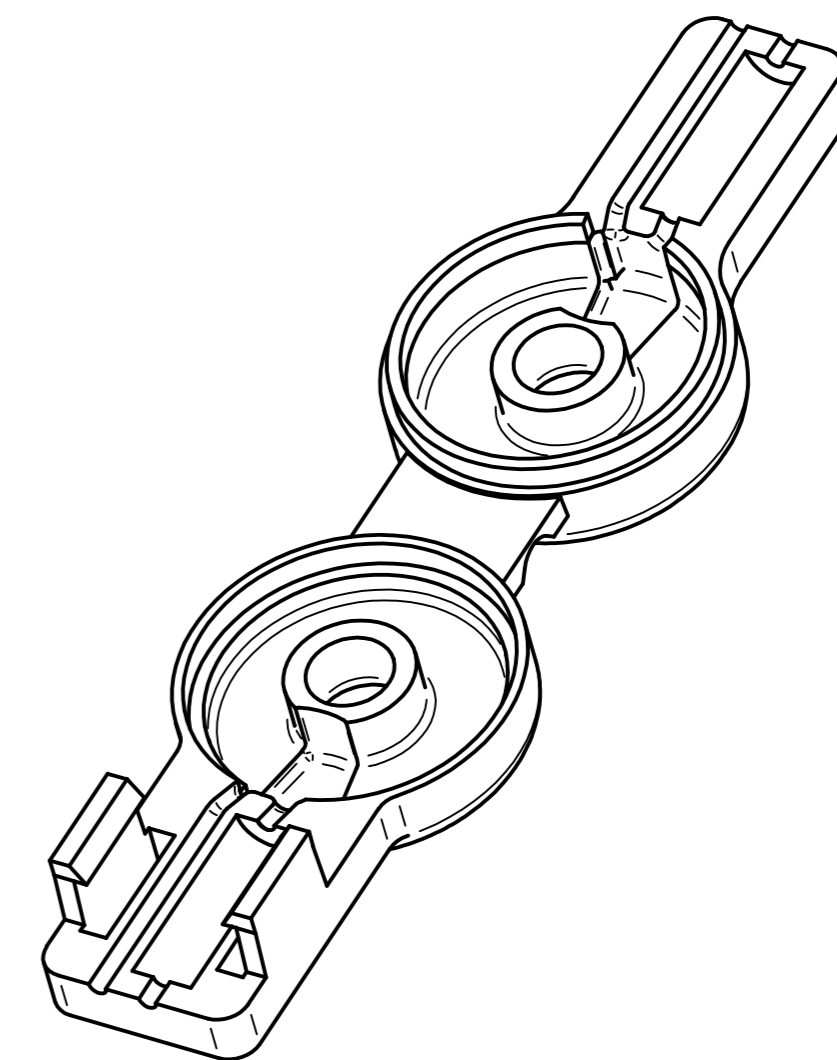
