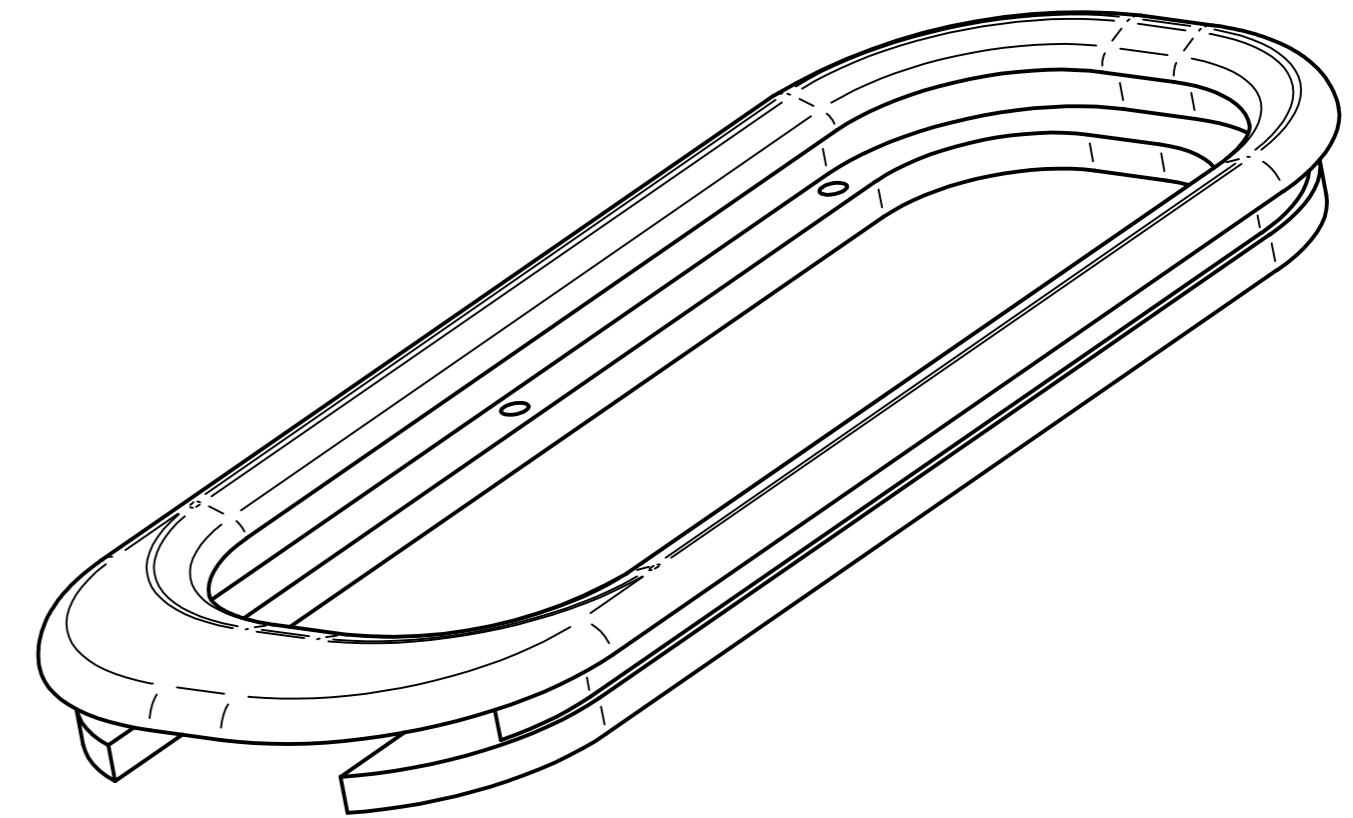
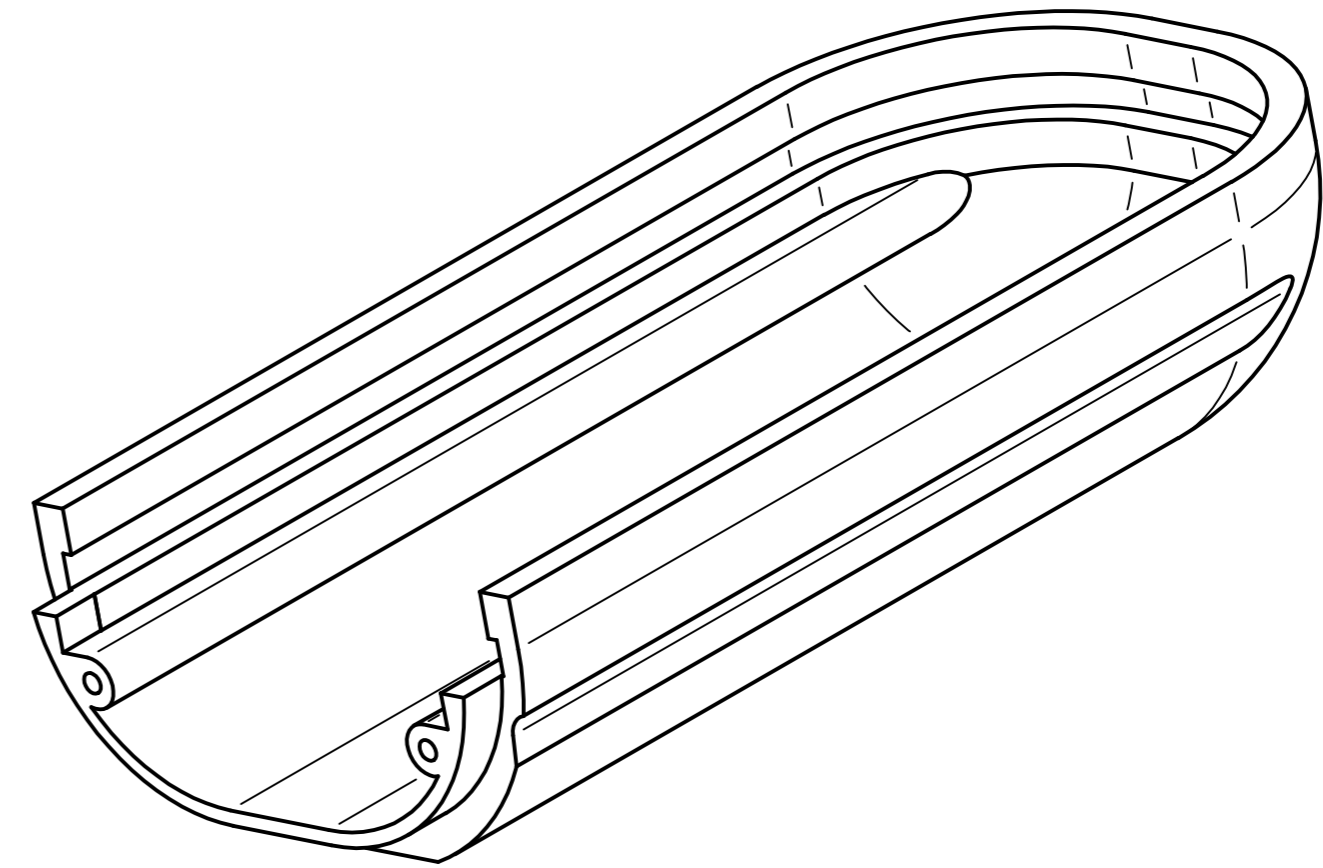
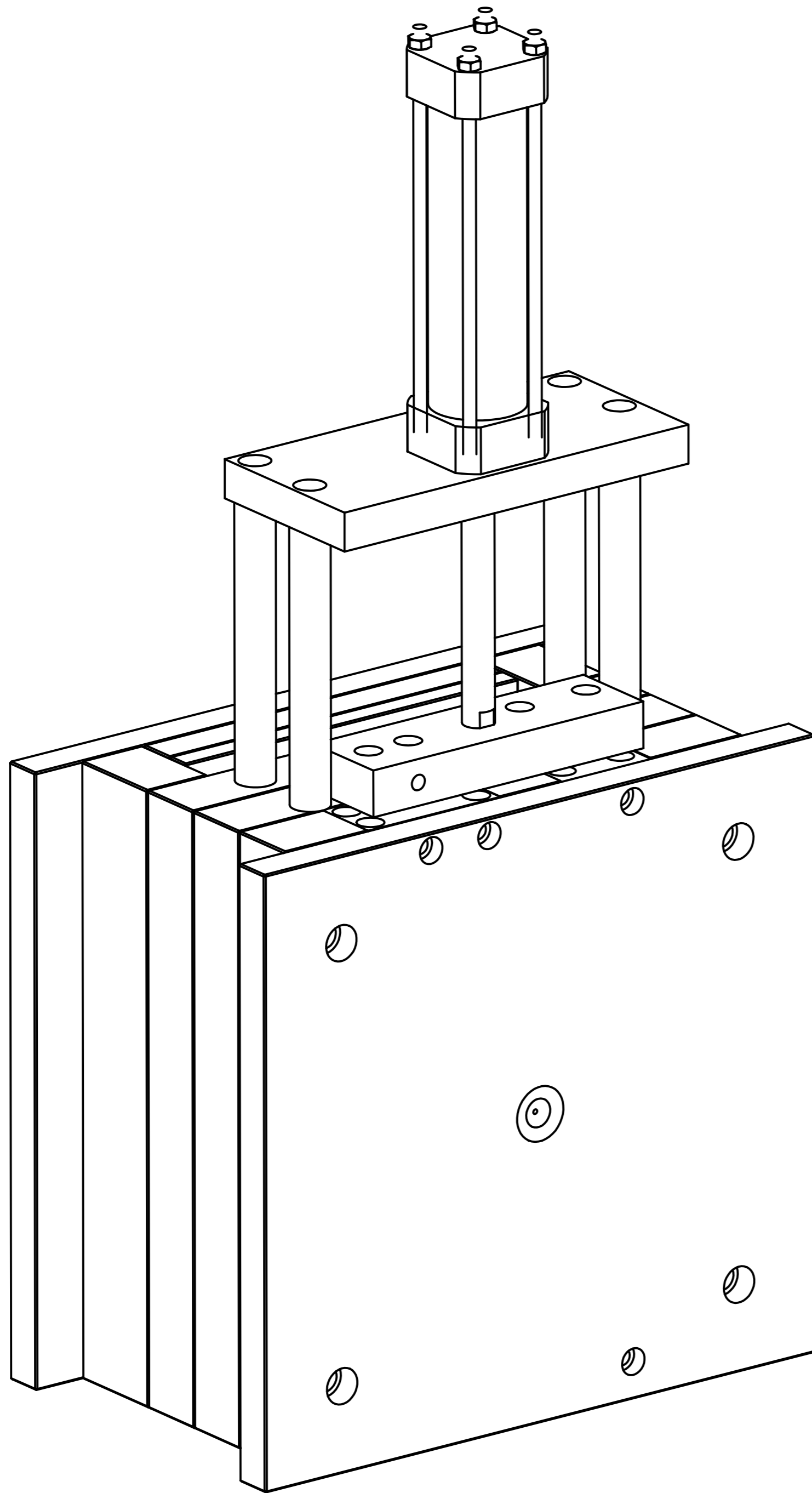
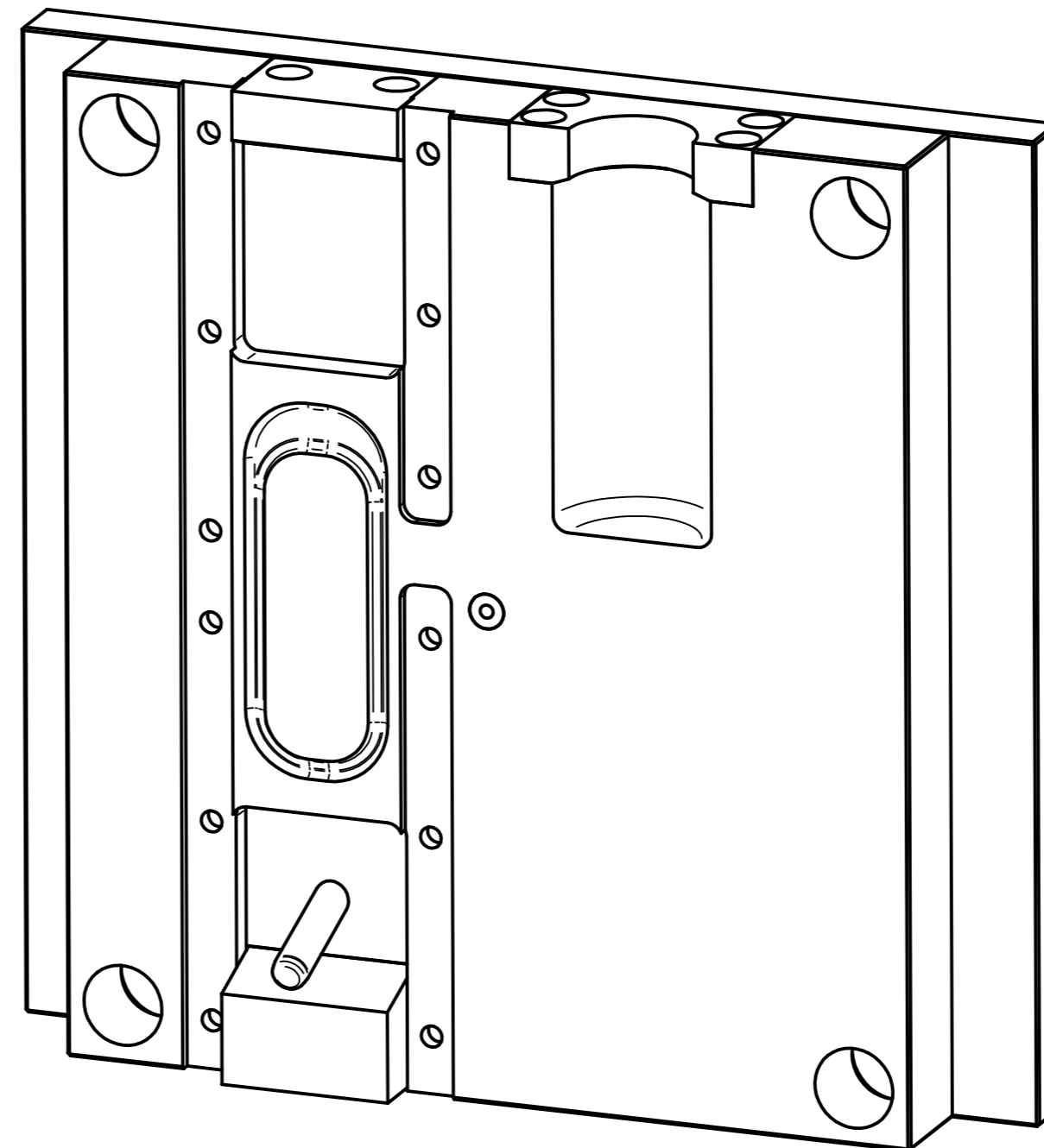
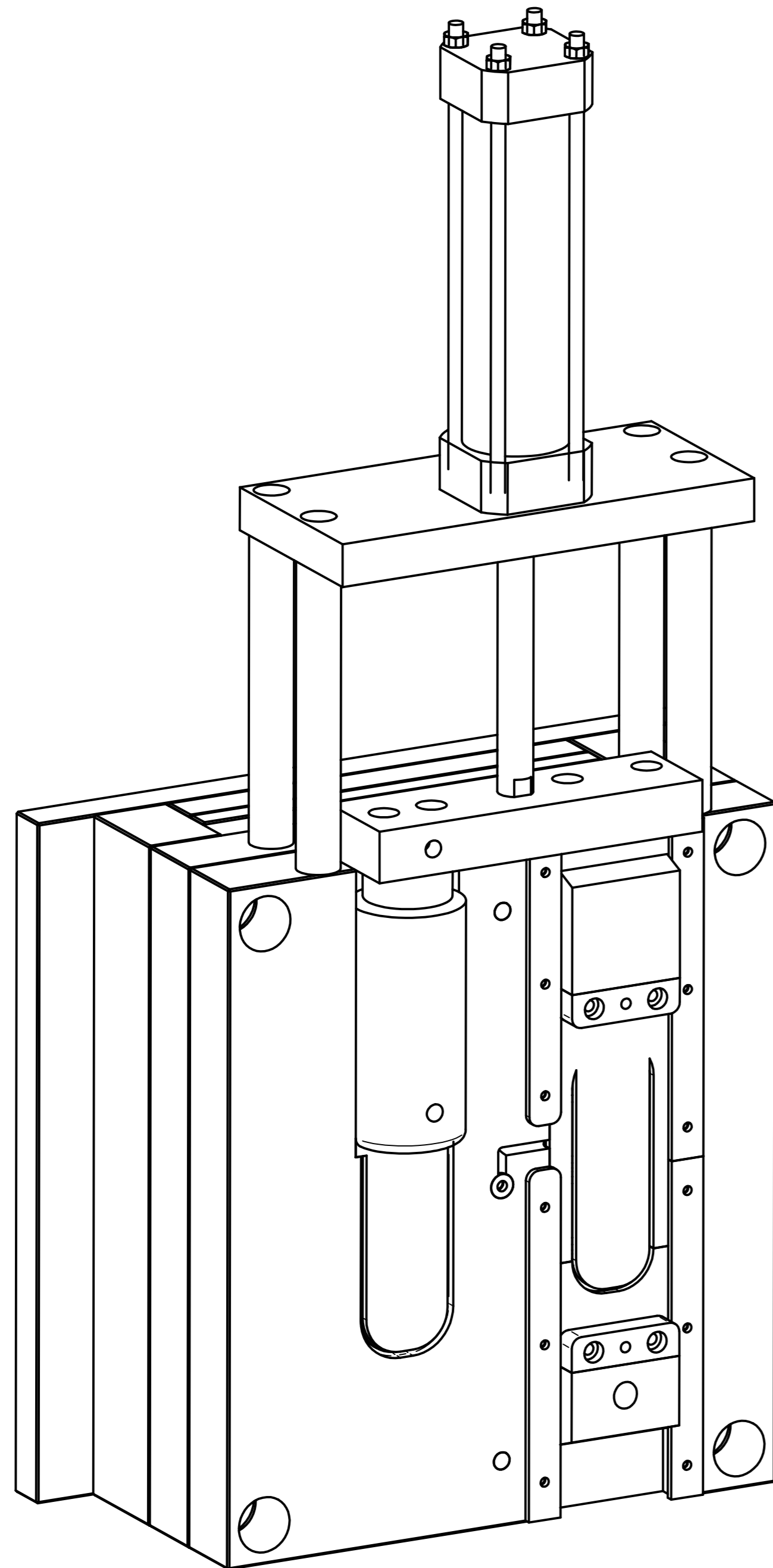


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



DRAWN	NAME	DATE	PREMAC		
APPROVED	Dan	02/15/11			
MATERIAL					
TREATMENT					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO	REV
1 st ANGLE ANGLES ±0.1°			A4		
2 PL ±0.02 3 PL ±0.005			FILE NAME: Base & Top Cover Die.dft		
SCALE:		WEIGHT:	SHEET 1 OF 25		

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



	NAME	DATE	PREMAC	
DRAWN	Dan	02/15/11		
APPROVED				
MATERIAL				
TREATMENT			TITLE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1st ANGLE ANGLES ±0.1°			FILE NAME: Base & Top Cover Die.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:
			SHEET 2 OF 25	

