

# ROUND MATE<sup>®</sup>

*Systems*

## **MOLDMAKERS REFERENCE GUIDE** **3", 4", 6" & 8" INSERTS**

**UNCONTROLLED FOR REFERENCE ONLY**

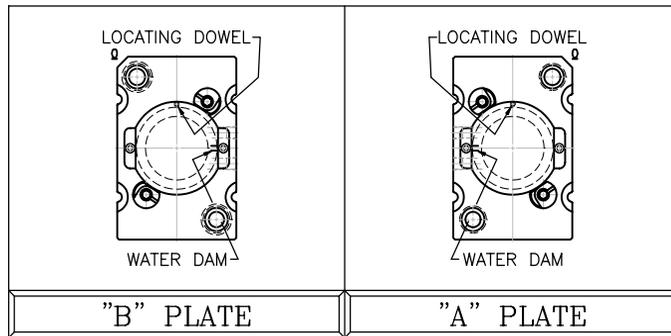
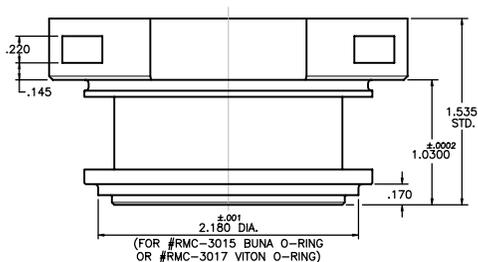
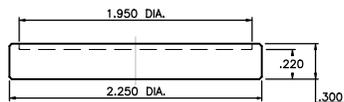
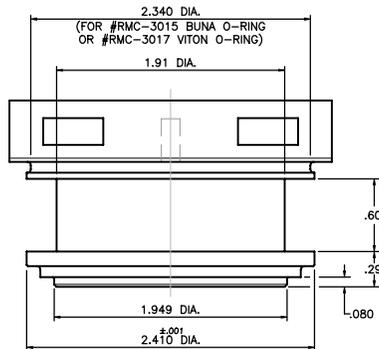
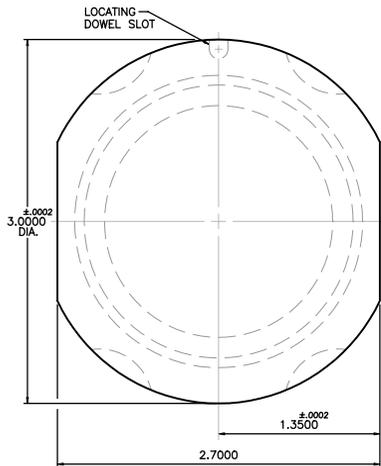
Issue Date:  
February 12, 2003

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# 3" ROUND MATE® SINGLE POSITION INSERT DIMENSIONS



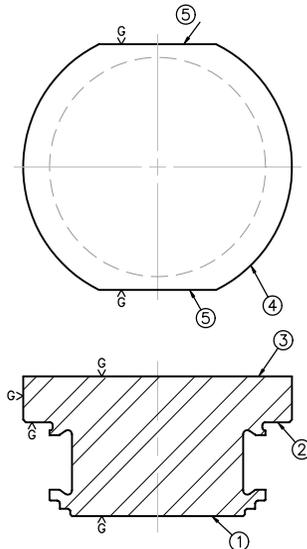
THE "A" INSERT IS THE SAME AS THE "B" INSERTS EXCEPT FOR THE WATER DAM LOCATION

TOOLMAKER IS TO INSTALL THE WATER DAM

WATER DAM IS TO LINE UP WITH WATER INLET/  
OUTLET IN THE MASTER FRAME

# 3" ROUND MATE® SINGLE POSITION GRINDING PROCEDURES

(SEE ILLUSTRATION)



## GRINDING PROCEDURES 3" ROUND MATE® INSERT

THIS DRAWING IS SUPPLIED TO AID IN GRINDING "HEAT TREATABLE"  
INSERTS AFTER "HEAT TREAT"

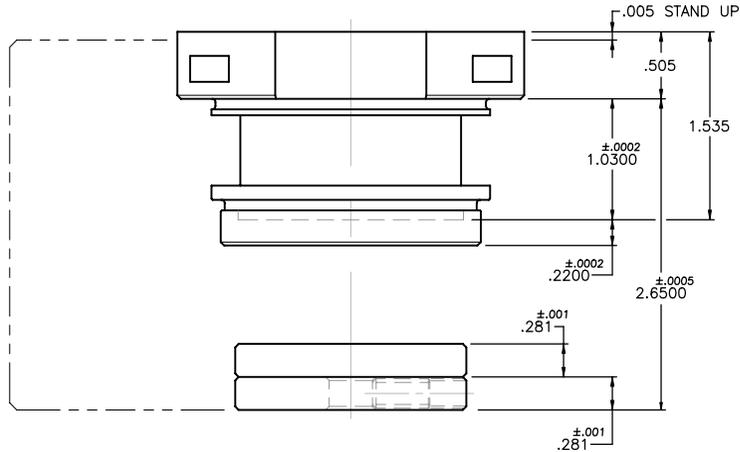
When you receive the "Round Mate"® insert, in any heat treatable steel, it is machined to .005 / .010 oversize, per side, on all critical dimensions. Following the heat treating process, this additional stock must be removed in the following sequence:

- (1) Grind .004 extra stock from the bottom, or small diameter end, of the insert.
- (2) Grind step, to the underside of the 3.000 diameter, to a measurement of 1.0300 ( +/-.0002) Approximately the same .004 will be removed.
- (3) Grind the face, or parting line, of the insert to achieve an over-all thickness of 1.535 (+.005/-.004) Grinding within these tolerances places the O-rings in ideal position for a perfect seal.
- (4) Grind the outside diameter of the insert head to 3.0000 (+/-.0002)
- (5) The final step is grinding the flats. It is extremely important that the flats be ground in relationship to the center of the insert diameter to assure registration and the absence of a parting line mismatch on the molded part. The dimension is 2.7000 (+/-.0002) between the flats (the 2.7000 must be centered on the 3.000 diameter +/-.0002 TIR).

Note: The other outside surfaces on the insert are NOT shipped oversized, therefore , grinding will probably be unnecessary. However, we suggest you check these O.D.'s for accuracy after heat treat.

# 3" ROUND MATE® SINGLE POSITION

**PIN AND PARTING  
LINE SETUP**



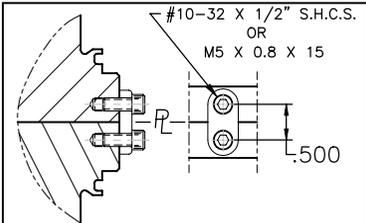
THIS DRAWING IS SUPPLIED TO AID WITH EJECTOR PIN AND PARTING LINE SET UP WHEN DESIGNING A ROUND MATE® MOLD.

THE 2.6500 DIMENSION IS SHOWN TO LOCATE THE EJECTOR PLATES, AND IN CONJUNCTION WITH DIMENSION: .281, TO DETERMINE EJECTOR PIN LENGTHS.

