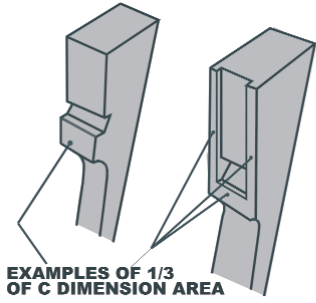


Retractable Core Theory & Concepts *Patented CUMSA System*



EXAMPLES OF 1/3 OF C DIMENSION AREA



AFTER TIGHTENING



.0005 CLEARANCE ON 3 SIDES



6° SIDE UNDER SPRING TENSION (NO CLEARANCE)

BRONZE / OILITE BUSHING

SHANK Ø	LENGTH
1/4	5/8
5/16	3/4

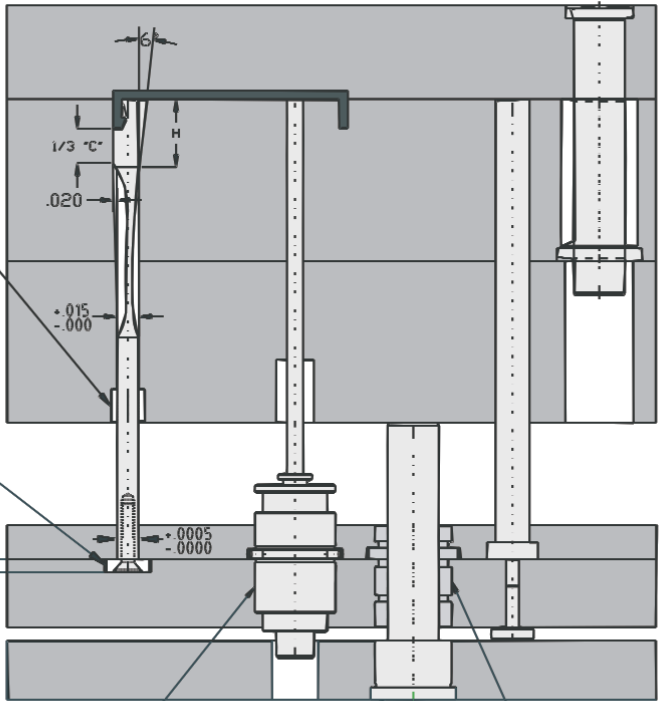
OILITE BUSHING 2 TO 3 TIMES THE SHANK Ø IN LENGTH TIGHT PRESS FIT THEN +.005 REAM

SHANK Ø	THICKNESS	F.H.C.S.
.500	.250	8-32
.625	.250	10-24

HEAD TO BE MADE FORM A CPS PIN SHANK. GRIND BOTH SIDES FLAT AND PARALLEL. DRILL .005 CLEARANCE & COUNTER SINK FOR FHCS WITH MIN CHAMFER ON HOLES & RETRACTABLE CORE SHANK

DEPTH OF COUNTER BORE TO BE THE SAME AS HEAD THICKNESS

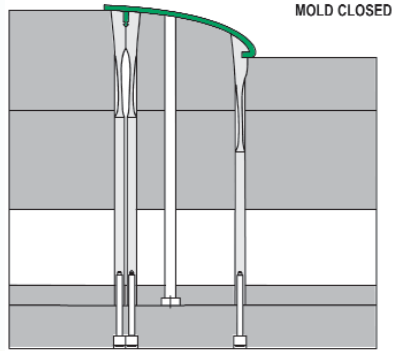
COUNTER BORE FOR HEAD IN EJECTOR PLATE



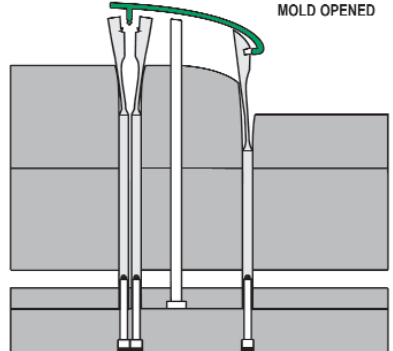
PCS ACCELERATED EJECTOR

PCS RGEB STYLE GUIDED EJECTOR BUSHING

A GUIDED EJECTOR SYSTEM IS HIGHLY RECOMMENDED



MOLD CLOSED



MOLD OPENED

