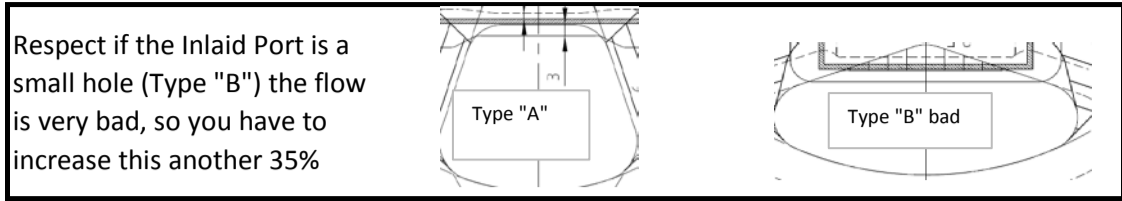


Hollow Die

1. Inlaid Port

1.1.

outside > 15% bigger Area



Respect if the Inlaid Port is a small hole (Type "B") the flow is very bad, so you have to increase this another 35%

1.1.2. Respect the different Profile Area

Example: Profile 80x45mm

Result:
Area "A" 1860
Area "B" 1757

Area "A" in Center is 1860mm; so the Area "B" should be 1041mm because the different Profile Area > 35-40% because the Inlaid Port Form so it should be 1406mm >25-30% because the Distance to the Center so it should be 1757mm.

Example: Profile 100x45mm

Result:
Area "A" 2235
Area "B" 1697

Area "A" in Center is 2235mm; so the Area "B" should be 1006mm because the different Profile Area > 35-40% because the Inlaid Port Form so it should be 1357mm >25-30% because the Distance to the Center so it should be 1697mm.

1.1.3. If same Center Inlaid for two Cavity use <10% bigger Area outside

If necessary use Steps to increase the Inlaid Port

1.1.4. spreading >6°

2. Pre Camber

2.1. a) 3mm high distance 2mm b) 5mm high distance 4mm c) 8mm high distance 6mm

2.1.2 at small Parts open the Area 2mm

2.1.3 If some small Peaks at the Profile go to an wider Area, because the small Peaks always pulls.

make a difference at the Precamber Area about a straight Profile Part to a Profile Part with some small Peaks!

2.1.4

3.Support

3.1. Garantie best possible support

3.1.1. 5-10mm distance each Part

3.1.2. > 2 Times the tongue high should be the Die Plate high after Bearing

3.1.3.

3.1.4.

4.Undercut

4.1. all around the same undercut

4.1.2 On the Edges >R2

4.1.3 Outside 0,0 to 0,5mm more undercut because the deflection

Between two Mandrel try to use a >30° Angle because the better stability

4.1.4

5. Bearing length

