

## GENERAL GUIDELINES AND STANDARD TOLERANCES ON SPECIAL MACHINING

All tolerances listed are in inches

DME will make the necessary changes to standard mold base features and tolerances based on our technical expertise and product knowledge. Listed below are our standard tolerances on special machining. If tighter tolerances are required, Customer will need to provide tolerance information for review at the quoting stage to confirm they are achievable.

### **Eyebolts / Lift Holes**

1/2-13 drilled 1.40 deep / tapped 1.22 deep

5/8-11 drilled 1.62 deep / tapped 1.38 deep

3/4-10 drilled 1.78 deep / tapped 1.59 deep

### **FCS Fixture Holes**

FCS fixture holes will be added to plates with the customer's approval and designed into customer's 3d solid

### **Finish Main Insert Pockets and Slide Pockets**

Lengths and widths overall ( +.002 / -.000 )

Locations to Guide Pins and Bushings ( ±.001 )

Depth ( +.000 / -.002 )

Taper per Wall ( ±.0005 ) in 3.0 inches

### **Pocket Corner Radius / Depths able to machine**

Depth of 2.0 (.25 minimum radius)

Depth of 3.0 (.375 minimum radius)

Depth of 4.0 (.500 minimum radius)

Depth of 5.0 (.625 minimum radius)

### **Finish Bores**

Diameter ( +.001 / -.000 )

Locations to Guide Pins and Bushings ( ±.001 )

Depth ( +.000 / -.002 )

### **Outside Plate Alignment**

With mold base assembled all plates will line up on the outside within  $\pm.005$

### **Outside Plate Chamfers**

All plate edges on outside chamfered 45 degrees (  $+0.030 / +0.050$  )

### **Assembly Screws**

Cleared and counter bored  $1/32$  oversize on diameters and depths

### **Tube Dowels / Solid Dowels**

Diameter (  $+0.001 / +0.003$  )

Locations ( $\pm.001$  )

### **Return Pins and Ejector Pin Clearance Holes and Counter Bore depths**

Diameters Cleared (  $+0.015 / +0.03$  ) over pin diameter

Counter Bore depth (  $+0.003 / -.000$  )

### **Return Pin Drilled or Reamed Holes**

Diameter carbide drilled or Reamed oversize (  $+0.002 / +0.004$  )

**Unless customer has supplied separate tolerances agreed to by DME all the above stated tolerances will apply.**