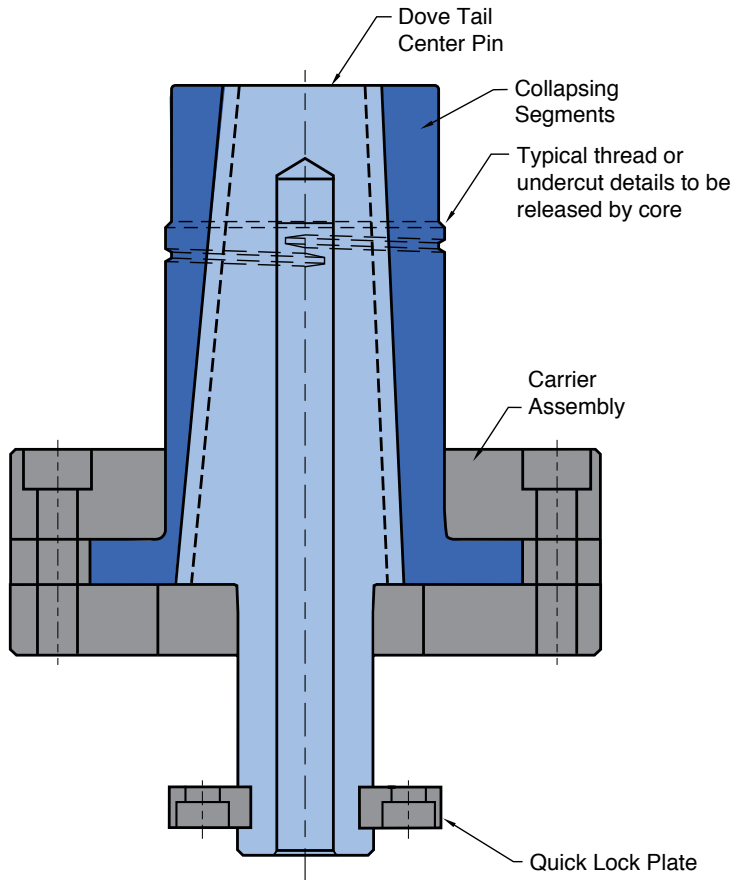


US Patent No. 8,033,810
Other patents pending



Collapsing Segments

M A-2 **H** 54-57 HRC

- Designed to mechanically collapse when the center pin is withdrawn.
- The fit between the segments is controlled to permit flash-free molding.

Center Pin

M D-2 **H** 58-63 HRC

- Serves to expand the segments of the core to their molding position
- The pin may be flush to the core face.

Carrier Assembly

M D-2 **H** 58-62 HRC

- Mounts DT Core assembly to the mold carrier plate.
- Provides guided and anti-rotational segment movement.

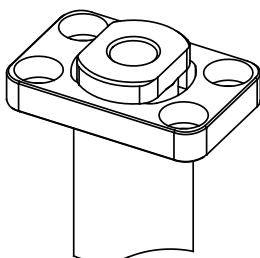


Quick Lock Feature

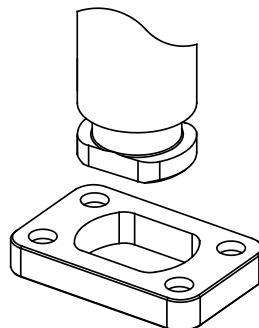
Plate Material: A-2, 54-57 HRC

Utilizing Progressive's exclusive Quick Lock mounting configuration, the DT Core can be removed and serviced while the mold remains in the press. This feature allows for a higher cavitation percentage and lower maintenance costs than other tool design approaches.

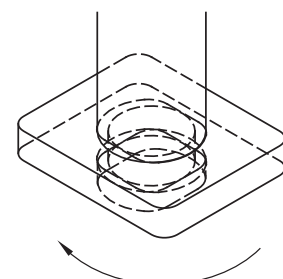
Bottom view of Center Pin and Quick Lock Plate in locked position.