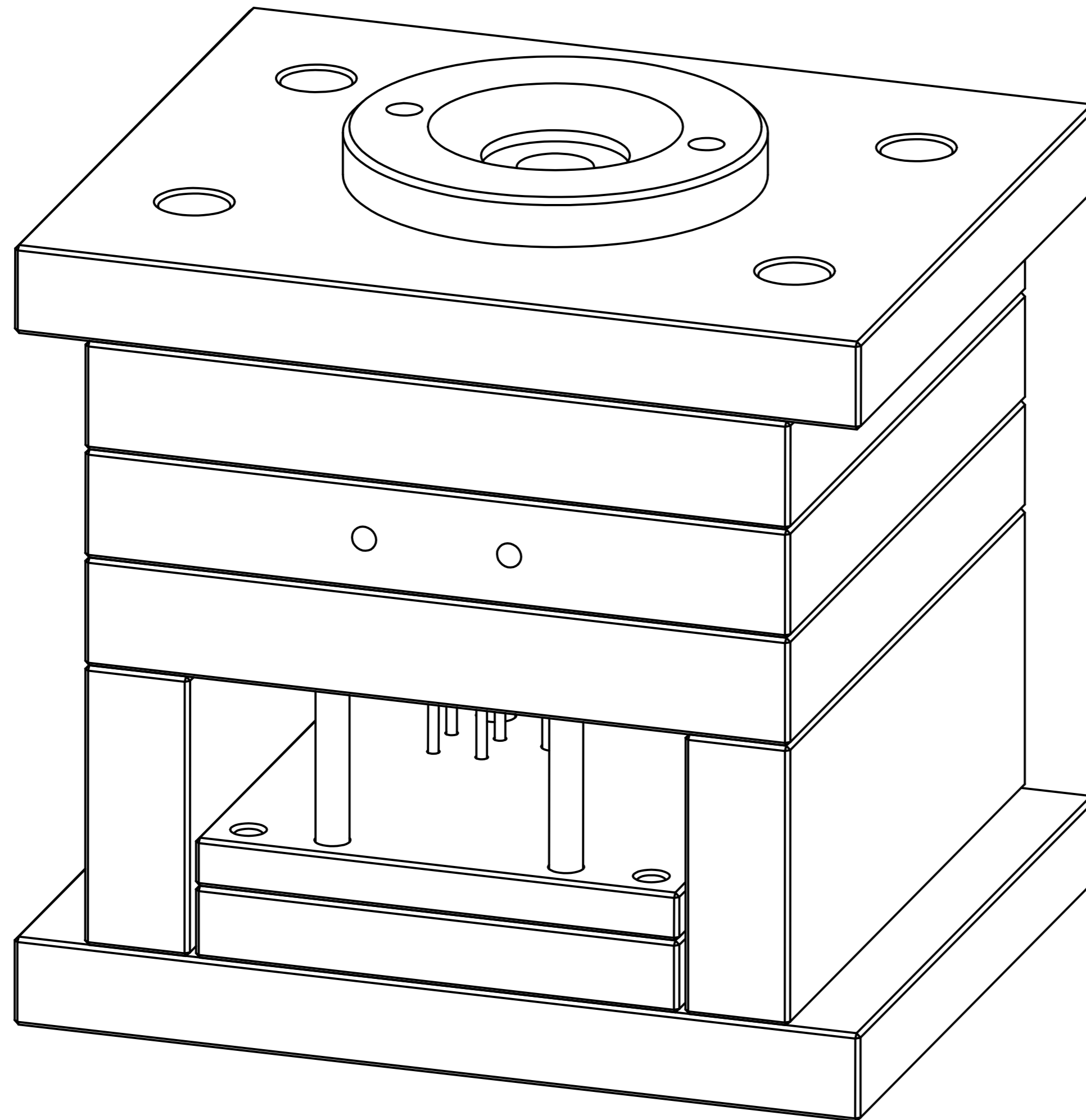