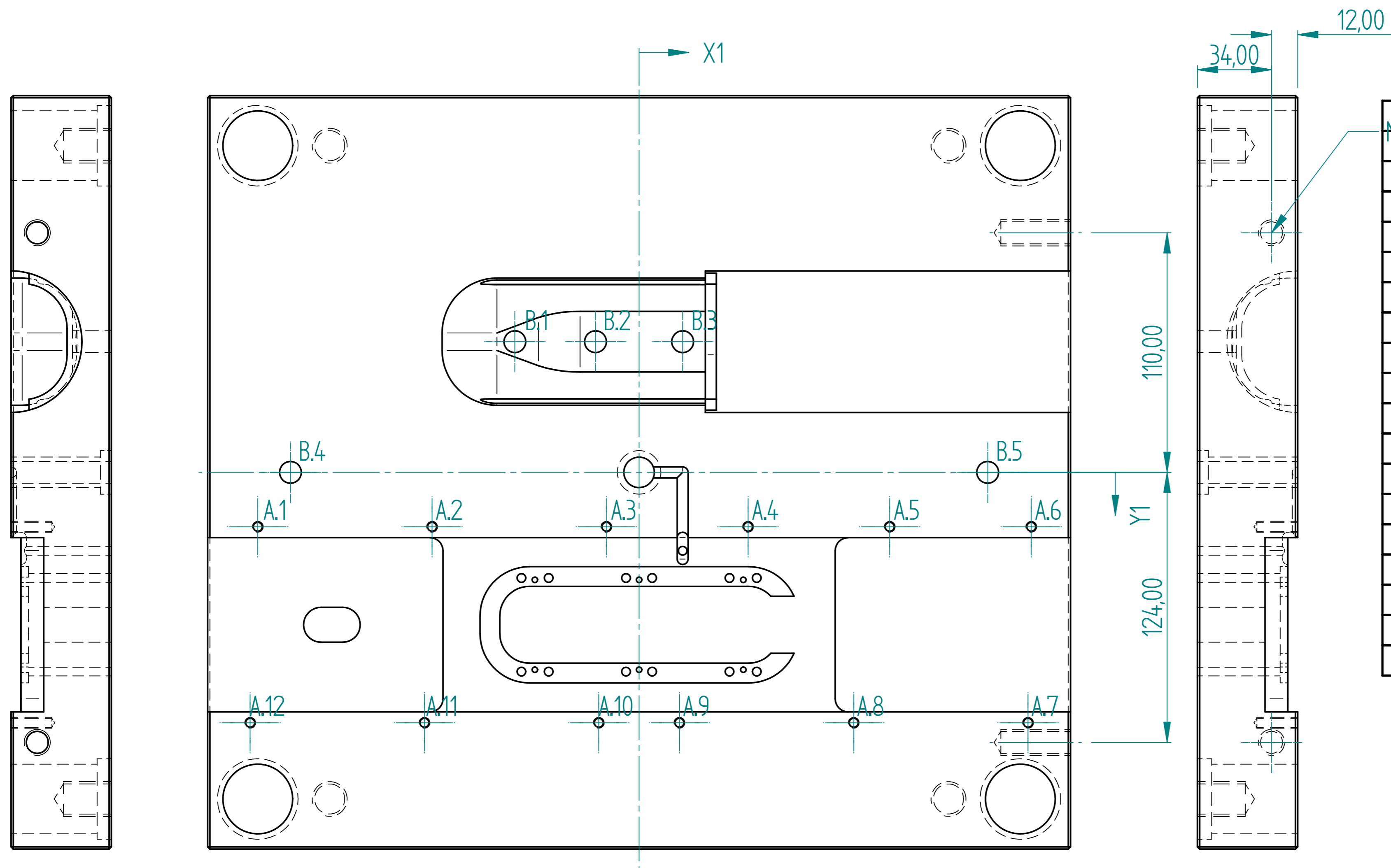
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

	Item Number	Document Number	Title	Quantity
#	1	APD14-85	Angle Pin	1
#	2	DIA 65 - 287	Base Core	1
#	3	100 x 46 x 23	Base Core Heel Block	1
#	4	20 x 68 x 15	Blade Clamp	2
#	5	80 x 60 x 4.6	Bottom Blade Core	1
#	6	80 x 70 x 30	Bottom Blade Slide	1
#	7	68 x 60 x 47	Bottom Slide Heel Block	1
	8	416 x 396 x 26	Clamping Plate FH	1
	9	416 x 396 x 26	Clamping Plate MH	1
#	10	60 x 204 x 30	Core Back Plate	1
#	11	260 x 120 x 25	Core Base Plate	1
	12	Ø25 x 180	Core Riser	4
	13	Ø85 x 50	Cyl Bottom End Cap	1
	14	M8 x 175	Cyl Stud	4
	15	Ø85 x 40	Cyl Top End Cap	1
	16	Ø50 ØØ60 x 200	Cyl Tube	1
	17	396 x 252 x 26	Ejector Clamping Plate	1
#	18	EP Dia 10 - 160	Ejector Pin	2
#	19	EP Dia 4 - 160	Ejector Pin	13
#	20	EP Dia 6 - 160	Ejector Pin	1
#	21	EP2 Dia 10 - 160	Ejector Pin	2

	Item Number	Document Number	Title	Quantity
#	22	EP3 Dia 10 - 160	Ejector Pin	1
	23	396 x 252 x 16	Ejector Plate	1
	24	346 x 396 x 46	Fixed Die Plate	1
	25	346 x 396 x 46	Moving Die Plate	1
	26	M8	Nut	4
	27	P3 x 44	O-Ring	2
	28	Ø50 x 28	Piston	1
	29	Ø20 x 255	Piston Rod	1
	30	PU 35-50-10	Polly U Seal	2
	31	PU 20-26-5	Poly U Seal	1
#	32	20 x 197 x 4	Rail	2
#	33	20 x 164 x 4	Rail A	1
#	34	20 x 204 x 4	Rail B	1
	35	396 x 46 x 66	Riser	2
#	36	Ø38 x 51	Sprue Bush	1
#	37	Ø20 x 46.1	Sprue Puller Bush	1
	38	346 x 396 x 46	Support Plate	1
#	39	80 x 180 x 4.6	Top Blade Core	1
#	40	80 x 110 x 30	Top Blade Slide	1
#	41	68 x 46 x 25	Top Slide Heel Block	1

	NAME	DATE	PREMAC	
DRAWN	Dan	02/15/11		
APPROVED				
MATERIAL				
TREATMENT			TITLE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1st ANGLE ANGLES ±0.1°			FILE NAME: Base & Top Cover Die.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT: SHEET 3 OF 25

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

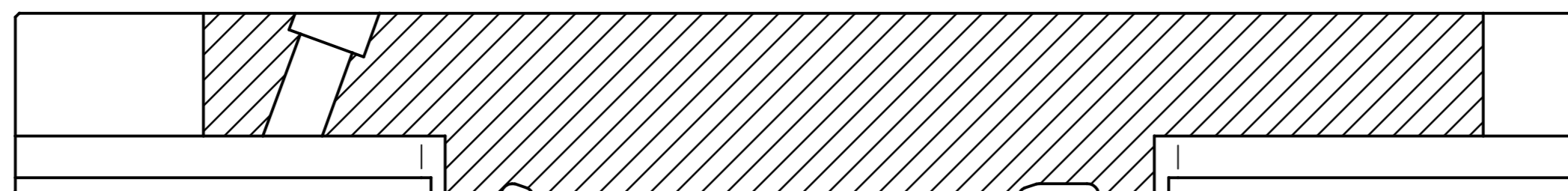
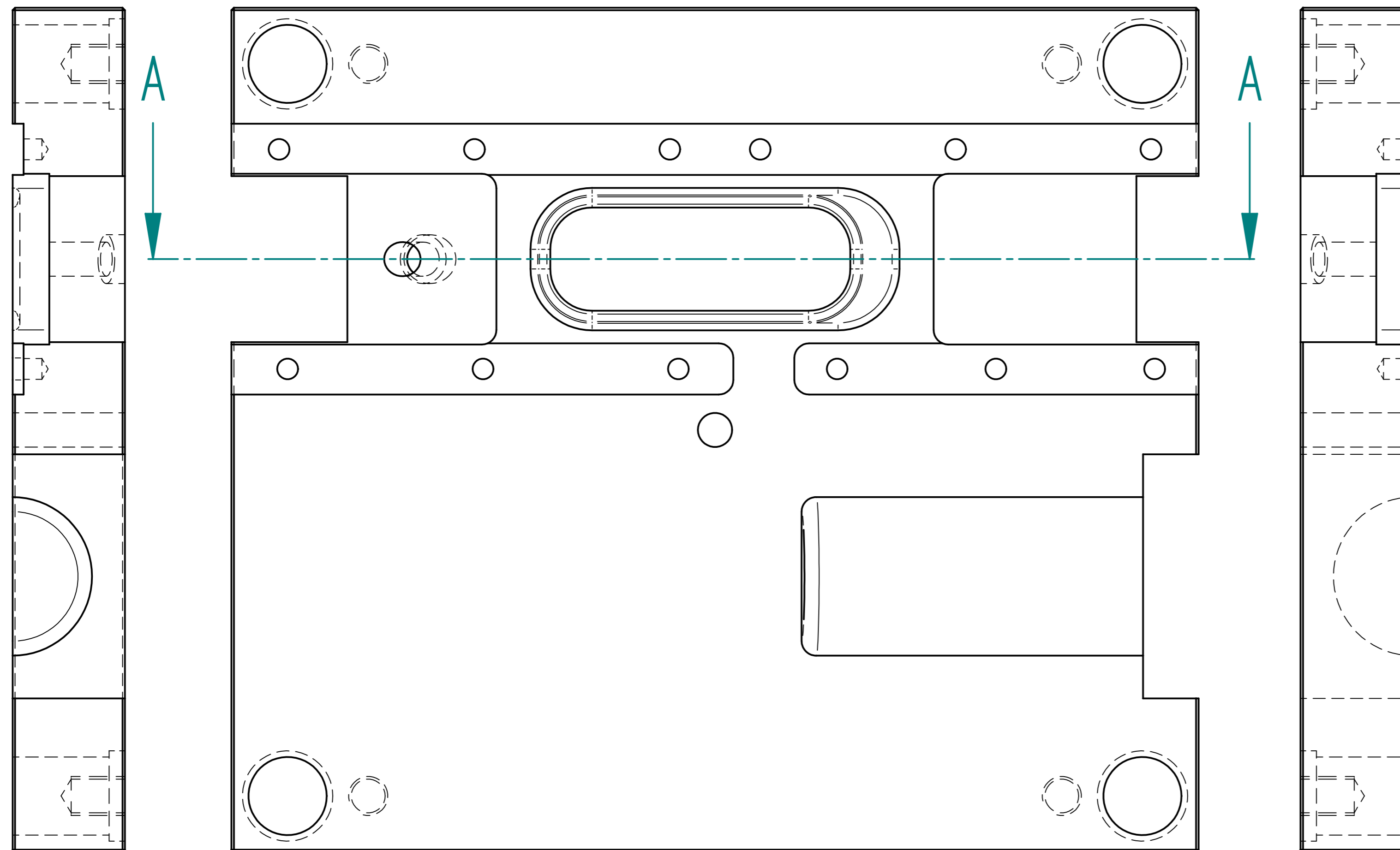


Hole Table		
Hole	X	Y
A.1	-175,00	-25,00
A.2	-95,00	-25,00
A.3	-15,00	-25,00
A.4	50,00	-25,00
A.5	115,00	-25,00
A.6	180,00	-25,00
A.7	178,50	-115,00
A.8	98,50	-115,00
A.9	18,50	-115,00
A.10	-18,50	-115,00
A.11	-98,50	-115,00
A.12	-178,50	-115,00
B.1	-57,00	60,00
B.2	-20,00	60,00
B.3	20,00	60,00
B.4	-160,00	0,00
B.5	160,00	0,00

MOVING DIE PLATE

DRAWN	NAME	DATE	PREMAC		
APPROVED	Dan	02/15/11			
MATERIAL					
TREATMENT					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO	REV
1st ANGLE ANGLES ±0.1°			A4		
2 PL ±0.02 3 PL ±0.005			FILE NAME: Base & Top Cover Die.dft		
			SCALE:	WEIGHT:	SHEET 4 OF 25

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

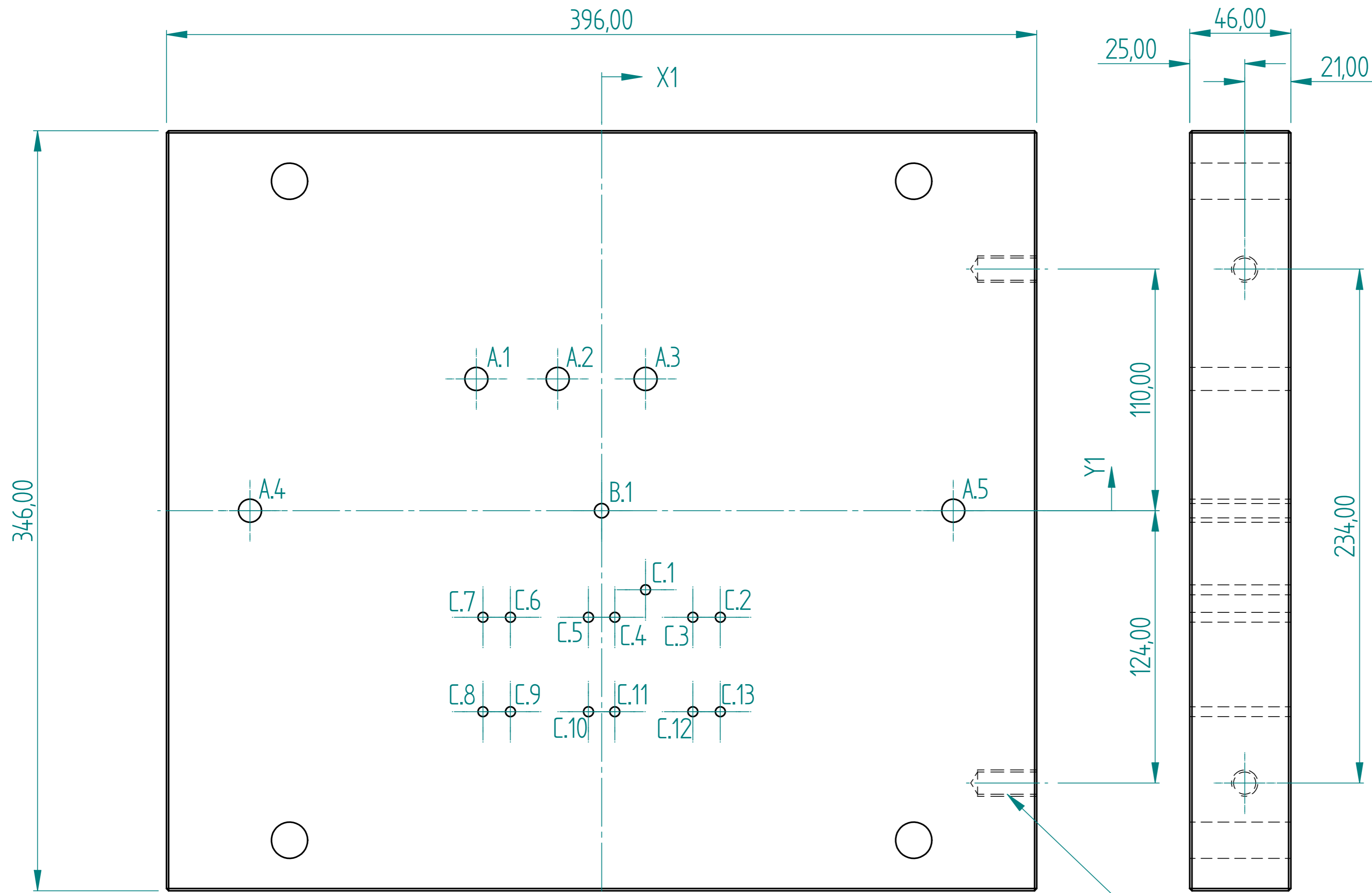


SECTION A-A

FIXED DIE PLATE

DRAWN	NAME	DATE	PREMAC	
APPROVED	Dan	02/15/11		
MATERIAL			TITLE	
TREATMENT			REV	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1 st ANGLE ANGLES ±0.1°			FILE NAME: Base & Top Cover Die.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT: SHEET 5 OF 25

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



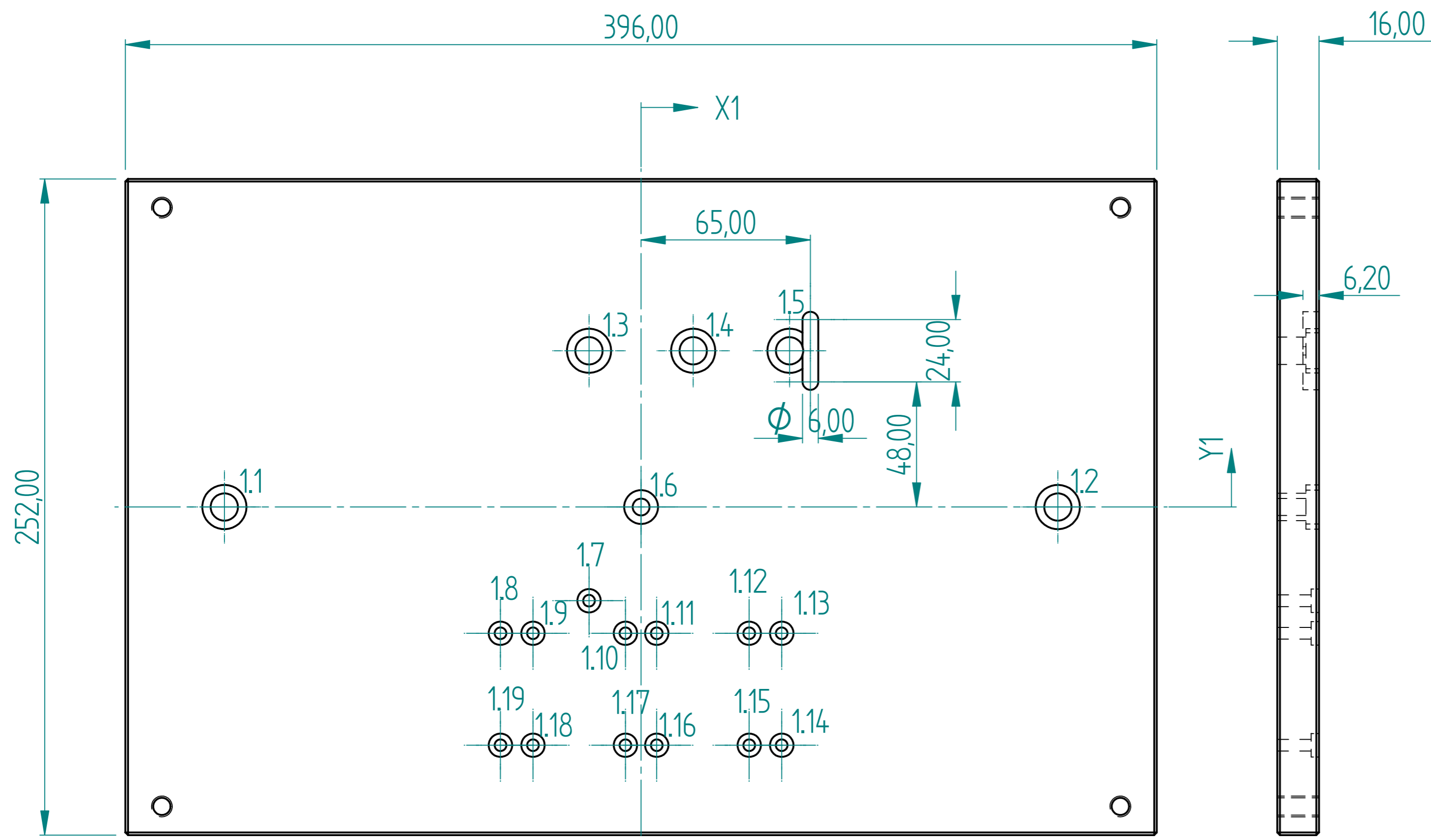
Hole Table			
Hole	X	Y	Size
A.1	-57	60	φ 10,5
A.2	-20	60	φ 10,5
A.3	20	60	φ 10,5
A.4	-160	0	φ 10,5
A.5	160	0	φ 10,5
B.1	0	0	φ 6,5
C.1	20	-36	φ 4,5
C.2	54	-48,5	φ 4,5
C.3	41,5	-48,5	φ 4,5
C.4	6	-48,5	φ 4,5
C.5	-6	-48,5	φ 4,5
C.6	-41,5	-48,5	φ 4,5
C.7	-54	-48,5	φ 4,5
C.8	-54	-91,5	φ 4,5
C.9	-41,5	-91,5	φ 4,5
C.10	-6	-91,5	φ 4,5
C.11	6	-91,5	φ 4,5
C.12	41,5	-91,5	φ 4,5
C.13	54	-91,5	φ 4,5