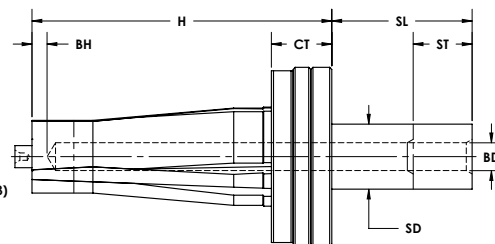
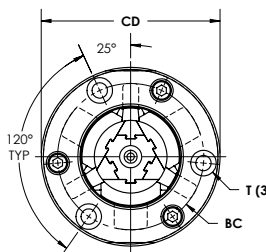
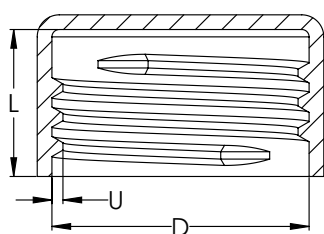


Align and push end of Center Pin through Quick Lock Plate.



Rotate Center Pin clockwise 90° to lock into place.

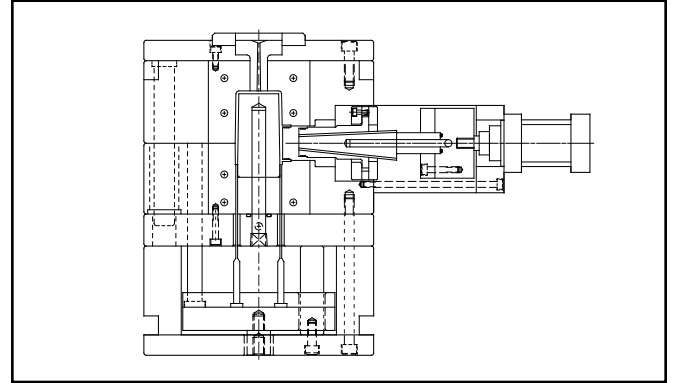
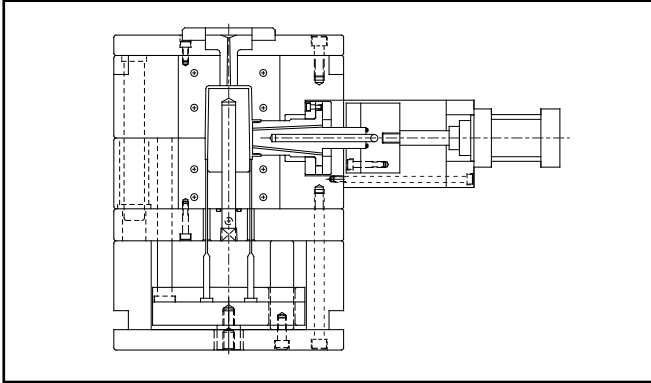