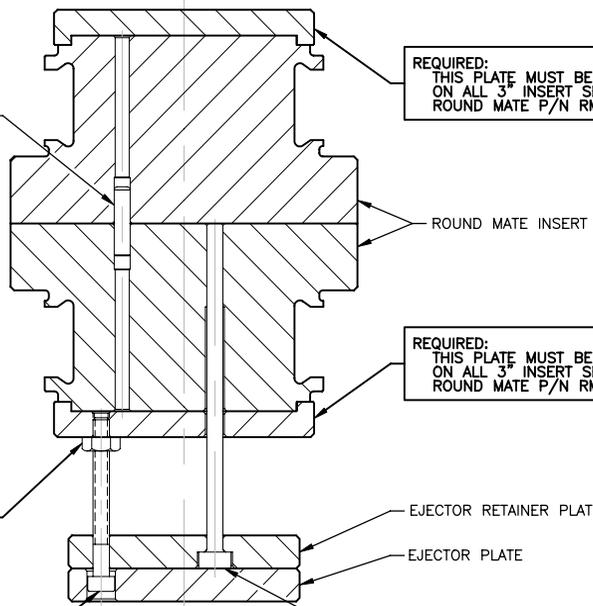
# 3" ROUND MATE® SINGLE POSITION REQUIREMENTS AND RECOMMENDATIONS

RECOMMENDED:  
LEADER PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
DOWELS ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.

REQUIRED:  
THIS PLATE MUST BE INSTALLED  
ON ALL 3" INSERT SETS.  
ROUND MATE P/N RMC-3001



RECOMMENDED:  
PARTING LINE SAFETY STRAPS  
SHOULD BE USED WHEN THE MOLD  
IS OUT OF THE MASTER FRAME  
TO PROTECT THE PARTING LINE.  
ONE INCLUDED WITH EACH INSERT  
ROUND MATE P/N RMC-0017



REQUIRED:  
THIS PLATE MUST BE INSTALLED  
ON ALL 3" INSERT SETS.  
ROUND MATE P/N RMC-3001

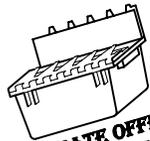
REQUIRED:  
ADD LOCK NUT TO BOLT.

EJECTOR RETAINER PLATE  
EJECTOR PLATE

REQUIRED:  
DRILL & C'BORE FOR SHCS TO  
RETAIN EJECTOR PLATES WHILE  
THE INSERT SET IS OUT OF THE  
MASTER FRAME

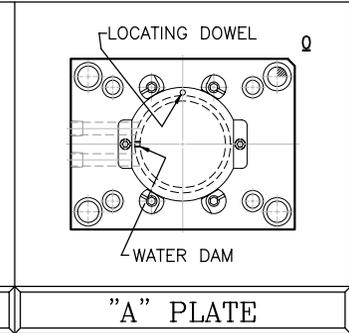
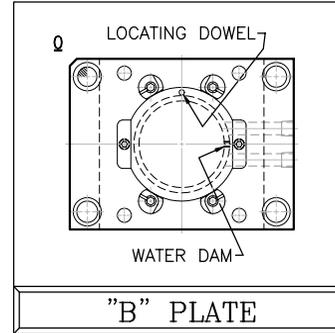
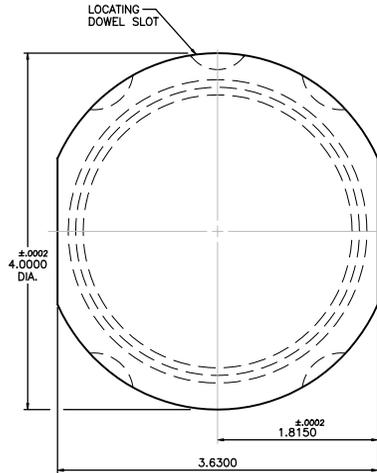
RECOMMENDED:  
RETURN PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
THEY ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.

# NOTES



**ROUND MATE OFFERS  
STORAGE BOXES FOR  
ALL SIZES OF INSERT SETS.  
REFERENCE CATALOG PAGE #6.02**

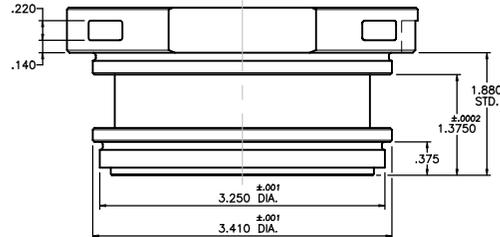
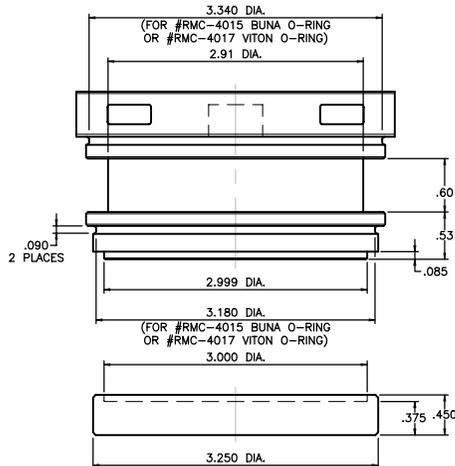
# 4" ROUND MATE® SINGLE POSITION INSERT DIMENSIONS



THE "A" INSERT IS THE SAME AS THE "B" INSERTS EXCEPT FOR THE WATER DAM LOCATION

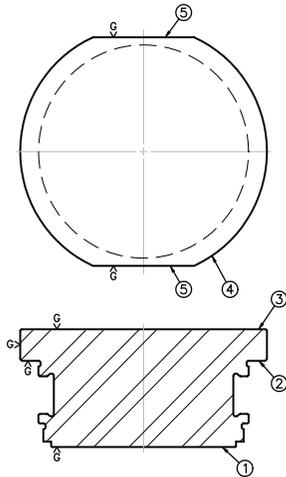
TOOLMAKER IS TO INSTALL THE WATER DAM

WATER DAM IS TO LINE UP WITH WATER INLET/OUTLET IN THE MASTER FRAME



# 4" ROUND MATE® SINGLE POSITION GRINDING PROCEDURES

(SEE ILLUSTRATION)



## GRINDING PROCEDURES 4" ROUND MATE® INSERT

THIS DRAWING IS SUPPLIED TO AID IN GRINDING "HEAT TREATABLE" INSERTS AFTER "HEAT TREAT"

When you receive the "Round Mate"® insert, in any heat treatable steel, it is machined to .005 / .010 oversize, on all critical dimensions. Following the heat treating process, this additional stock must be removed in the following sequence:

- (1) Grind .004 extra stock from the bottom, or small diameter end, of the insert.
- (2) Grind step, to the underside of the 4.000 diameter, to a measurement of 1.375 ( +/ - .0002) Approximately the same .004 will be removed.
- (3) Grind the face, or parting line, of the insert to achieve an over-all thickness of 1.880 (+.005/- .004) (important note: this tolerance is compensated by springs under the return pins in the master frame. These spring will absorb up to .015 overall margin in the master frame parting line) Grinding within these tolerances places the O-rings in ideal position for a perfect seal.
- (4) Grind the outside diameter of the insert head to 4.0000 (+/- .0002)
- (5) The final step is grinding the flats. It is extremely important that the flats be ground in relationship to the center of the insert diameter to assure registration and the absence of a parting line mismatch on the molded part. The dimension is 3.6300 (+/- .0002) between the flats (the 3.6300 must be centered on the 4.000 diameter +/- .0002 TIR).