SUPPORT PLATE

M12 - 30,00 DEEP

	NAME	DATE	PREMAC	
DRAWN	Dan	02/15/11		
APPROVED				
MATERIAL				
TREATMENT			TITLE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1st ANGLE ANGLES ±0,1°			FILE NAME: Base & Top Cover Die.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:
			SHEET 6 OF 25	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

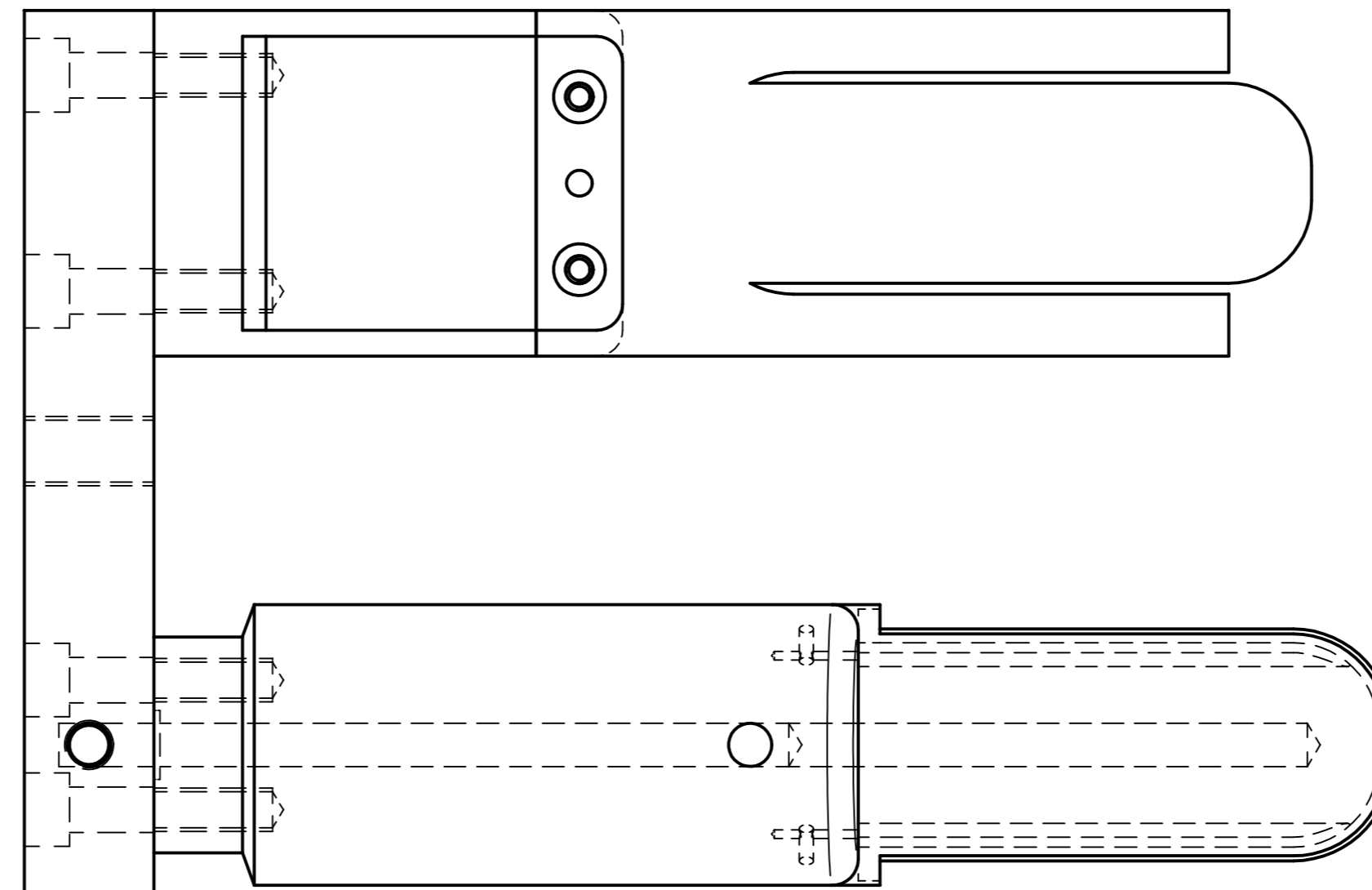
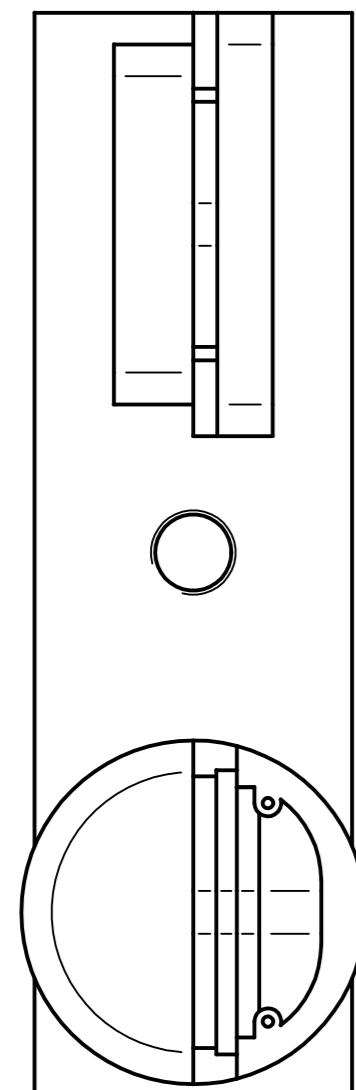
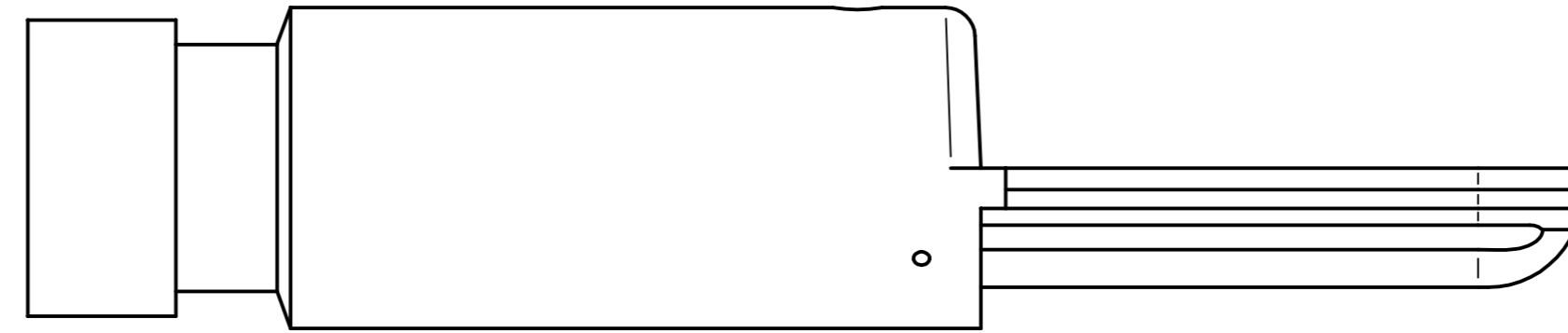


Hole Table				
Hole	X	Y	Size	C \ Bore
1.1	-160	0	φ 10,5	φ17-5,05
1.2	160	0	φ 10,5	φ17-5,05
1.3	-20	60	φ 10,5	φ17-5,05
1.4	20	60	φ 10,5	φ17-5,05
1.5	57	60	φ 10,5	φ17-5,05
1.6	0	0	φ 6,5	φ13-5,05
1.7	-20	-36	φ 4,5	φ9-3,05
1.8	-54	-48,5	φ 4,5	φ9-3,05
1.9	-41,5	-48,5	φ 4,5	φ9-3,05
1.10	-6	-48,5	φ 4,5	φ9-3,05
1.11	6	-48,5	φ 4,5	φ9-3,05
1.12	41,5	-48,5	φ 4,5	φ9-3,05
1.13	54	-48,5	φ 4,5	φ9-3,05
1.14	54	-91,5	φ 4,5	φ9-3,05
1.15	41,5	-91,5	φ 4,5	φ9-3,05
1.16	6	-91,5	φ 4,5	φ9-3,05
1.17	-6	-91,5	φ 4,5	φ9-3,05
1.18	-41,5	-91,5	φ 4,5	φ9-3,05
1.19	-54	-91,5	φ 4,5	φ9-3,05

EJECTOR PLATE

DRAWN	NAME	DATE	PREMAC		
APPROVED	Dan	02/15/11			
MATERIAL					
TREATMENT					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO	REV
1st ANGLE ANGLES ±0,1°			FILE NAME: Base & Top Cover Die.dft		
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:	SHEET 7 OF 25

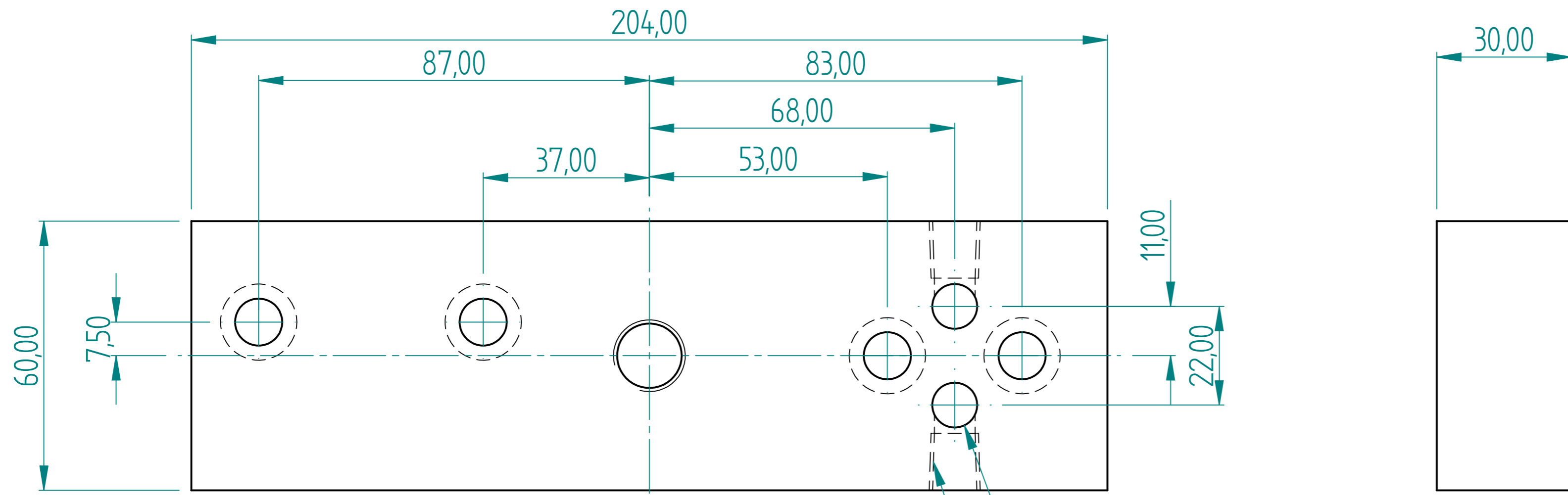
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



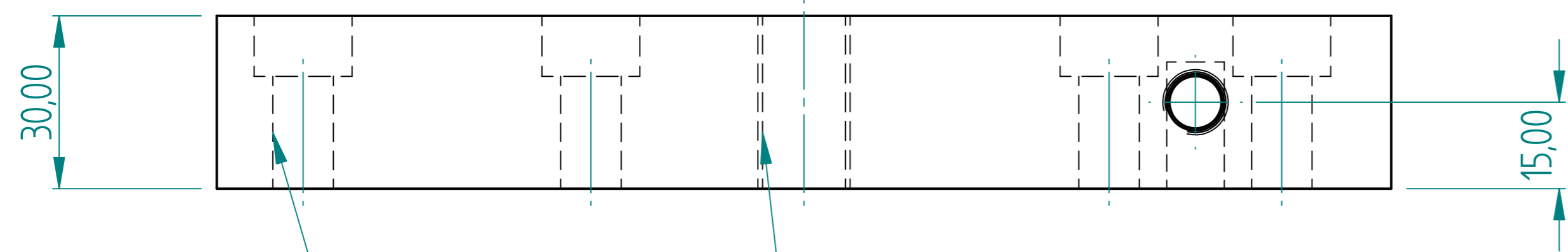
TOP CORE ASSEMBLY

	NAME	DATE	PREMAC	
DRAWN	Dan	02/15/11		
APPROVED			TITLE	
MATERIAL				
TREATMENT			SIZE A4 DWG NO FILE NAME: Base & Top Cover Die.dft	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS 1st ANGLE ANGLS ±0.1° 2 PL ±0.02 3 PL ±0.005				
				SHEET 9 OF 25

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



ϕ 10,00 - 22,00 DEEP
 1/8-27 NPT - 12,70 DEEP

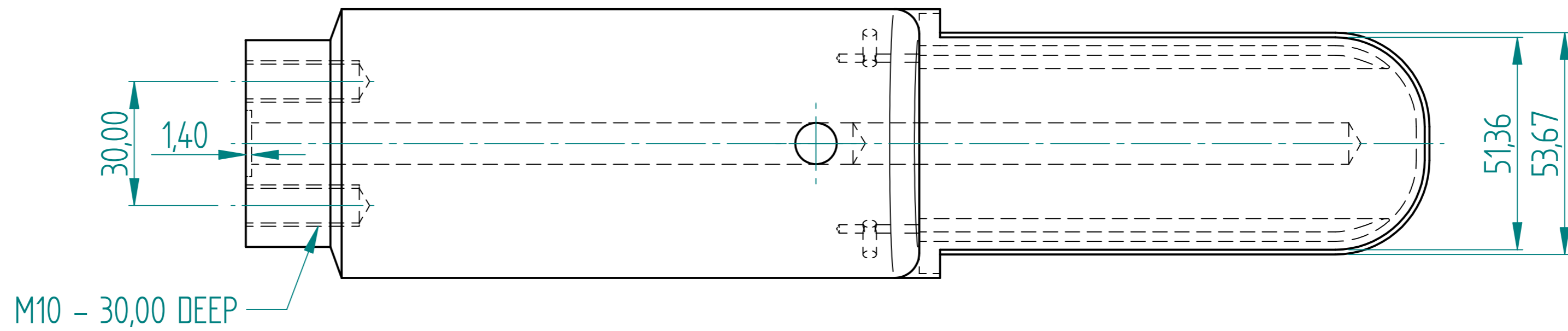
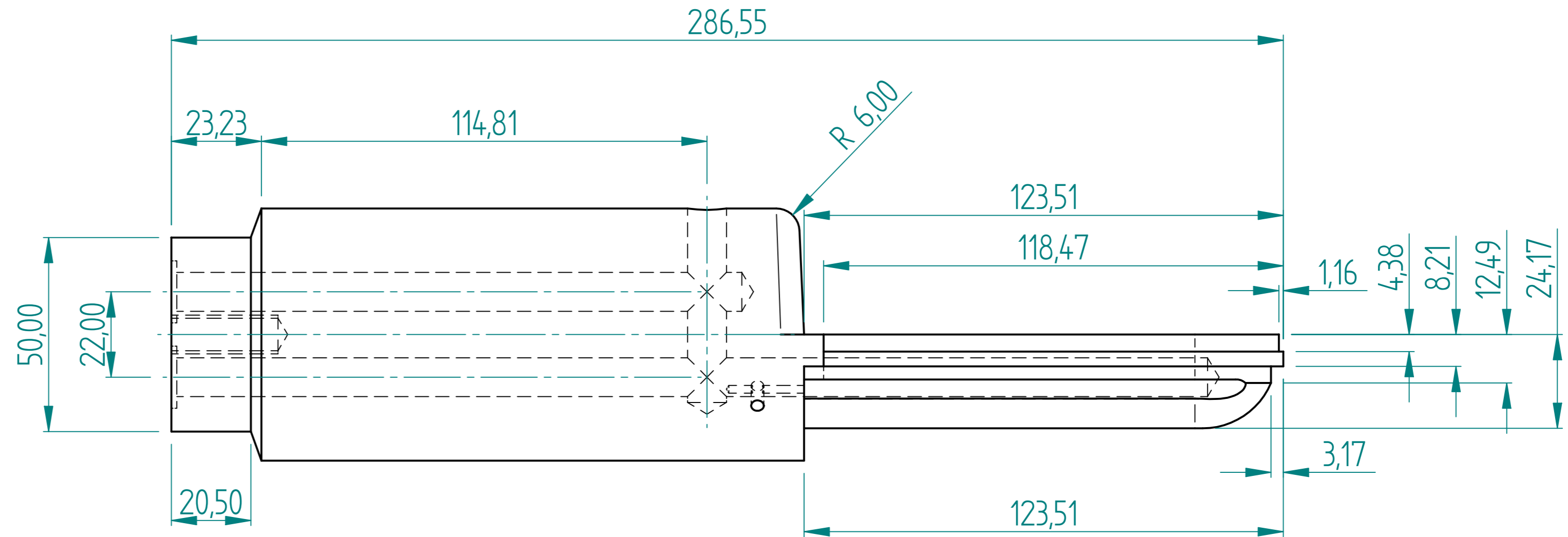
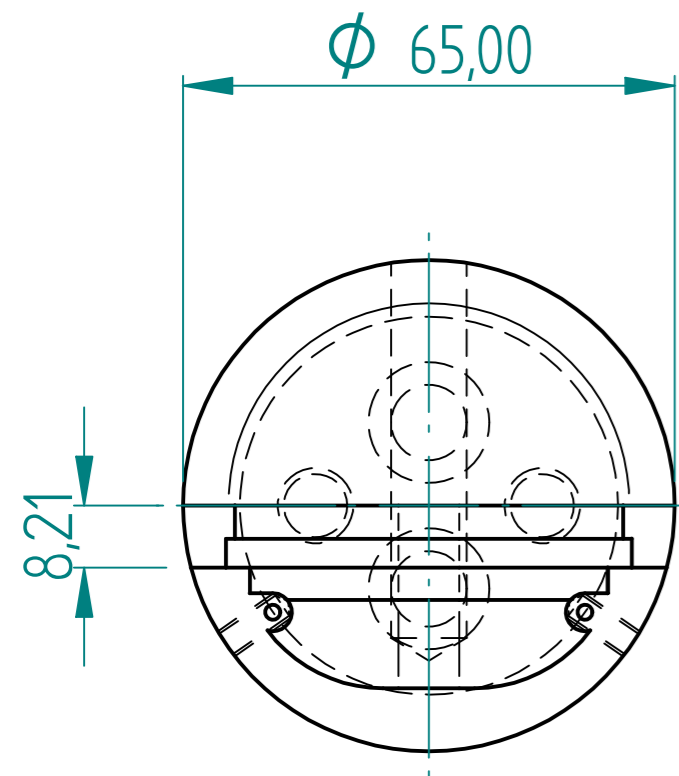