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

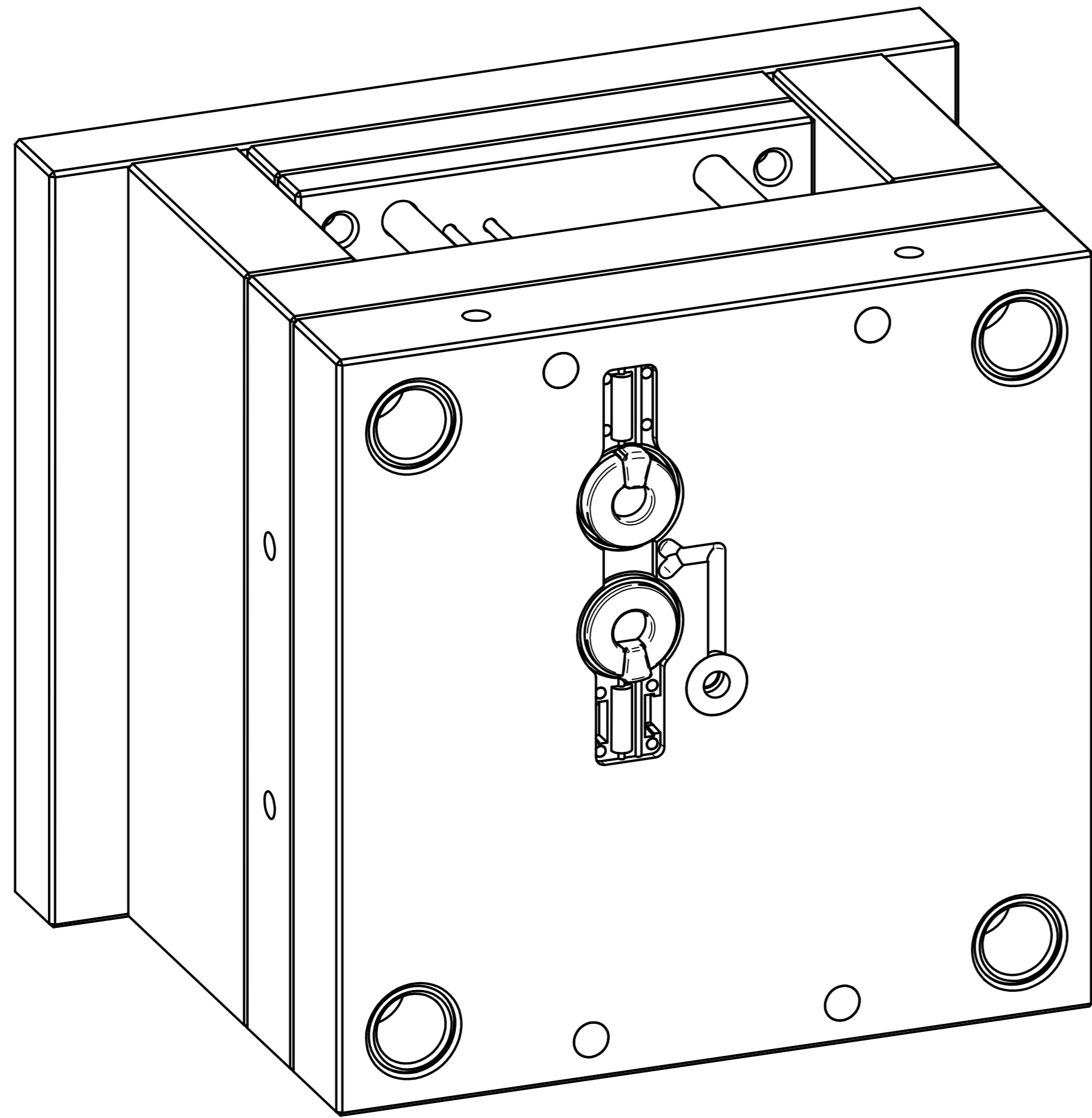


MAGNASTART

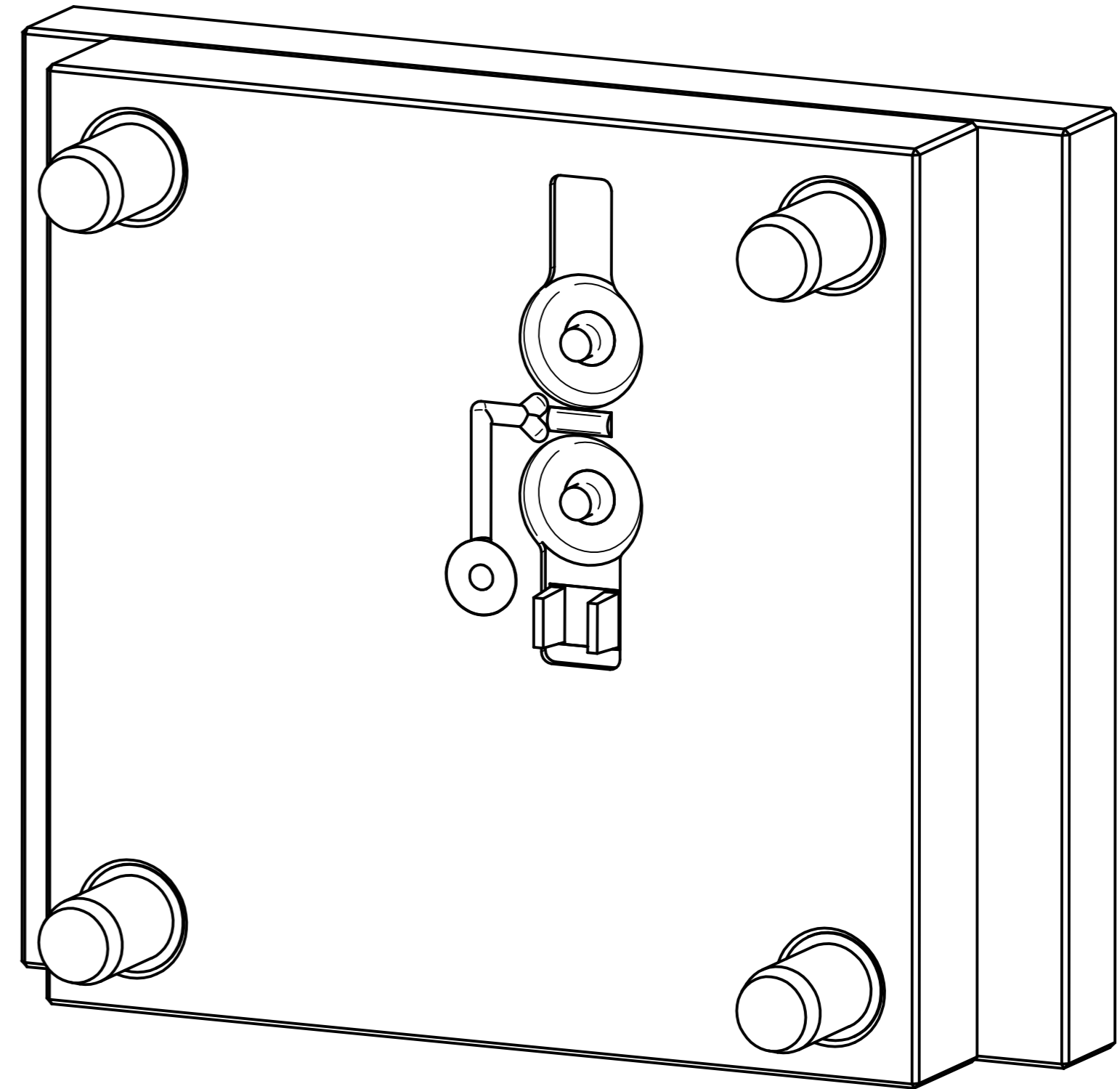
MAGNASTART MOULD

	NAME	DATE	PREMAC	
DRAWN	Dan	10/23/10	TITLE	
APPROVED			Magnastart Mould	
MATERIAL			SIZE	DWG NO
TREATMENT			A4	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: Magnastart Mould.dft	REV
1 st ANGLE ANGLES ±0.1°			SCALE:	WEIGHT:
2 PL ±0.02 3 PL ±0.005				SHEET 1 OF 19

