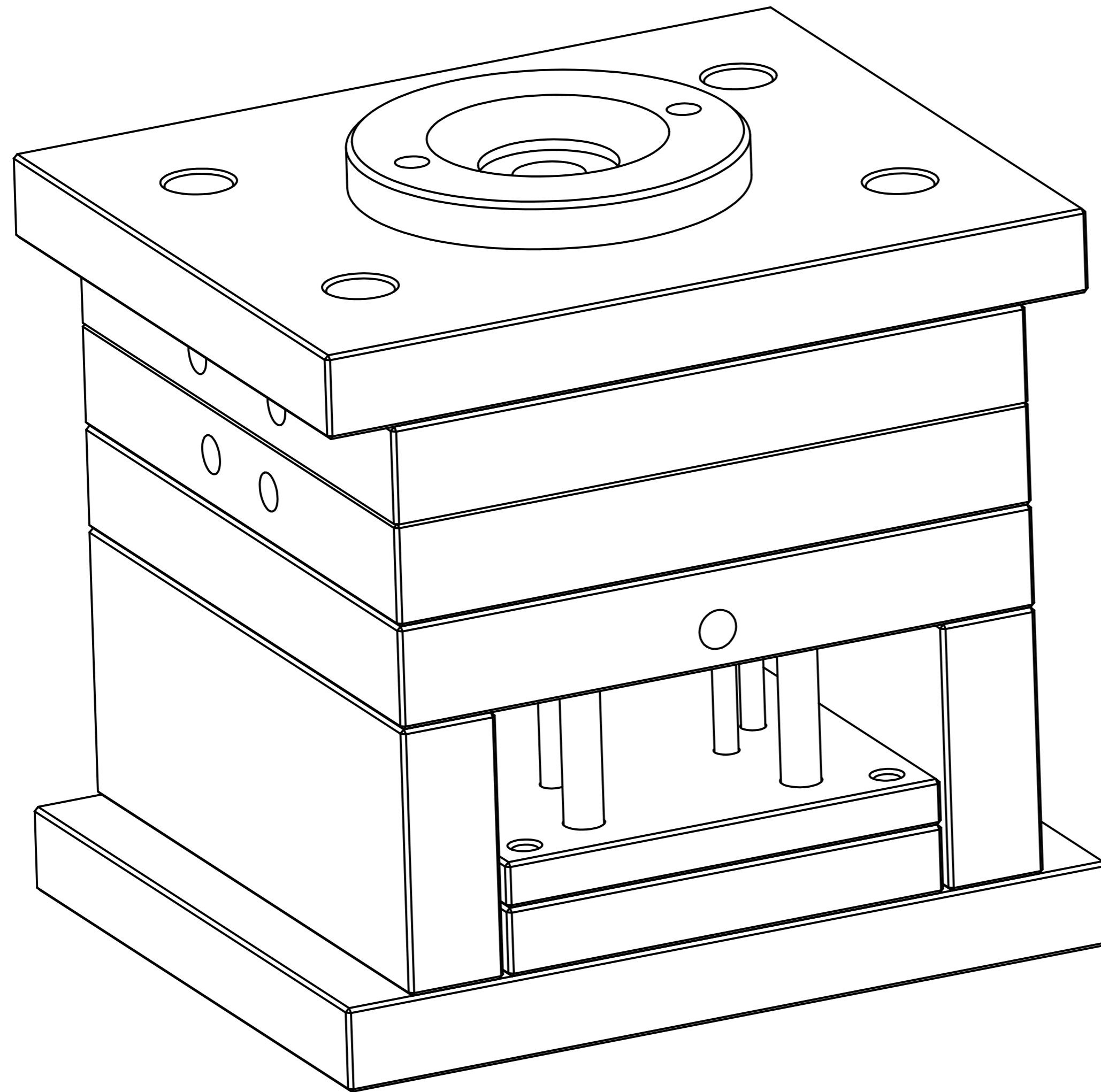


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



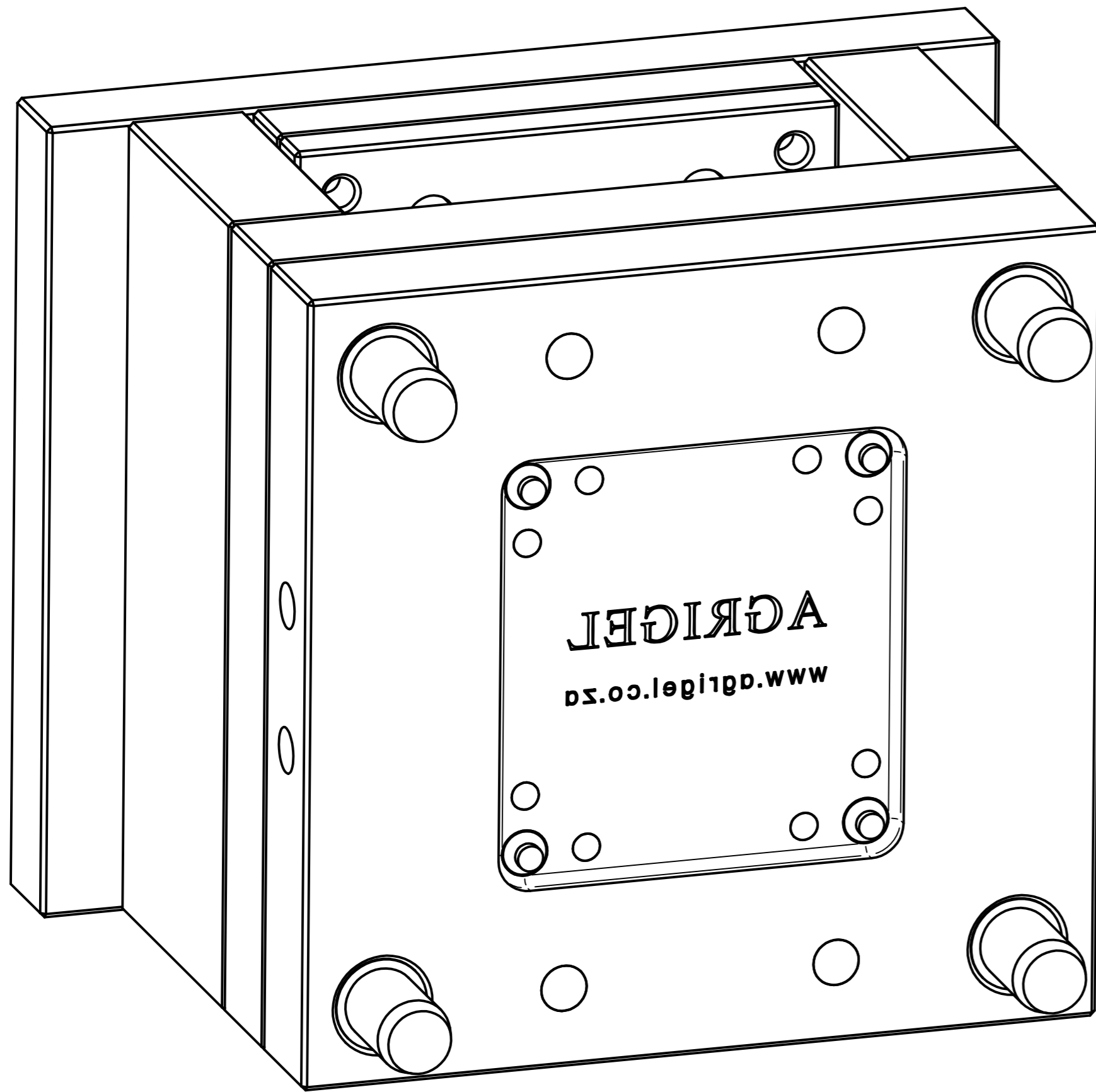
D B LID DIE



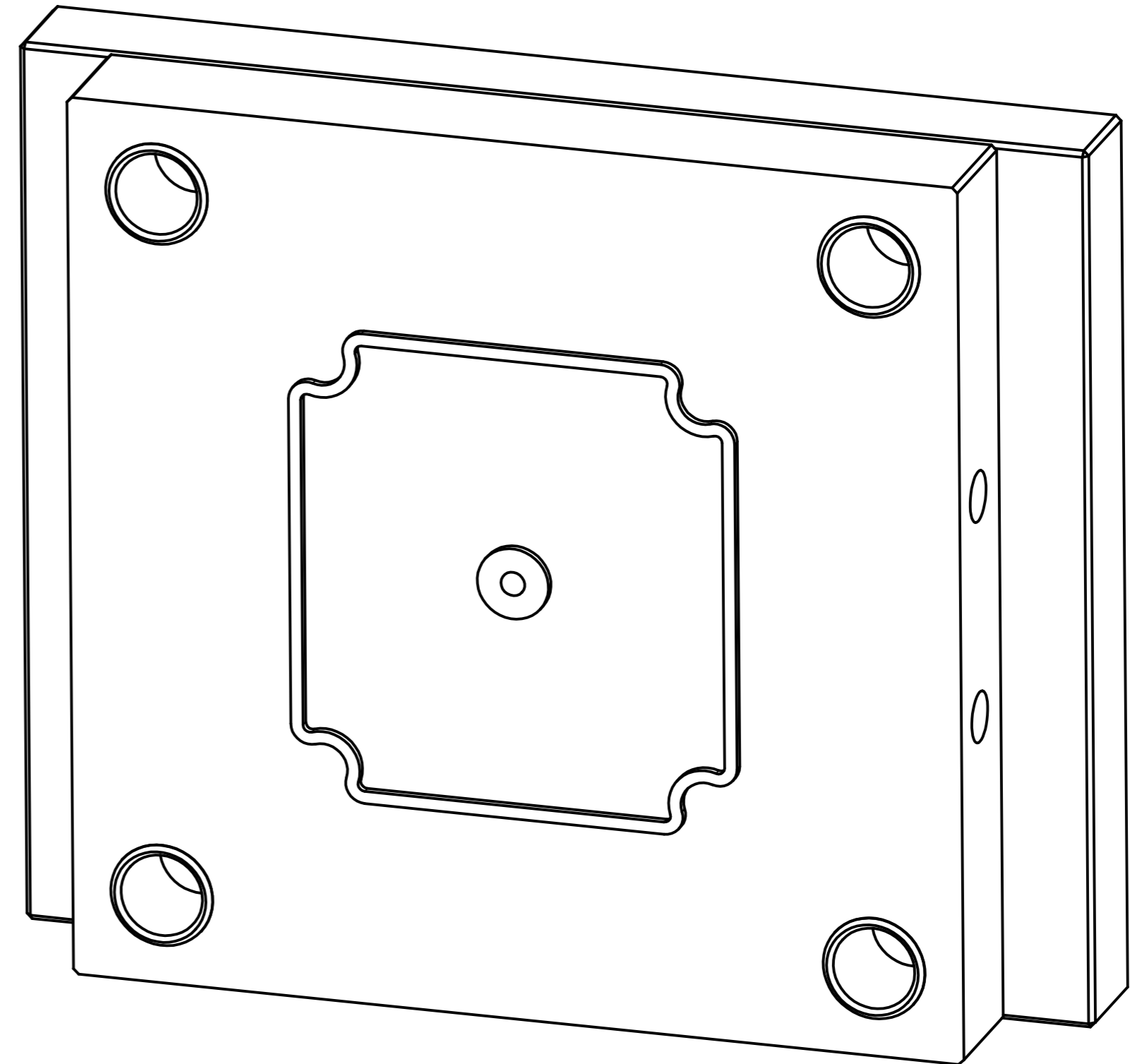
D B LID

	NAME	DATE	AGRIGEL	
DRAWN	Dan	12/29/09	TITLE	
APPROVED			D B Lid Die	
MATERIAL			SIZE	DWG NO
TREATMENT			A4	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: D B Lid Die.dft	REV
1st ANGLE ANGLES ±0.1°			SCALE:	WEIGHT:
2 PL ±0.02 3 PL ±0.005				SHEET 1 OF 11

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



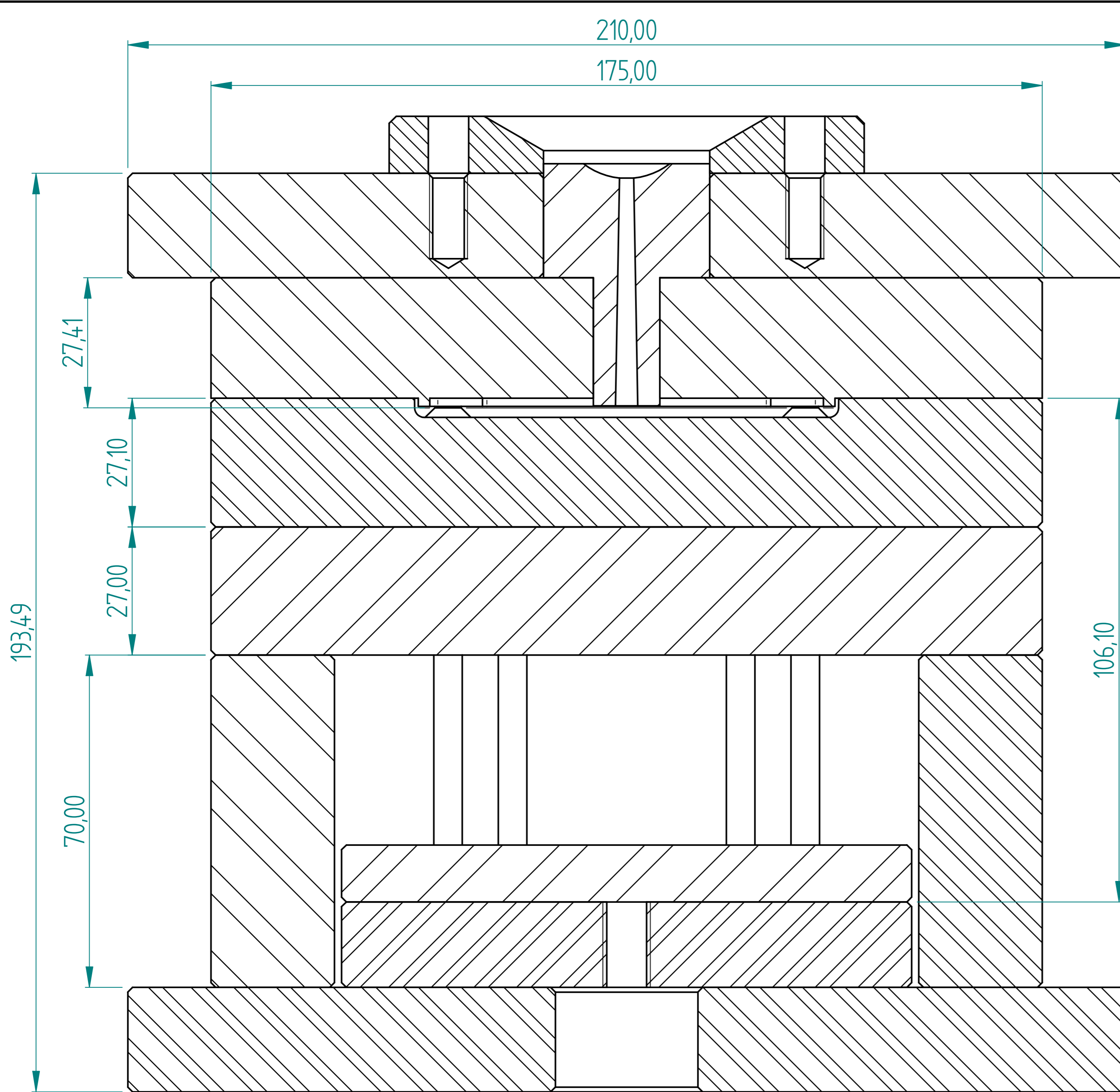
MOVING HALF



FIXED HALF

	NAME	DATE	AGRIGEL	
DRAWN	Dan	12/29/09	TITLE	
APPROVED			D B Lid Die	
MATERIAL			SIZE	DWG NO
TREATMENT			A4	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: D B Lid Die.dft	REV
1st ANGLE ANGLES ±0.1°			SCALE:	WEIGHT:
2 PL ±0.02 3 PL ±0.005				SHEET 2 OF 11