ϕ 10,50
 C'BORE ϕ 17,00 - 10,50 DEEP
 M16 x 1.5

CORE BACK PLATE

DRAWN	NAME	DATE	PREMAC	
APPROVED	Dan	02/15/11		
MATERIAL			TITLE	
TREATMENT			REV	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1st ANGLE ANGLES $\pm 0,1^\circ$			FILE NAME: Base & Top Cover Die.dft	
2 PL $\pm 0,02$ 3 PL $\pm 0,005$			SCALE:	WEIGHT: SHEET 10 OF 25

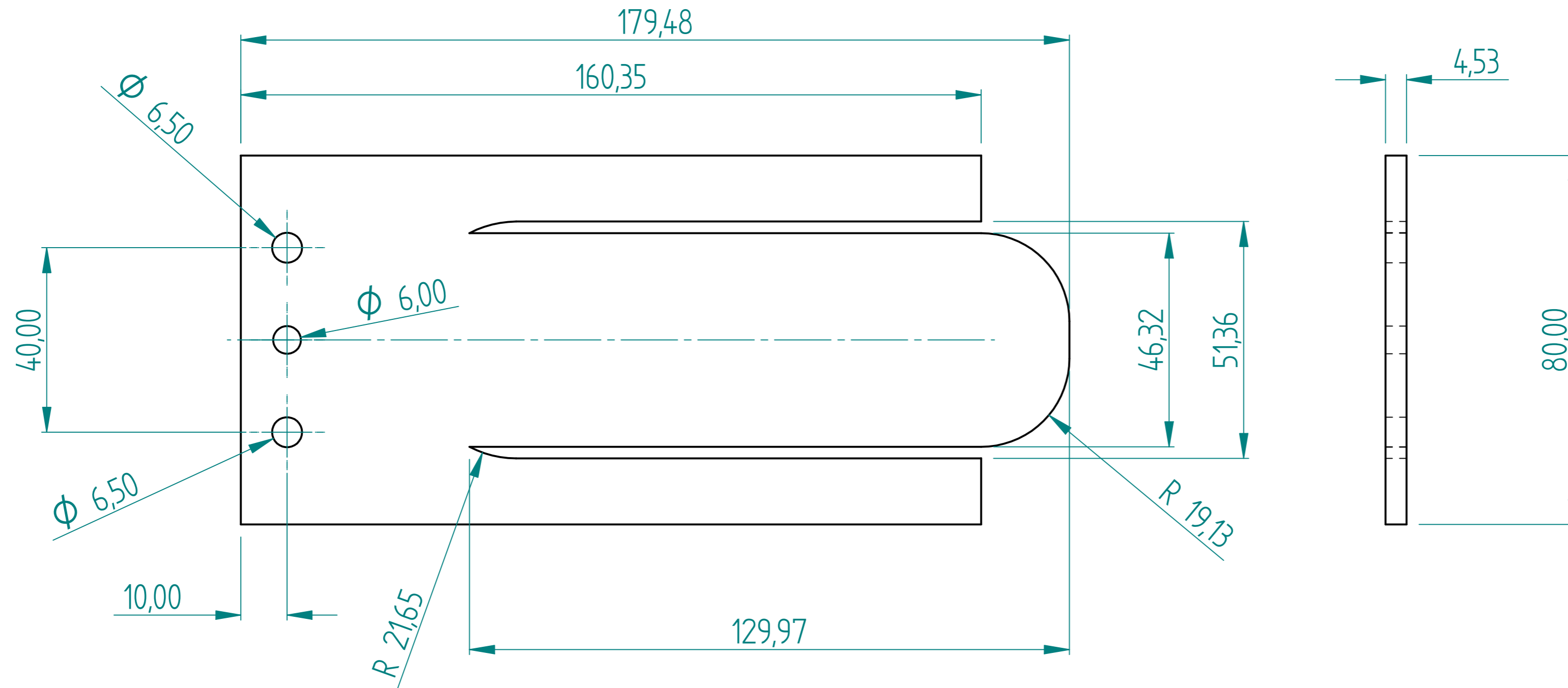
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



BASE CORE

DRAWN	NAME	DATE	PREMAC		
APPROVED	Dan	02/15/11			
MATERIAL					
TREATMENT					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO	REV
1st ANGLE ANGLES ±0.1°			A4		
2 PL ±0.02 3 PL ±0.005			FILE NAME: Base & Top Cover Die.dft		
			SCALE:	WEIGHT:	SHEET 11 OF 25

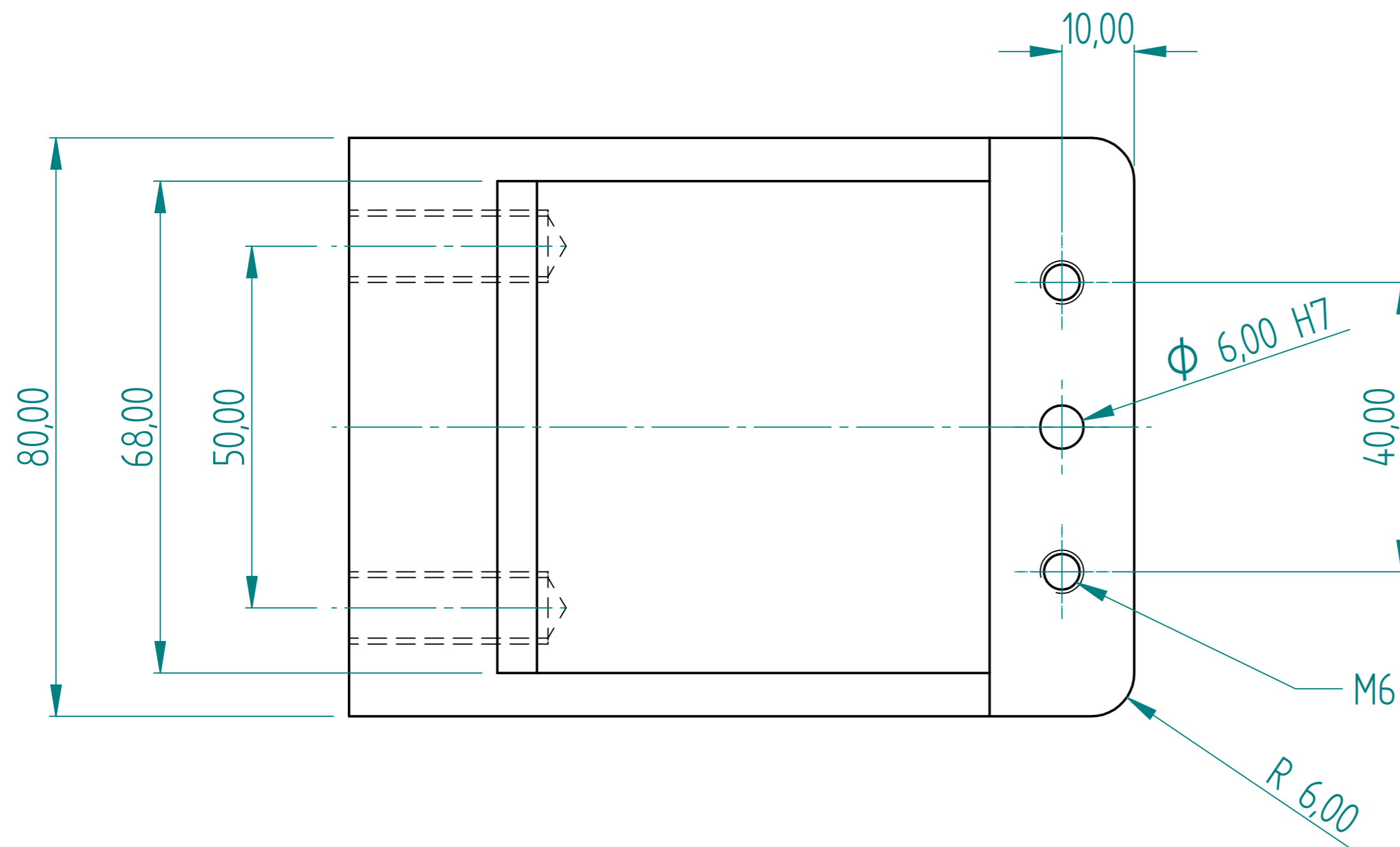
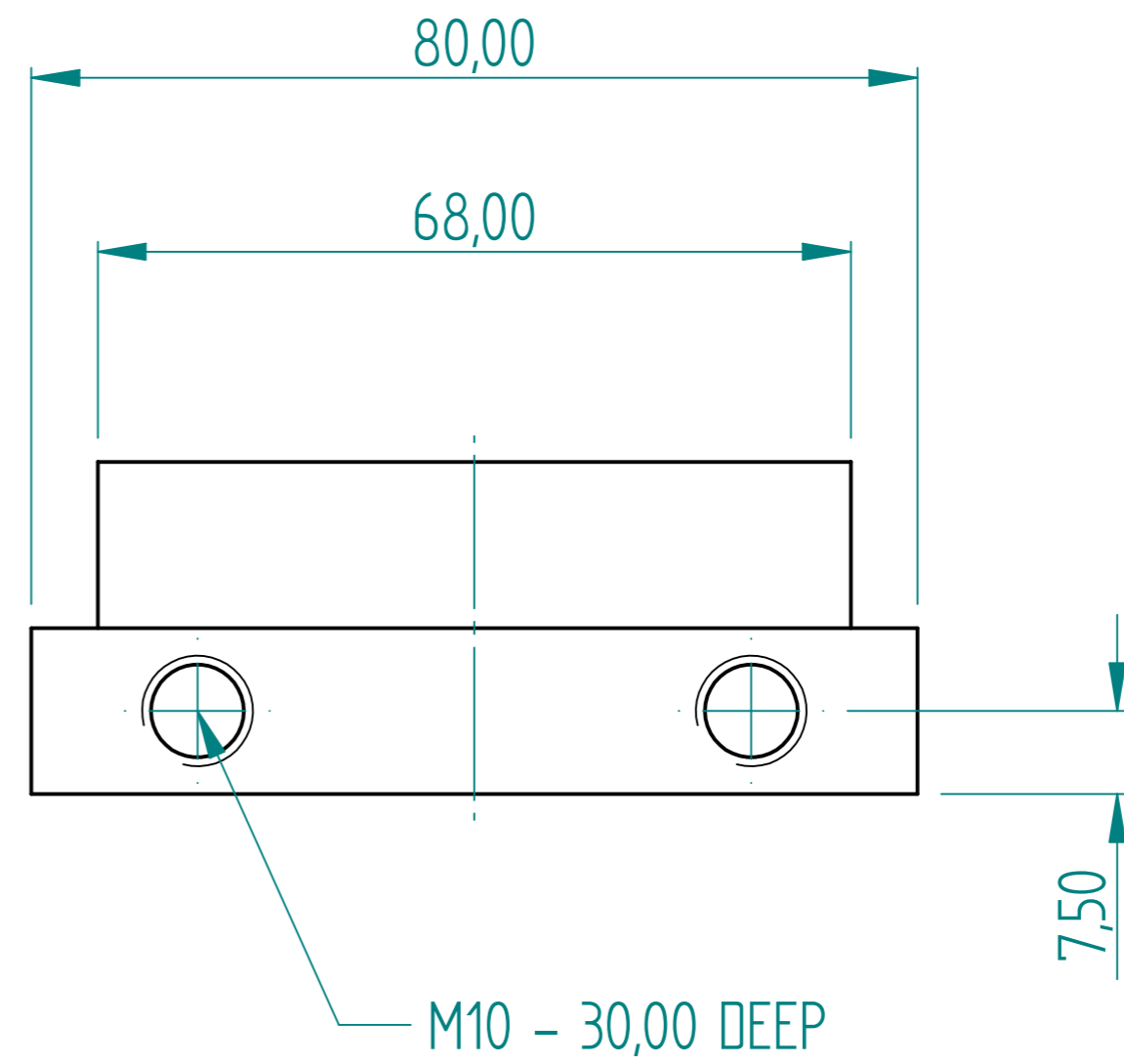
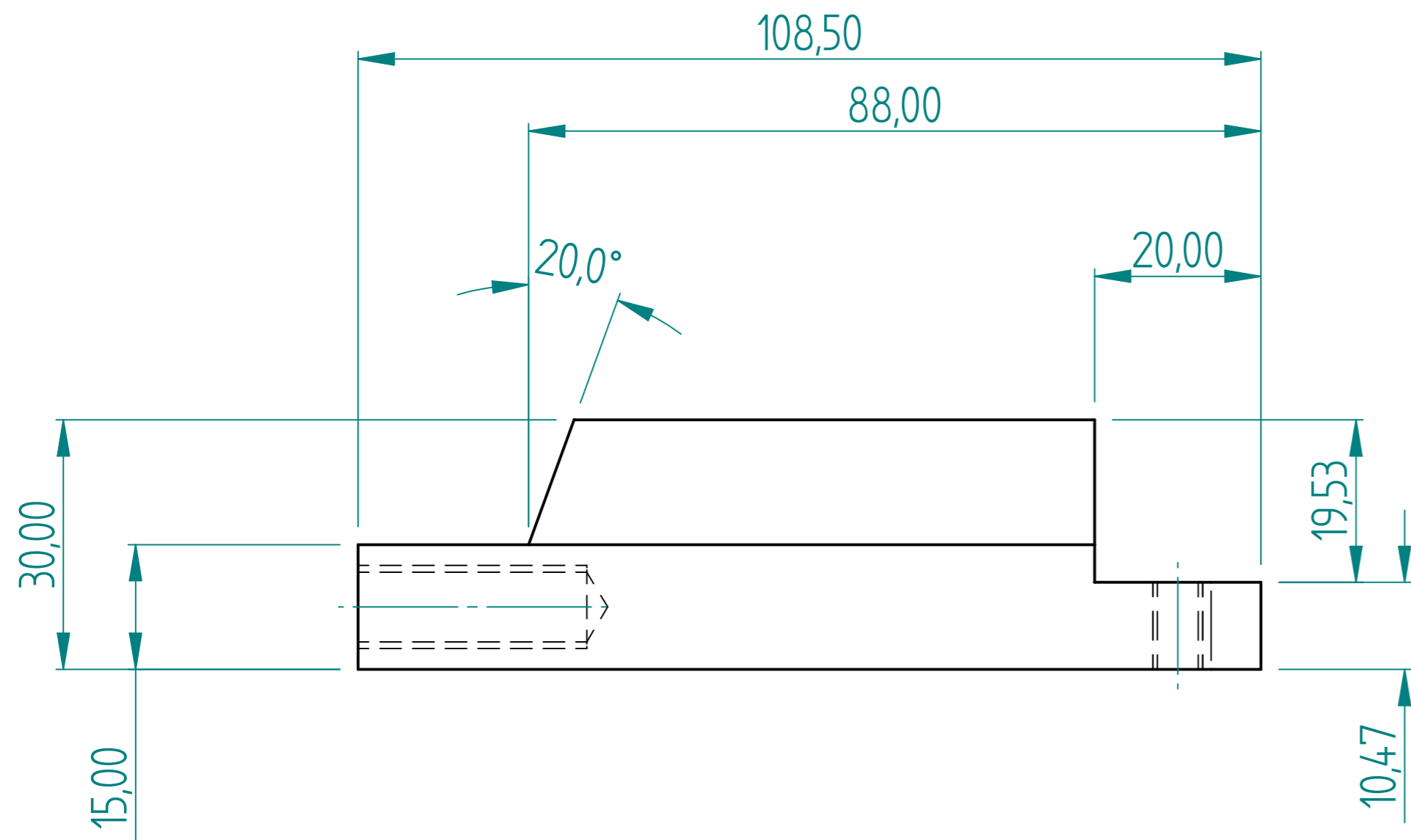
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



TOP BLADE

	NAME	DATE	PREMAC	
DRAWN	Dan	02/15/11		
APPROVED				
MATERIAL				
TREATMENT			TITLE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1 st ANGLE ANGLES $\pm 0,1^\circ$			FILE NAME: Base & Top Cover Die.dft	
2 PL $\pm 0,02$ 3 PL $\pm 0,005$			SCALE:	WEIGHT:
			SHEET 12 OF 25	

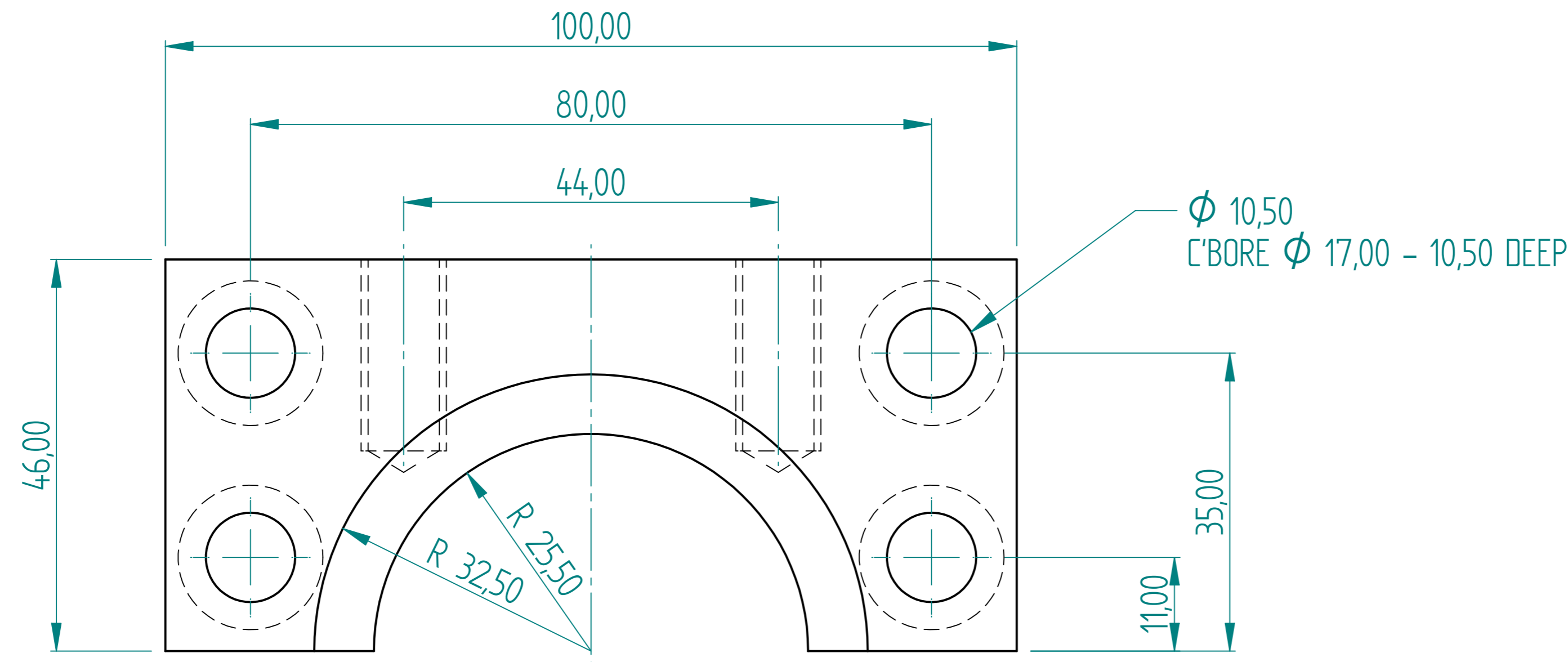
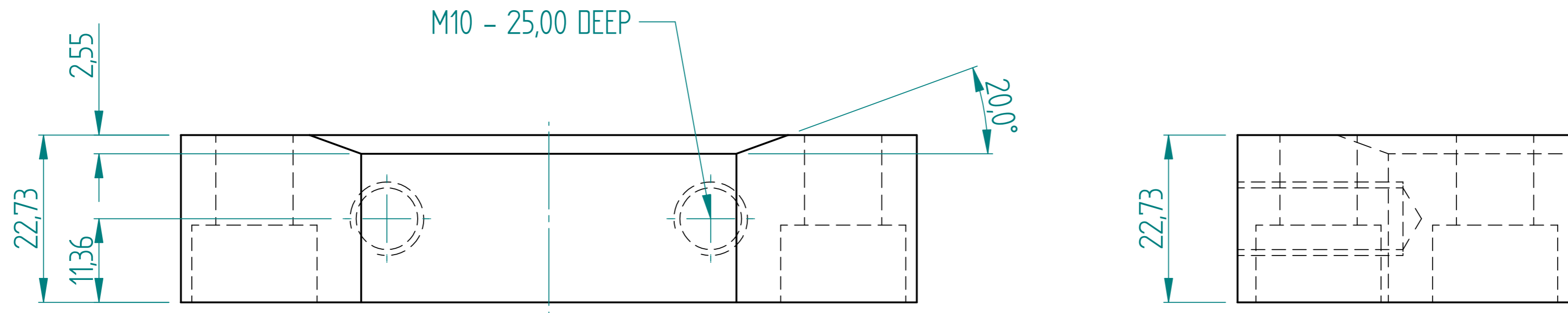
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



