

Minimum Recommended Additional Assembly SHCS

MOLD BASE SIZE	A PLATE THICKNESS	EXISTING TOTAL NUMBER OF SHCS	MOLDING MACHINE FORCE (TONS) / MOLD OPENING FORCE (LBS.)										
			15 THROUGH 400 3000 THROUGH 80,000	425 85,000	450 90,000	475 95,000	500 100,000	525 105,000	550 110,000	575 115,000	600 120,000	625 125,000	650 130,000
88	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
812	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
108	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1012	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1016	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1020	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1112	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1114	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1118	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1123	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1212	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1215	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1220	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1223	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1315	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1318	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1321	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1323	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1326	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1329	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1518	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1524	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1529	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1616	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1620	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1623	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1626	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1629	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1635	.0875	12	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0
1724	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1729	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1818	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1820	.0875	4	0	+1	+1	+1	+1	+1	+2	+2	+2	+2	+2
	1.375 TO 5.875	4	0	0	0	0	0	0	+1	+1	+1	+1	+2
1823	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1826	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1829	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1835	.0875	12	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0
1924	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1929	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
1935	.0875	12	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0
2424	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
2429	.0875	8	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0
2435	.0875	12	0	0	0	0	0	0	0	0	0	0	0
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0

NOTES:

- Blue color configurations require additional assembly screws.
- Numbers of additional assembly screws suggested are minimum required.
- No safety factor considered. The moldmaker is entirely responsible for the chosen configuration.

KEY:

- = No additional assembly screws required
- = Add screws as noted (+)
- N/A = Not available/not recommended

Minimum Recommended Additional Assembly SHCS

Standard & Optional Mold Base Features | Minimum Recommended Additional Assembly SHCS

MOLD BASE SIZE	A PLATE THICKNESS	EXISTING TOTAL NUMBER OF SHCS	MOLDING MACHINE FORCE (TONS) / MOLD OPENING FORCE (LBS.)															
			675 135,000	700 140,000	725 145,000	750 150,000	775 155,000	800 160,000	825 165,000	850 170,000	875 175,000	900 180,000	925 185,000	950 190,000	975 195,000	1000 200,000		
88	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
812	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
108	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1012	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1016	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1020	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1112	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1114	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1118	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	N/A	N/A	N/A	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1123	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1212	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1215	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1220	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1223	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1315	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1318	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1321	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1323	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1326	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1329	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1518	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1524	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1529	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1616	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1620	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1623	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1626	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1629	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1635	.0875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1724	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1729	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1818	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1820	.0875	4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+4	+6	+6	+6	
	1.375 TO 5.875	4	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+2	+4	+4	+4	
1823	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1826	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1829	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1835	.0875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1924	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1929	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
1935	.0875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
2424	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
2429	.0875	8	0	0	0	0	0	0	0	0	0	0	0	0	+2	+2	+2	
	1.375 TO 5.875	8	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
2435	.0875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
	1.375 TO 5.875	12	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	

NOTES:

- Blue color configurations require additional assembly screws.
- Numbers of additional assembly screws suggested are minimum required.
- No safety factor considered. The moldmaker is entirely responsible for the chosen configuration.

KEY:

- = No additional assembly screws required
- = Add screws as noted (+)
- N/A = Not available/not recommended