Note: The other outside surfaces on the insert are NOT shipped oversized, therefore , grinding will probably be unnecessary. However, we suggest you check these O.D.'s for accuracy after heat treat.



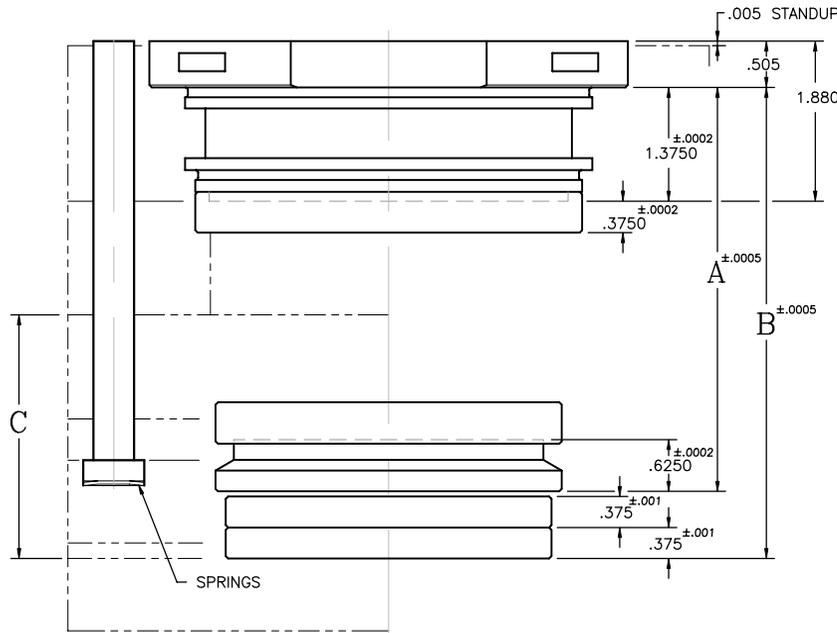
# 4" ROUND MATE® MULTI-POSITION PIN, SLEEVE, AND PARTING LINE SET UP

THIS DRAWING IS SUPPLIED TO AID WITH EJECTOR PIN, SLEEVE EJECTOR AND PARTING LINE SET UP WHEN DESIGNING A ROUND MATE® MOLD.

THE DIMENSION: "A", IS SHOWN TO LOCATE THE EJECTOR PLATES, AND IN CONJUNCTION WITH DIMENSION: .6250, TO DETERMINE EJECTOR PIN LENGTHS.

THE DIMENSION: "B", LOCATES THE CORE RETAINER PLATES, IF SLEEVE EJECTION IS UTILIZED, AND IN CONJUNCTION WITH DIMENSION: .375, TO DETERMINE CORE PIN LENGTHS.

ON MULTI POSITION MASTER FRAMES, WITH THE RUNNER RUNNING ACROSS THE FLAT OF THE INSERT FROM THE SIDE, THE .005 INSERT STANDUP ABOVE THE MOLD PLATE MUST BE HELD. RUNNER BLOCKS IN THE MASTER FRAME MUST LINE UP WITH THE PARTING LINE OF THE INSERT. THIS IS SET TO BE .005 ABOVE THE MOLD PLATE ON BOTH THE "A" AND THE "B" SIDES OF THE MASTER FRAME.

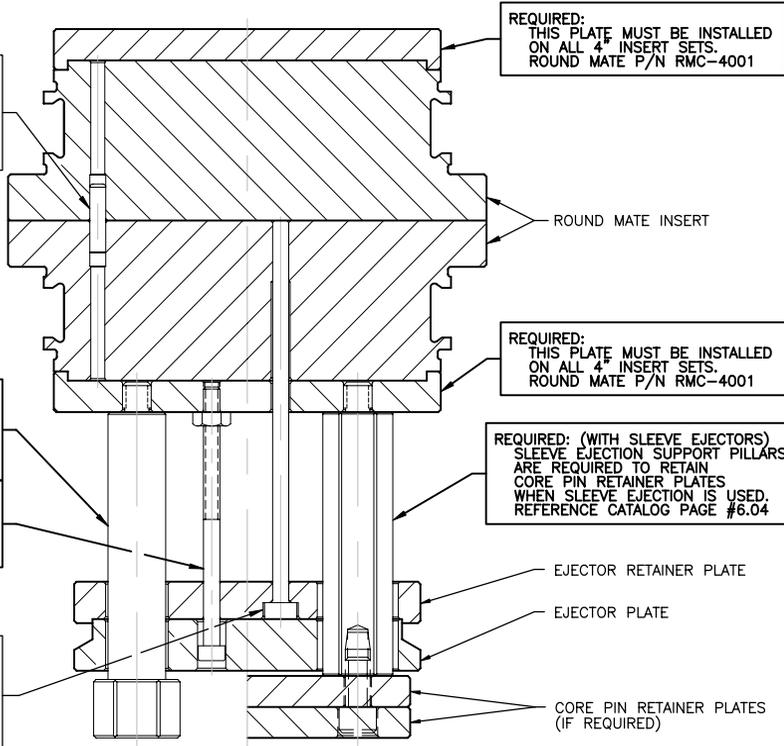


MASTER FRAME	C	A	B
RMF-0423	3.000	5.4375	6.2500

# 4" ROUND MATE® SINGLE POSITION & MULTI-POSITION

## REQUIREMENTS AND RECOMMENDATIONS

RECOMMENDED:  
LEADER PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
DOWELS ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.



REQUIRED:  
THIS PLATE MUST BE INSTALLED  
ON ALL 4" INSERT SETS.  
ROUND MATE P/N RMC-4001

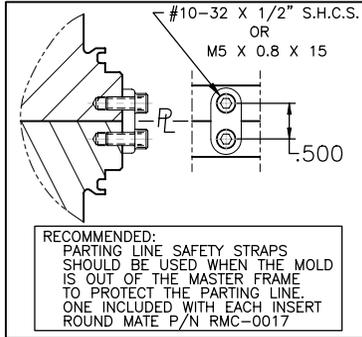
REQUIRED:  
THIS PLATE MUST BE INSTALLED  
ON ALL 4" INSERT SETS.  
ROUND MATE P/N RMC-4001

REQUIRED: (PREFERRED OPTION)  
SUPPORT PILLARS MUST BE USED  
TO RETAIN EJECTOR PLATES WHILE  
THE INSERT SET IS OUT OF THE  
MASTER FRAME.  
REFERENCE CATALOG PAGE #6.04

REQUIRED: (ALTERNATE OPTION)  
DRILL & C'BORE FOR SHCS TO  
RETAIN EJECTOR PLATES WHILE  
THE INSERT SET IS OUT OF THE  
MASTER FRAME

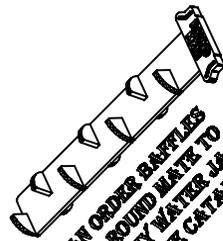
RECOMMENDED:  
RETURN PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
THEY ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.