TOP BLADE SLIDE

	NAME	DATE	PREMAC	
DRAWN	Dan	02/15/11		
APPROVED				
MATERIAL				
TREATMENT			TITLE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1 st ANGLE ANGLES ±0,1°			FILE NAME: Base & Top Cover Die.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:
			SHEET 13 OF 25	

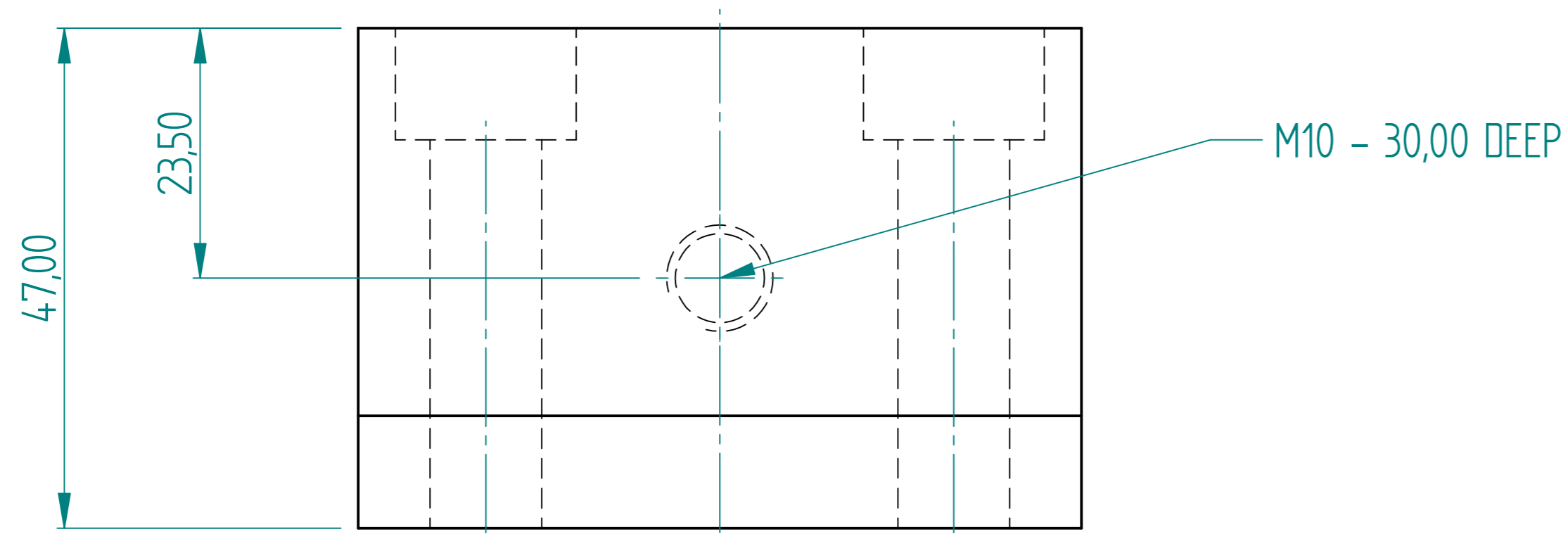
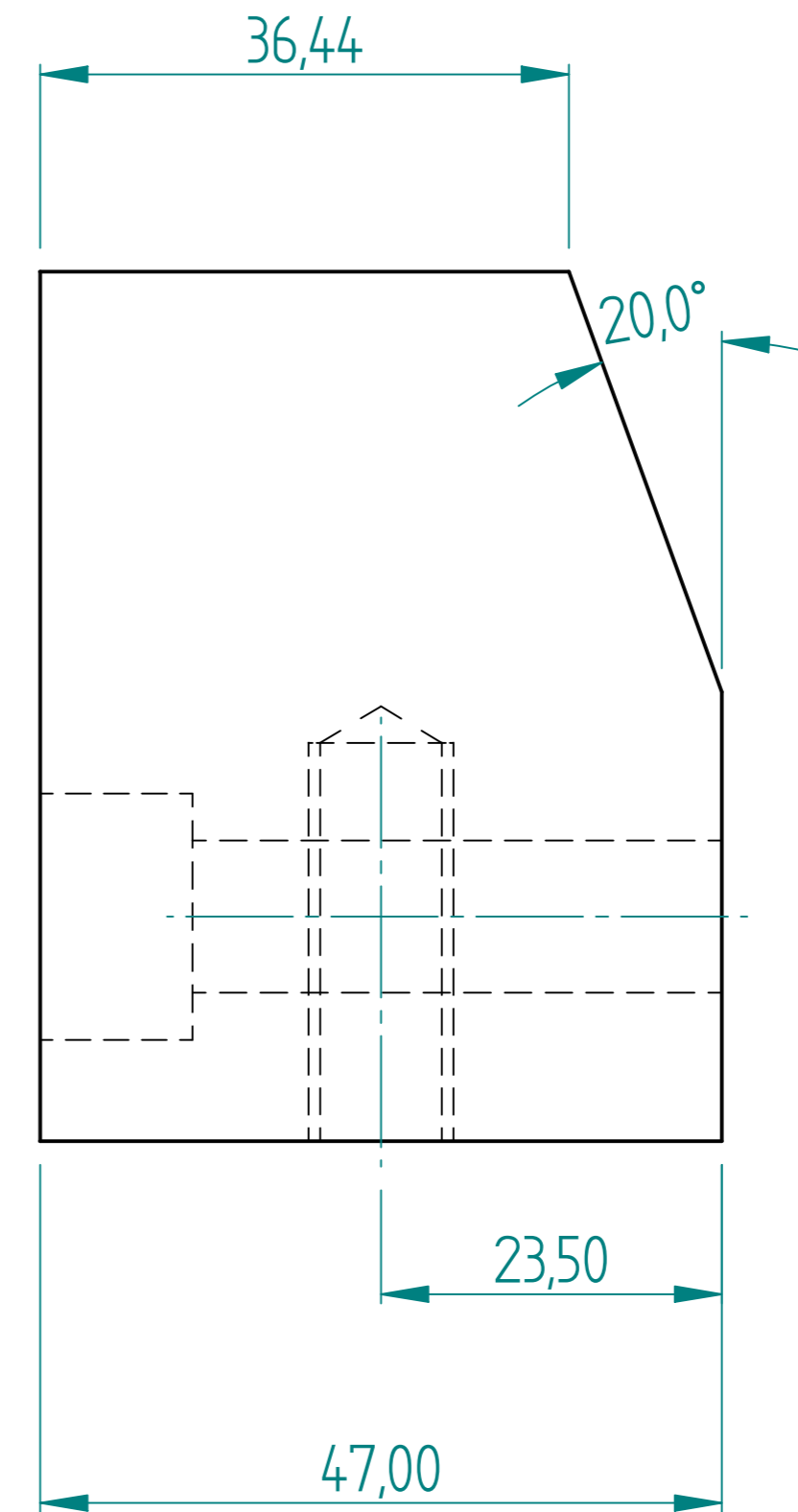
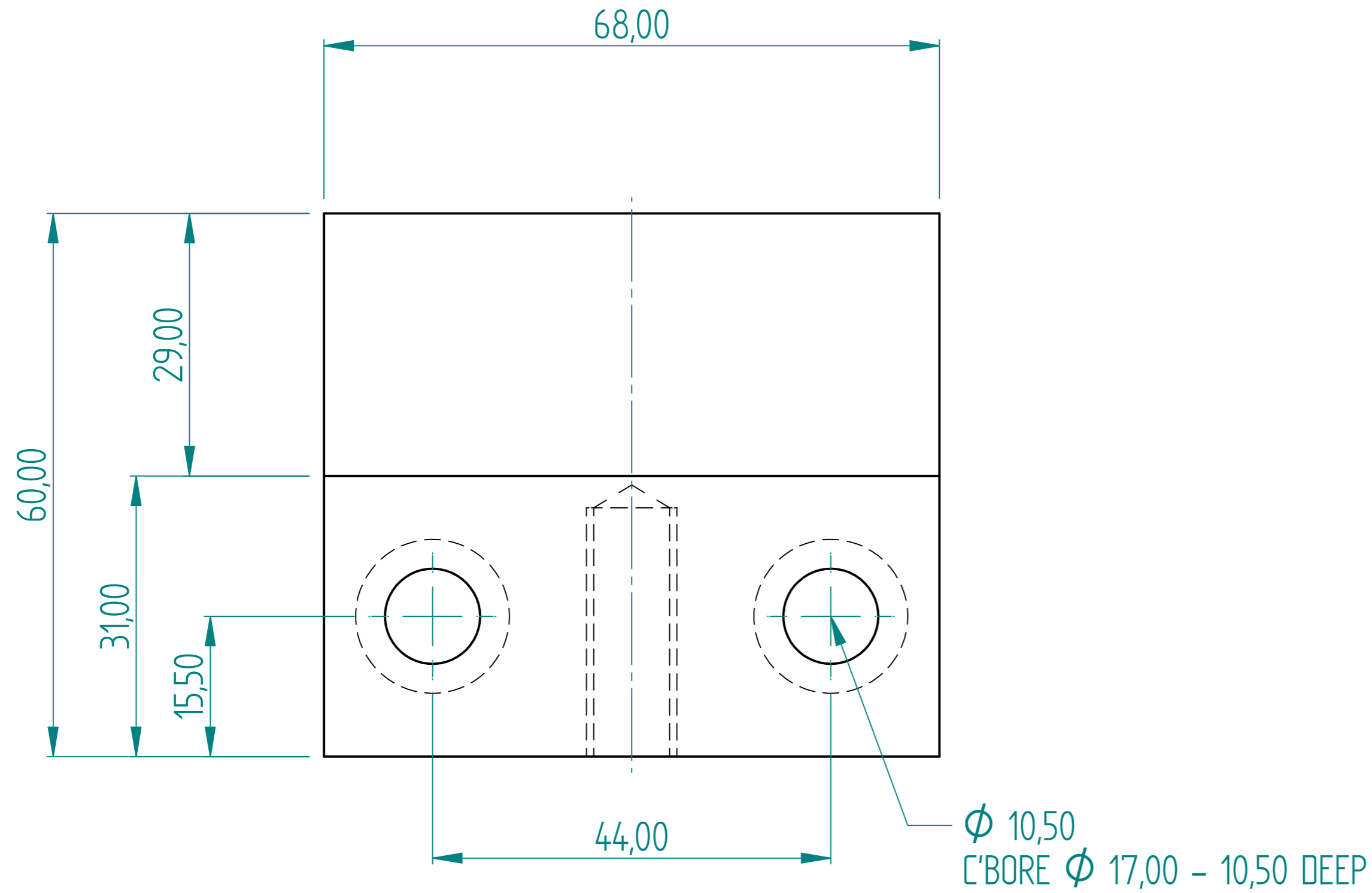
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



BASE CORE HEEL BLOCK

DRAWN	NAME	DATE	PREMAC		
APPROVED	Dan	02/15/11			
MATERIAL					
TREATMENT					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO	REV
1st ANGLE ANGLES ±0.1°			A4		
2 PL ±0.02 3 PL ±0.005			FILE NAME: Base & Top Cover Die.dft		
SCALE:		WEIGHT:	SHEET 14 OF 25		

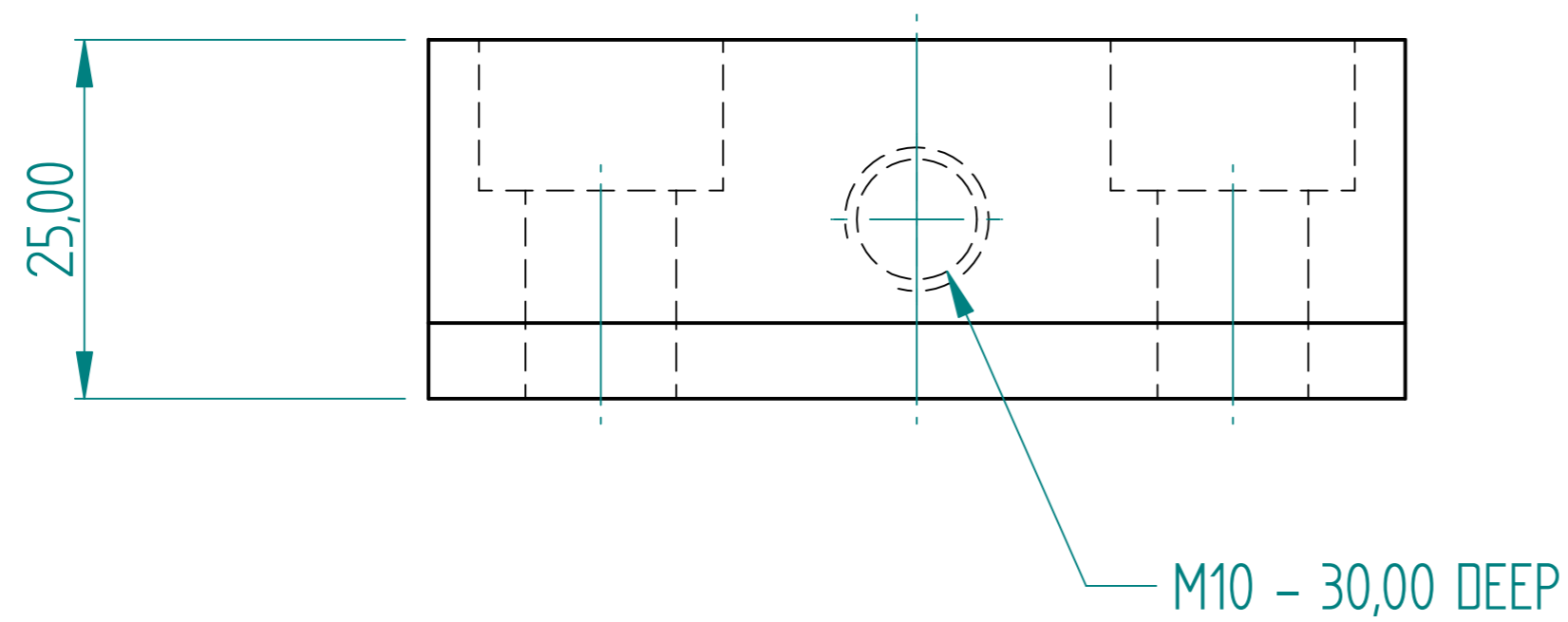
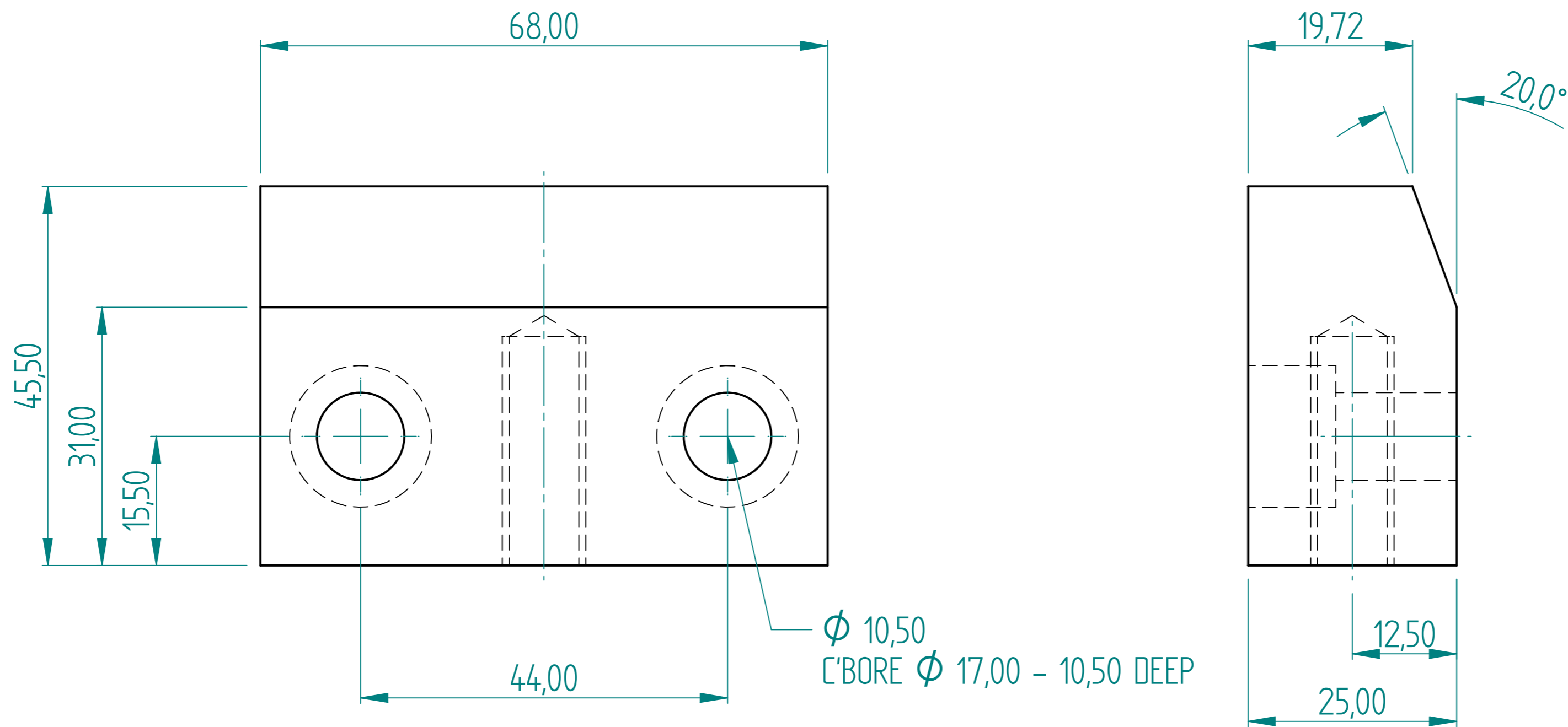
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



