

D-M-E Molding Undercuts

Solutions that maximize design
and production efficiency



D-M-E
Every step of the way

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Taking lifter systems to the next level



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Efficiently mold plastic parts requiring internal threads, undercuts, protrusions or cut-outs



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Expandable Cavity Systems 60 to 70

Proven technology for molding external threads, grooves and undercuts

Online Price Guide

Go to www.dme.net/prices for the latest pricing guide.

D-M-E VectorForm Lifter Systems

TAKING LIFTER SYSTEMS
TO THE NEXT LEVEL



VectorForm Lifter Systems

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Overview

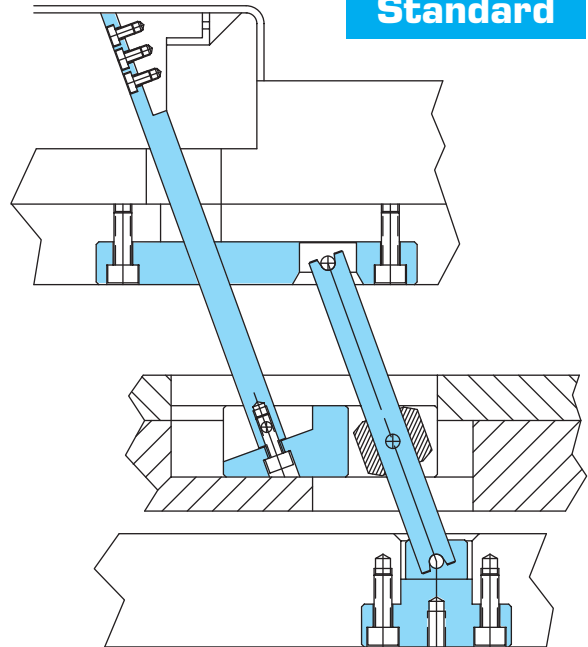
VectorForm Lifter Advantages

- 30°+ Angle – Half the stroke for the same undercut
- Simple plate machining
- Easy installation
- May be ganged
 - Multiple systems may be “ganged” to lift a large lifter core
 - A single system can lift multiple lifter cores
- Accelerate or decelerate the motion of the lifter core relative to the ejector plate
- Cooling may be added
- Design flexibility is improved

View a VectorForm Lifter animation at www.dme.net/vectorform

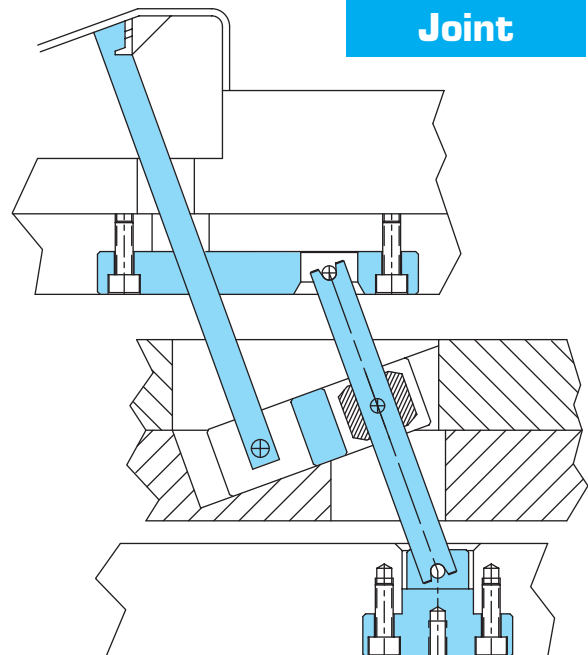
VectorForm Lifter Systems Design and Assembly Guide available upon request or at www.dme.net/vectorform

Standard



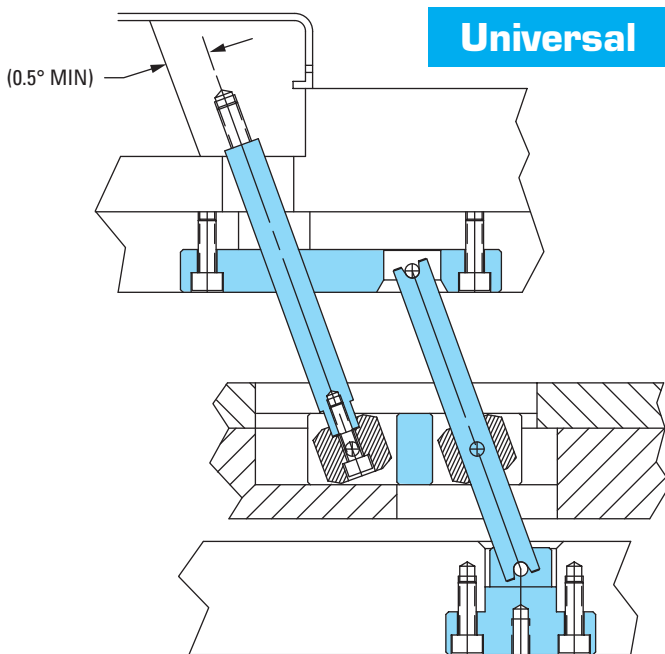
General installation. Standard Slide Base in typical ejector plate installation shown.

