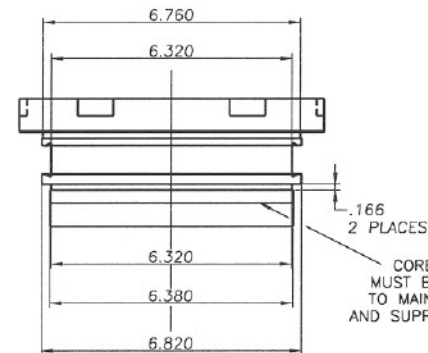
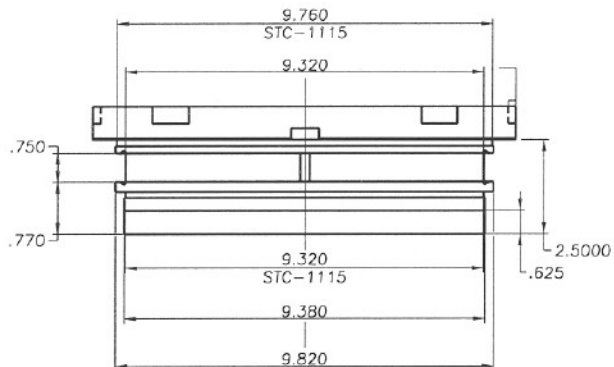
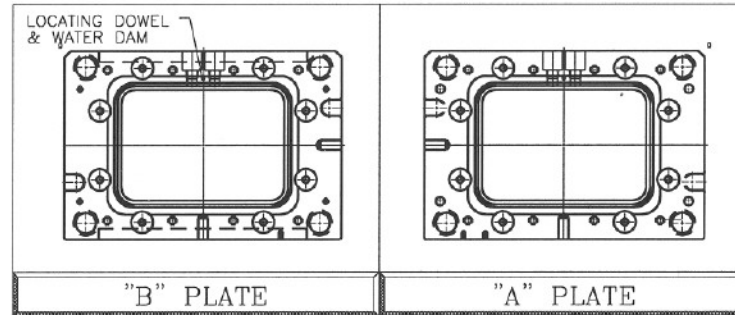
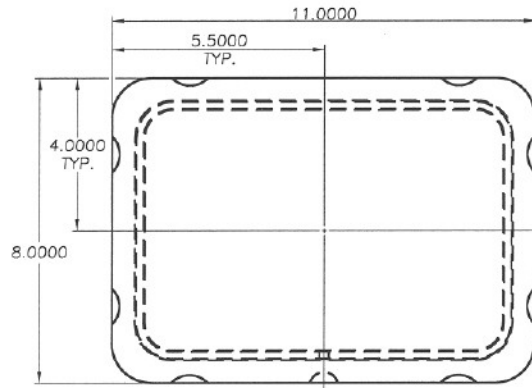