REQUIRED: (WITH SLEEVE EJECTORS)  
SLEEVE EJECTION SUPPORT PILLARS  
ARE REQUIRED TO RETAIN  
CORE PIN RETAINER PLATES  
WHEN SLEEVE EJECTION IS USED.  
REFERENCE CATALOG PAGE #6.04



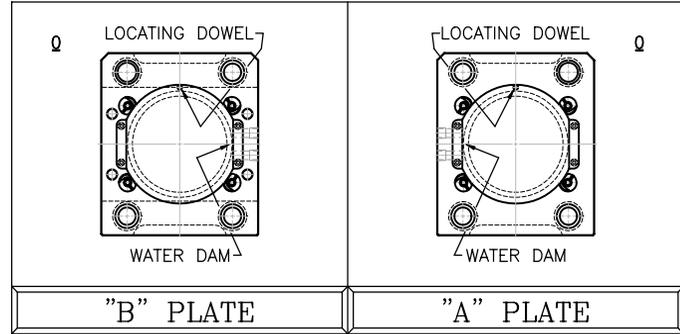
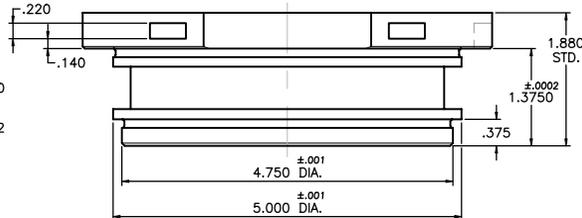
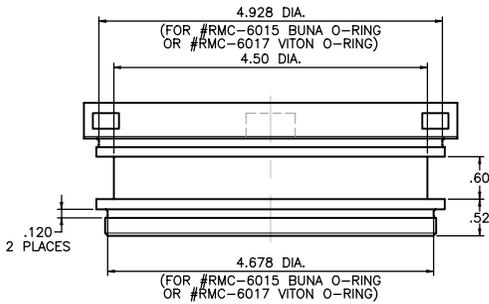
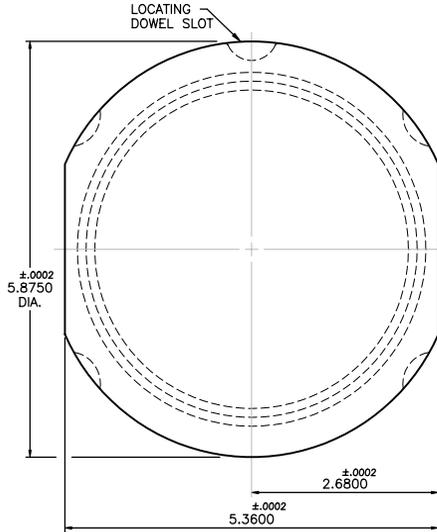
RECOMMENDED:  
PARTING LINE SAFETY STRAPS  
SHOULD BE USED WHEN THE MOLD  
IS OUT OF THE MASTER FRAME  
TO PROTECT THE PARTING LINE.  
ONE INCLUDED WITH EACH INSERT  
ROUND MATE P/N RMC-0017

# NOTES



**I CAN ORDER BAFFLES  
FROM ROUND WARE TO  
USE IN MY WATER JACKETS.  
REFERENCE CATALOG PAGE PG.08**

# 6" ROUND MATE® SINGLE POSITION INSERT DIMENSIONS



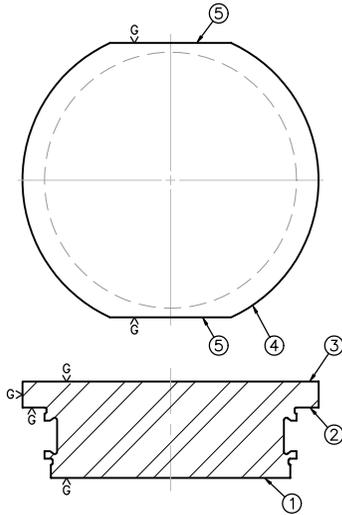
THE "A" INSERT IS THE SAME AS THE "B" INSERTS  
EXCEPT FOR THE WATER DAM LOCATION

TOOLMAKER IS TO INSTALL THE WATER DAM

WATER DAM IS TO LINE UP WITH WATER INLET/  
OUTLET IN THE MASTER FRAME

# 6" ROUND MATE® SINGLE POSITION GRINDING PROCEDURES

(SEE ILLUSTRATION)



THIS DRAWING IS SUPPLIED TO AID IN GRINDING "HEAT TREATABLE" INSERTS AFTER "HEAT TREAT"

When you receive the "Round Mate"® insert, in any heat treatable steel, it is machined to .005 / .010 oversize, per side, on all critical dimensions. Following the heat treating process, this additional stock must be removed in the following sequence:

- (1) Grind .004 extra stock from the bottom, or small diameter end, of the insert.
- (2) Grind step, to the underside of the 5.875 diameter, to a measurement of 1.375 ( +/-.0002) Approximately the same .004 will be removed.
- (3) Grind the face, or parting line, of the insert to achieve an over-all thickness of 1.880 (+.000/-.004) (important note: this tolerance is compensated by springs under the return pins in the master frame. These springs will absorb up to .015 overall margin in the master frame parting line) Grinding within these tolerances places the O-rings in ideal position for a perfect seal.
- (4) Grind the outside diameter of the insert head to 5.8750 (+/-.0002)
- (5) The final step is grinding the flats. It is extremely important that the flats be ground in relationship to the center of the insert diameter to assure registration and the absence of a parting line mismatch on the molded part. The dimension is 5.360 (+/-.0002) between the flats (the 5.360 must be centered on the 5.875 diameter +/--.0002 TIR).

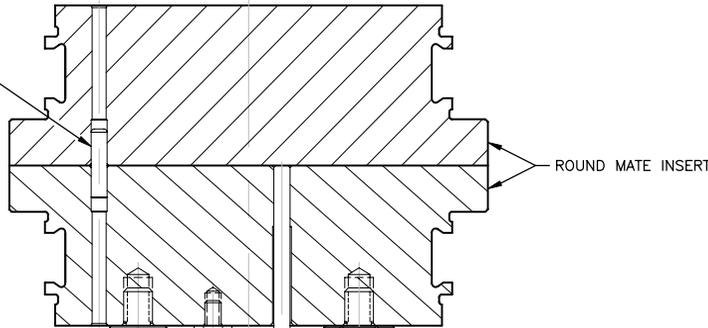
Note: The other outside surfaces on the insert are NOT shipped oversized, therefore, grinding will probably be unnecessary. However, we suggest you check these O.D.'s for accuracy after heat treat.



