

# 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
<b>CAVITY &amp; CORE INSERT POCKETS</b>	<b>MILLED</b> Length & Width: $(+0.002"/-0.000")$  <b>MILLED</b> Depth: $(+0.000"/-0.002")$ Measured from Parting Line  <b>WIRE EDM</b> Length & Width: $(+0.001"/-0.000")$	<b>MILLED</b> Pocket Depths: $<3.000"$ will have a min. $.312"$ Corner Radii with $.030"$ Radii at the floor.  <b>MILLED</b> 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.
<b>SLIDE &amp; HEEL BLOCK POCKETS</b>	<b>BORED</b> Diameter: $(+0.0008"/-0.0000")$	<b>BORED</b> Diameter Range: $2.000" - 8.000"$ Max Depth: $8.000"$
<b>SPRING POCKETS</b>	<b>MILLED</b> Length & Width $(+0.002"/-0.000")$ Depth: $(+0.000"/-0.002")$ Measured from parting line	<b>MILLED</b> Length & Width: Nominal  Depth: Nominal
<b>ALIGNMENT LOCK POCKETS</b>	<b>MILLED</b> General Fit  Machined to Fit & Install	<b>MILLED</b> Length & Width: Nominal  Depth: Nominal  All feature edges will be broken and or chamfered



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

### DRILLING

- Angle Pin Holes
- Return Pin Holes
- Ejector & Core Pin Holes
- Spring Return Holes
- Hoist Ring / Eyebolt Holes
- Stripper Bolts
- Guided Ejection
- Knockout Holes
- Support Pillar Clearance
- Leader Pin Holes
- 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