



## Premium, Interchangeable Plate Mold Base “PLUS” Additional Services

### DME XPRESS™ PLUS MOLD BASE

The DME XPress is an A or B-Series mold base, available in 23 sizes, which can be configured into 58,000 standard mold bases. Please see the XPress configurator on page 2.

With a value, quality, and lead time that is so compelling the DME XPress Mold Base enables even the most efficient shop to save time and money by purchasing instead of making – *increasing productivity as much as 40%.*

#### Now take it to the next level...

DME XPress PLUS offers the XPress mold base features, *plus* additional services to meet your needs and a 50% faster lead time than the industry standard.

### THE DME XPRESS ADVANTAGE

#### Stress Relieved & Pre-Hardened Steel

- Increases your cutting speeds
- Reduces machine center spindle time
- Avoid unnecessary downtime
- Extended tool life
- DME #3 premium P20 steel - “Machined 4 Quality”

#### Interchangeable plates

- Precision machined
- Repeatable
- Replacement plates ship same day

#### Off the Shelf

- 58,000 configurations
- Engineered and validated
- Immediate shipment\*

### CONTACT MILACRON - DME

For more information or delivery options contact at:  
800-626-6653 (U.S.) • 800-387-6600 (Canada) • 248-398-6000 (Worldwide).

[www.dme.net](http://www.dme.net)

<https://store.milacron.com>

Keyword search: **XPRESS**



### ADDITIONAL XPRESS PLUS SERVICES

- Support Pillars
- Secondary and/or Reversed Leader Pins
- Additional Stop Disks, Assembly Screws, Return Pins
- Knock Out Holes
- Waterlines Horizontal & Vertical
- Ejector Pin and Spring Holes
- Rectangular Pockets - Rough or Finished
- Lock and Slide Pockets
- Rough Bore – Blind/Through
- Side & Parting Line Interlocks
- Stripper Bolt, Safety Strap and Lift Holes
- Pipe Clearance Slots
- Shot Counter Pocketing

*See other side for specific service details*

### XPRESS MOLD BASE STEEL COMPOSITION

**#1 Steel:** AISI 1045, 1.1730 or equivalent, stress-relieved, annealed

**#2 Steel:** AISI 4130, 4140 or equivalent, stress-relieved, pre-hardened, 28-34 HRC

**#3 Steel:** AISI P20, DIN 1.2311, G40CrMnMo7 or equivalent, stress-relieved, pre-hardened, 28-35 HRC

### XPRESS MOLD BASE STEEL

DESCRIPTION	STEEL	T	W X L
Top Clamp Plate	#2	±0.001	±0.002
AC-Plate	#3	±0.001	±0.002
A-Plate	#3	±0.001	±0.002
B-Plate	#3	±0.001	±0.002
Support Plate	#2	±0.001	±0.002
Rails	#1	±0.001	+0/-0.004
Ejector Retainer Plate	#1	±0.015	+0/-0.004
Ejector Plate	#1	±0.015	+0/-0.004
Bottom Clamp Plate	#1	±0.001	±0.002

\*Plates ≥ 5 7/8" thick may require additional time for delivery.



**Get XPress 3D CAD data:** Go to: [www.dme.net/xpresscad](http://www.dme.net/xpresscad)  
3D CAD data available in SolidWorks® Parametric, Creo Parametric and Parasolid.