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

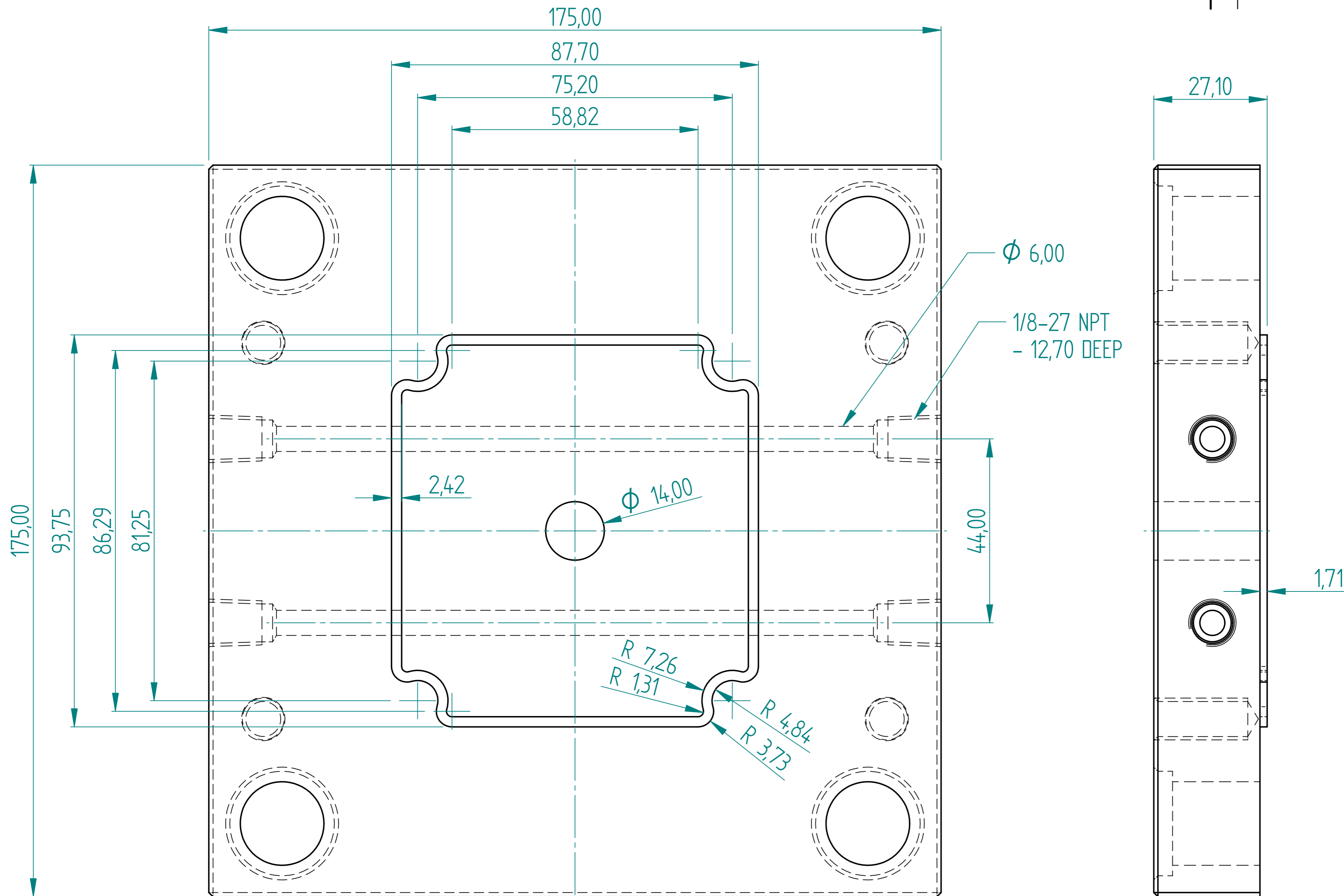


D B LID DIE

Item Number	Document Number	Title	Quantity
1	175 x 120 x 12	Ejector Plate	1
2	175 x 120 x 18	Ejector Clamping Plate	1
3	175 x 175 x 27	Fixed Die Plate	1
4	175 x 175 x 27	Moving Die Plate	1
5	175 x 175 x 27	Support Plate	1
6	175 x 26 x 70	Riser	2
7	210 x 175 x 22	Moving Clamping Plate	1
8	210 x 175 x 22	Fixed Clamping Plate	1
9	B3-24 x 51	Sprue Bush	1
10	CV16 x 26	Locating Bush	4
11	Dia 10 - 100.par	Core Pin	4
12	Dia 10 - 125.par	Ejector Pin	4
13	Dia 6 - 125.par	Ejector Pin	8
14	GC16X26X26	Locating Pin	4
15	LR-100	Locating Ring	1

	NAME	DATE	AGRIGEL	
DRAWN	Dan	12/29/09		
APPROVED				
MATERIAL				
TREATMENT			TITLE	D B Lid Die
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
1st ANGLE			A4	
			FILE NAME: D B Lid Die.dft	REV
			SCALE:	WEIGHT:
				SHEET 3 OF 11

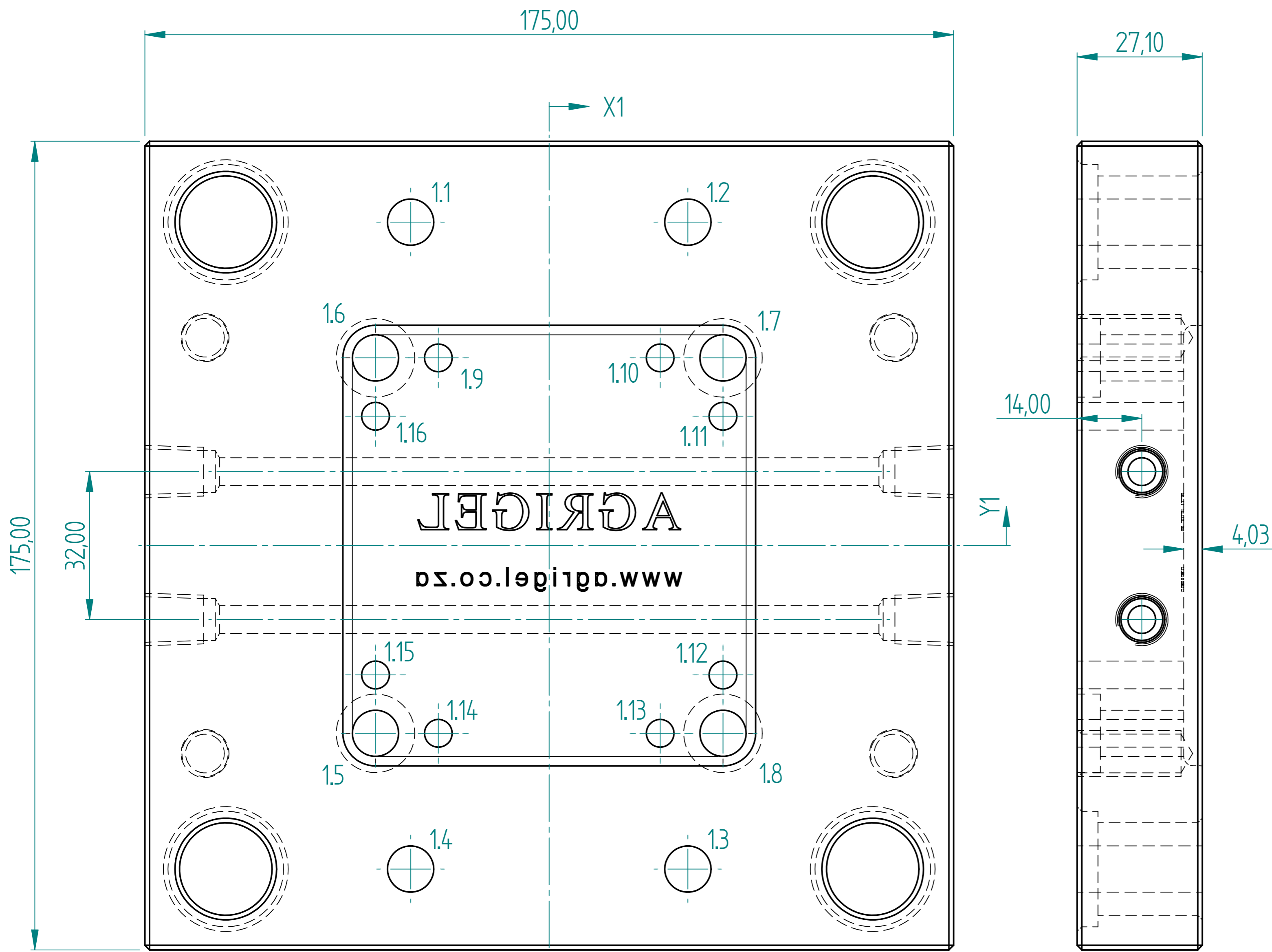
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