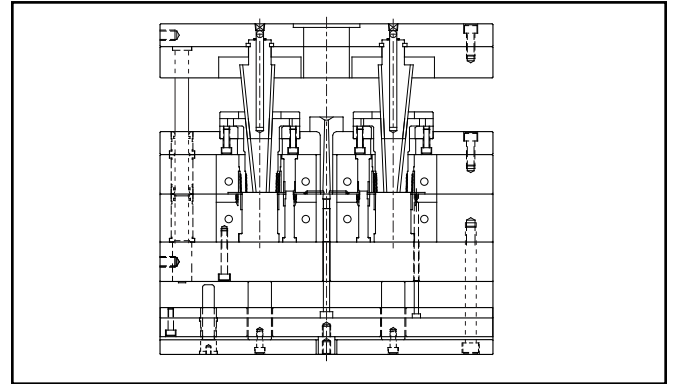
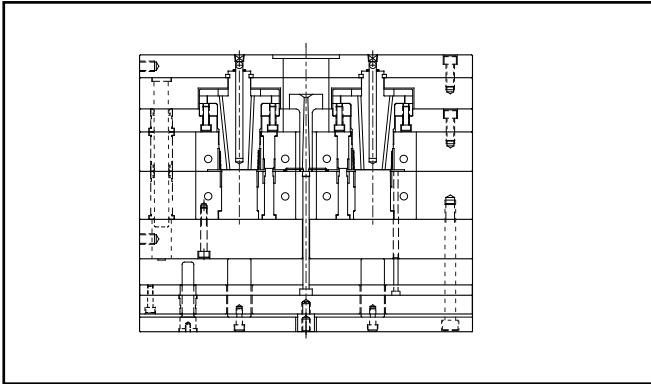
CATALOG NUMBER	D Maximum Outer Diameter	U Max Undercut	L Maximum Molding Length	ST Maximum Collapse Stroke	H Core Length	SD Shaft Diameter	BD Cooling Hole Diameter	BH Distance to Cooling Hole	SL Shaft Length	CD Carrier Diameter	CT Carrier Assembly Thickness	BC Mounting Screw Bolt Circle	T Mounting Screws (SHCS)
DT1010	10.00-10.99mm .394-.433in	.36mm .014in	7.5mm .295in	43.5mm 1.713in	87mm 3.425in	10.5mm .413in	3mm .1in	5mm .2in	58mm 2.283in	50mm 1.969in	21mm .827in	37mm 1.457in	M5 x 25
DT1111	11.00-11.99mm .433-.472in	.41mm .016in	8mm .315in	44.5mm 1.752in									
DT1212	12.00-12.99mm .472-.511in	.46mm .018in	8.5mm .335in	45.5mm 1.791in									
DT1313	13.00-13.99mm .512-.551in	.51mm .020in	9mm .354in	46.5mm 1.831in	87mm 3.425in	12mm .472in	4mm .2in	5mm .2in	59mm 2.323in	52mm 2.047in	21mm .827in	38mm 1.496in	M6 x 35
DT1414	14.00-14.99mm .551-.590in	.56mm .022in	9.5mm .374in	47mm 1.850in									
DT1515	15.00-15.99mm .591-.630in	.61mm .024in	10mm .394in	47.5mm 1.870in									
DT1616	16.00-16.99mm .630-.669in	.66mm .026in	10.5mm .413in	48mm 1.890in	87mm 3.425in	15.5mm .610in	6mm .2in	5mm .2in	62mm 2.362in	54mm 2.126in	21mm .827in	43mm 1.614in	M5x25
DT1717	17.00-17.99mm .669-.708in	.71mm .028in	11mm .433in	48.5mm 1.909in									
DT1819	18.00-19.99mm .709-.787in	.82mm .032in	12mm .472in	50mm 1.969in									
DT2021	20.00-21.99mm .787-.866in	.92mm .036in	12.5mm .492in	55mm 2.165in	99mm 3.898in	18mm .709in	8mm .3in	6mm .2in	61mm 2.402in	63mm 2.480in	24mm .945in	49mm 1.929in	M6x30
DT2224	22.00-24.99mm .866-.984in	1.04mm .041in	13mm .512in	59mm 2.323in									
DT2527	25.00-27.99mm .984-1.102in	1.20mm .047in	15mm .591in	66.5mm 2.618in									
DT2830	28.00-30.99mm 1.102-1.220in	1.36mm .053in	18mm .709in	71mm 2.795in	129mm 5.079in	28mm 1.102in	12mm .5in	6mm .2in	60mm 2.362in	77mm 3.031in	26mm 1.024in	63mm 2.480in	M6x30
DT3133	31.00-33.99mm 1.220-1.338in	1.50mm .059in	21mm .827in	78mm 3.071in									
DT3436	34.00-36.99mm 1.339-1.456in	1.73mm .068in	22mm .866in	79mm 3.110in									
DT3739	37.00-39.99mm 1.457-1.574in	1.88mm .074in	24mm .945in	85mm 3.346in	139mm 5.472in	34mm 1.339in	14mm .6in	6mm .2in	64mm 2.520in	93mm 3.661in	27mm 1.063in	75mm 2.953in	M8x30
DT4042	40.00-42.99mm 1.575-1.693in	2.06mm .081in	25mm .984in	86mm 3.386in									
DT4345	43.00-45.99mm 1.693-1.811in	2.24mm .088in	27mm 1.063in	93mm 3.661in									
DT4648	46.00-48.99mm 1.811-1.929in	2.42mm .095in	28mm 1.102in	94mm 3.701in	161mm 6.339in	42mm 1.654in	20mm .8in	6mm .2in	69mm 2.717in	110mm 4.331in	32mm 1.260in	90mm 3.543in	M8x35
DT4951	49.00-51.99mm 1.929-2.047in	2.57mm .101in	31mm 1.220in	99mm 3.898in									
DT5254	52.00-54.99mm 2.047-2.165in	2.77mm .109in	32mm 1.260in	100mm 3.937in									
DT5557	55.00-57.99mm 2.165-2.283in	2.95mm .116in	34mm 1.339in	106mm 4.173in	183mm 7.205in	50mm 1.969in	22mm .9in	6mm .2in	85mm 3.346in	130mm 5.118in	39mm 1.535in	107mm 4.213in	M10x45
DT5860	58.00-60.99mm 2.283-2.401in	3.10mm .122in	36mm 1.417in	111mm 4.370in									