# 11" SYSTEM 2

INSERT DIMENSIONS  
WITH CORE PLATE ADDED



THE "A" INSERT IS THE SAME AS  
THE "B" INSERT

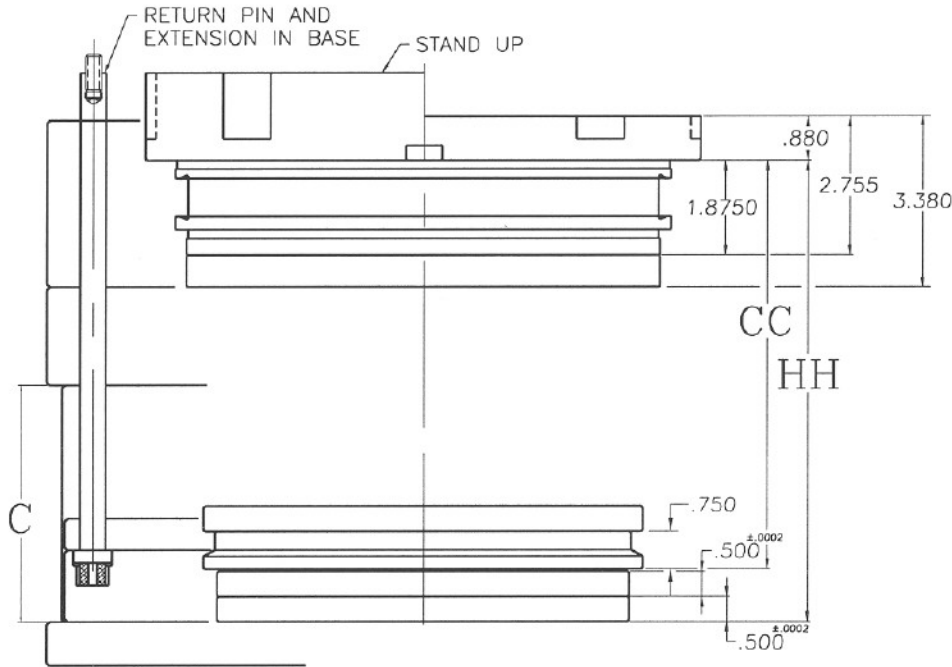
TOOLMAKER IS TO  
INSTALL THE WATER DAM

WATER DAM IS TO BE  
IN BETWEEN WATER INLET/OUTLET  
IN MASTER FRAME

CORE RETAINER PLATE  
MUST BE ADDED TO INSERT  
TO MAINTAIN MOLD STACKUP  
AND SUPPORT IN MASTER FRAME

# 1 1" SYSTEM 2

PIN, SLEEVE, AND PARTING LINE SET UP



THIS DRAWING IS SUPPLIED TO AID WITH EJECTOR PIN, SLEEVE EJECTOR AND PARTING LINE SET UP WHEN DESIGNING A SYSTEM 2 MOLD.

THE DIMENSION: "cc", IS SHOWN TO LOCATE THE EJECTOR PLATES, AND IN CONJUNCTION WITH DIMENSION: .750, TO DETERMINE EJECTOR PIN LENGTHS.

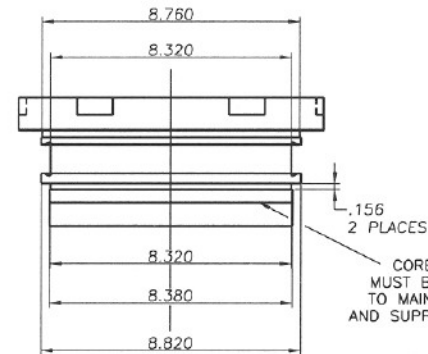
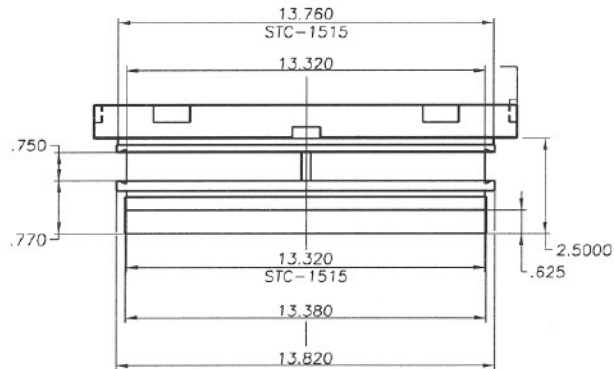
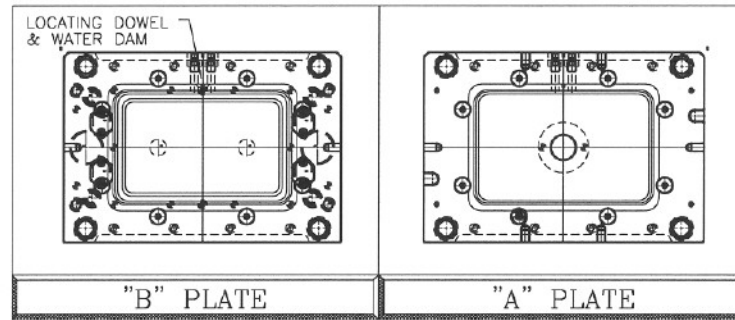
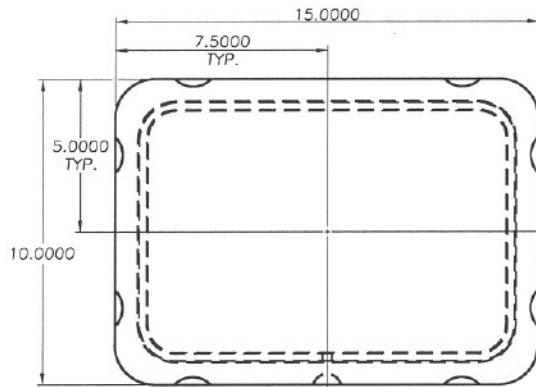
THE DIMENSION: "HH", LOCATES THE CORE RETAINER PLATES, IF SLEEVE EJECTION IS UTILIZED, AND IN CONJUNCTION WITH DIMENSION: .500, TO DETERMINE CORE PIN LENGTHS.

TO ALLOW FOR MINOR ADJUSTMENTS OF THE PARTING LINE OF THE INSERTS, (i.e. SHARPEN CAVITY EDGE, ETC.), THE WORKING THICKNESS OF THE INSERTS WITH RETAINER PLATES IS 3.380, WHILE THE "A" AND "B" PLATES OF THE MASTER FRAME ARE 3.375, LEAVING APPROXIMATELY .005 PER SIDE FOR ADJUSTMENT. PLEASE NOTE SPRINGS BENEATH THE RETURN PINS AUTOMATICALLY COMPENSATE FOR A .000 TO .015 GAP IN THE MASTER FRAME PARTING LINE. INSERTS, WITH STAND UP FOR AN EXTENDED PARTING LINE ARE SOLD IN HALF INCH INCREMENTS.