FIXED DIE PLATE

DRAWN	NAME	DATE	AGRIGEL	
APPROVED	Dan	12/29/09	TITLE	
MATERIAL			D B Lid Die	
TREATMENT			SIZE	DWG NO
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			A4	REV
1st ANGLE ANGLES $\pm 0,1^\circ$			FILE NAME: D B Lid Die.dft	
2 PL $\pm 0,02$ 3 PL $\pm 0,005$			SCALE:	WEIGHT: SHEET 4 OF 11

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

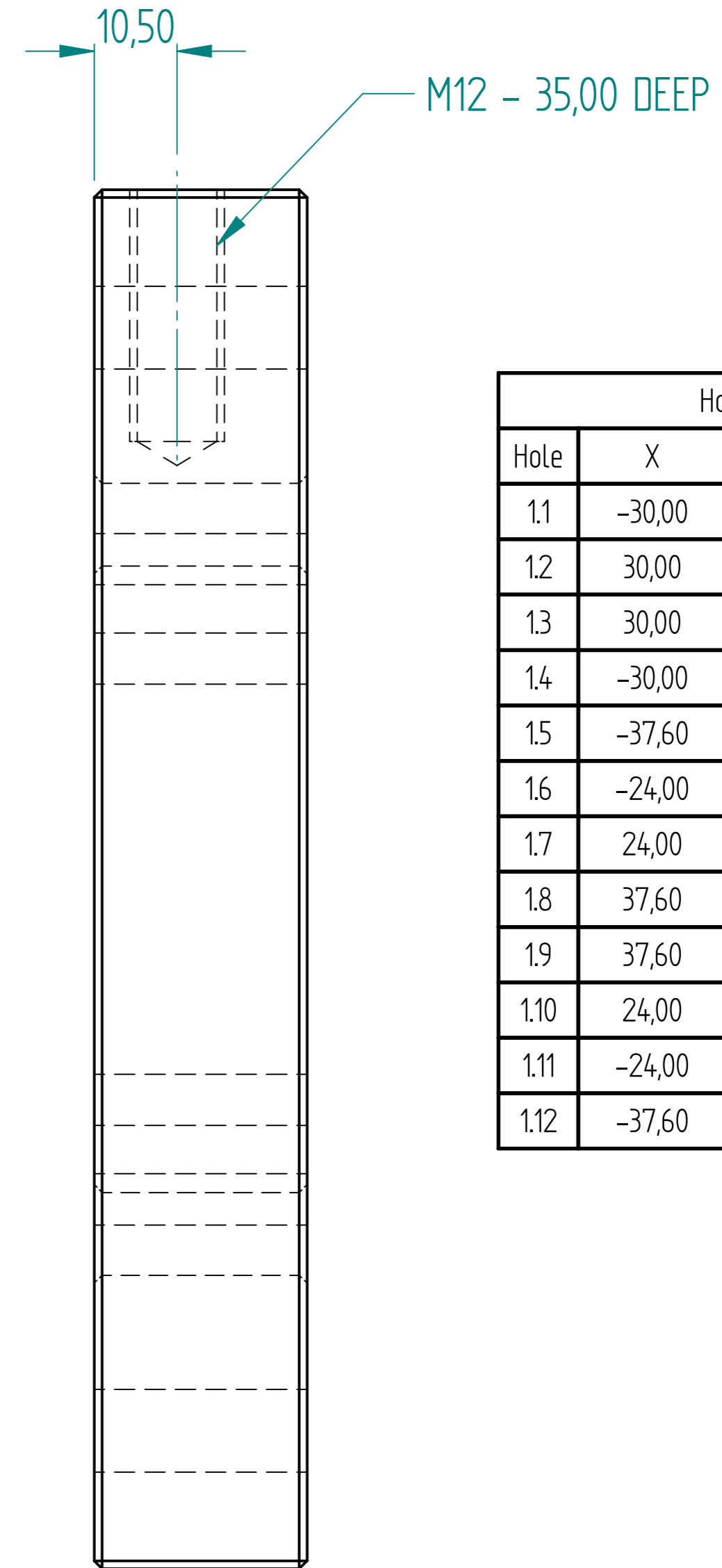
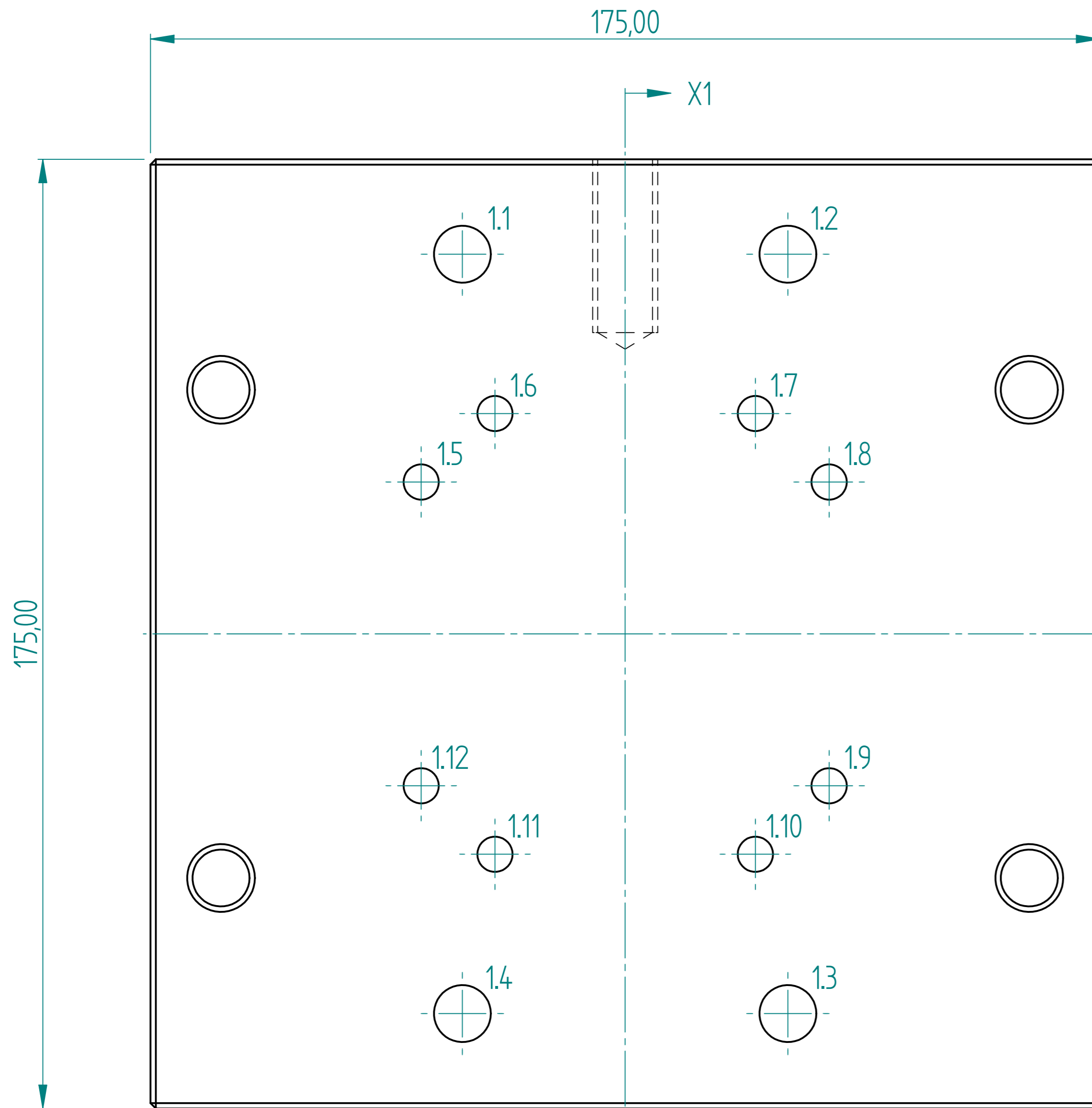