BOTTOM SLIDE HEEL BLOCK

DRAWN	NAME	DATE	PREMAC	
APPROVED	Dan	02/15/11		
MATERIAL				
TREATMENT				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1 st ANGLE ANGLES $\pm 0,1^\circ$			FILE NAME: Base & Top Cover Die.dft	
2 PL $\pm 0,02$ 3 PL $\pm 0,005$			SCALE:	WEIGHT:
			SHEET 15 OF 25	

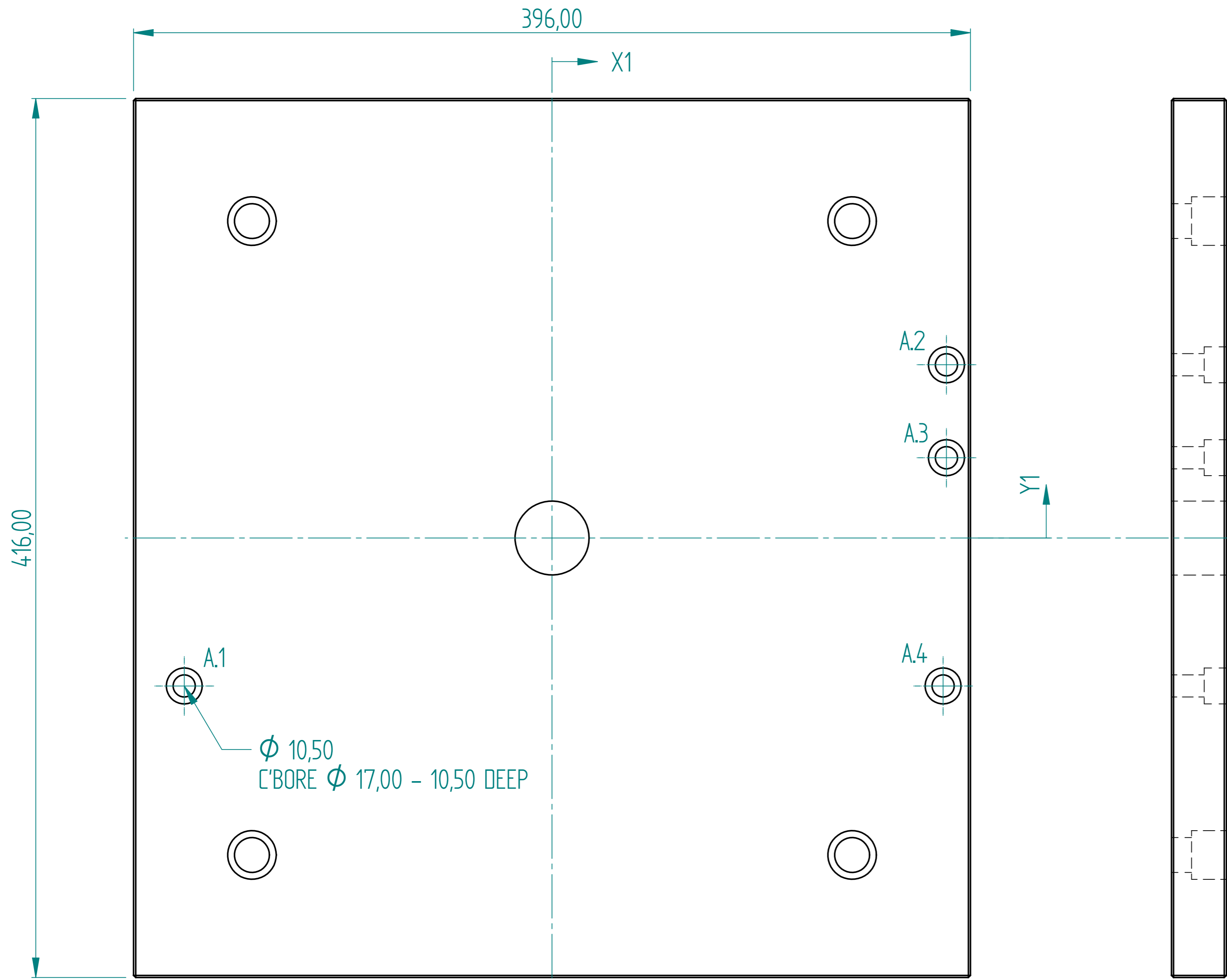
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



TOP SLIDE HEEL BLOCK

	NAME	DATE	PREMAC	
DRAWN	Dan	02/15/11		
APPROVED				
MATERIAL				
TREATMENT			TITLE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1 st ANGLE ANGLES $\pm 0,1^\circ$			FILE NAME: Base & Top Cover Die.dft	
2 PL $\pm 0,02$ 3 PL $\pm 0,005$			SCALE:	WEIGHT:
			SHEET 16 OF 25	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

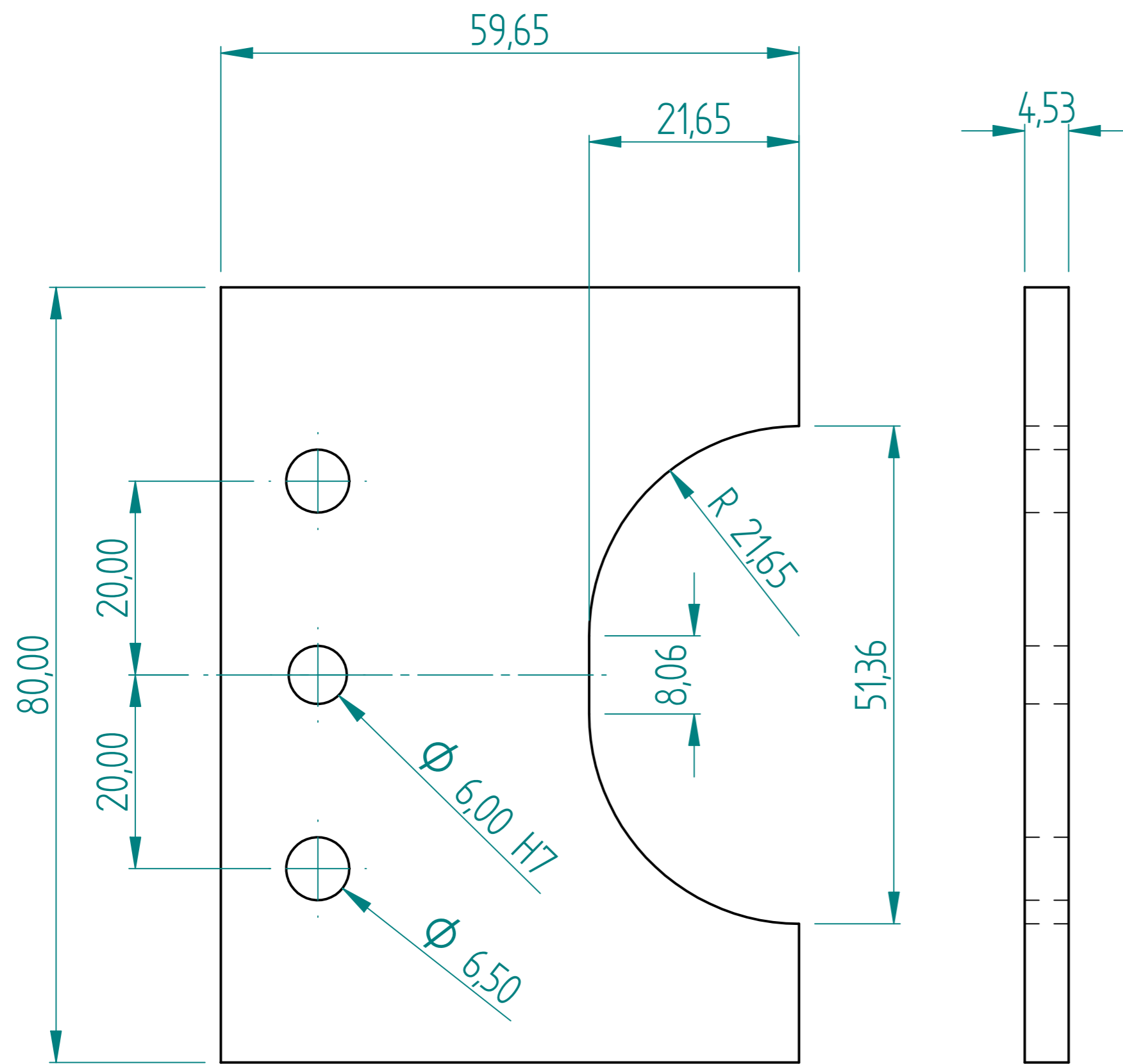


Hole	X	Y
A.1	-174,04	-70,00
A.2	186,63	82,00
A.3	186,63	38,00
A.4	185,04	-70,00

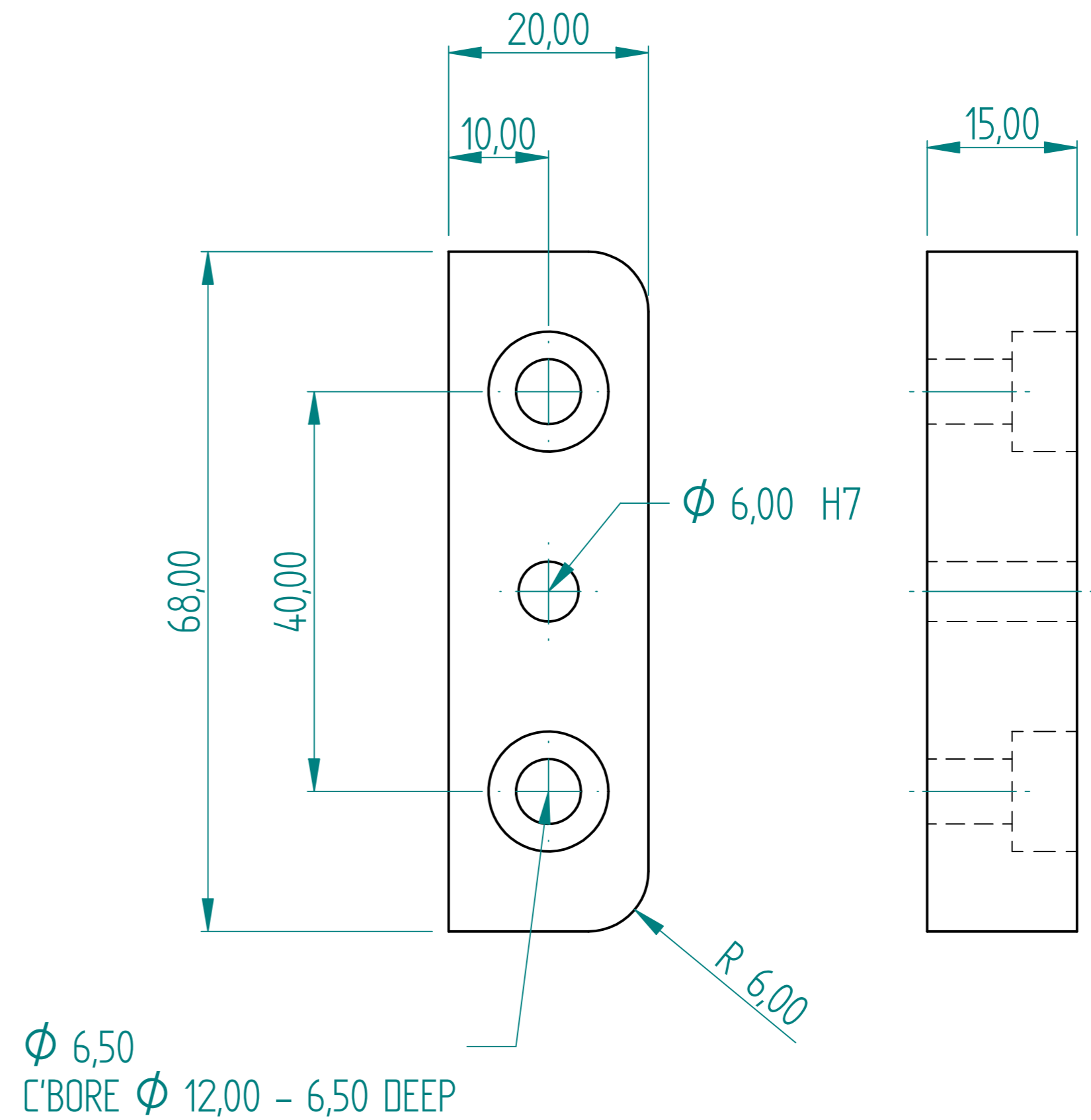
FIXED CLAMPING PLATE

	NAME	DATE	PREMAC	
DRAWN	Dan	02/15/11		
APPROVED				
MATERIAL				
TREATMENT			TITLE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1st ANGLE ANGLES ±0,1°			FILE NAME: Base & Top Cover Die.dft	REV
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:
			SHEET 17 OF 25	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



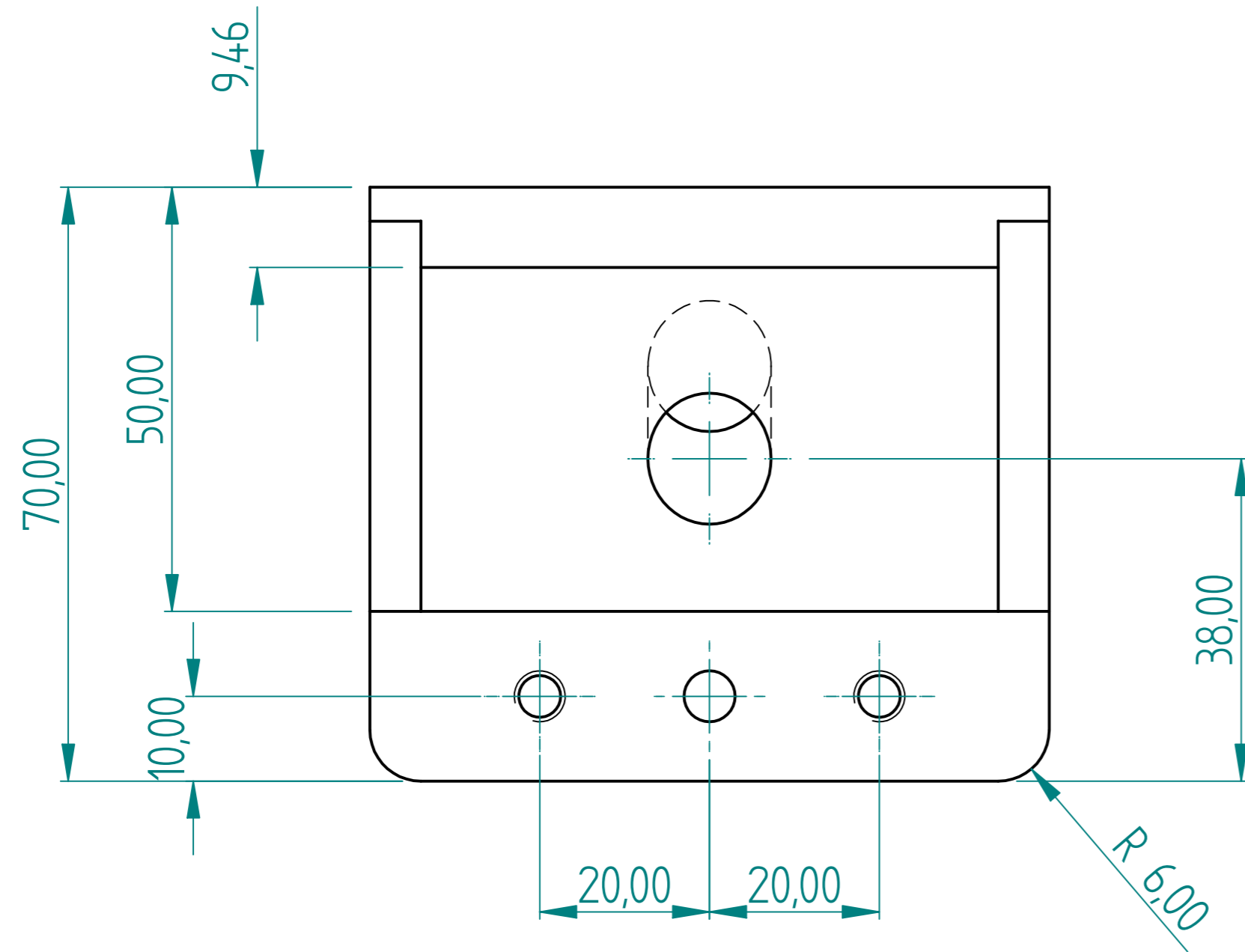
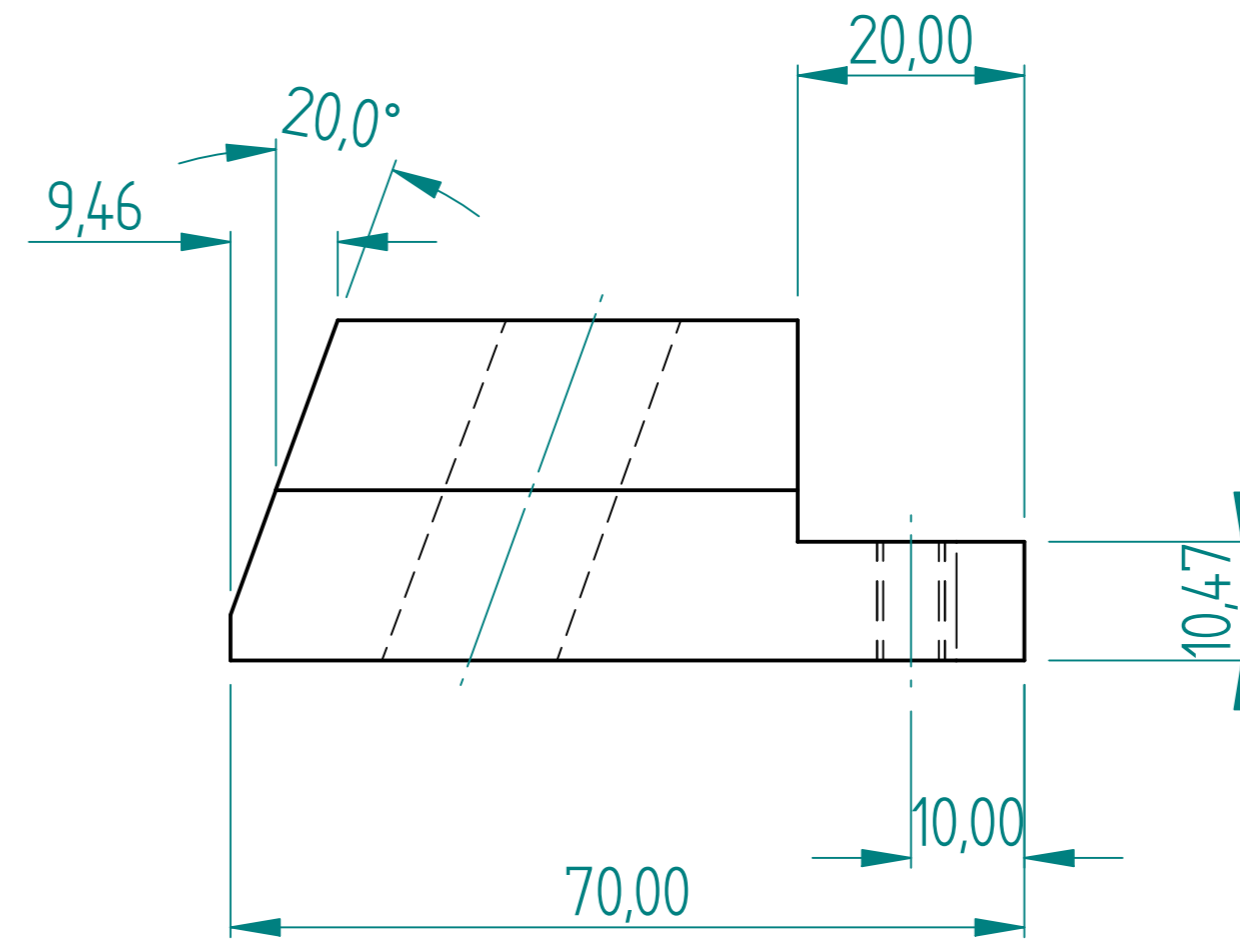
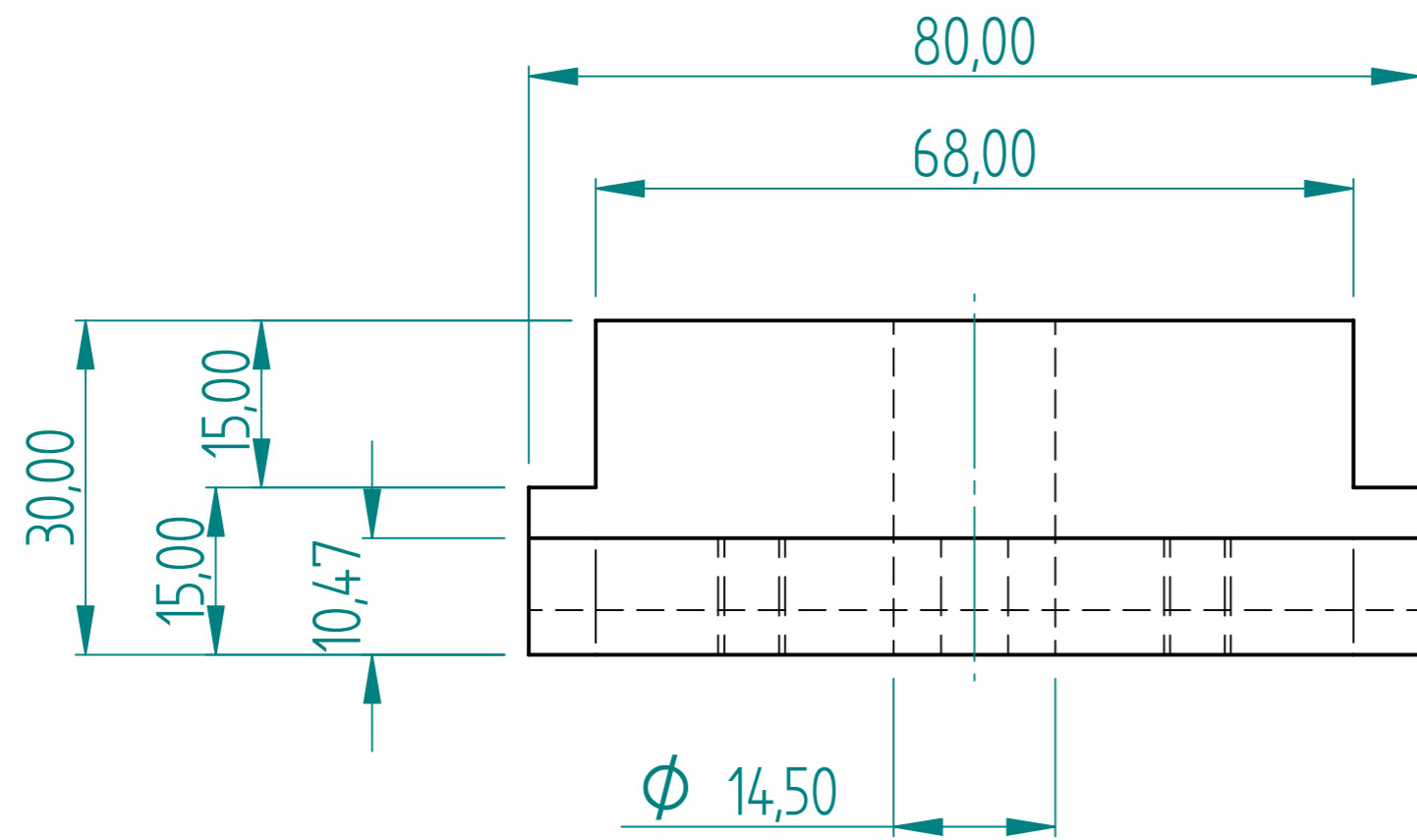
BOTTOM BLADE