PART No.	C	CC	HH
STF-1110	3.000	6.3250	7.3750
STF-1111	4.000	7.3250	8.3750
STF-1112	5.000	8.3250	9.3750

# 15" SYSTEM 2

INSERT DIMENSIONS  
WITH CORE PLATE ADDED



THE "A" INSERT IS THE SAME AS THE "B" INSERT

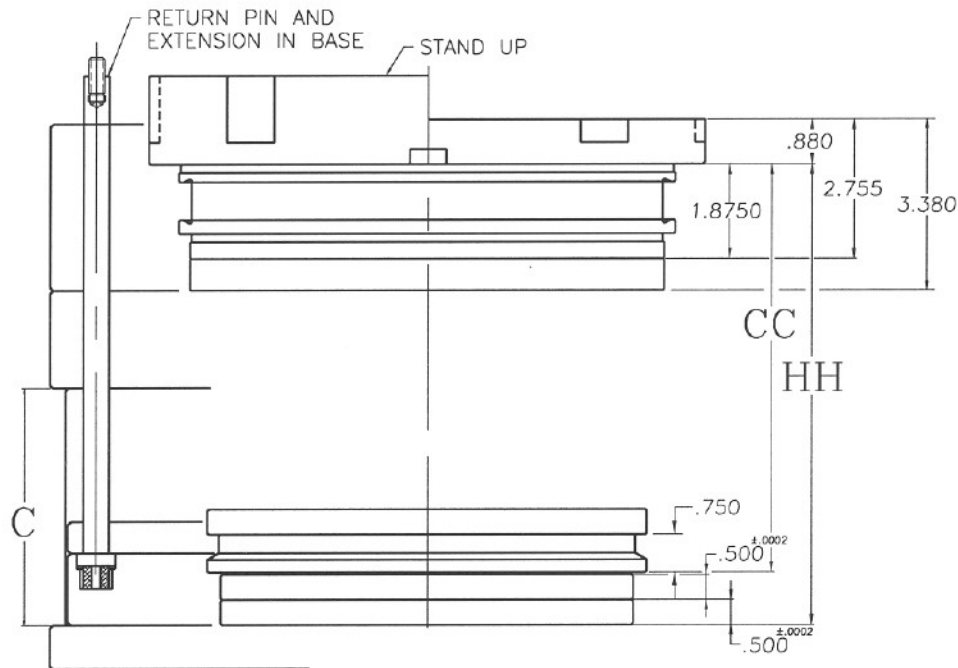
TOOLMAKER IS TO INSTALL THE WATER DAM

WATER DAM IS TO BE IN BETWEEN WATER INLET/OUTLET IN MASTER FRAME

CORE RETAINER PLATE MUST BE ADDED TO INSERT TO MAINTAIN MOLD STACKUP AND SUPPORT IN MASTER FRAME

# 15" SYSTEM 2

PIN, SLEEVE, AND PARTING LINE SET UP



THIS DRAWING IS SUPPLIED TO AID WITH EJECTOR PIN, SLEEVE EJECTOR AND PARTING LINE SET UP WHEN DESIGNING A SYSTEM 2 MOLD.

THE DIMENSION: "cc", IS SHOWN TO LOCATE THE EJECTOR PLATES, AND IN CONJUNCTION WITH DIMENSION: .750, TO DETERMINE EJECTOR PIN LENGTHS.

THE DIMENSION: "HH", LOCATES THE CORE RETAINER PLATES, IF SLEEVE EJECTION IS UTILIZED, AND IN CONJUNCTION WITH DIMENSION: .500, TO DETERMINE CORE PIN LENGTHS.

