SPECIAL MOLD BASE MACHINING

CAPABILITIES & GUIDELINES

PCS Company machines to 3D CAD files and follow Quality ISO9001:2015 guideline. CMM Reports included with each Mold Base.

POCKET WORK
Rough or Finished · Blind & Through · Milled or Wire EDM Machining

MACHINE ALL COMMON MOLD FEATURES INCLUDING, BUT NOT LIMITED TO:

	TOLERANCES	DESIGN GUIDELINES
CAVITY & CORE INSERT POCKETS	**MILLED** Length & Width: (+0.002"/-0.000") **MILLED** Depth: (+0.000"/-0.002") Measured from Parting Line **PRECISION MILLED/ WIRE EDM** Length & Width: (+0.001"/-0.000") **PRECISION MILLED DEPTH:** (+0.000"/-0.001") Measured from the Parting Line **BORED** Diameter: (+0.0008"/-0.0000")	**MILLED** Pocket Depths: <3.000" will have a min. .312" Corner Radii with .030" Radii at the floor. **MILLED** Pocket Depths: >3.000" will have a min. .500" Corner Radii with .030" Radii at the floor. Insert pockets are left sharp at Parting Line unless showing in CAD model and/or requested in writing. **BORED** Diameter Range: 2.000" - 8.000" Max Depth: 8.000"
SLIDE & HEEL BLOCK POCKETS	**MILLED** Length & Width (+0.002"/-0.000") Depth: (+0.000"/-0.002") Measured from parting line	**MILLED** Length & Width: Nominal Depth: Nominal
SPRING POCKETS	**MILLED** General Fit	**MILLED** Length & Width: Nominal Depth: Nominal
ALIGNMENT LOCK POCKETS	Machined to Fit & Install	All feature edges will be broken and or chamfered

DRILLING

- → Angle Pin Holes
- → Ejector & Core Pin Holes
- → Hoist Ring / Eyebolt Holes
- → Guided Ejection
- → Knockout Holes
- → Leader Pin Holes
- → Return Pin Holes
- → Spring Return Holes
- → Stripper Bolts
- → Support Pillar Clearance
- → Waterlines / Pipe Clearance (Depth: Up to 30")

ADVANCED CUSTOM MACHINING

- → Finished Bored Holes
- → Secondary & Reversed Leader Pins
- → Hot Half & Manifolds
- → Parting Line Relief / Vent Runners
- → Finished Tapered Pockets

SLOTTING

- → Clamp Slots
- → Pry Bar Slots
- → Wire Slots

ADDITIONAL CAPABILITIES

- → Saw Cut
- → Grinding