BLADE CLAMP 2 OF

	NAME	DATE	PREMAC	
DRAWN	Dan	02/15/11		
APPROVED			TITLE	
MATERIAL				
TREATMENT				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1 st ANGLE ANGLES $\pm 0,1^\circ$			REV	
2 PL $\pm 0,02$ 3 PL $\pm 0,005$			FILE NAME: Base & Top Cover Die.dft	
SCALE:			WEIGHT:	SHEET 18 OF 25

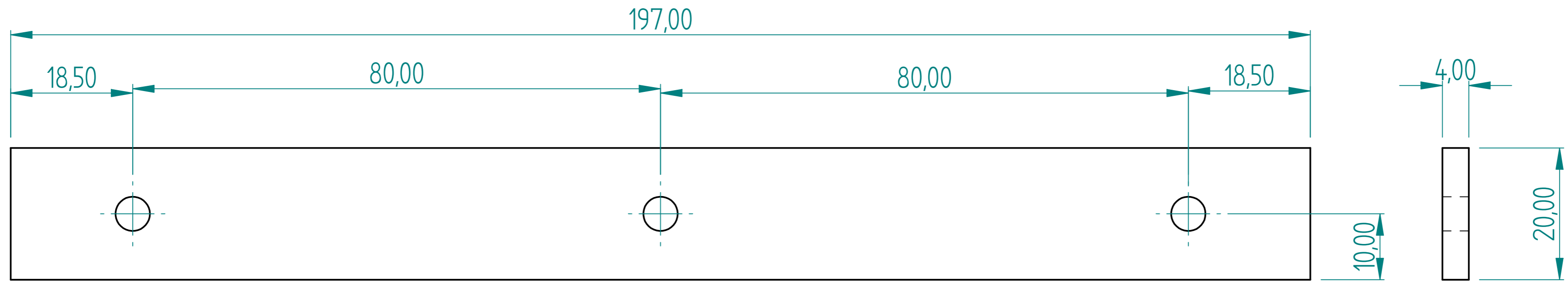
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



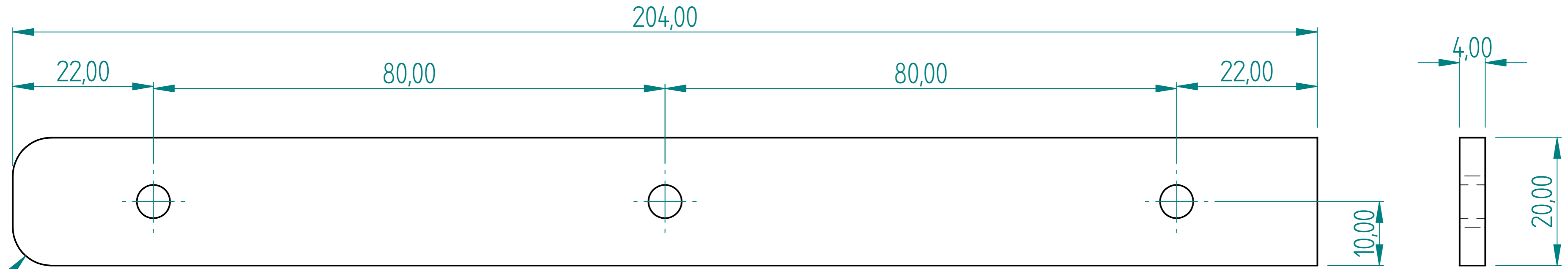
BOTTOM BLADE SLIDE

	NAME	DATE	PREMAC		
DRAWN	Dan	02/15/11			
APPROVED			TITLE		
MATERIAL					
TREATMENT			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS ANGLES ±0,1° 1st ANGLE		
			SIZE A4	DWG NO	REV
			FILE NAME: Base & Top Cover Die.dft		
			SCALE:	WEIGHT:	SHEET 19 OF 25

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

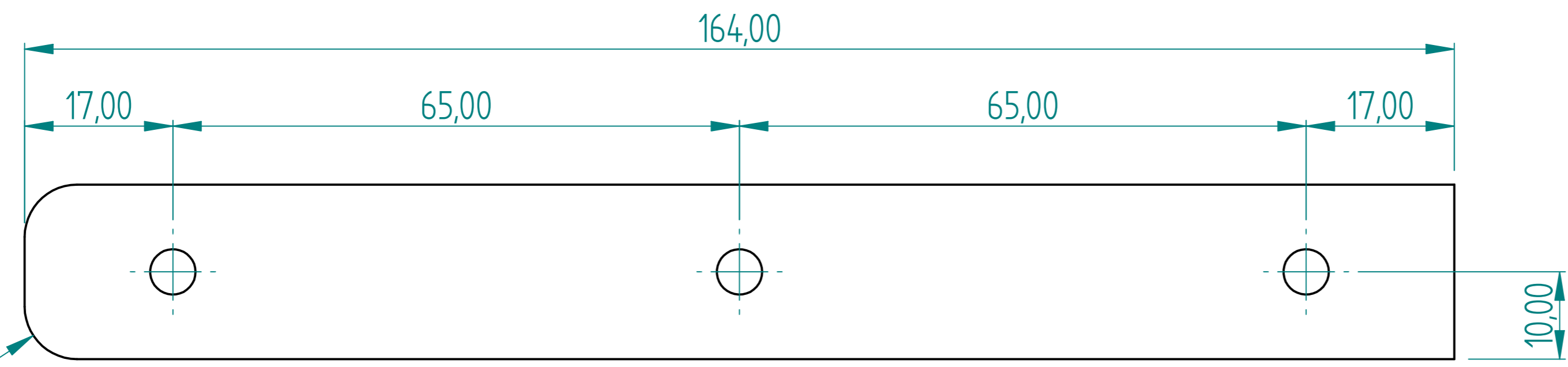


RAIL



RAIL B

R 6,00

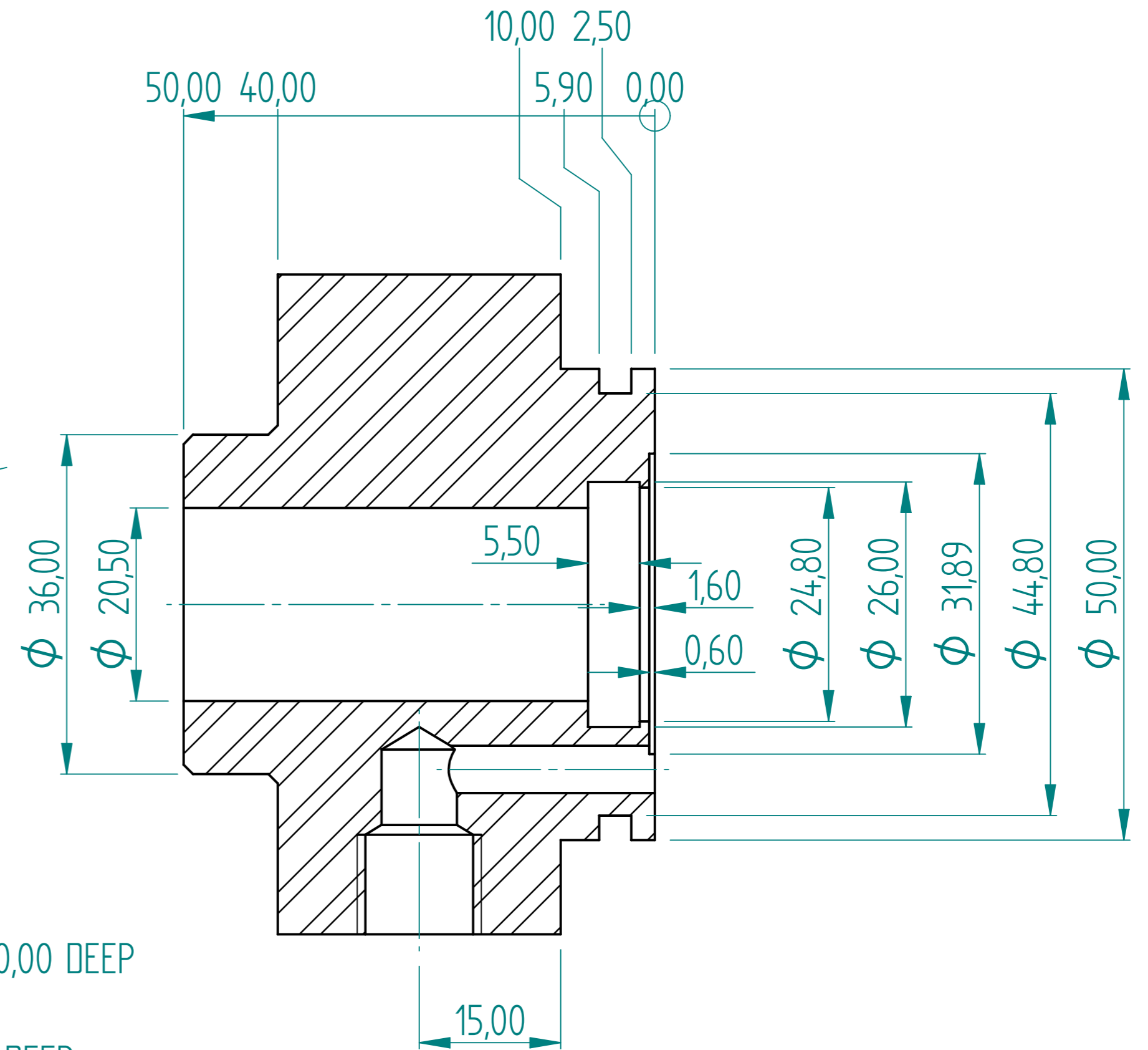
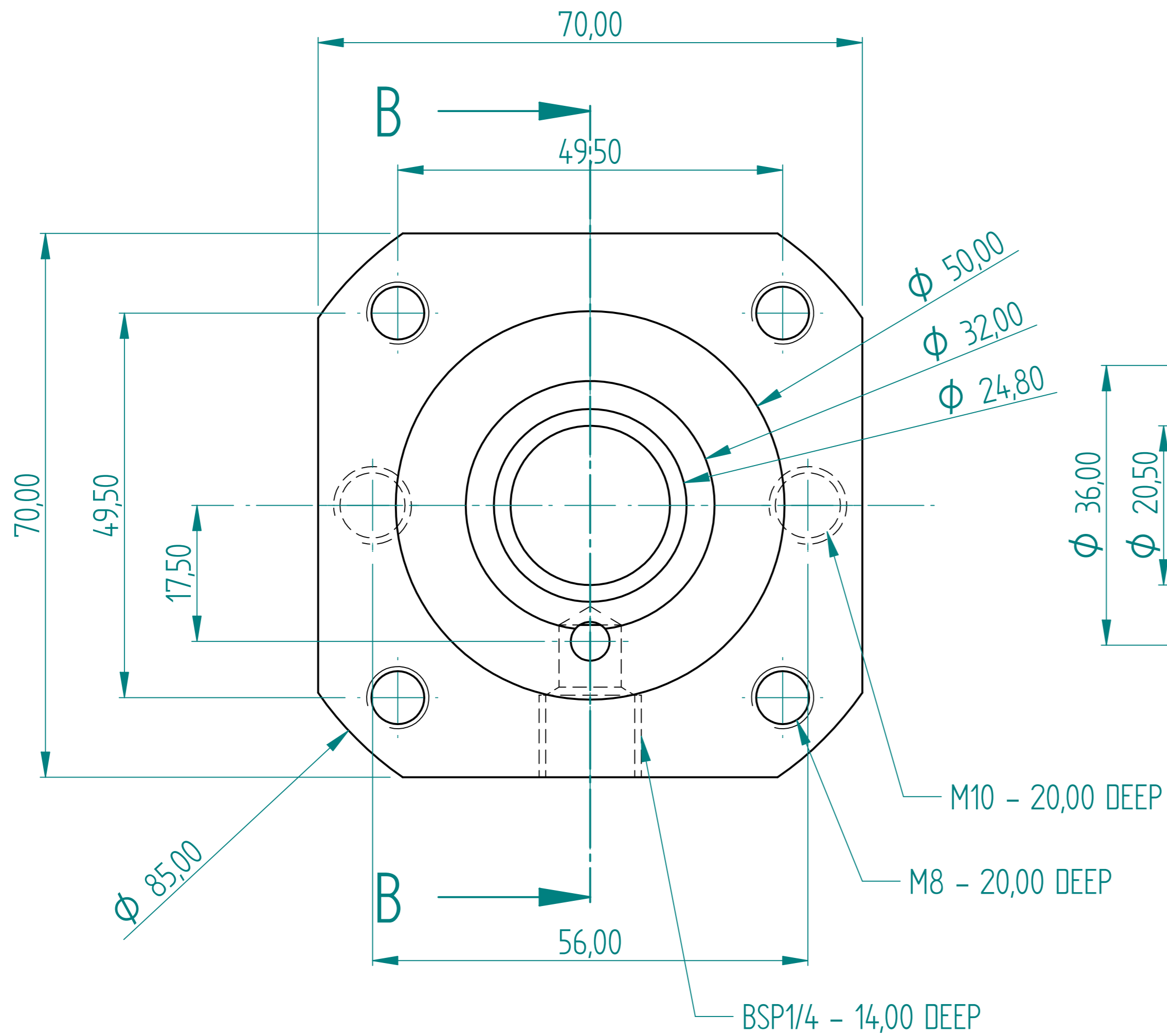


RAIL A

R 6,00

DRAWN	NAME	DATE	PREMAC		
APPROVED	Dan	02/15/11			
MATERIAL					
TREATMENT					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO	REV
1 st ANGLE			A4		
2 PL ±0.02 3 PL ±0.005			FILE NAME: Base & Top Cover Die.dft		
			SCALE:	WEIGHT:	SHEET 20 OF 25