# 6" ROUND MATE® SINGLE POSITION

## REQUIREMENTS AND RECOMMENDATIONS

RECOMMENDED:  
LEADER PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
DOWELS ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.



REQUIRED: (PREFERRED OPTION)  
SUPPORT PILLARS MUST BE USED  
TO RETAIN EJECTOR PLATES WHILE  
THE INSERT SET IS OUT OF THE  
MASTER FRAME  
REFERENCE CATALOG PAGE #6.04

REQUIRED: (ALTERNATE OPTION)  
DRILL & C BORE FOR SHCS TO  
RETAIN EJECTOR PLATES WHILE  
THE INSERT SET IS OUT OF THE  
MASTER FRAME

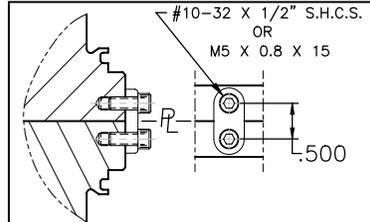
RECOMMENDED:  
RETURN PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
THEY ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.

REQUIRED: (WITH SLEEVE EJECTORS)  
SLEEVE EJECTION SUPPORT PILLARS  
ARE REQUIRED TO RETAIN  
CORE PIN RETAINER PLATES  
WHEN SLEEVE EJECTION IS USED.  
REFERENCE CATALOG PAGE #6.04

EJECTOR RETAINER PLATE

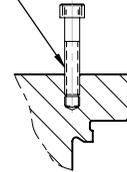
EJECTOR PLATE

CORE PIN RETAINER PLATES  
(IF REQUIRED)



RECOMMENDED:  
PARTING LINE SAFETY STRAPS  
SHOULD BE USED WHEN THE MOLD  
IS OUT OF THE MASTER FRAME  
TO PROTECT THE PARTING LINE.  
ONE INCLUDED WITH EACH INSERT  
ROUND MATE P/N RMC-0017

TAP FOR S.H.C.S.



RECOMMENDED:  
TAPPED HOLES CAN BE ADDED TO  
THE PARTING LINE OF THE INSERT  
SET. A BOLT CAN THEN BE USED  
AS A HANDLE TO LOAD THE INSERT  
SET INTO THE MASTER FRAME.

# 6" ROUND MATE® MULTI-POSITION

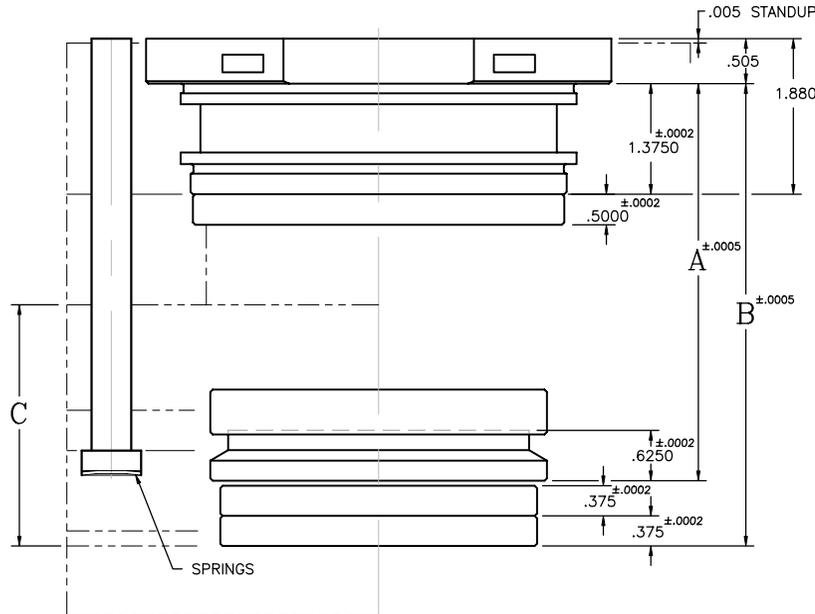
## PIN, SLEEVE, AND PARTING LINE SET UP

THIS DRAWING IS SUPPLIED TO AID WITH EJECTOR PIN, SLEEVE EJECTOR AND PARTING LINE SET UP WHEN DESIGNING A ROUND MATE® MOLD.

THE DIMENSION: "A", IS SHOWN TO LOCATE THE EJECTOR PLATES, AND IN CONJUNCTION WITH DIMENSION: .6250, TO DETERMINE EJECTOR PIN LENGTHS.

THE DIMENSION: "B", LOCATES THE CORE RETAINER PLATES, IF SLEEVE EJECTION IS UTILIZED, AND IN CONJUNCTION WITH DIMENSION: .375, TO DETERMINE CORE PIN LENGTHS.

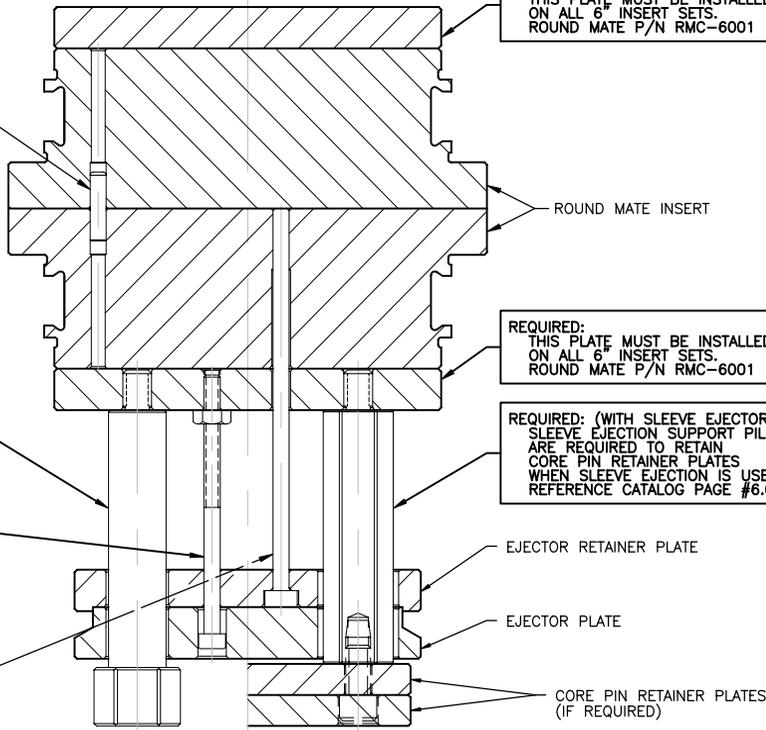
ON MULTI POSITION MASTER FRAMES, WITH THE RUNNER RUNNING ACROSS THE FLAT OF THE INSERT FROM THE SIDE, THE .005 INSERT STANDUP ABOVE THE MOLD PLATE MUST BE HELD. RUNNER BLOCKS IN THE MASTER FRAME MUST LINE UP WITH THE PARTING LINE OF THE INSERT. THIS IS SET TO BE .005 ABOVE THE MOLD PLATE ON BOTH THE "A" AND THE "B" SIDES OF THE MASTER FRAME.