Joint



Angled Slide Base installation may be used to accelerate or decelerate the action of the VectorForm Lifter System. In this example, the VectorForm Lifter System movement is decelerated relative to the movement of the ejector plate.

Universal

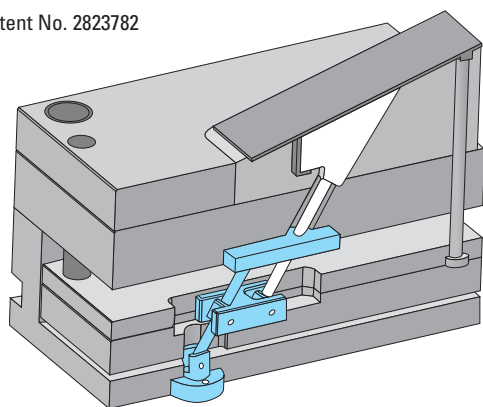


Universal Slide Base shown in typical ejector plate installation.

Overview

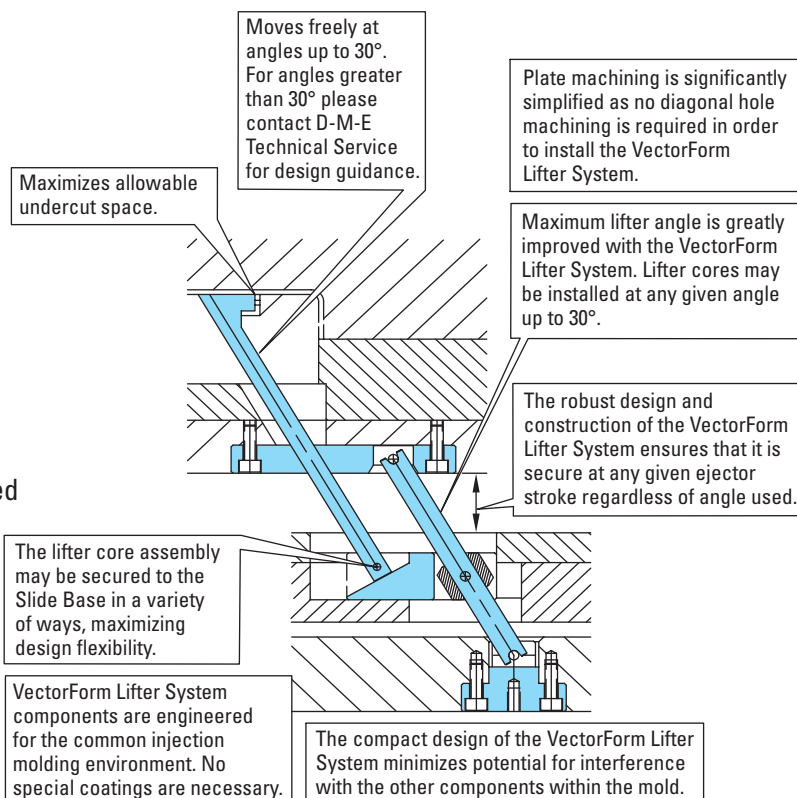
VectorForm Lifter System Features & Benefits

Patent No. 2823782



D-M-E Supplied Customer Supplied

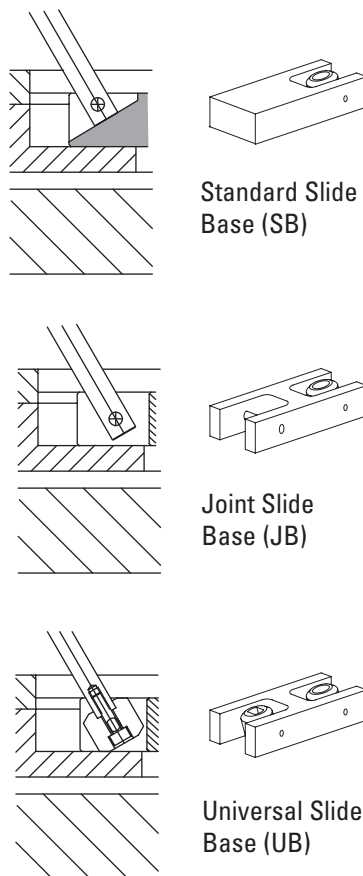
VectorForm Lifter Systems maximize design flexibility and offer off-the-shelf installation into most lifter applications.