For sizes larger than 60mm, contact Mould & Die Solutions

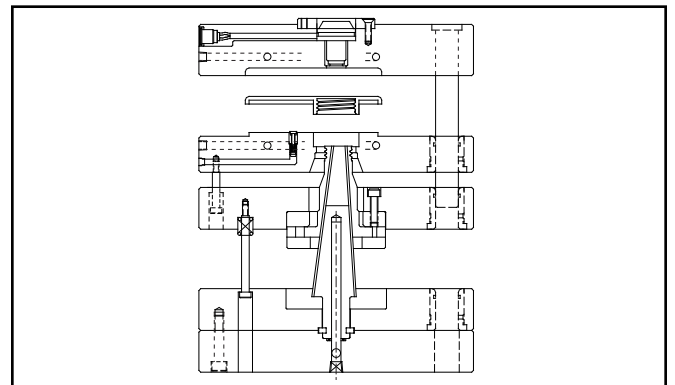
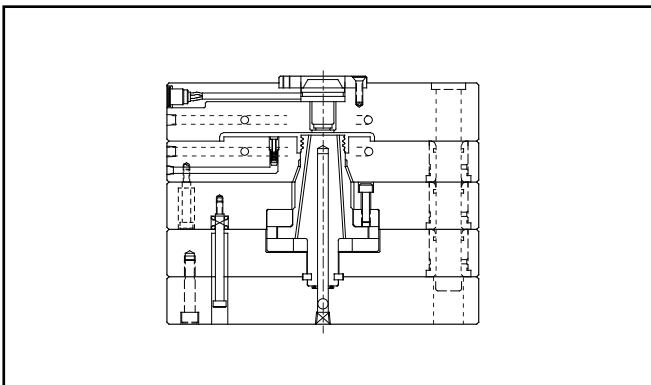
Side Action



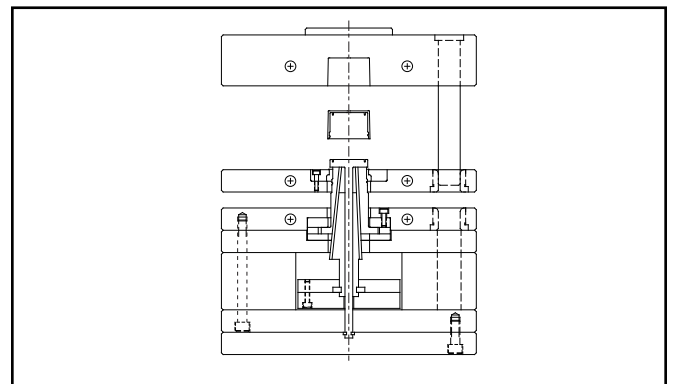
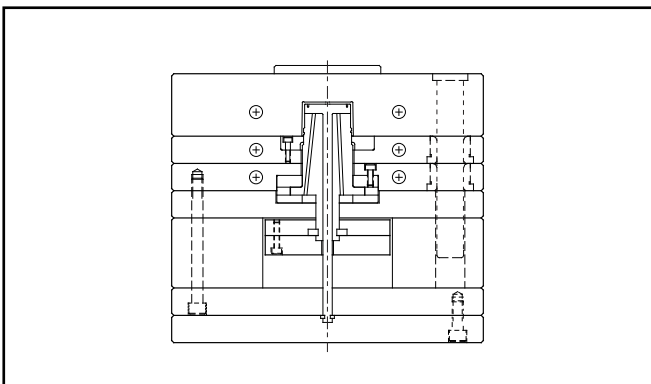
Cavity Side

