

Jumbo Gate-Mate®

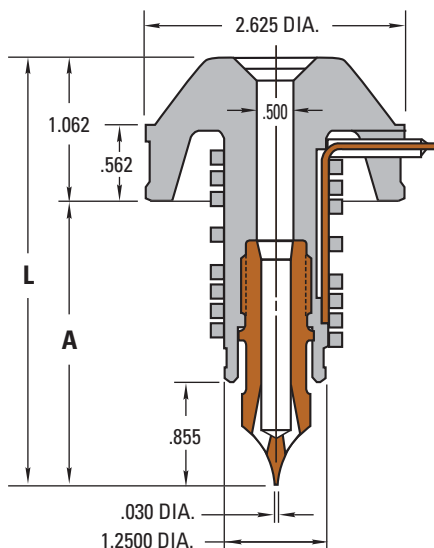


The Jumbo Gate-Mate Bushing is designed for direct part gating in single cavity molds, eliminating the conventional cold sprue. The unique design of the bushing provides minimal gate vestige, without the objectionable witness lines so commonly found on direct gated parts.

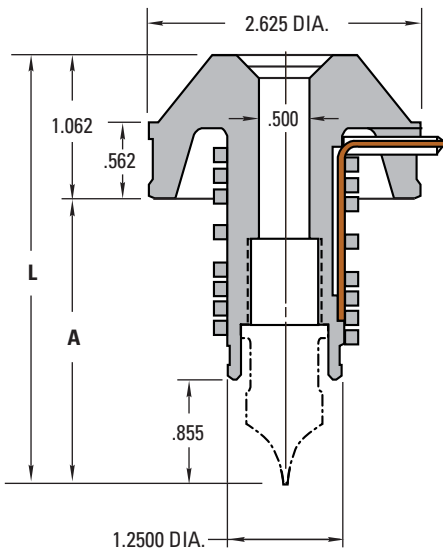
The bushing transfers molten plastics from the machine nozzle to the mold cavity via a direct channel in the body. The bushing, in conjunction with the recommended tip and gate configuration, controls gate vestige height.

The Jumbo Gate-Mate Bushing utilizes an advanced design square coil heater and an independent thermocouple, strategically located for precise temperature control.

Bushing Assembly



Bushing Sub-Assembly



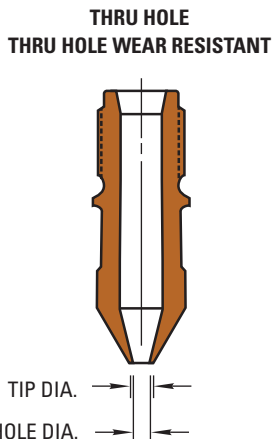
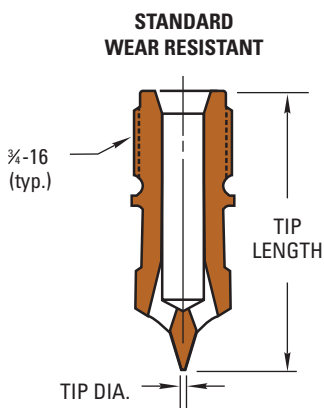
**BUSHING ASSEMBLY
(INCLUDES GMT0004 TIP)**

