

# RUNNER SHUT-OFFS



(U.S. Patent No. 5,208,053)

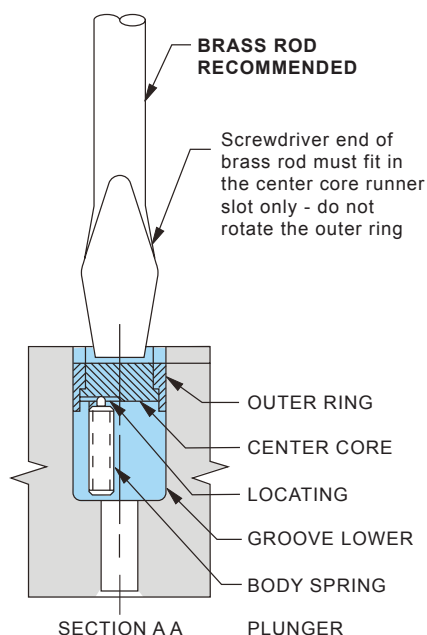
Runner Shut-offs are supplied unmachined as shown in background of photo. Foreground shows sample machining of runner, typically done with shut-off installed in mold.

Runner Shut-Offs provide a precise method of blocking or directing material flow to one or more cavities in multi-cavity or family molds.

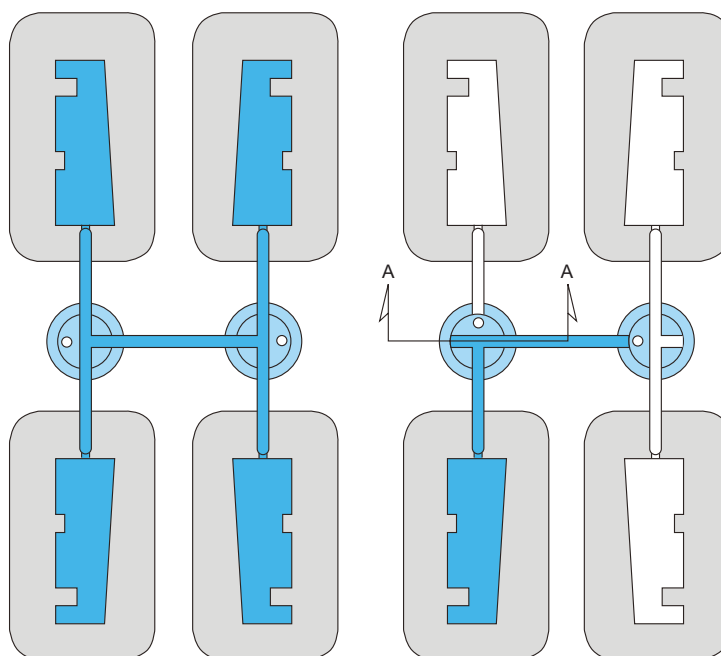
- Safer and more positive than the use of brass or ejector pins
- Reduces scrap and sorting
- Improves cycle time

## Typical Applications

Shutting Off the Runner to One or More Cavities



**NOTE:** Spring plunger in Runner Shut-Off Insert engages a locating groove in the center core. This holds the center core in position at each 90° rotation of the center core, thus providing several combinations of runner shut-off positions.



Runner Shut-Offs are shown above in the open position, which allows material to flow to all cavities.

By rotating the center core of the Runner end of a brass rod, material flow to one or several cavities can be shut off, as shown above.

## Runner Shut-Offs - RSO

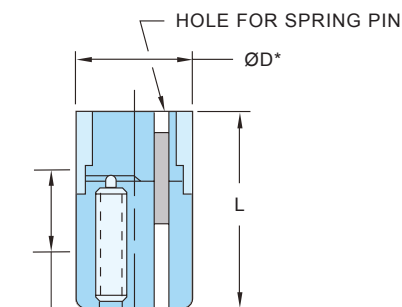
| ITEM NUMBER | ØD            | L LENGTH      |
|-------------|---------------|---------------|
| RSO-13      | .5118 (13mm)  | .885 (22.5mm) |
| RSO-16      | .6299 (16mm)  | .885 (22.5mm) |
| RSO-26      | 1.0236 (26mm) | 1.260 (32mm)  |

All dimensions are in inches except for several parenthetical reference dimensions in millimeters.

### INFORMATION KEY:

C = Depth of Runner  
D = Diameter  
L = Length  
R = Radius  
W = Runner  
Material: Stainless Steel  
Hardness: 50 ± 3HRC  
Max. Temp: 120°C (250°C)  
Dimensions: All dimensions are in inches, except as noted.

\*Measure ØD in this area only. Top and bottom of insert have a very slight relief for proper installation and operation.



Do not adjust spring plunger. It has been supplied installed to the correct position.