

# 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 OR WIRE EDM

Length & Width:  
(+ 0.002" / - 0.00")

Depth:  
(+ 0.002" / - 0.00")  
*Measured from Parting Line*

##### MILLED OR WIRE EDM

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

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:  
(+ 0.0005" / - 0.0005")

##### BORED

Diameter Range:  
2.000" – 8.000"  
Max Depth: 8.000"

#### SLIDE & HEEL BLOCK POCKETS

##### MILLED

Length & Width:  
(+ 0.002" / - 0.00")  
Depth:  
(+ 0.002" / - 0.00")

##### MILLED

Length & Width:  
Nominal  
Depth: Nominal

#### SPRING POCKETS

General Fit

#### ALIGNMENT LOCK POCKETS

Machined to Fit &  
Installed

##### MILLED

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
- 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