VectorForm Slide Bases

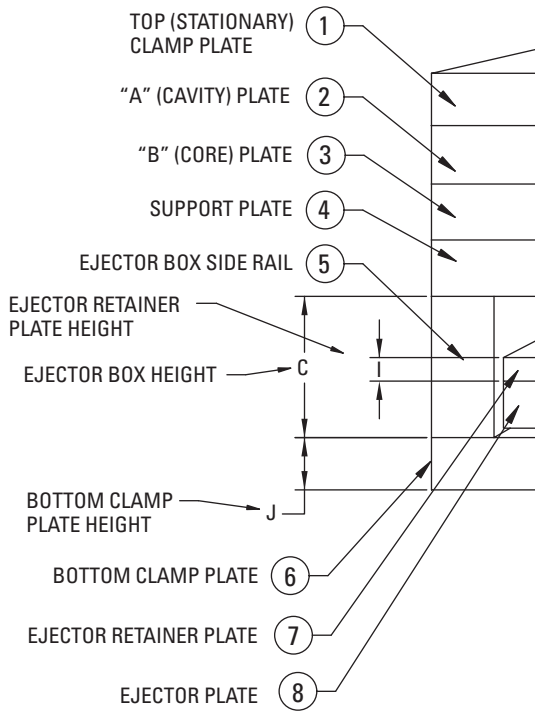
VectorForm Lifter Systems offer three types of slide bases to meet the needs of your applications.

- The **Standard Slide Base (SB)** is the most flexible and the most economical slide base. The Standard Slide Base can be custom machined by the mold builder to meet specialized application requirements. The Standard Slide Base is also the most robust slide base with respect to loads and forces.
- The **Joint Slide Base (JB)** permits the lifter core assembly to be retained with a single pin.
- The **Universal Slide Base (UB)** is similar to the Joint Slide Base, although the single pin is replaced by a universal joint which offers greater flexibility than the Joint Slide Base (JB) while still requiring only one screw to retain the lifter core assembly.