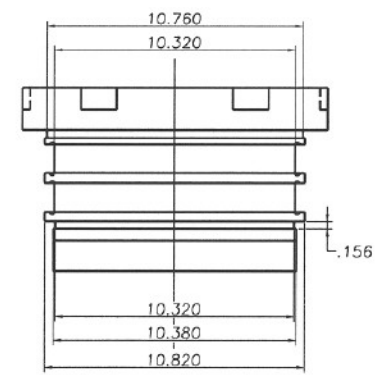
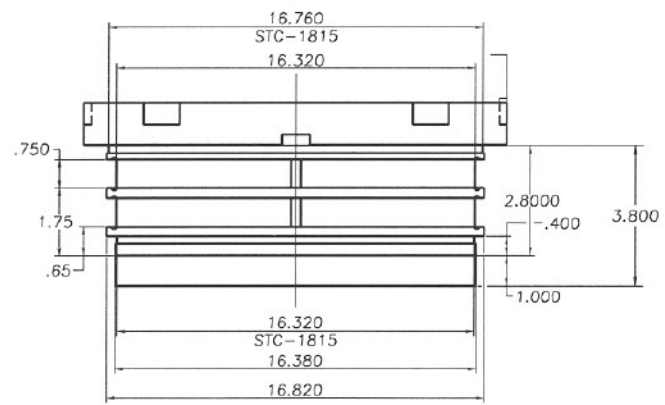
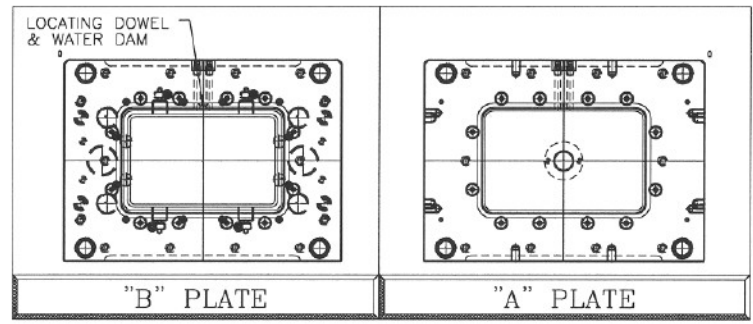
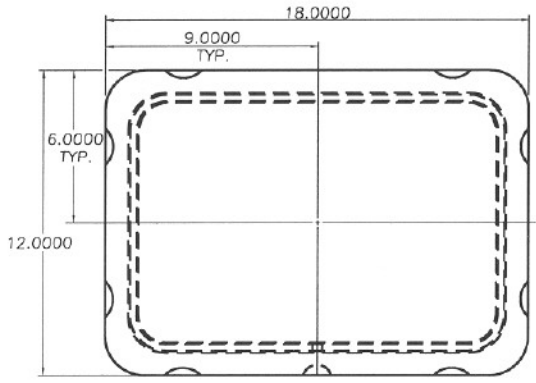
TO ALLOW FOR MINOR ADJUSTMENTS OF THE PARTING LINE OF THE INSERTS, (I.E. SHARPEN CAVITY EDGE, ETC.), THE WORKING THICKNESS OF THE INSERTS WITH RETAINER PLATES IS 3.380, WHILE THE "A" AND "B" PLATES OF THE MASTER FRAME ARE 3.375, LEAVING APPROXIMATELY .005 PER SIDE FOR ADJUSTMENT. PLEASE NOTE SPRINGS BENEATH THE RETURN PINS AUTOMATICALLY COMPENSATE FOR A .000 TO .015 GAP IN THE MASTER FRAME PARTING LINE. INSERTS, WITH STAND UP FOR AN EXTENDED PARTING LINE ARE SOLD IN HALF INCH INCREMENTS.

