- Waterlines / Pipe Clearance (Depth: Up to 30")



ADVANCED CUSTOM MACHINING

- Finished Bored Holes
- Secondary & Reversed Leader Pins
- Hot Half & Manifolds
- Parting Line Relief / Vent Runners
- Finished Tapered Pockets



SLOTTING

- Clamp Slots
- Pry Bar Slots
- Wire Slots

ADDITIONAL CAPABILITIES

- Saw Cut
- Grinding