

Collapsible Cores



Dove Tail Collapsible Cores

- Positive mechanically actuated Collapsible Core
- Collapse amount: 5% to 7% per side
- Eliminates costly Rack and Gear Systems
- Enables faster mold cycle times
- Patented Quick Lock helps cut service time
- Built-in center cooling channel
- Standard and custom sizes available



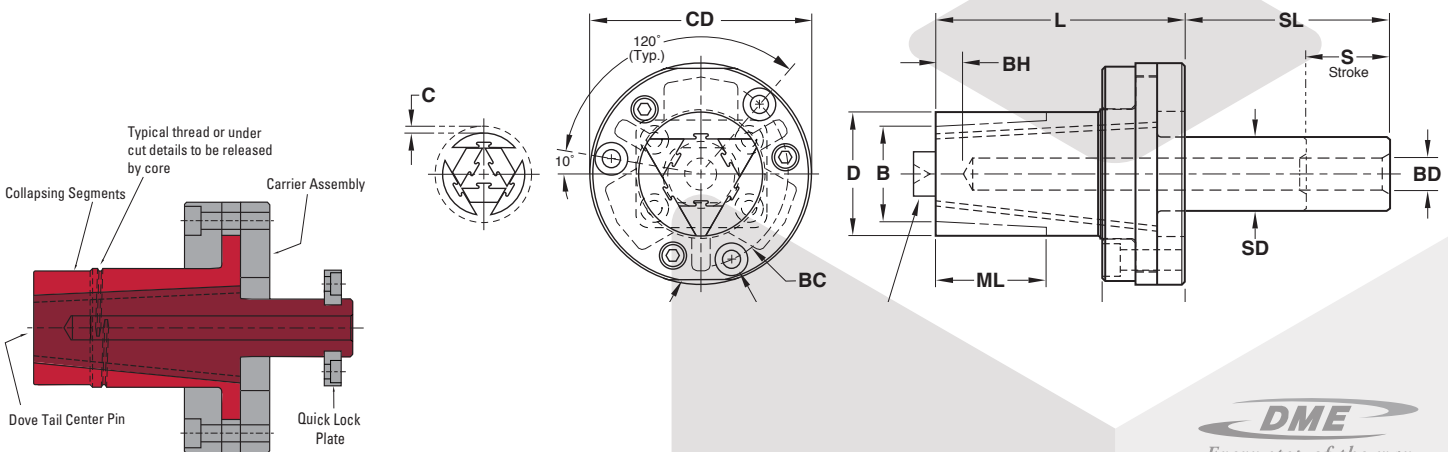
Simplified Mold Design Maximizes Cost Savings

The Collapsible Core DT Series provides a more compact and simplified solution to molding challenging internal undercut features such as o-ring grooves, slots and snap-fit designs. Available in four standard sizes, as well as custom sizes to meet your specific requirements, the DT Collapsible Core Series eliminates the need for unscrewing mechanisms.

Dove Tail Collapsible Cores Enable Application Design Flexibility

- All standard DT Series Collapsible Cores offer 360 degree molding of threads or other undercut features
- Molded parts are not required to be closed at one end; they may be partially or completely open
- DME offers customized DT Cores with pre-machined part detail
- A variety of coatings and treatments are available
- For an engineering review, email your part drawing or application to dme@dme.net

ITEM NUMBER	D Minimum Outer Diameter	B Minimum Inner Diameter +3/Side	ML Maximum Molding Length	C Maximum Collapse	CD Carrier Diameter +0.00 - 0.05	CT Carrier Assembly Thickness ± 0.05	L Core Length +0.1 - 0.0	SL Shaft Length	SD Shaft Diameter +0.00 - 0.02	BD Cooling Hole Diameter	BH Distance to Cooling Hole	BC Mounting Screw Bolt Circle	T Mounting Screws	S Maximum Collapse Stroke
DT18	21	17	22	1.1	53	21	60	60	16	6	6	40	M5 x 25	34
DT28	33	25	28	1.6	60	22	67	60	20	8	8	47	M5 x 25	38
DT38	42	33	43	2.1	76	28	85	60	25	10	10	60	M6 x 35	54
DT48	54	42	50	2.4	98	37	104	70	30	12	12	78	M8 x 40	62



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Standard & Mini Collapsible Cores

Economically produce complex plastic parts

The Collapsible Core is a major breakthrough for molding plastic parts requiring internal threads, undercuts, protrusions or cut-outs. The patented design incorporates only three moving parts, which utilize conventional mold movements.