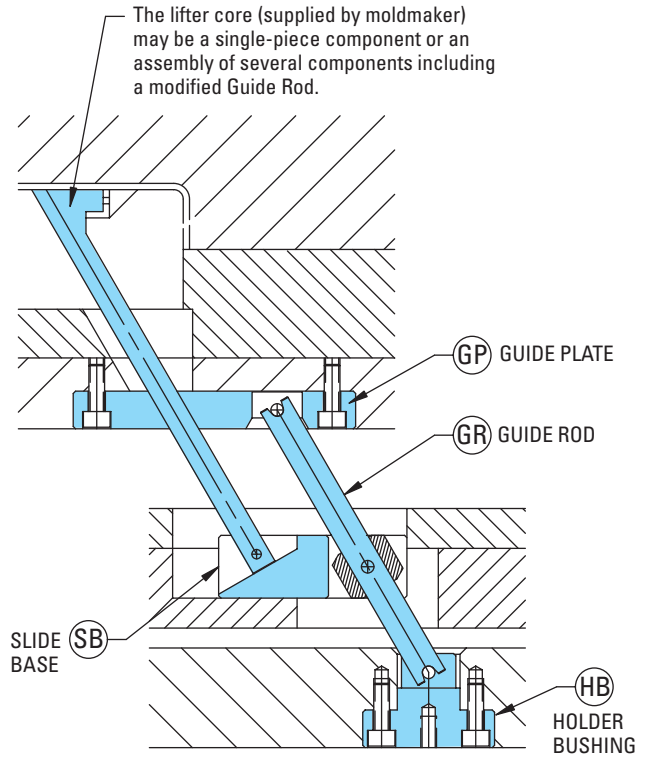


Overview

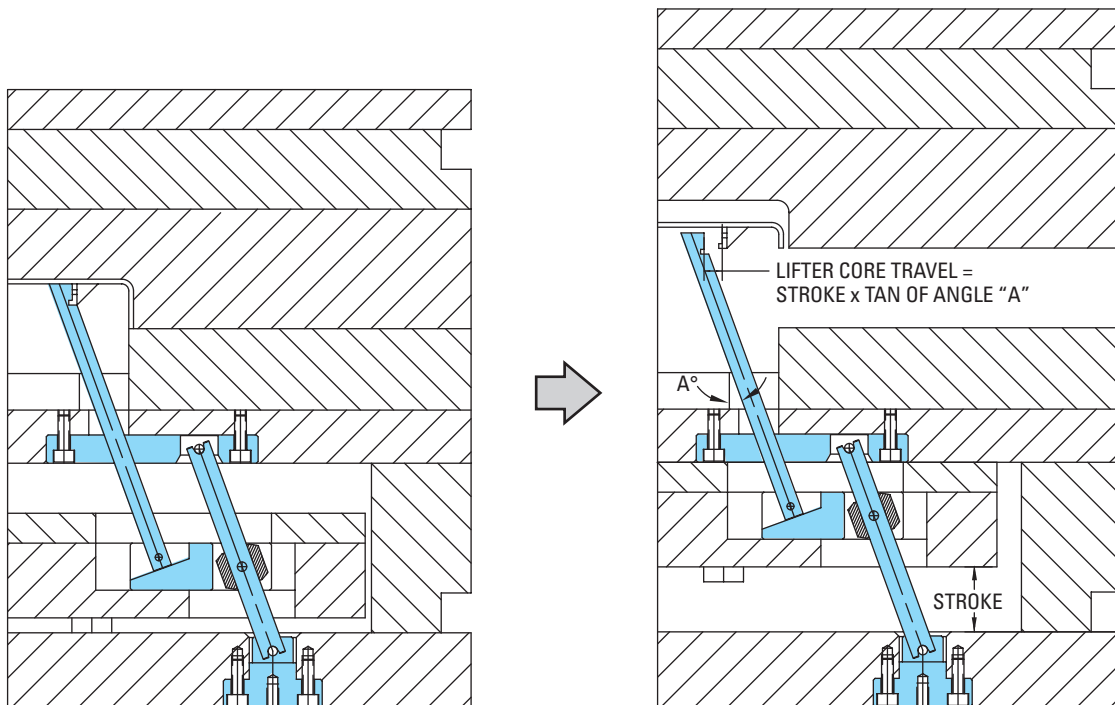
Mold Base Overview



VectorForm Lifter Overview

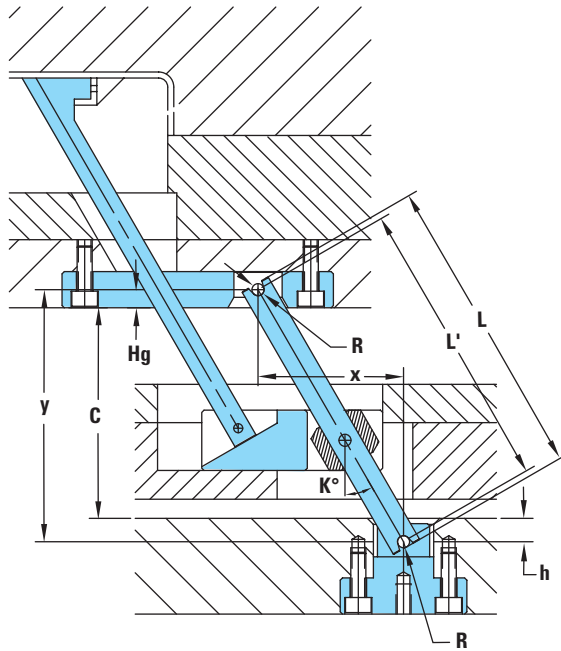


VectorForm Lifter Operating Sequence

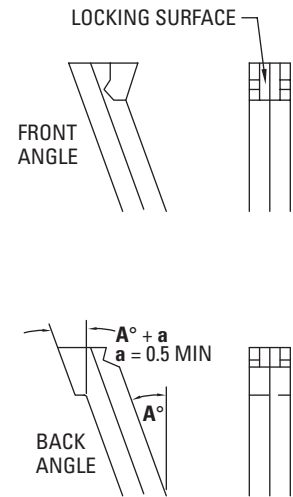


Design Guidelines

LENGTH OF GUIDE ROD:
 $y = C + Hg + h$
 $L' = y / \cos K^\circ$ $L = L' + 2R$



Locking Angles



1. General Installation

- It is recommended that the VectorForm Lifter System be installed as shown above.
- For each given VectorForm set, all components **MUST** be of the same size. However, separate sets of different sizes may be installed in the same mold.
- Actuation of VectorForm Lifter Systems can be accelerated or decelerated by an inclined sliding surface on the ejector plate and ejector retainer plate.

2. Angles

- The VectorForm Lifter System may be used with angles ranging from 5° (minimum) to 30° (maximum).
- Deep undercuts in the molded part can be obtained by using a larger angle in the lifter core and by increasing the ejector plate stroke.

3. Lifter Core Guidance

- The lifter core must have sufficient guidance in the tool. For multiple lifter cores installed in tandem in the tool, additional guidance in the core inserts is recommended.
- If resistance in actuation is great, an additional Guide Plate may be placed directly below the core insert.

4. Guided Ejection

- Guided ejection is recommended for all designs.