MASTER FRAME	C	A	B
RMF-0623	3.000	4.9375	5.7500
RMF-0624	4.000	5.9375	6.7500
RMF-0625	5.000	6.9375	7.7500

# 6" ROUND MATE® MULTI-POSITION

## REQUIREMENTS AND RECOMMENDATIONS



RECOMMENDED:  
LEADER PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
DOWELS ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.

REQUIRED:  
THIS PLATE MUST BE INSTALLED  
ON ALL 6" INSERT SETS.  
ROUND MATE P/N RMC-6001

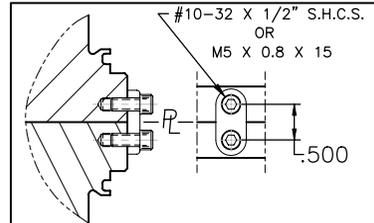
REQUIRED:  
THIS PLATE MUST BE INSTALLED  
ON ALL 6" INSERT SETS.  
ROUND MATE P/N RMC-6001

REQUIRED: (PREFERRED OPTION)  
SUPPORT PILLARS MUST BE USED  
TO RETAIN EJECTOR PLATES WHILE  
THE INSERT SET IS OUT OF THE  
MASTER FRAME  
REFERENCE CATALOG PAGE #6.04

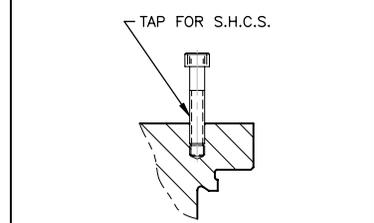
REQUIRED: (ALTERNATE OPTION)  
DRILL & C BORE FOR SHCS TO  
RETAIN EJECTOR PLATES WHILE  
THE INSERT SET IS OUT OF THE  
MASTER FRAME

RECOMMENDED:  
RETURN PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
THEY ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.

REQUIRED: (WITH SLEEVE EJECTORS)  
SLEEVE EJECTION SUPPORT PILLARS  
ARE REQUIRED TO RETAIN  
CORE PIN RETAINER PLATES  
WHEN SLEEVE EJECTION IS USED.  
REFERENCE CATALOG PAGE #6.04

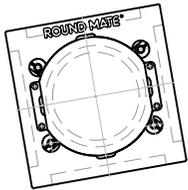


RECOMMENDED:  
PARTING LINE SAFETY STRAPS  
SHOULD BE USED WHEN THE MOLD  
IS OUT OF THE MASTER FRAME  
TO PROTECT THE PARTING LINE.  
ONE INCLUDED WITH EACH INSERT  
ROUND MATE P/N RMC-0017



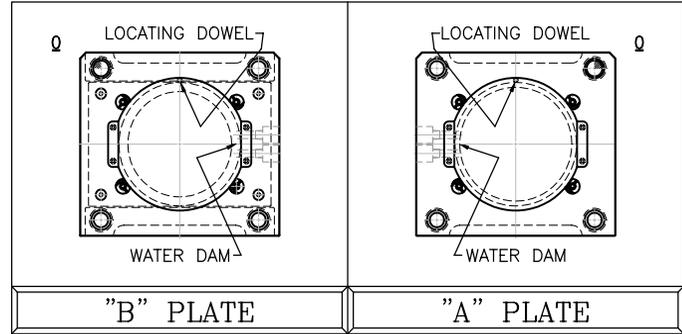
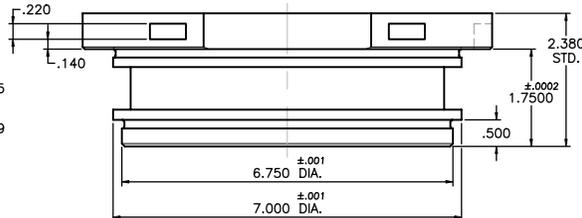
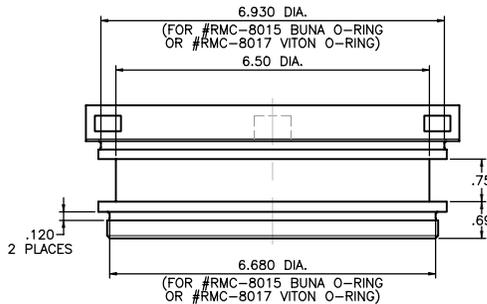
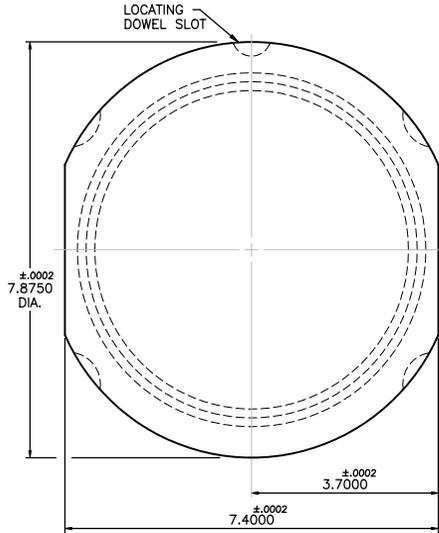
RECOMMENDED:  
TAPPED HOLES CAN BE ADDED TO  
THE PARTING LINE OF THE INSERT  
SET. A BOLT CAN THEN BE USED  
AS A HANDLE TO LOAD THE INSERT  
SET INTO THE MASTER FRAME.

# NOTES



**MACHINING FIXTURES ARE  
AVAILABLE FROM ROUND MATE.  
REFERENCE CATALOG PAGE #8.02**

# 8" ROUND MATE® SINGLE POSITION INSERT DIMENSIONS



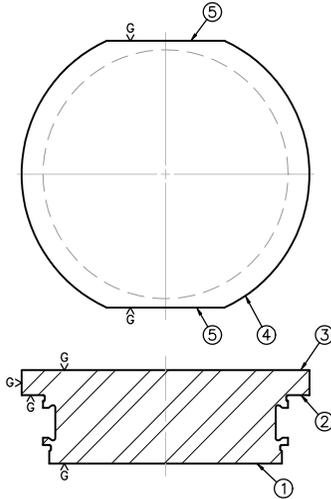
THE "A" INSERT IS THE SAME AS THE "B" INSERTS EXCEPT FOR THE WATER DAM LOCATION

TOOLMAKER IS TO INSTALL THE WATER DAM

WATER DAM IS TO LINE UP WITH WATER INLET/OUTLET IN THE MASTER FRAME

# 8" ROUND MATE® SINGLE POSITION GRINDING PROCEDURES

(SEE ILLUSTRATION)



THIS DRAWING IS SUPPLIED TO AID IN GRINDING "HEAT TREATABLE"  
INSERTS AFTER "HEAT TREAT"