## TO ORDER AN XPRESS PLUS MOLD BASE:

Go to the Milacron/DME eStore: [store.milacron.com](http://store.milacron.com) and then select configurator and DME Americas online store.  
Click on DME XPress A or B-Series tab and configure your XPress mold base through the following 6 steps:

Configure your mold base using steps 1-7 below. Example Part Number for highlighted selections: **XPA1012 -17 -17 -35 -GE -3**

**1** XP A 1012 -17 -17 -35 -GE -3

FAMILY			SERIES		BASE	SIZE (W" X L")	AP	THICKNESS	BP	THICKNESS	RAIL	HEIGHT	EJECTION		A/B PLATE MATERIAL	
XP	A	A Series	0808	7.875 x 7.875	7*	0.875"	7	0.875"	25†	2.50"	GE	Guided Ejection	3	P20		
XP	B	B Series	0812	7.875 x 11.875	13*	1.375"	13	1.375"	30	3.00"	NG	No Guided Ejection				
			1008	9.875 x 8	17	1.875"	17	1.875"	35	3.50"						
			1012	9.875 x 11.875	23	2.375"	23	2.375"	40	4.00"						
			1016	9.875 x 16	27	2.875"	27	2.875"	45	4.50"						
			1112	10.875 x 12	33	3.375"	33	3.375"								
			1114	10.875 x 14	37	3.875"	37	3.875"								
			1118	10.875 x 18	47	4.875"	47	4.875"								
			1212	11.875 x 12	57	5.875"	57	5.875"								
			1215	11.875 x 15	7NCH*	0.875"										
			1220	11.875 x 20	13NCH*	1.375"										
			1315	13.375 X 15	17NHC	1.875"										
			1318	13.375 X 18	23NHC	2.375"										
			1321	13.375 X 20.75	27NHC	2.875"										
			1518	14.875 x 17.875	33NHC	3.375"										
			1524	14.875 x 23.75	37NHC	3.875"										
			1616	15.875 x 16	47NHC	4.875"										
			1620	15.875 x 20	57NHC	5.875"										
			1623	15.875 x 23.5												
			1818	17.875 x 18												
			1820	17.875 x 20												
			1823	17.875 x 23.5												
			1924	19.5 x 23.75												



**2**

0 - 7/32"

SPRUE ORIFICE

0	5/32"
	7/32"
	9/32"
	11/32"
	Omit

**3**

R - 1/2"

SPRUE RADIUS

R	1/2"
	3/4"
	Omit

**4**

L - 6501

LOCATION	RING	DESCRIPTION
L	6501	3.99 Ø Standard
	6521	3.99 Ø Standard, Extra Length
	6504	3.99 Ø Clamp Type
		Omit

- A & B-Series plates with no additional letters include center hole in the TCP & AP, or AC plates.
- **NCH** = No center hole in the TCP and the AP plate for the A-Series or the AC plate for B-Series
- \* 7/8" and 1 3/8" available only in the A-Series
- † = 2.5" Rails only available in base sizes 0808 to 1118

### 5 SELECT A QUANTITY

### 6 ADD XPRESS PLUS SERVICES

### 7 SEND CAD FILES TO DME

## CUSTOMER SUPPORT MATERIAL

**Drawing Formats:** Electronic drawing/models from you:

- Download DME XPress 3D CAD data in: Solidworks™ Parasolids, Creo Parasolids and Step
- Return to DME ([dme\\_cad@dme.net](mailto:dme_cad@dme.net)): Modified 3D model with additional features required
- 2D-drawings with tolerances

DME is able to work paperless only from 3D-models, 2D-Data is required for tolerance info.

- Support Pillars
- Secondary Leader Pins – Manifold Alignment
- Reversed Leader Pins – Manifold Alignment
- Additional Stop Disks – (drill/tapped holes)
- Additional Assembly Screws
- Additional Return Pins
- Additional Pry bar Slots
- Waterlines – including Counterbores & Taps
- Ejector Pin Holes
- Spring Holes (std. dia. only) Return Pin Loc.
- Rectangular Insert Pockets – Blind/Through (max pocket depth 3" / minimum 0.375" corner radius)
- Rough or Finished Pockets
- Lock Pockets
- Slide Pockets
- Rough Bore – Blind/Through
- Side & Parting Line Interlocks
- Knock Out Holes
- Stripper Bolt holes
- Safety Strap Holes
- Additional Lift Holes
- Pipe Clearance Slots
- Shot Counter Pocketing