5. Fit and Finish

- Standard component dimensions and Rockwell hardness are provided in the component specifications section of this brochure. Should the standard components need to be modified, additional performance can be obtained by

treating after finish machining (TiN coating, flash-chrome, etc.). Component installations can be fitted to suit.

- Ensure a loose fit on the Holder Bushing and Guide Plate installation. Ensure a precise fit between the lifter core and the Guide Plate. The Holder Bushing will automatically align prior to bolting the bushing to the clamp plate.
- Lubrication is not generally required nor recommended. If lubrication is used, it should be low-viscosity.

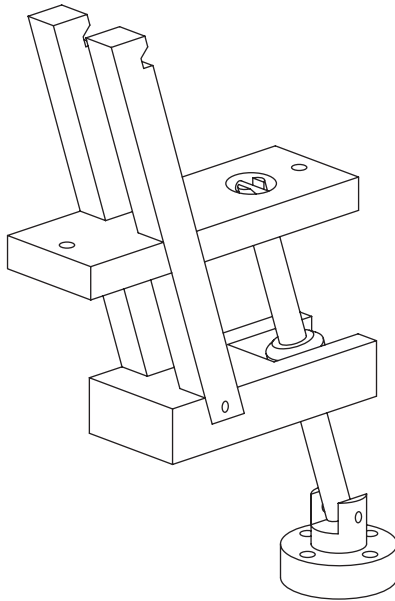
6. Locking Angles/Component Back-Up

- Locking angles may be designed to provide a locking surface to counter against molding pressure.
- A block construction using a square lifter core can also allow the resin pressure to be backed up by the core insert.
- If the axial load acting on the lifter core exceeds the limit allowed for the slide base pin (used in JB and UB Slide Bases), use a Standard (SB) Slide Base and back the lifter core on the slide by machining a ledge that is perpendicular to the axis of the lifter core. The lifter core must then seat firmly against the angled face of the Slide Base.

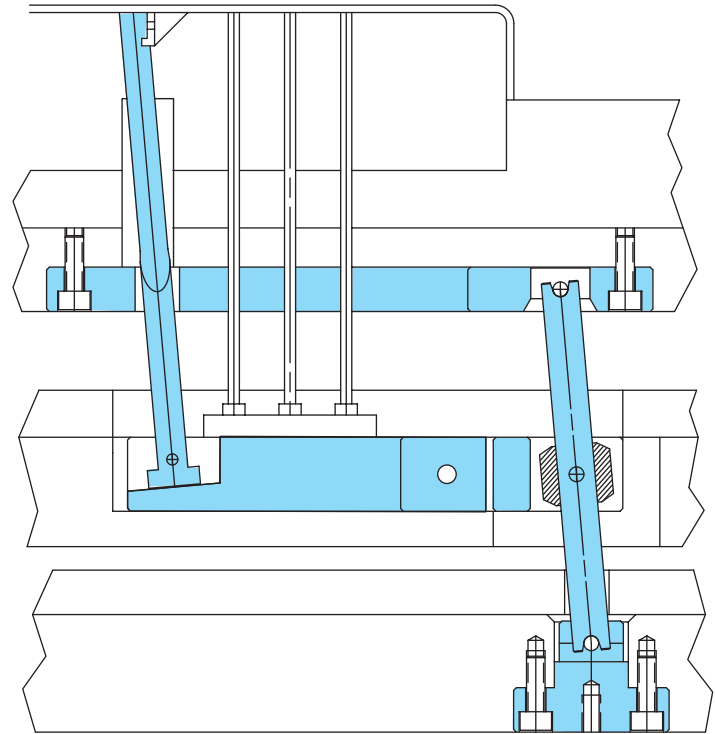
7. Non-Standard Shapes/Materials

- Lifter core blocks may be machined to any desired shape and size, provided the chosen number and size of the VectorForm Lifter System core standard components will support the lifter core blocks. Lifter core blocks are to be supplied by the moldmaker.

Advanced Applications

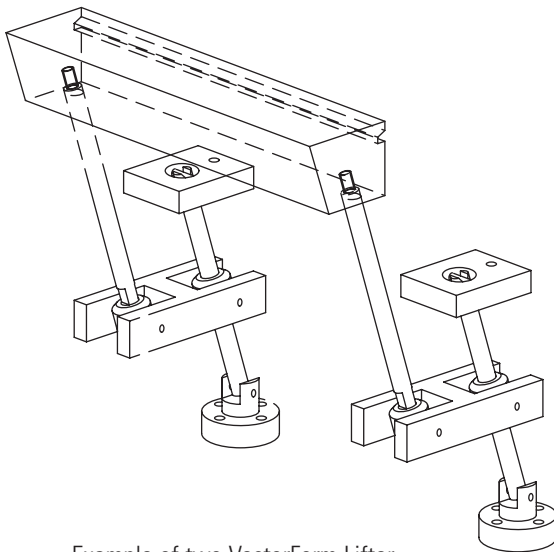


Example of multiple lifter cores being actuated in parallel by a Standard Slide Base (SB).