Hole Table				
Hole	X	Y	Size H7	Counterbore
1.1	-30,00	70,00	φ 10,00	
1.2	30,00	70,00	φ 10,00	
1.3	30,00	-70,00	φ 10,00	
1.4	-30,00	-70,00	φ 10,00	
1.5	-37,60	-40,62	φ 10,00	φ17,00-5,02
1.6	-37,60	40,62	φ 10,00	φ17,00-5,02
1.7	37,60	40,62	φ 10,00	φ17,00-5,02
1.8	37,60	-40,62	φ 10,00	φ17,00-5,02
1.9	-24,00	40,62	φ 6,00	
1.10	24,00	40,62	φ 6,00	
1.11	37,60	28,00	φ 6,00	
1.12	37,60	-28,00	φ 6,00	
1.13	24,00	-40,62	φ 6,00	
1.14	-24,00	-40,62	φ 6,00	
1.15	-37,60	-28,00	φ 6,00	
1.16	-37,60	28,00	φ 6,00	

MOVING DIE PLATE

DRAWN	NAME	DATE	AGRIGEL	
APPROVED	Dan	12/29/09		
MATERIAL			TITLE	
TREATMENT			D B Lid Die	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1st ANGLE ANGLES ±0,1°			FILE NAME: D B Lid Die.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT: SHEET 5 OF 11

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

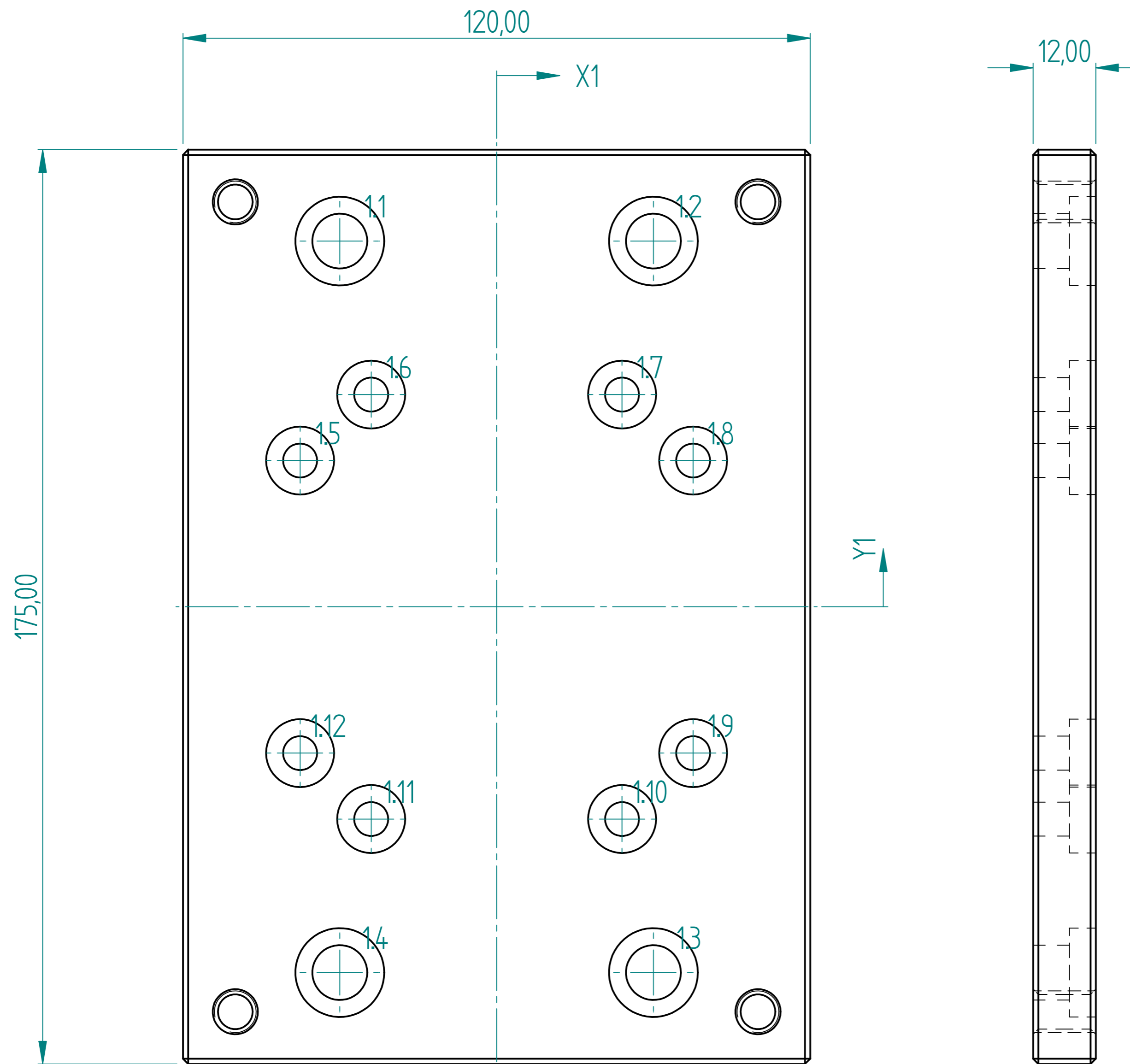


Hole Table			
Hole	X	Y	Size
1.1	-30,00	70,00	φ 10,50
1.2	30,00	70,00	φ 10,50
1.3	30,00	-70,00	φ 10,50
1.4	-30,00	-70,00	φ 10,50
1.5	-37,60	28,00	φ 6,50
1.6	-24,00	40,62	φ 6,50
1.7	24,00	40,62	φ 6,50
1.8	37,60	28,00	φ 6,50
1.9	37,60	-28,00	φ 6,50
1.10	24,00	-40,62	φ 6,50
1.11	-24,00	-40,62	φ 6,50
1.12	-37,60	-28,00	φ 6,50

SUPPORT DIE PLATE

	NAME	DATE	AGRIGEL		
DRAWN	Dan	12/29/09			
APPROVED			TITLE D B Lid Die		
MATERIAL					
TREATMENT			SIZE A4	DWG NO	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: D B Lid Die.dft		
1st ANGLE ANGLES ±0,1° 2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:	SHEET 6 OF 11