PART No.	C	CC	HH
STF-15110	3.000	6.3250	7.3750
STF-15111	4.000	7.3250	8.3750
STF-15112	5.000	8.3250	9.3750

# 18" SYSTEM 2

INSERT DIMENSIONS  
WITH CORE PLATE ADDED

DOUBLE WATER JACKET INSERT  
DIMENSIONS WITH CORE PLATE ADDED



THE "A" INSERT IS THE SAME AS  
THE "B" INSERT

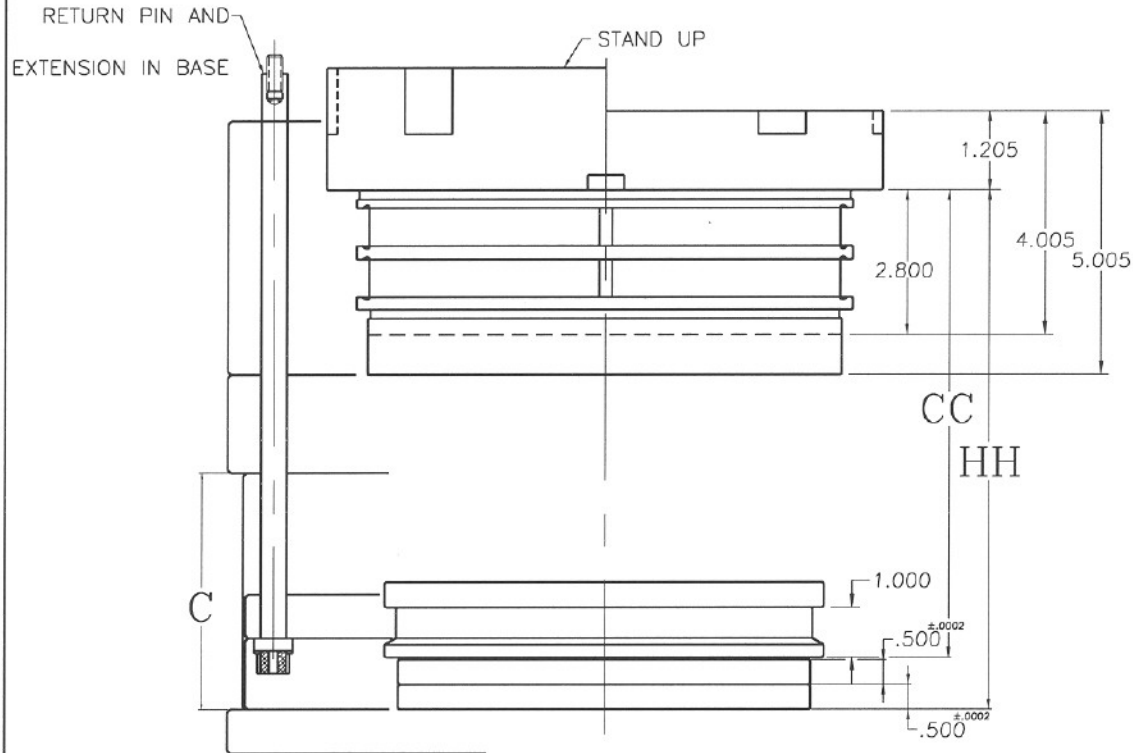
TOOLMAKER IS TO  
INSTALL THE WATER DAM

WATER DAM IS TO BE  
IN BETWEEN WATER INLET/OUTLET  
IN MASTER FRAME

IT IS IMPORTANT TO KNOW  
THAT THE DOUBLE WATER  
JACKET INSERT MUST HAVE  
A THICKER "A" AND "B" PLATE

# 18" SYSTEM 2

PIN, SLEEVE, AND PARTING LINE SET UP



THIS DRAWING IS SUPPLIED TO AID WITH EJECTOR PIN, SLEEVE EJECTOR AND PARTING LINE SET UP WHEN DESIGNING A SYSTEM 2 MOLD.

THE DIMENSION: "CC", IS SHOWN TO LOCATE THE EJECTOR PLATES, AND IN CONJUNCTION WITH DIMENSION: 1.000, TO DETERMINE EJECTOR PIN LENGTHS.

THE DIMENSION: "HH", LOCATES THE CORE RETAINER PLATES, IF SLEEVE EJECTION IS UTILIZED, AND IN CONJUNCTION WITH DIMENSION: .500, TO DETERMINE CORE PIN LENGTHS.

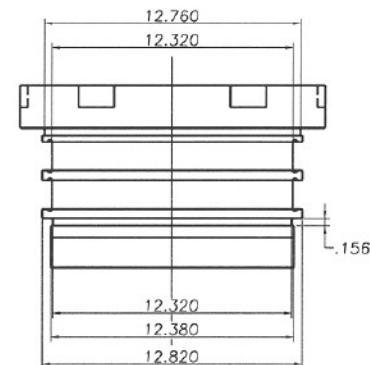
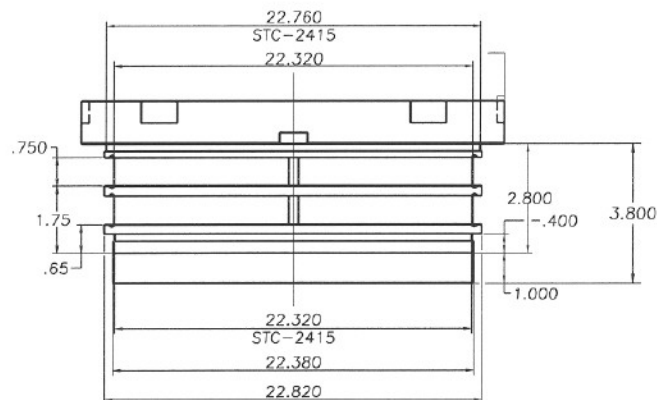
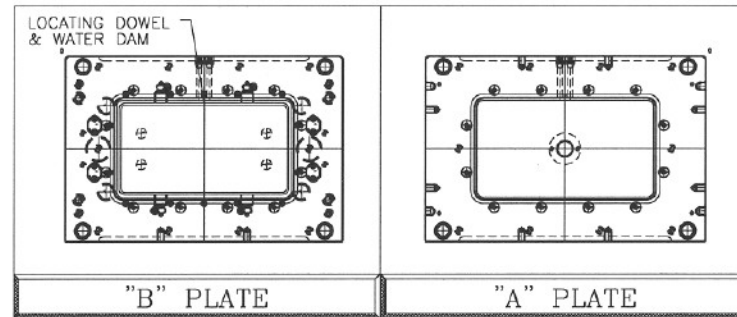
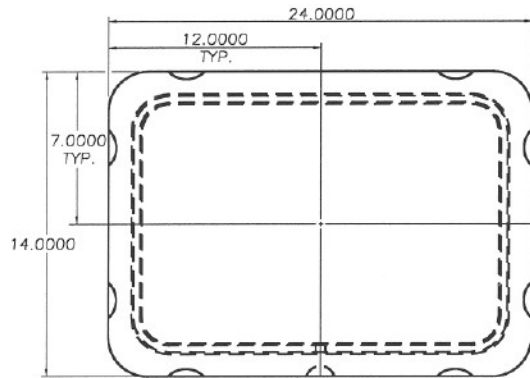
TO ALLOW FOR MINOR ADJUSTMENTS OF THE PARTING LINE OF THE INSERTS, (I.E. SHARPEN CAVITY EDGE, ETC.), THE WORKING THICKNESS OF THE INSERTS WITH RETAINER PLATES IS 5.005, WHILE THE "A" AND "B" PLATES OF THE MASTER FRAME ARE 5.000, LEAVING APPROXIMATELY .005 PER SIDE FOR ADJUSTMENT. PLEASE NOTE SPRINGS BENEATH THE RETURN PINS AUTOMATICALLY COMPENSATE FOR A .000 TO .015 GAP IN THE MASTER FRAME PARTING LINE. INSERTS, WITH STAND UP FOR AN EXTENDED PARTING LINE ARE SOLD IN HALF INCH INCREMENTS.