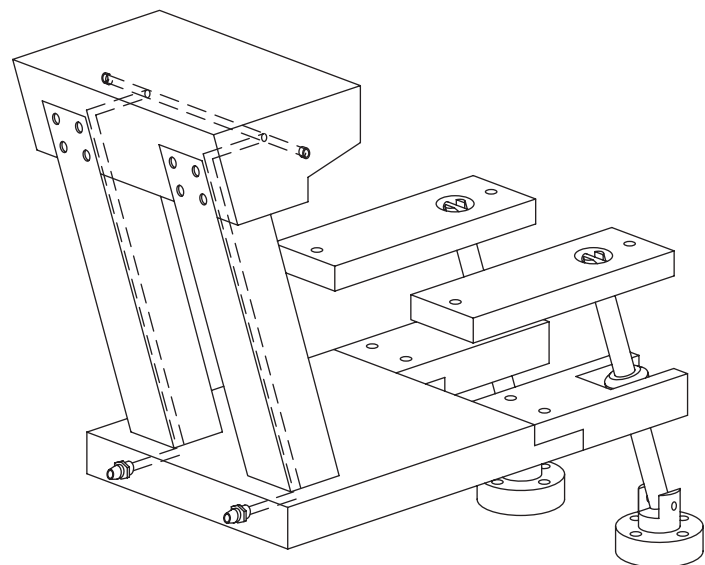


VectorForm Lifter System example with tandem ejector pins in close proximity to slide base. Joint Slide Base (JB) shown.

NOTE: Ejector pins are secured to, and move with, the ejector plate assembly, not the VectorForm System Slide Base.

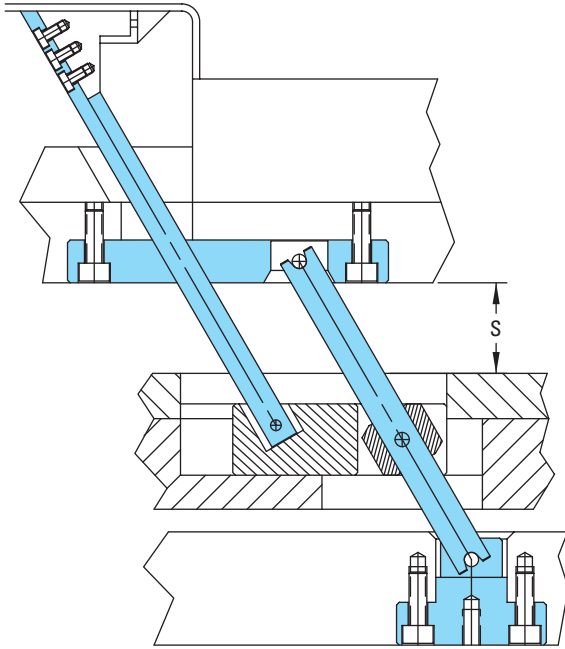


Example of two VectorForm Lifter System assemblies being used in parallel to lift a large lifter core assembly (UB shown).

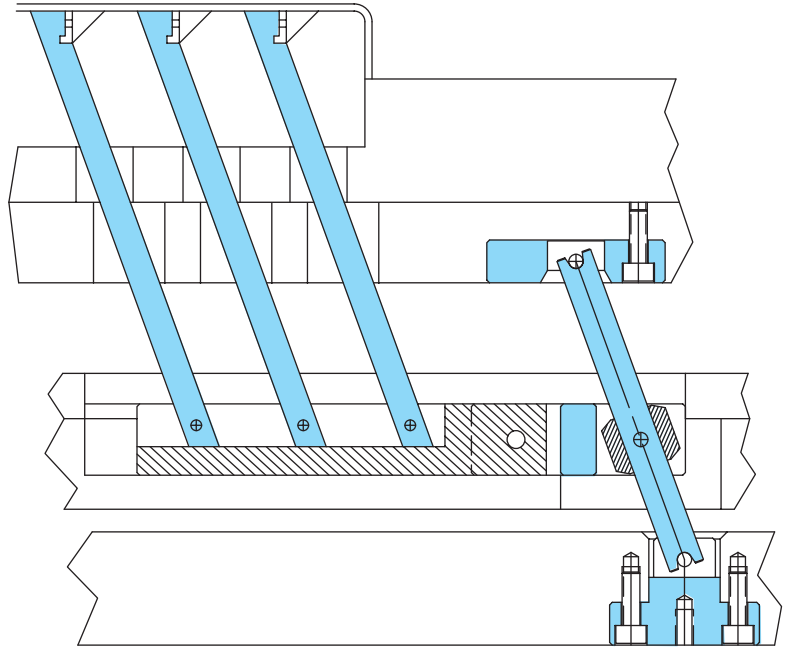


Multiple VectorForm Lifter Systems shown in parallel, actuating a large water-cooled lifter core through an extended Standard Slide Base.