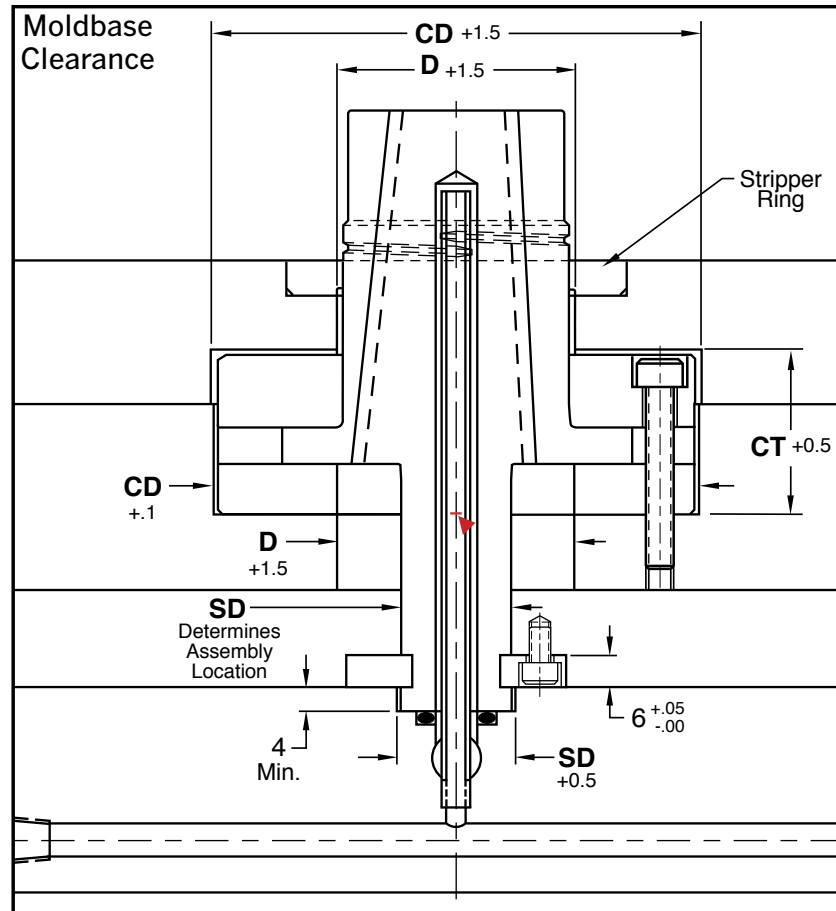


Boss Detail



Seal Ring





Each Dove Tail Collapsible Core includes:

- DT Series Core/Pin/Carrier Assembly
- Quick Lock Plate
- All mounting screws

Application Guidelines

- All standard DT Series Cores offer 360° molding of threads or other undercuts.
- Molded parts do not need to be closed at one end. They may be partially or completely open.
- Stripper ring can be provided by moldmaker with either a tapered or straight fit, as shown in the machining guidelines at left.
- Parts with size requirements that fall outside of the standard sizes are available on a custom order basis.
- Progressive can provide Dove Tail cores with your thread or cap detail already machined. Also, coatings and treatments may also be provided. Email your part drawing or application to tech@procomps.com for a review.