PART No.	C	CC	HH
STF-18121	4.000	9.6250	10.6750
STF-18122	5.000	10.6250	11.6750

# 24" SYSTEM 2

INSERT DIMENSIONS  
WITH CORE PLATE ADDED

DOUBLE WATER JACKET INSERT  
DIMENSIONS WITH CORE PLATE ADDED



THE "A" INSERT IS THE SAME AS  
THE "B" INSERT

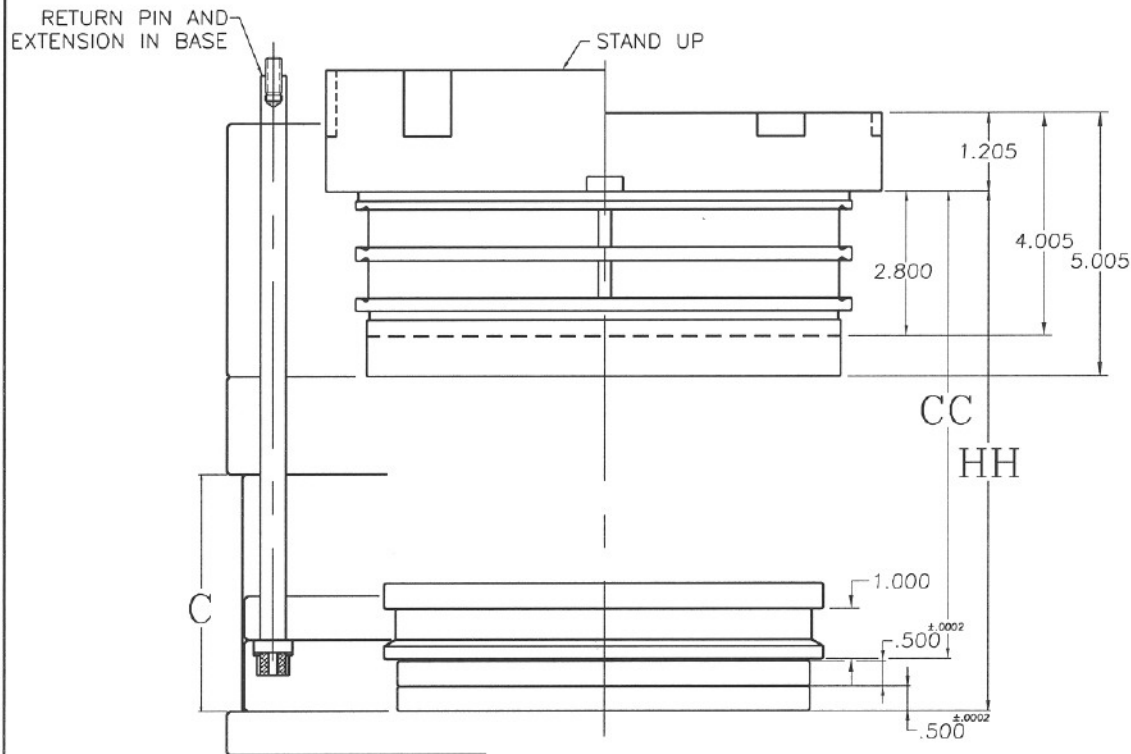
TOOLMAKER IS TO  
INSTALL THE WATER DAM

WATER DAM IS TO BE  
IN BETWEEN WATER INLET/OUTLET  
IN MASTER FRAME

IT IS IMPORTANT TO KNOW  
THAT THE DOUBLE WATER  
JACKET INSERT MUST HAVE  
A THICKER "A" AND "B" PLATE

# 24" SYSTEM 2

PIN, SLEEVE, AND PARTING LINE SET UP



THIS DRAWING IS SUPPLIED TO AID WITH EJECTOR PIN, SLEEVE EJECTOR AND PARTING LINE SET UP WHEN DESIGNING A SYSTEM 2 MOLD.

THE DIMENSION: "CC", IS SHOWN TO LOCATE THE EJECTOR PLATES, AND IN CONJUNCTION WITH DIMENSION: 1.000, TO DETERMINE EJECTOR PIN LENGTHS.

