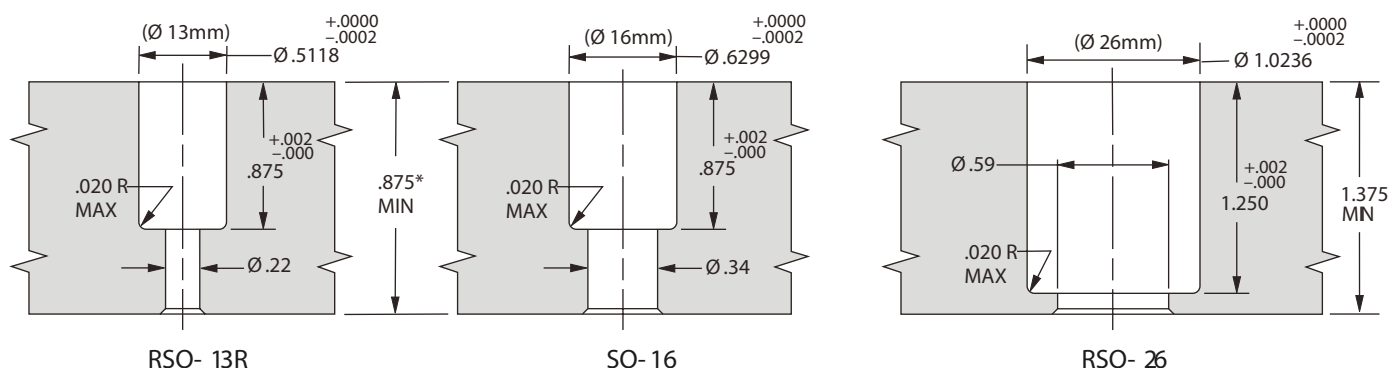


RUNNER SHUT-OFFS

MACHINING INFORMATION

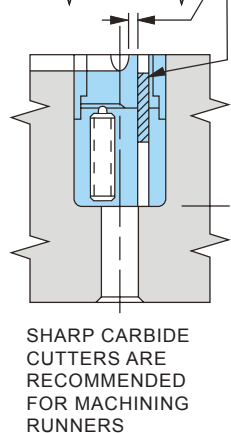
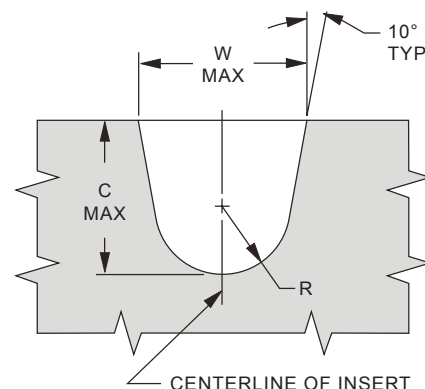
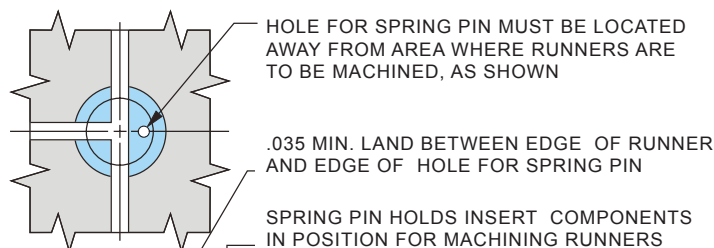
DIMENSIONS FOR MACHINING POCKET FOR RUNNER SHUT-OFFS

- > Pockets are typically bored in soft steel and jig ground in hardened steel
- > Maintain a close tolerance press fit, as specified. Too loose a fit could allow the insert to move out of position, while too tight a press fit might prevent the center core from rotating when required



*When using a 7/8 thick plate with the RSO 0013 or RSO 0016 inserts, machine the .5118 or .6299 diameters through the plate. Inserts must seal against a supporting plate before any grinding or matching is done and during the molding process.

DIMENSIONS FOR MACHINE RUNNERS



All dimensions are in inches except for some metric dimensions which are shown in parentheses.

RECOMMENDED RUNNER SIZES					
Use Insert Item Number	W MAX	C MAX	R RADIUS	\varnothing	AREA S
RSO- 13 (RS)	0.099	0.091	0.040	0.095	0.007
	0.126	0.120	0.050	0.123	0.012
RSO- (RSO-)	0.150	0.131	0.062	0.141	0.016
	0.168	0.144	0.070	0.156	0.019
	0.186	0.157	0.078	0.172	0.023
	0.206	0.175	0.086	0.191	0.029
RSO-	0.260	0.218	0.109	0.239	0.045
	0.298	0.250	0.125	0.274	0.059
	0.334	0.281	0.140	0.308	0.074
	0.372	0.312	0.156	0.342	0.092
	0.410	0.343	0.172	0.377	0.112
	0.446	0.375	0.187	0.411	0.133

NOTE: All runners should be machined along the center line of the insert and at 90° to the center line. If this is not done the runners will not align closely when rotated 90° or 180° to shutoff material flow to a cavity. All runners should be machined with inserts installed in the mold.