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

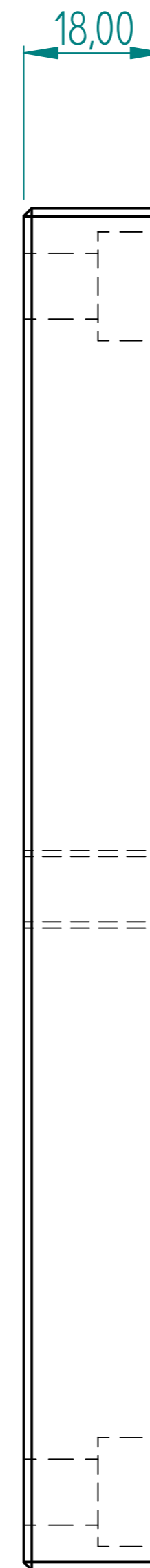
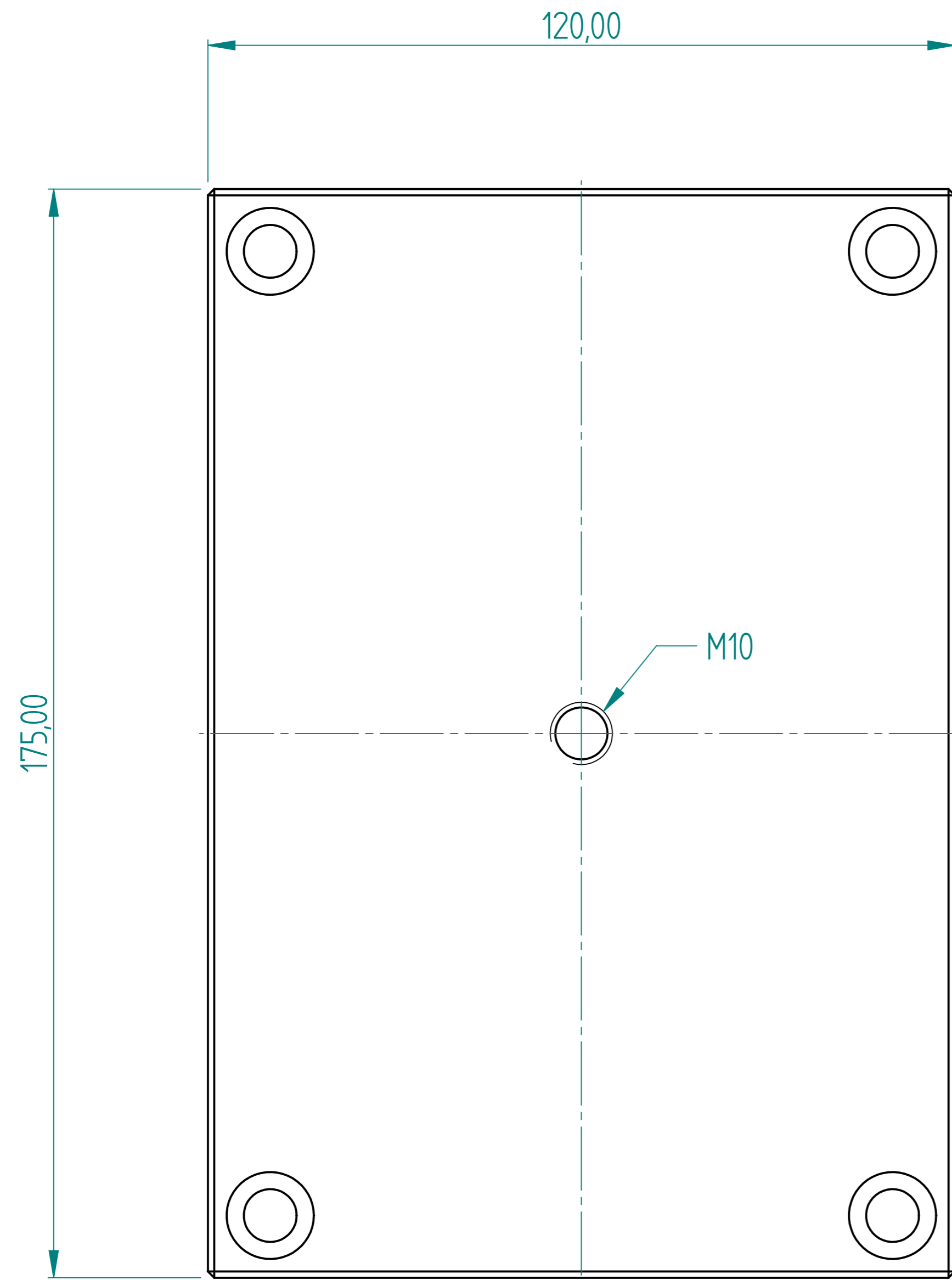


Hole Table				
Hole	X	Y	Size	CounterBore
1.1	-30,00	70,00	φ 10,50	φ17,00-5,05
1.2	30,00	70,00	φ 10,50	φ17,00-5,05
1.3	30,00	-70,00	φ 10,50	φ17,00-5,05
1.4	-30,00	-70,00	φ 10,50	φ17,00-5,05
1.5	-37,60	28,00	φ 6,50	φ13,00-5,05
1.6	-24,00	40,62	φ 6,50	φ13,00-5,05
1.7	24,00	40,62	φ 6,50	φ13,00-5,05
1.8	37,60	28,00	φ 6,50	φ13,00-5,05
1.9	37,60	-28,00	φ 6,50	φ13,00-5,05
1.10	24,00	-40,62	φ 6,50	φ13,00-5,05
1.11	-24,00	-40,62	φ 6,50	φ13,00-5,05
1.12	-37,60	-28,00	φ 6,50	φ13,00-5,05

EJECTOR PLATE

	NAME	DATE	AGRIGEL		
DRAWN	Dan	12/29/09			
APPROVED			TITLE D B Lid Die		
MATERIAL					
TREATMENT			SIZE A4	DWG NO	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: D B Lid Die.dft		
1st ANGLE ANGLES ±0.1°			SCALE:	WEIGHT:	SHEET 7 OF 11
2 PL ±0.02 3 PL ±0.005					

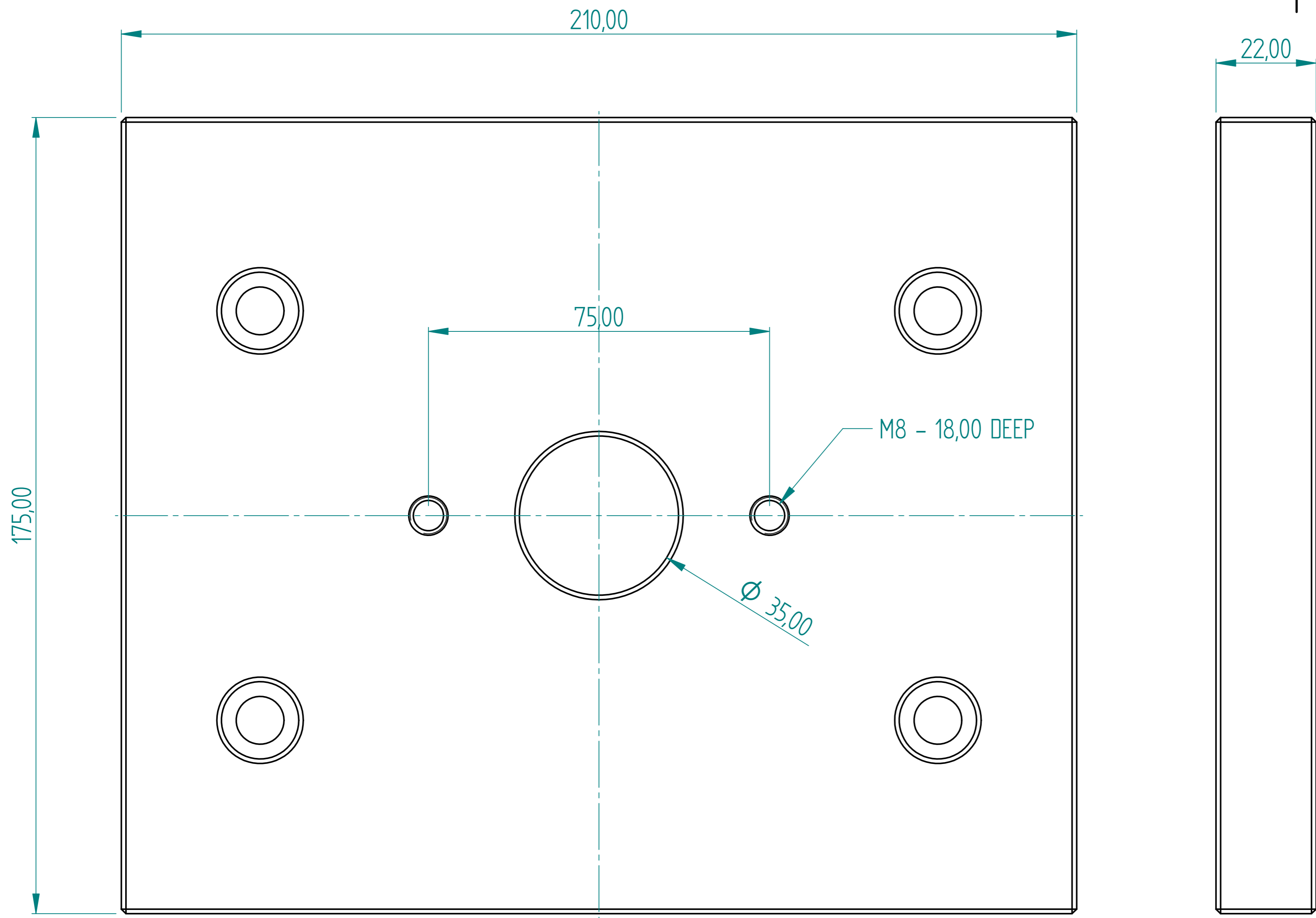
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