THE DIMENSION: "HH", LOCATES THE CORE RETAINER PLATES, IF SLEEVE EJECTION IS UTILIZED, AND IN CONJUNCTION WITH DIMENSION: .500, TO DETERMINE CORE

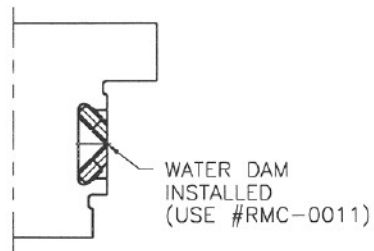
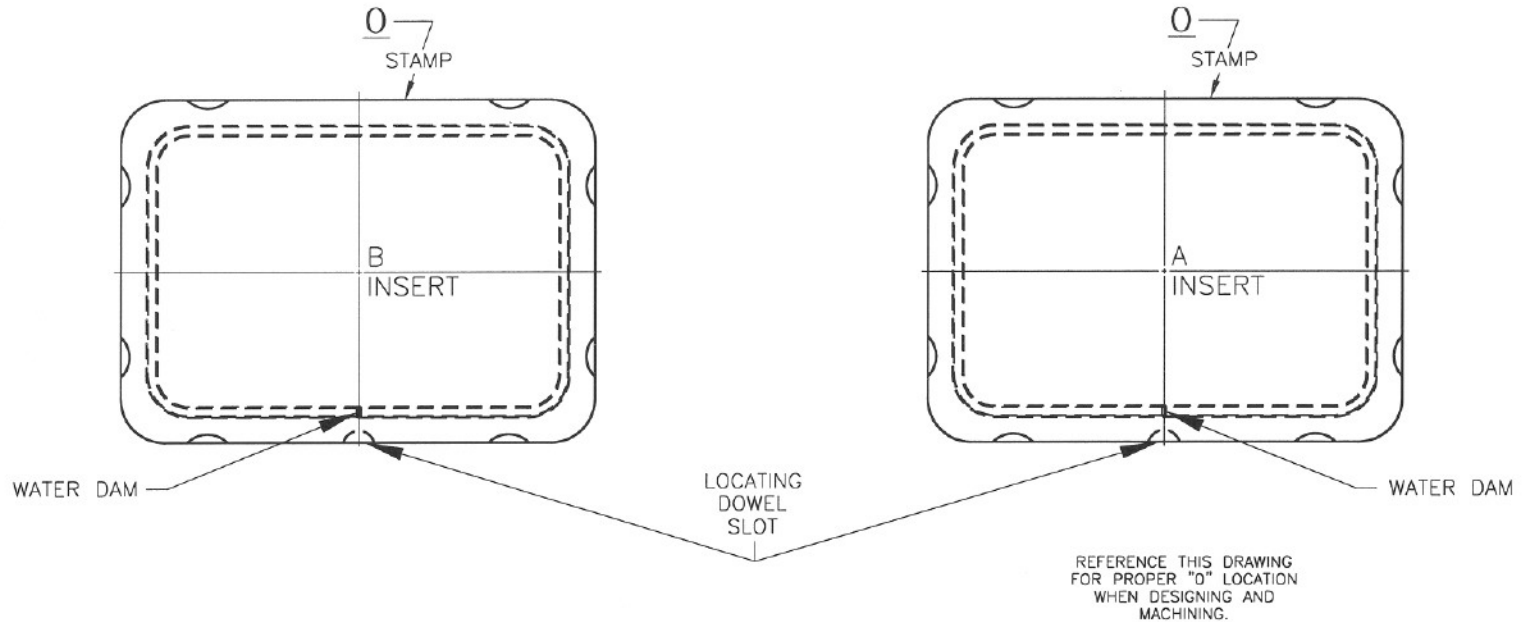
TO ALLOW FOR MINOR ADJUSTMENTS OF THE PARTING LINE OF THE INSERTS, (I.E. SHARPEN CAVITY EDGE, ETC.), THE WORKING THICKNESS OF THE INSERTS WITH RETAINER PLATES IS 5.005, WHILE THE "A" AND "B" PLATES OF THE MASTER FRAME ARE 5.000, LEAVING APPROXIMATELY .005 PER SIDE FOR ADJUSTMENT. PLEASE NOTE SPRINGS BENEATH THE RETURN PINS AUTOMATICALLY COMPENSATE FOR A .000 TO .015 GAP IN THE MASTER FRAME PARTING LINE. INSERTS, WITH STAND UP FOR AN EXTENDED PARTING LINE ARE SOLD IN HALF INCH INCREMENTS.