The Collapsible Core's automatic operation makes it possible for you to produce parts that, previously, had been considered impossible to mold. Parts with internal protrusions, dimples, interrupted threads and cut-outs can now be economically produced on a high- or low-volume basis.

ITEM NUMBER	A MAX O.D. OF THREAD OR CONFIG		B MIN I.D. OF THREAD OR CONFIG		H CENTER PIN DIAMETER (AT TOP OF CORE)		L MAX WORKING LENGTH (INCL MOLD SHUT-OFF)		C COLLAPSE PER SIDE AT TOP OF CORE**				O.A.L. OVERALL LENGTH OF COLLAPSIBLE CORE (ONLY)	
	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	*inch	*mm	inch	mm
CC125PC	.720	18.29	.620	15.75	.490	12.45	.800	20.32	.027	.69	.032	.81	5.605	142.37
CC150PC	.850	21.59	.700	17.78	.580	14.73	1.000	25.40	.037	.94	.042	1.07	6.615	168.02
CC175PC	.970	24.64	.760	19.30	.640	16.26	1.000	25.40	.043	1.09	.048	1.21	6.615	168.02
CC200PC	1.270	32.25	.910	23.11	.785	19.93	1.150	29.21	.043	1.09	.048	1.21	7.315	185.80
†CC250PC	1.270	32.25	.910	23.11	.785	19.93	1.150	29.21	.043	1.09	.048	1.21	5.440	138.17
CC202PC	1.390	35.30	1.010	25.65	.885	22.47	1.150	29.21	.055	1.39	.064	1.62	7.315	185.80
†CC252PC	1.390	35.30	1.010	25.65	.885	22.47	1.150	29.21	.055	1.39	.064	1.62	5.440	138.17
CC302PC	1.740	44.19	1.270	32.25	1.105	28.06	1.400	35.56	.068	1.72	.083	2.10	7.315	185.80
†CC352PC	1.740	44.19	1.270	32.25	1.105	28.06	1.400	35.56	.068	1.72	.083	2.10	6.065	154.05
CC402PC	2.182	55.42	1.593	40.46	1.388	35.25	1.700	43.18	.090	2.28	.103	2.61	7.815	198.50
CC502PC	2.800	71.12	2.060	52.32	1.750	44.45	1.900	48.26	.115	2.92	.125	3.17	9.625	244.47
CC602PC	3.535	89.78	2.610	66.29	2.175	55.24	2.400	60.96	.140	3.55	.148	3.75	11.250	285.75
CC652PC	3.800	96.52	2.890	73.41	2.450	62.23	2.400	60.96	.150	3.81	.160	4.06	11.250	285.75
CC702PC	4.225	107.31	3.350	85.09	2.875	73.02	2.400	60.96	.165	4.19	.170	4.32	11.250	285.75

Easily mold parts with closures as small as 13mm

The Collapsible Mini-Core broadens the applications of collapsible core molds for closures as small as 13mm. Due to the smaller diameters involved, these Mini-Cores employ three larger collapsing segments combined with three narrow, non-collapsing blades, which are an integral part of the center pin.

As a result, up to 80% full threads or undercuts can be molded. The function of the collapsing core also permits threads to stop at any point along the molded length – threads need not run out to the top of the core as with unscrewing molds. If a seal is required in the top of the closure, an undercut can be molded into the part to hold such a seal in place.

Three standard sizes of Collapsible Mini-Cores are available, for 13-16, 17-20 and 21-24mm closures.

ITEM NUMBER	FOR CLOSURE DIAMETER RANGE	A MAX O.D. OF THREAD OR CONFIG		B MIN I.D. OF THREAD OR CONFIG		H CENTER PIN DIAMETER (AT TOP OF CORE)		WIDTH OF (3) NON-COLLAPSING CENTER OF PIN BLADES (AT TOP OF CORE)		L MAX WORKING LENGTH (INCL MOLD SHUT-OFF)		C COLLAPSE PER SIDE AT TOP OF CORE*	
	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm
CCM0001	13-16	.645	16.38	.425	10.80	.300	7.62	.170	4.32	.850	21.59	.052	1.32
CCM0002	17-20	.805	20.45	.560	14.22	.420	10.67	.190	4.83	.850	21.59	.057	1.45
CCM0003	21-24	.965	24.51	.710	18.03	.560	14.22	.200	5.08	1.000	25.40	.059	1.50