EJECTOR CLAMPING PLATE

	NAME	DATE	AGRIGEL	
DRAWN	Dan	12/29/09	TITLE	
APPROVED			D B Lid Die	
MATERIAL			SIZE	DWG NO
TREATMENT			A4	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: D B Lid Die.dft	REV
1st ANGLE ANGLES ±0,1°			SCALE:	WEIGHT:
2 PL ±0.02 3 PL ±0.005				SHEET 8 OF 11

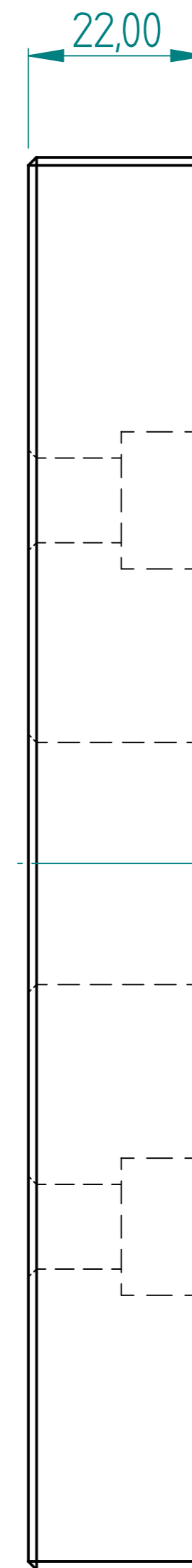
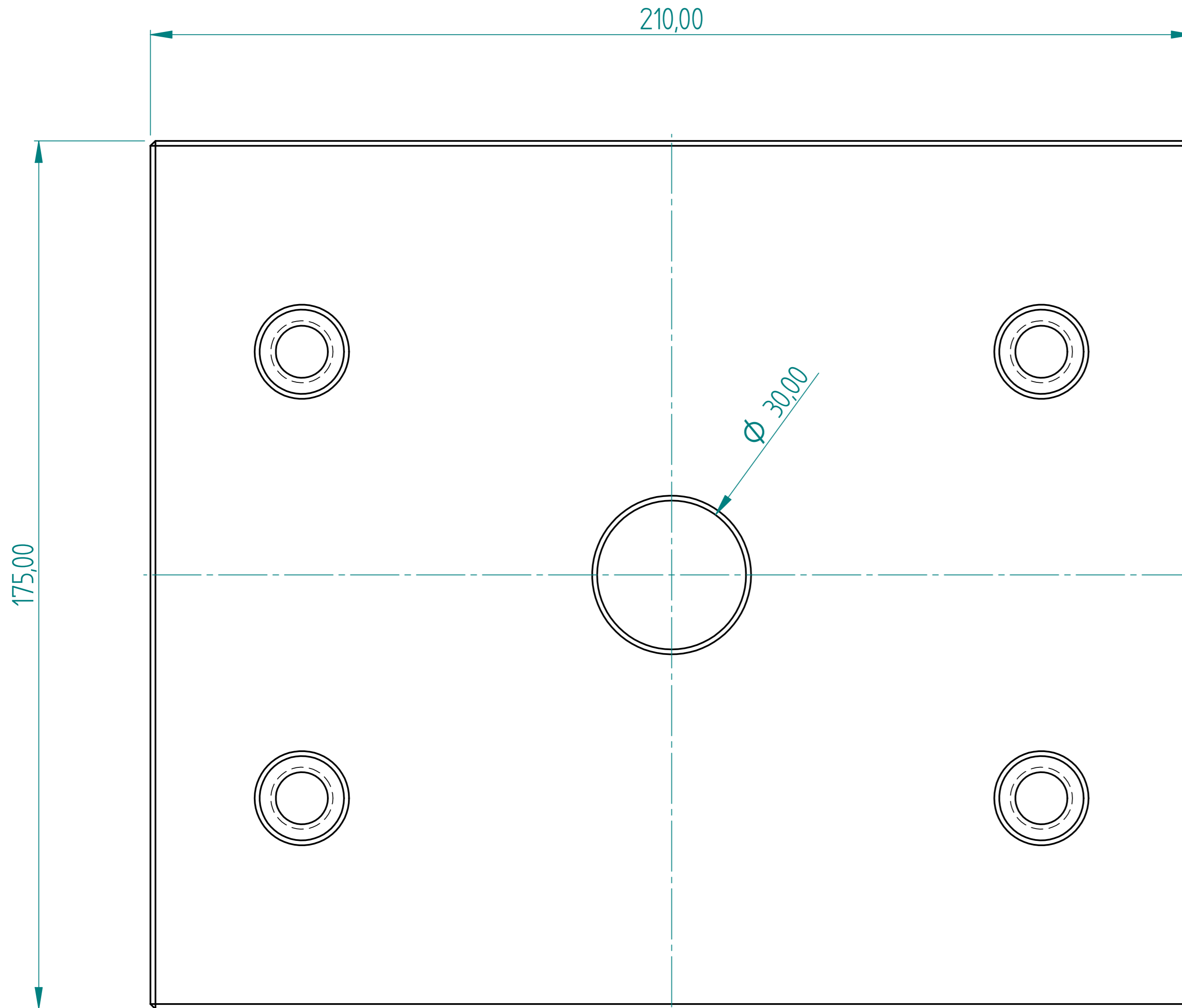
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



FIXED CLAMPING PLATE

DRAWN	NAME	DATE	AGRIGEL	
APPROVED	Dan	12/29/09	TITLE	
MATERIAL			D B Lid Die	
TREATMENT			SIZE	DWG NO
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			A4	REV
1st ANGLE ANGLES ±0.1°			FILE NAME: D B Lid Die.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT: SHEET 9 OF 11