When you receive the "Round Mate"® insert, in any heat treatable steel, it is machined to .005 / .010 oversize, per side, on all critical dimensions. Following the heat treating process, this additional stock must be removed in the following sequence:

- (1) Grind .004 extra stock from the bottom, or small diameter end, of the insert.
- (2) Grind step, to the underside of the 7.875 diameter, to a measurement of 1.750 ( +/− .0002 ) Approximately the same .004 will be removed.
- (3) Grind the face, or parting line, of the insert to achieve an over-all thickness of 2.380 (+0.000/−.004) (important note: this tolerance is compensated by springs under the return pins in the master frame. These springs will absorb up to .015 overall margin in the master frame parting line) Grinding within these tolerances places the O-rings in ideal position for a perfect seal.
- (4) Grind the outside diameter of the insert head to 7.8750 (+/−.0002)
- (5) The final step is grinding the flats. It is extremely important that the flats be ground in relationship to the center of the insert diameter to assure registration and the absence of a parting line mismatch on the molded part. The dimension is 7.400 (+/−.0002) between the flats (the 7.400 must be centered on the 7.875 diameter +/−.0002 TIR).

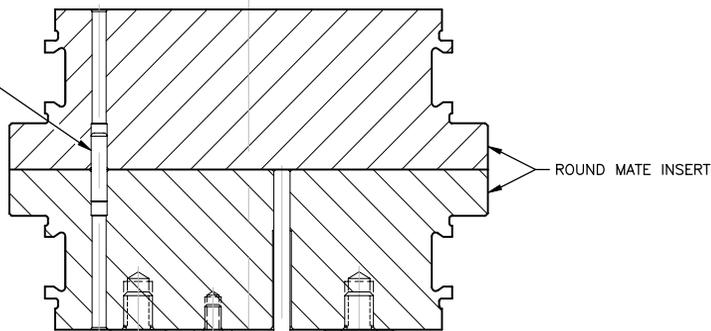
Note: The other outside surfaces on the insert are NOT shipped oversized, therefore , grinding will probably be unnecessary. However, we suggest you check these O.D.'s for accuracy, after heat treat.



# 8" ROUND MATE® SINGLE POSITION

## REQUIREMENTS AND RECOMMENDATIONS

**RECOMMENDED:**  
LEADER PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
DOWELS ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.



**REQUIRED: (PREFERRED OPTION)**  
SUPPORT PILLARS MUST BE USED  
TO RETAIN EJECTOR PLATES WHILE  
THE INSERT SET IS OUT OF THE  
MASTER FRAME  
REFERENCE CATALOG PAGE #6.04

**REQUIRED: (ALTERNATE OPTION)**  
DRILL & C BORE FOR SHCS TO  
RETAIN EJECTOR PLATES WHILE  
THE INSERT SET IS OUT OF THE  
MASTER FRAME

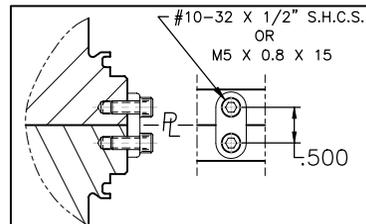
**RECOMMENDED:**  
RETURN PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
THEY ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.

**REQUIRED: (WITH SLEEVE EJECTORS)**  
SLEEVE EJECTION SUPPORT PILLARS  
ARE REQUIRED TO RETAIN  
CORE PIN RETAINER PLATES  
WHEN SLEEVE EJECTION IS USED.  
REFERENCE CATALOG PAGE #6.04

EJECTOR RETAINER PLATE

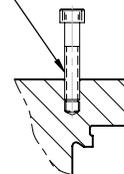
EJECTOR PLATE

CORE PIN RETAINER PLATES  
(IF REQUIRED)



**RECOMMENDED:**  
PARTING LINE SAFETY STRAPS  
SHOULD BE USED WHEN THE MOLD  
IS OUT OF THE MASTER FRAME  
TO PROTECT THE PARTING LINE.  
ONE INCLUDED WITH EACH INSERT  
ROUND MATE P/N RMC-0017

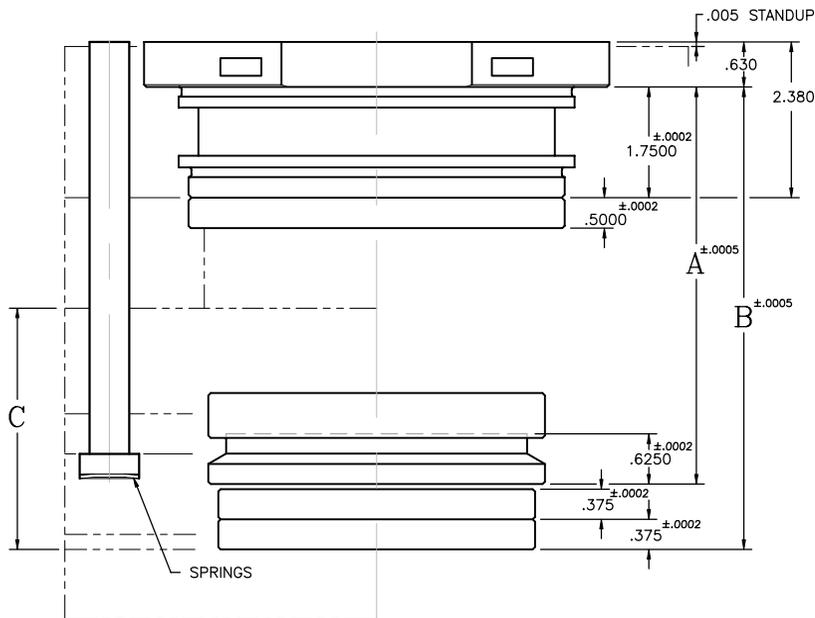
TAP FOR S.H.C.S.



**RECOMMENDED:**  
TAPPED HOLES CAN BE ADDED TO  
THE PARTING LINE OF THE INSERT  
SET. A BOLT CAN THEN BE USED  
AS A HANDLE TO LOAD THE INSERT  
SET INTO THE MASTER FRAME.

# 8" ROUND MATE® MULTI-POSITION

## PIN, SLEEVE, AND PARTING LINE SET UP



THIS DRAWING IS SUPPLIED TO AID WITH EJECTOR PIN, SLEEVE EJECTOR AND PARTING LINE SET UP WHEN DESIGNING A ROUND MATE® MOLD.

THE DIMENSION: "A", IS SHOWN TO LOCATE THE EJECTOR PLATES, AND IN CONJUNCTION WITH DIMENSION: .6250, TO DETERMINE EJECTOR PIN LENGTHS.