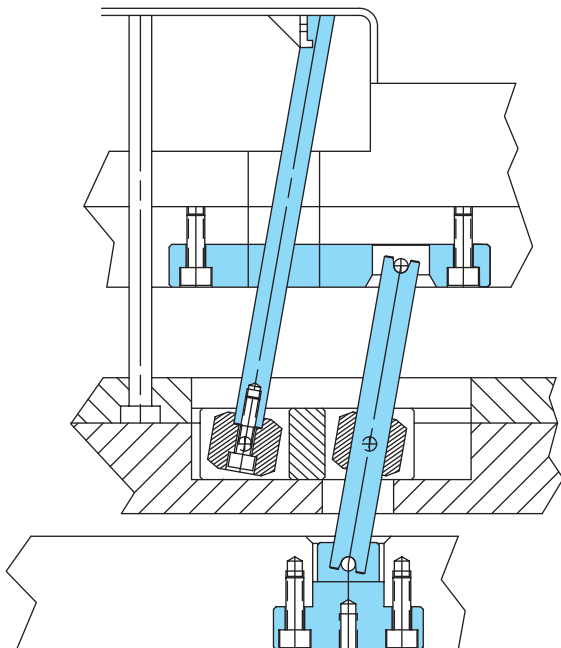
Advanced Applications



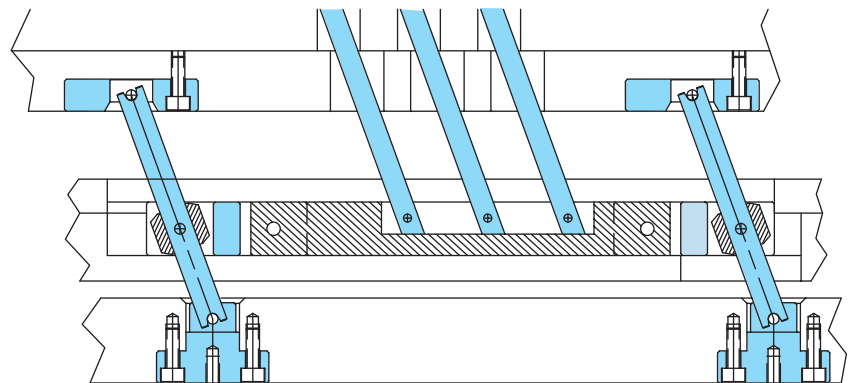
Deep undercut attained by increasing the shift angle and by having sufficient stroke "S".
Standard Slide Base (SB) shown.



Multiple VectorForm Lifter Systems can be operated in tandem by a single Guide Rod assembly with the use of a simple extension coupled with a standard slide plate.
Joint Slide Base (JB) shown.



Avoid interference with the adjacent components by using a small section lifter core and by using reverse installation. Universal Slide Base (UB) shown.

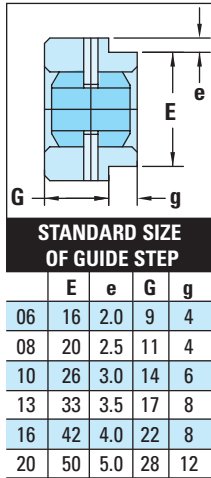


In cases of high ejection resistance, serial tandem guidance can be aided by using two or more Guide Rod assemblies.
Joint Slide Base (JB) shown.

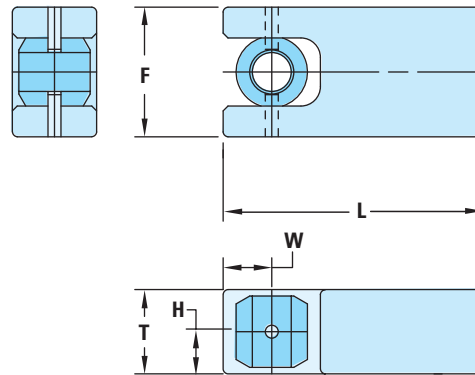
VectorForm Component Specifications

Standard Slide Base – SB

Material: SCM-440 / DIN-1.7225 / AISI-4140
Hardness: 29-34 HRC



NOTE: Dimensions for retaining step to be machined by moldmaker as necessary.