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

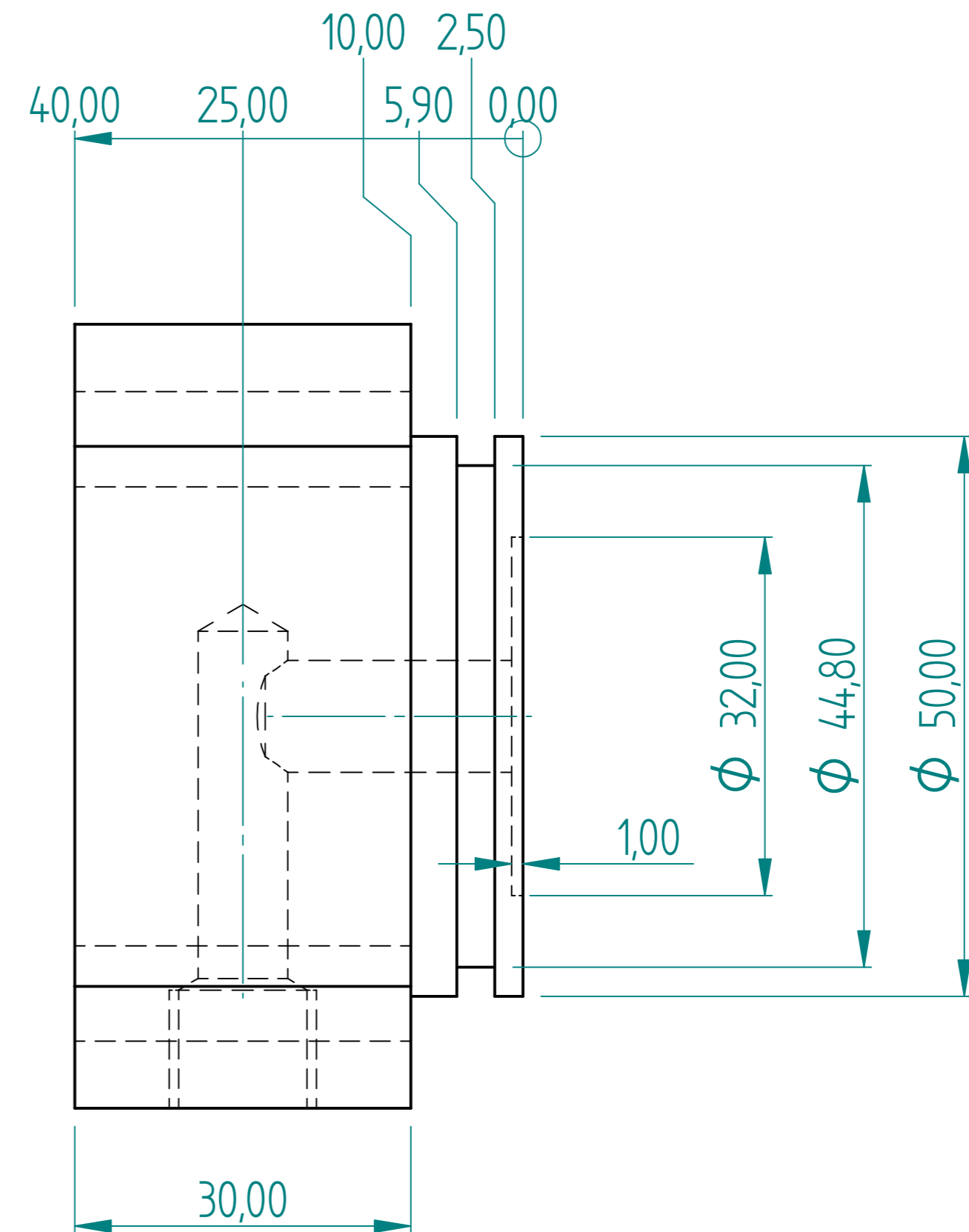
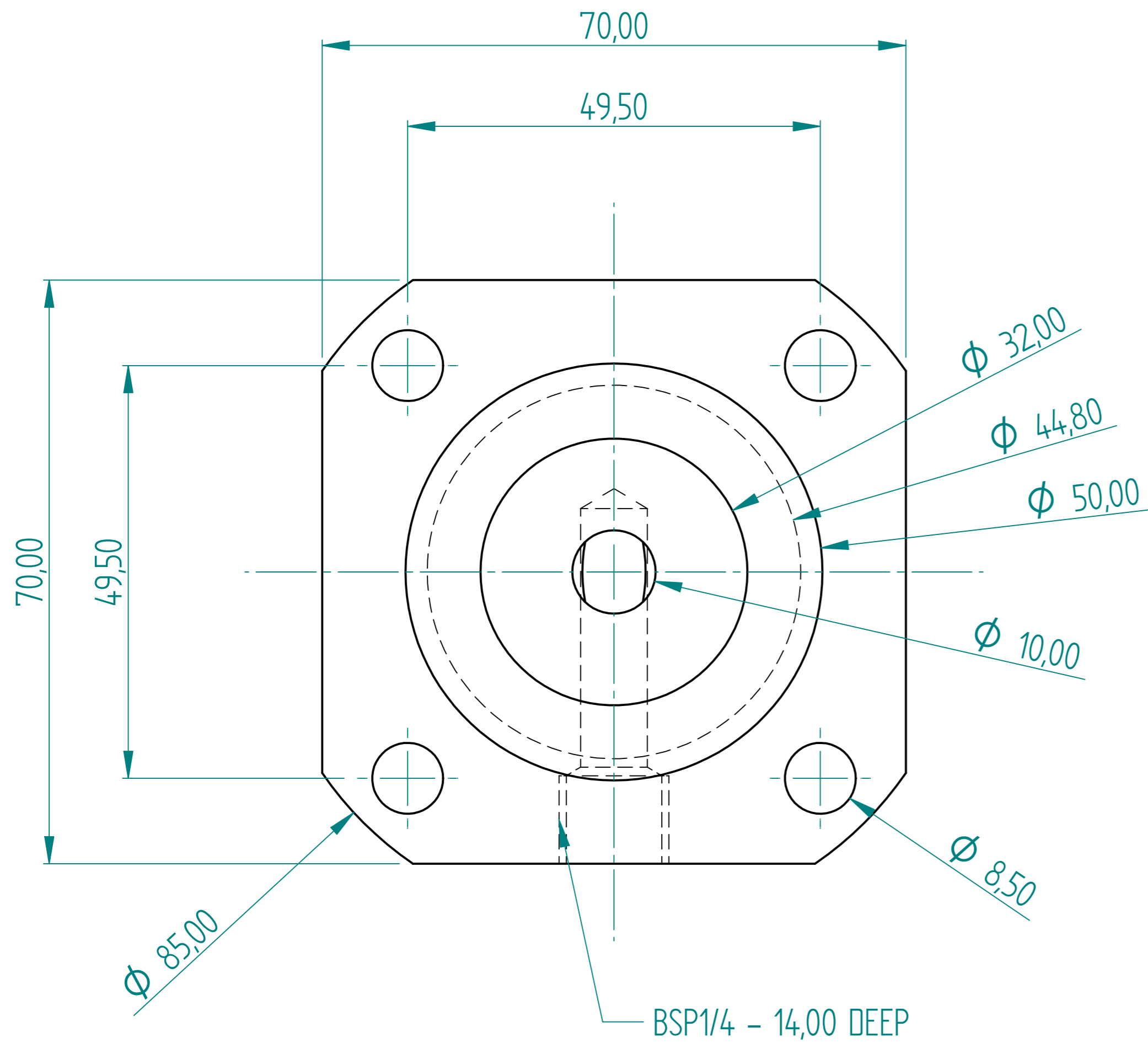


SECTION B-B

BOTTOM END CAP

DRAWN	NAME	DATE	PREMAC		
APPROVED	Dan	02/15/11			
MATERIAL					
TREATMENT					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO	REV
1st ANGLE ANGLES ±0,1°			A4		
2 PL ±0,02 3 PL ±0,005			FILE NAME: Base & Top Cover Die.dft		
SCALE:		WEIGHT:	SHEET 22 OF 25		

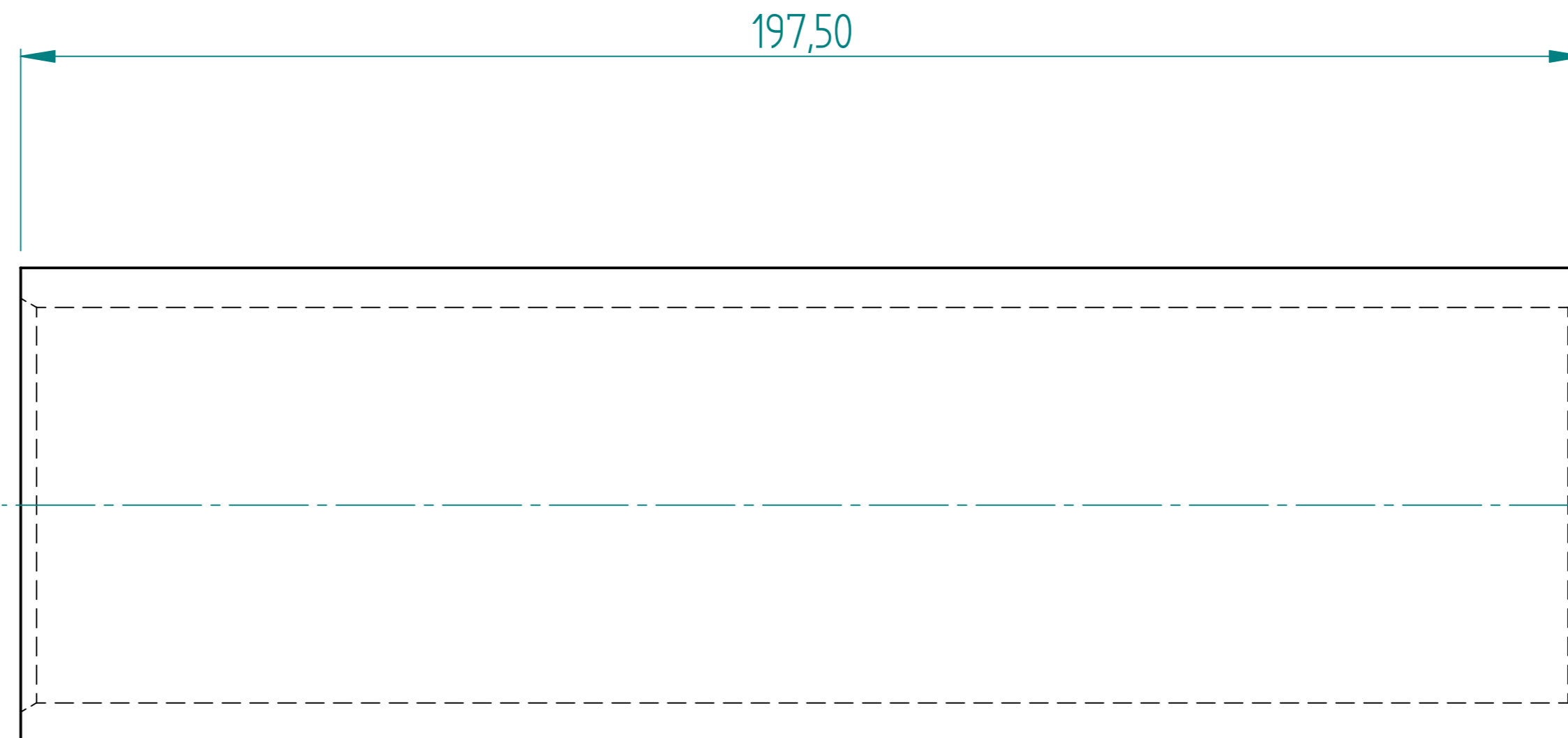
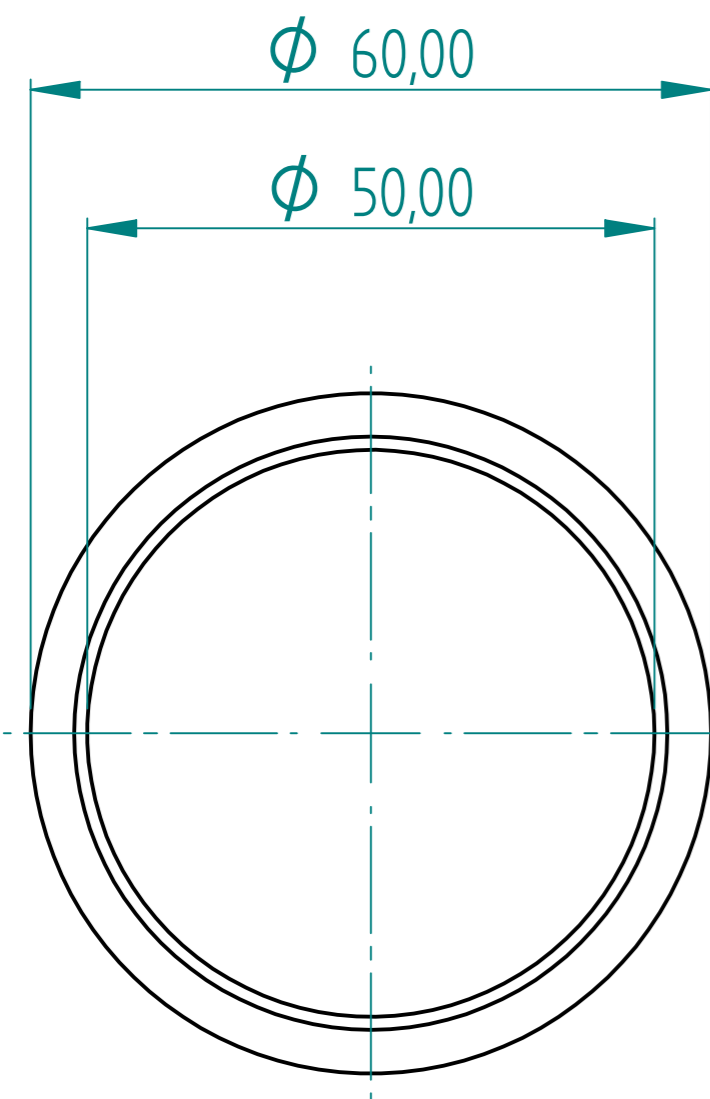
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



TOP END CAP

DRAWN	NAME	DATE	PREMAC		
APPROVED	Dan	02/15/11			
MATERIAL					
TREATMENT					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO	REV
1 st ANGLE ANGLES ±0,1°			A4		
2 PL ±0,02 3 PL ±0,005			FILE NAME: Base & Top Cover Die.dft		
SCALE:			WEIGHT:	SHEET 23 OF 25	

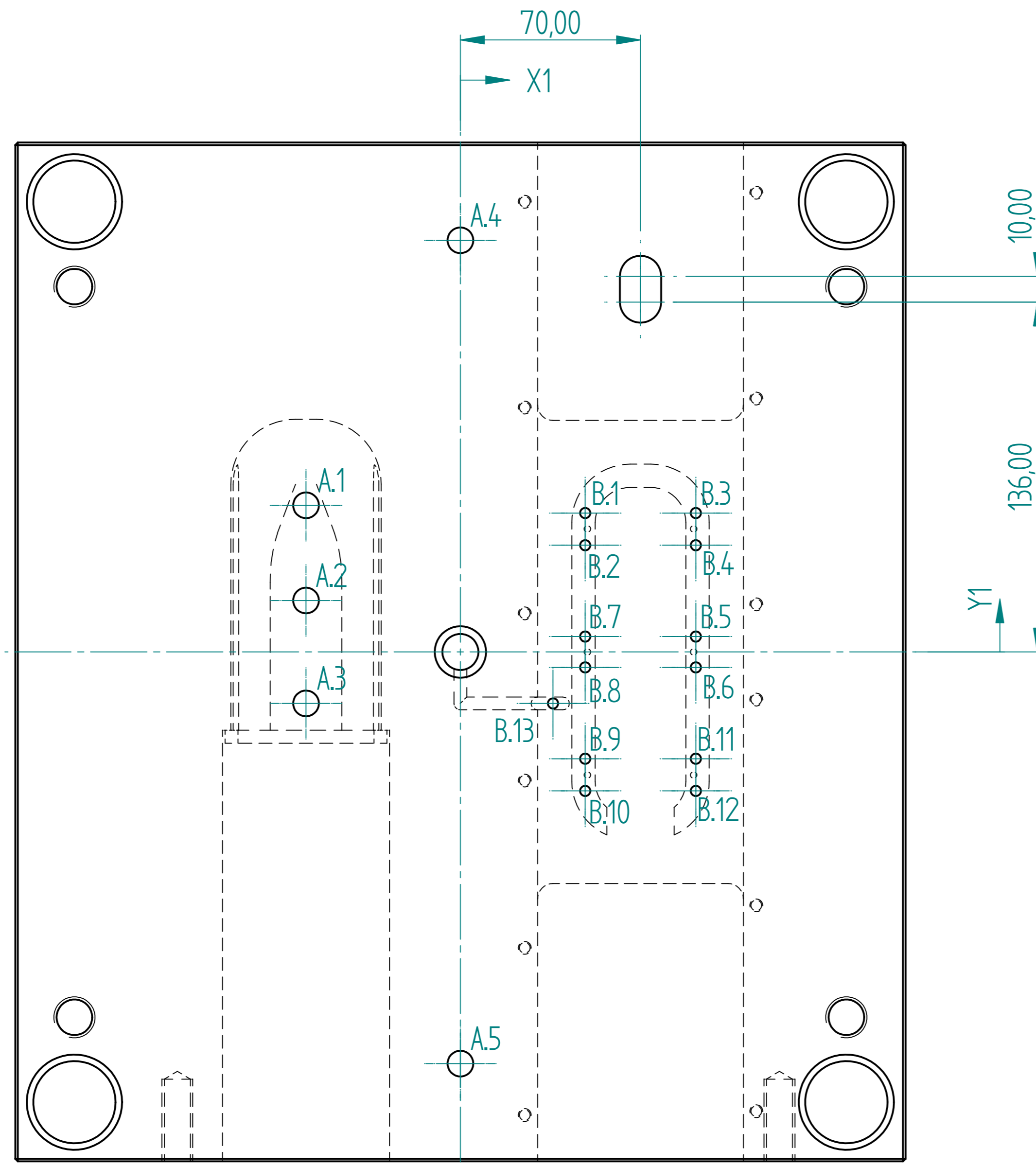
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



CYL TUBE

	NAME	DATE	PREMAC	
DRAWN	Dan	02/15/11		
APPROVED				
MATERIAL				
TREATMENT			TITLE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1st ANGLE 2 PL ±0.02 3 PL ±0.005			FILE NAME: Base & Top Cover Die.dft	REV
			SCALE:	WEIGHT:
			SHEET 24 OF 25	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



Hole Table			
Hole	X	Y	Size H7
A.1	-60,00	57,00	φ 10,00
A.2	-60,00	20,00	φ 10,00
A.3	-60,00	-20,00	φ 10,00
A.4	0,00	160,00	φ 10,00
A.5	0,00	-160,00	φ 10,00
B.1	48,50	54,00	φ 4,00
B.2	48,50	41,50	φ 4,00
B.3	91,50	54,00	φ 4,00
B.4	91,50	41,50	φ 4,00
B.5	91,50	6,00	φ 4,00
B.6	91,50	-6,00	φ 4,00
B.7	48,50	6,00	φ 4,00
B.8	48,50	-6,00	φ 4,00
B.9	48,50	-41,50	φ 4,00
B.10	48,50	-54,00	φ 4,00
B.11	91,50	-41,50	φ 4,00
B.12	91,50	-54,00	φ 4,00
B.13	36,00	-20,00	φ 4,00

MOVING DIE PLATE DRILL & REAM

DRAWN	NAME	DATE	PREMAC	
APPROVED	Dan	02/15/11		
MATERIAL			TITLE	
TREATMENT			FILE NAME: Base & Top Cover Die.dft	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1st ANGLE ANGLES ±0.1°			SCALE:	WEIGHT:
2 PL ±0.02 3 PL ±0.005			SHEET 25 OF 25	