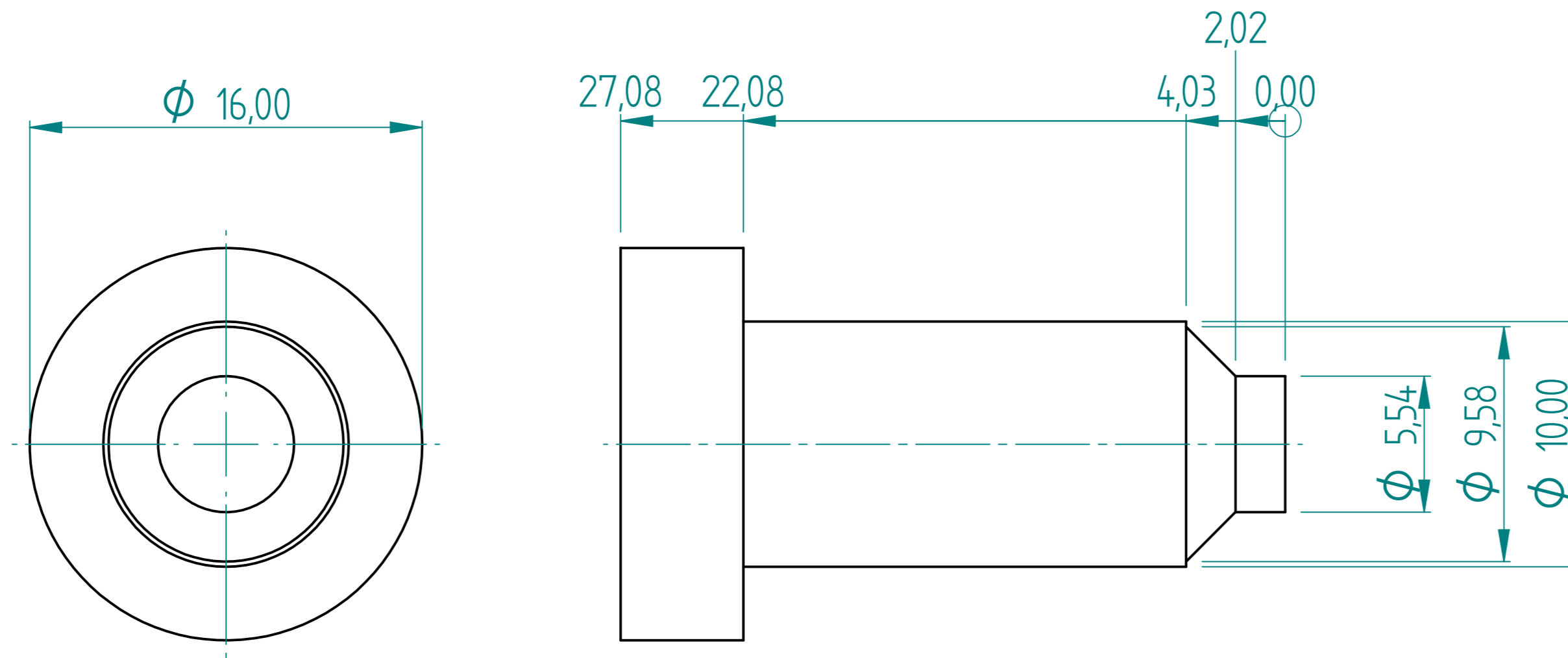
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



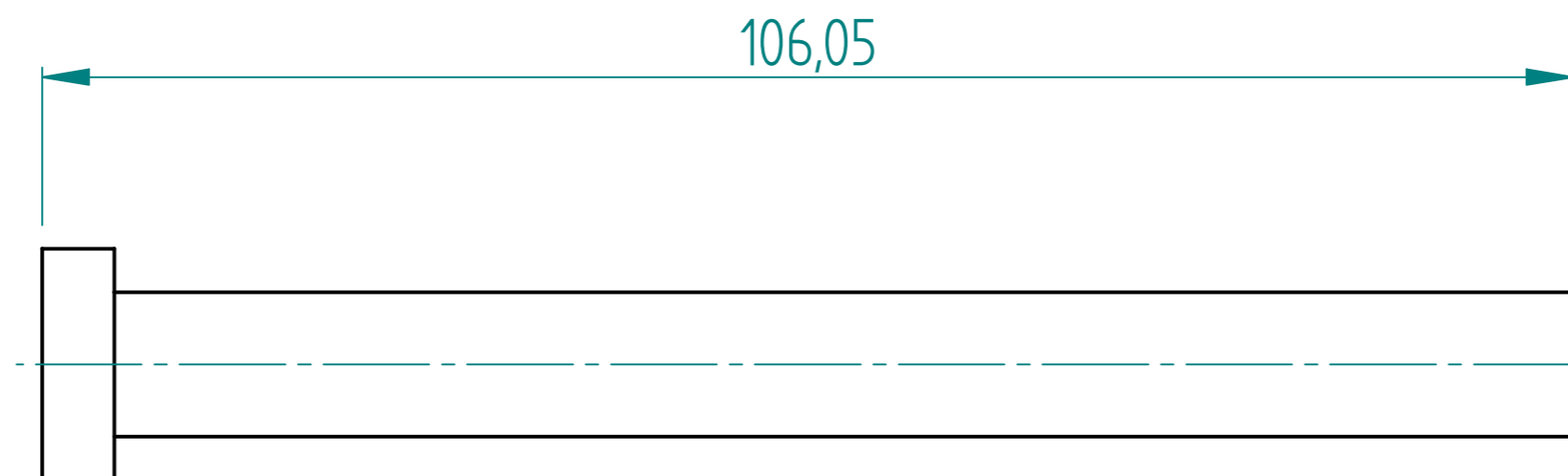
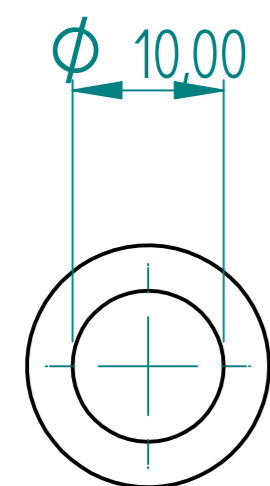
MOVING CLAMPING PLATE

	NAME	DATE	AGRIGEL	
DRAWN	Dan	12/29/09	TITLE	
APPROVED			D B Lid Die	
MATERIAL			SIZE	DWG NO
TREATMENT			A4	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: D B Lid Die.dft	REV
1st ANGLE ANGLES ±0,1°			SCALE:	WEIGHT:
2 PL ±0,02 3 PL ±0,005				SHEET 10 OF 11

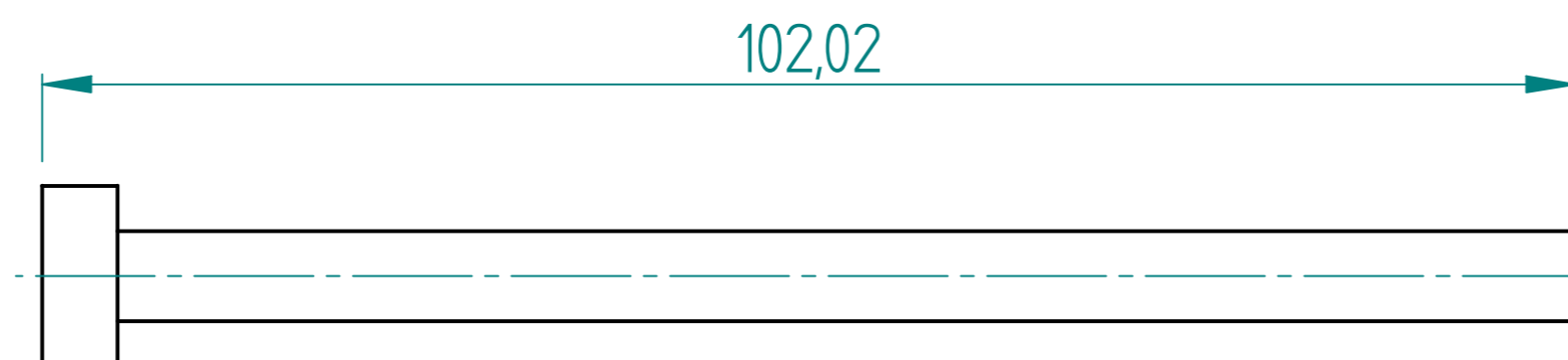
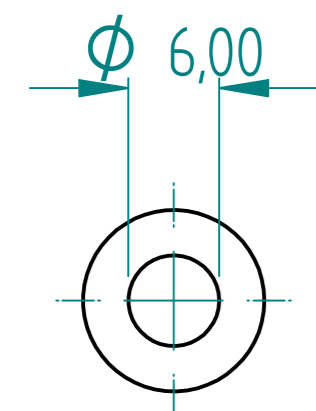
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



CORE PIN 4 OF



PUSH BACK 4 OF



EJECTOR PIN 8 OF

	NAME	DATE	AGRIGEL	
DRAWN	Dan	12/29/09		
APPROVED				
MATERIAL				
TREATMENT			TITLE	D B Lid Die
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
1 st ANGLE			A4	
2 PL ±0.02 3 PL ±0.005			FILE NAME: D B Lid Die.dft	REV
			SCALE:	WEIGHT:
				SHEET 11 OF 11