ITEM NUMBER	A	L	SPH. RAD.
GMB0008	2.500	3.562	1/2 & 3/4
GMB0009	3.500	4.562	1/2 & 3/4

**BUSHING SUB-ASSEMBLY
(ORDER TIP SEPARATELY)**

ITEM NUMBER	A	L	SPH. RAD.
GMB0113	2.500	3.562	1/2 & 3/4
GMB0114	3.500	4.562	1/2 & 3/4

Jumbo Gate-Mate® Tips



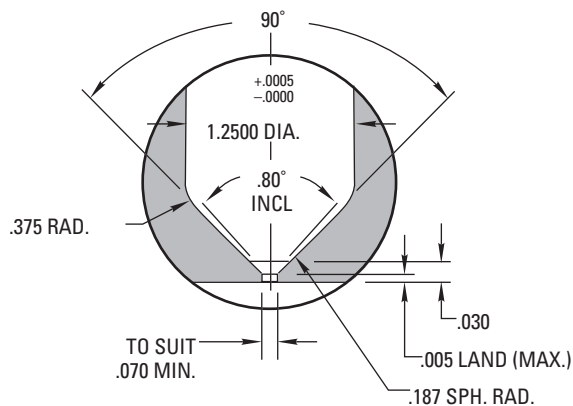
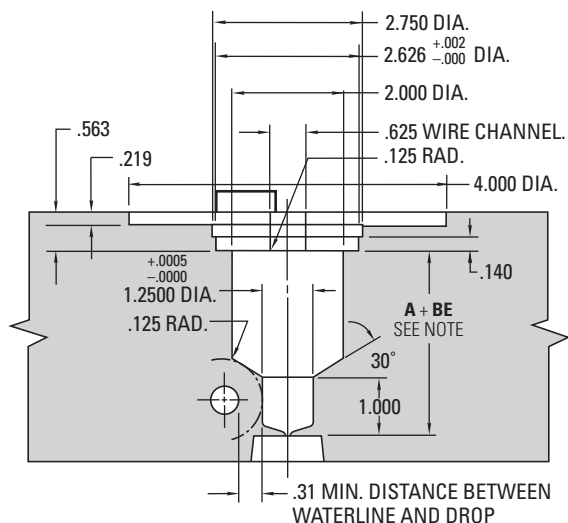
TIP STYLE	ITEM NUMBER	TIP LENGTH	TIP DIA.	HOLE DIA.
STANDARD	GMT0004	1.855	.030	N/A
WEAR RESISTANT	GMT0406			
THRU HOLE	GMT0007			
THRU HOLE WEAR RESISTANT	GMT0407	1.815	.140	.100

NOTES:

1. Thru-hole tip designed .040 shorter in length to be a direct replacement for the standard tip; use a .080 to .125 diameter gate
2. Contact DME for tip recommendations and assistance with your application

Jumbo Gate-Mate® Machining Dimensions

Machining Dimensions for Bushings



ITEM NUMBER REFERENCE		A
BUSHING ASSEMBLY	BUSHING SUB-ASSEMBLY	
GMB0008	GMB0113	2.500
GMB0009	GMB0114	3.500

NOTE:

The expansion factor must be taken into consideration prior to machining for, and installing bushing. This factor (BE) must then be added to the nominal A dimension. Formula for determining this expansion is as follows: BE = "A" dimension x 0.00000633 x nozzle set point - 68°F (assuming the mold is at 68°F during operation). If mold temperature is different, substitute 68°F with actual mold temperature.

EXAMPLE:

Given a 2.500 inch A dimension, with a Bushing Set Point temp. of 500°F: BE = 2.500 x .0000063 x (500 - 68) = .007 thus A + BE will be 2.507.

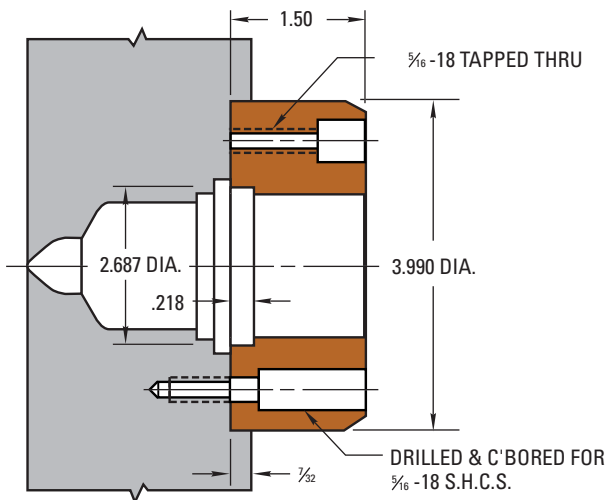
Please note that this information is given as an example. Variations may occur based on mold configurations and cooling factor. In some instances, it may be necessary to obtain an empirical factor.

Replacement Parts

Improved tip insulation, elimination of material degradation in threaded area of tip, and faster color changes can be achieved through use of a Gate Shell Insulator.

ITEM NUMBER REFERENCE		SQUARE COIL HEATERS (240 VAC)			THERMOCOUPLE (TYPE J, 36" LEADS)	
BUSHING ASSEMBLY	BUSHING SUB-ASSEMBLY	ITEM NUMBER	WATTS	LENGTH	ITEM NUMBER	LENGTH
GMB0008	GMB0113	SCH0002	600	1.70	TC0002	1.18
GMB0009	GMB0114	SCH0001	800	2.70	TC0001	2.18

Jumbo Gate-Mate Locating Ring



ITEM NUMBER
GMB0007

NOTES:

- Two (2) 5/16 -18 S.H.C.S. are included with Locating Ring
- Two (2) Drilled and C'bored holes for 5/16 -18 S.H.C.S. are on a 1.656 Circle radius in Locating Ring
- C'bore depth in Top Clamp Plate and C'bore depth in locating ring can be altered to suit application