Additional Machining:

- Retaining bolt installation on lifter core rod or assembly
- Grooves as shown to far left of figure (for alignment) if required

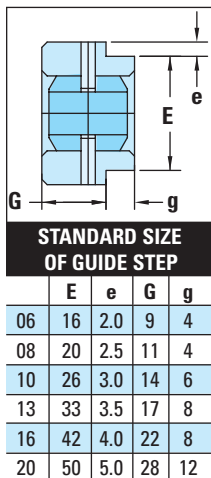
Heat Treatment:

- Gas nitriding is permissible after additional machining has been performed

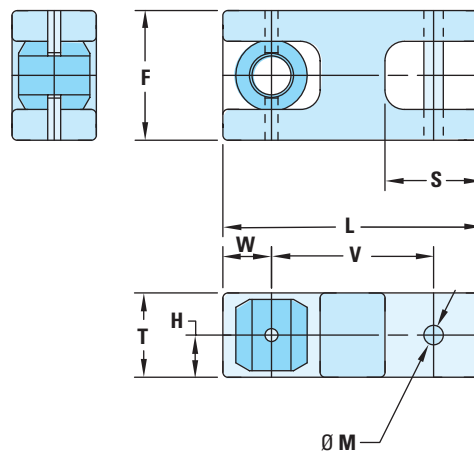
Joint Slide Base – JB

Material: SCM-440 / DIN-1.7225 / AISI-4140
Hardness: 29-34 HRC

Joint Pin material: SKH-51 / DIN-1.1213 / AISI-1050
Hardness: 60-66 HRC
Tempering temperature: 600°C



NOTE: Dimensions for retaining step to be machined by moldmaker as necessary.



Additional Machining:

None

Attachment: Joint Pin

Heat Treatment:

- Gas nitriding is permissible
- During nitriding, use a pin finer (-0.01) than the attached joint pin

VectorForm Component Specifications

Universal Slide Base – UB

Material: SCM-440 / DIN-1.7225 / AISI-4140

Hardness: 29-34 HRC

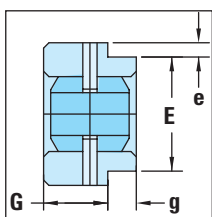
Heat Treatment: Nitriding is permissible



Additional Machining:

None

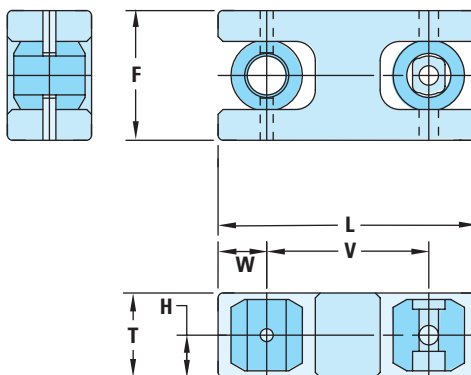
Attachment: None



STANDARD SIZE OF GUIDE STEP

	E	e	G	g
06	16	2.0	9	4
08	20	2.5	11	4
10	26	3.0	14	6
13	33	3.5	17	8
16	42	4.0	22	8
20	50	5.0	28	12

NOTE: Dimensions for retaining step to be machined by moldmaker as necessary.



Slide Base Ordering Information

SIZES	ITEM NUMBER					
	06	08	10	13	16	20
SB – STANDARD SLIDE BASE	VF 06 SB	VF 08 SB	VF 10 SB	VF 13 SB	VF 16 SB	VF 20 SB
JB – JOINT SLIDE BASE	VF 06 JB	VF 08 JB	VF 10 JB	VF 13 JB	VF 16 JB	VF 20 JB
UB – UNIVERSAL SLIDE BASE	VF 06 UB	VF 08 UB	VF 10 UB	VF 13 UB	VF 16 UB	VF 20 UB

SYMBOL	DIMENSIONS						INSTALLATION CLASSIFICATION
	06	08	10	13	16	20	
I	13	15	20	25	30	35	
J	20	25	30	35	40	50	
C	50-120	50-150	70-200	100-250	120-300	120-400	
T	13 ⁰ _{-0.02}	15 ⁰ _{-0.02}	20 ⁰ _{-0.03}	25 ⁰ _{-0.03}	30 ⁰ _{-0.05}	40 ⁰ _{-0.05}	
F	20 ⁰ _{-0.02}	25 ⁰ _{-0.02}	32 ⁰ _{-0.03}	40 ⁰ _{-0.03}	50 ⁰ _{-0.05}	60 ⁰ _{-0.05}	
L	40	50	60	80	100	130	
D	10.5	13.5	17	22	27	33	
S	15	20	25	30	40	50	
H	6.5	7.5	10	12.5	15	20	
W	7.5	10	12.5	15	20	25	
N	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	
V*	25	30	35	50	60	80	
M*	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	

*Applies to JB and UB only.