PART No.	C	CC	HH
STF-24121	4.000	9.6250	10.6750
STF-24122	5.000	10.6250	11.6750



# SYSTEM 2

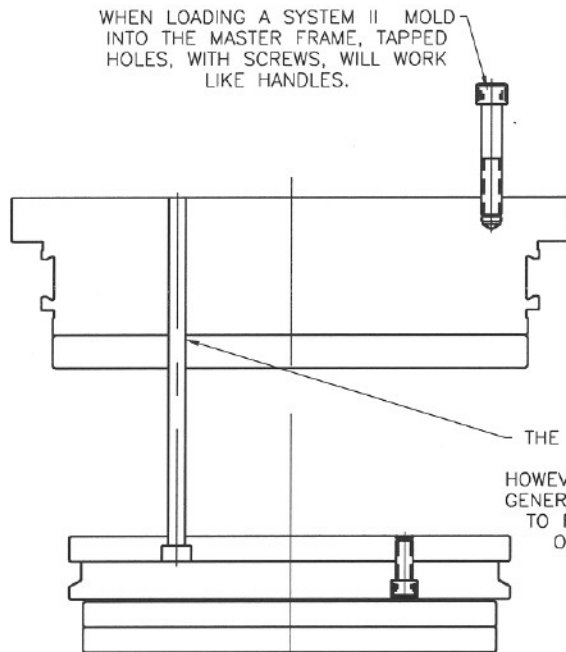
WATER DAM INSTALLATION



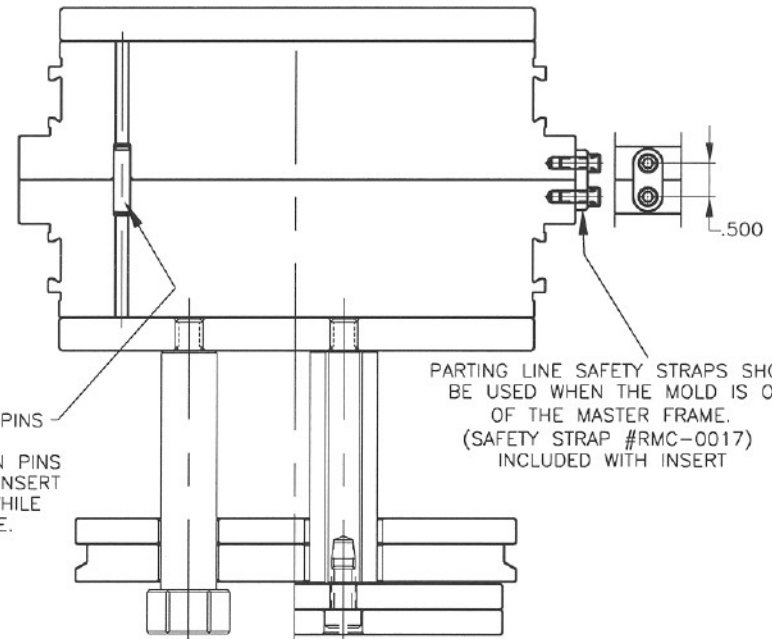
# SYSTEM 2

PRACTICAL DESIGN IDEAS

WHEN LOADING A SYSTEM II MOLD INTO THE MASTER FRAME, TAPPED HOLES, WITH SCREWS, WILL WORK LIKE HANDLES.



THE MASTER FRAME HAS LEADER PINS AND RETURN PINS BUILT IN. HOWEVER, DOWEL PINS AND RETURN PINS GENERALLY ARE INSTALLED IN THE INSERT TO PROTECT THE PARTING LINE WHILE ON THE BENCH OR IN STORAGE.



PARTING LINE SAFETY STRAPS SHOULD BE USED WHEN THE MOLD IS OUT OF THE MASTER FRAME. (SAFETY STRAP #RMC-0017) INCLUDED WITH INSERT