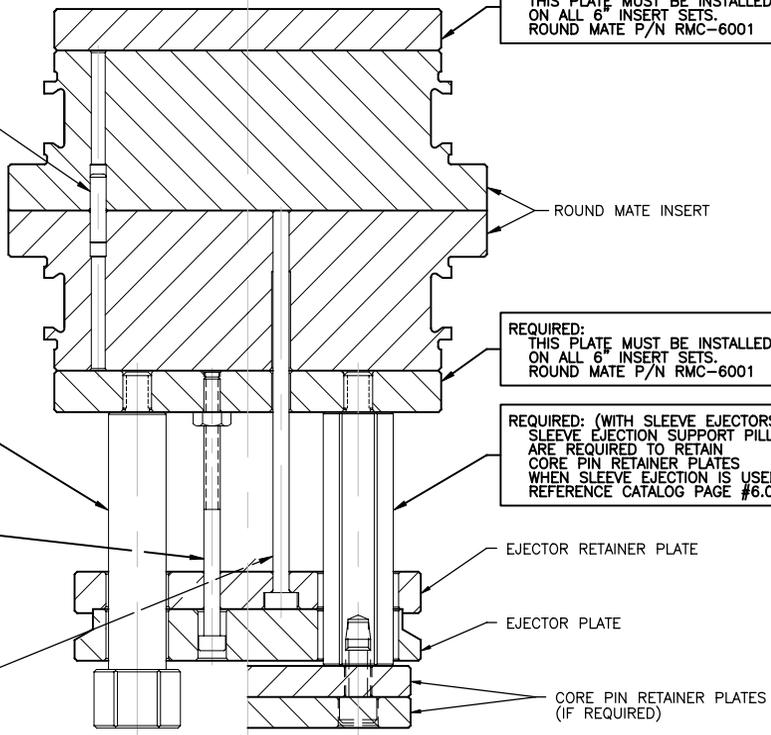
THE DIMENSION: "B", LOCATES THE CORE RETAINER PLATES, IF SLEEVE EJECTION IS UTILIZED, AND IN CONJUNCTION WITH DIMENSION: .375, TO DETERMINE CORE PIN LENGTHS.

ON MULTI POSITION MASTER FRAMES, WITH THE RUNNER RUNNING ACROSS THE FLAT OF THE INSERT FROM THE SIDE, THE .005 INSERT STANDUP ABOVE THE MOLD PLATE MUST BE HELD. RUNNER BLOCKS IN THE MASTER FRAME MUST LINE UP WITH THE PARTING LINE OF THE INSERT. THIS IS SET TO BE .005 ABOVE THE MOLD PLATE ON BOTH THE "A" AND THE "B" SIDES OF THE MASTER FRAME.

MASTER FRAME	C	A	B
RMF-0823	3.000	6.3125	7.1250
RMF-0824	4.000	7.3125	8.1250
RMF-0825	5.000	8.3125	9.1250

# 8" ROUND MATE® MULTI-POSITION

## REQUIREMENTS AND RECOMMENDATIONS



RECOMMENDED:  
LEADER PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
DOWELS ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.

REQUIRED:  
THIS PLATE MUST BE INSTALLED  
ON ALL 6" INSERT SETS.  
ROUND MATE P/N RMC-6001

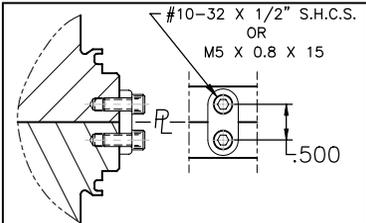
REQUIRED: (PREFERRED OPTION)  
SUPPORT PILLARS MUST BE USED  
TO RETAIN EJECTOR PLATES WHILE  
THE INSERT SET IS OUT OF THE  
MASTER FRAME  
REFERENCE CATALOG PAGE #6.04

REQUIRED:  
THIS PLATE MUST BE INSTALLED  
ON ALL 6" INSERT SETS.  
ROUND MATE P/N RMC-6001

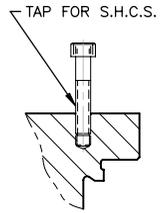
REQUIRED: (ALTERNATE OPTION)  
DRILL & C'BORE FOR SHCS TO  
RETAIN EJECTOR PLATES WHILE  
THE INSERT SET IS OUT OF THE  
MASTER FRAME

REQUIRED: (WITH SLEEVE EJECTORS)  
SLEEVE EJECTION SUPPORT PILLARS  
ARE REQUIRED TO RETAIN  
CORE PIN RETAINER PLATES  
WHEN SLEEVE EJECTION IS USED.  
REFERENCE CATALOG PAGE #6.04

RECOMMENDED:  
RETURN PINS ARE INSTALLED  
IN THE MASTER FRAME. HOWEVER  
THEY ARE GENERALLY INSTALLED  
IN THE INSERT SET TO PROTECT  
THE PARTING LINE WHILE ON THE  
BENCH OR IN STORAGE.

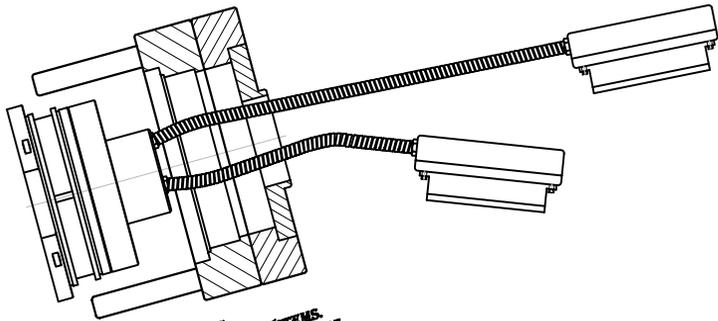


RECOMMENDED:  
PARTING LINE SAFETY STRAPS  
SHOULD BE USED WHEN THE MOLD  
IS OUT OF THE MASTER FRAME  
TO PROTECT THE PARTING LINE.  
ONE INCLUDED WITH EACH INSERT  
ROUND MATE P/N RMC-0017



RECOMMENDED:  
TAPPED HOLES CAN BE ADDED TO  
THE PARTING LINE OF THE INSERT  
SET. A BOLT CAN THEN BE USED  
AS A HANDLE TO LOAD THE INSERT  
SET INTO THE MASTER FRAME.

# NOTES



**ROUND MATE HAS  
THEIR OWN MANFOLD SYSTEMS.  
REFERENCE CATALOG SECTION #7**

# ROUND MATE<sup>®</sup>

*Systems*

**ROUND MATE SYSTEMS USES A COMBINATION OF ENGINEERING, CREATIVITY,  
SKILL AND CRAFTSMANSHIP TO DESIGN AND PRODUCE TOP QUALITY PRODUCTS.**

**WE ARE DEDICATED TO SERVING OUR CUSTOMERS IN THE MOST EFFICIENT  
METHODS AVAILABLE WHILE MAINTAINING A TOTAL COMMITMENT TO QUALITY.**

**MATERIAL SAFETY DATA SHEET (MSDS) ENCLOSED**

*Pleasant Precision, Inc.*

13840 U.S. Rt. 68 South, Kenton, Ohio, 43326  
PH. (800) 860-3974 or PH. (419) 675-0556  
FAX (419) 675-0557

E-mail: [info@modularmoldsystems.com](mailto:info@modularmoldsystems.com)  
TOOLING AND ENGINEERING FOR THE PLASTICS INDUSTRIES