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



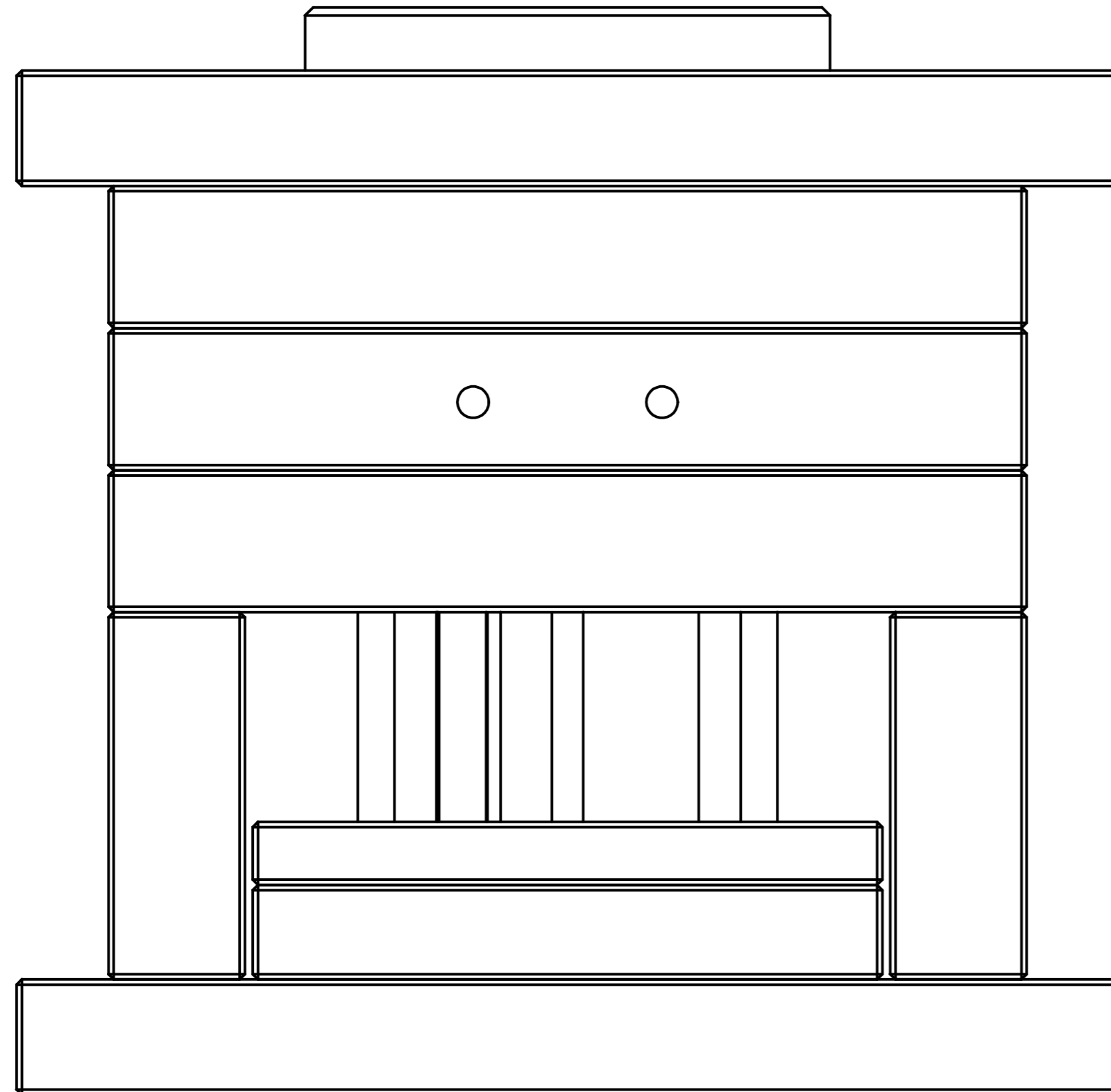
MOVING HALF



FIXED HALF

	NAME	DATE	PREMAC	
DRAWN	Dan	10/23/10	TITLE	
APPROVED			Magnastart Mould	
MATERIAL			SIZE	DWG NO
TREATMENT			A4	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: Magnastart Mould.dft	REV
1st ANGLE ANGLES ±0.1°			SCALE:	WEIGHT:
2 PL ±0.02 3 PL ±0.005				SHEET 2 OF 19

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

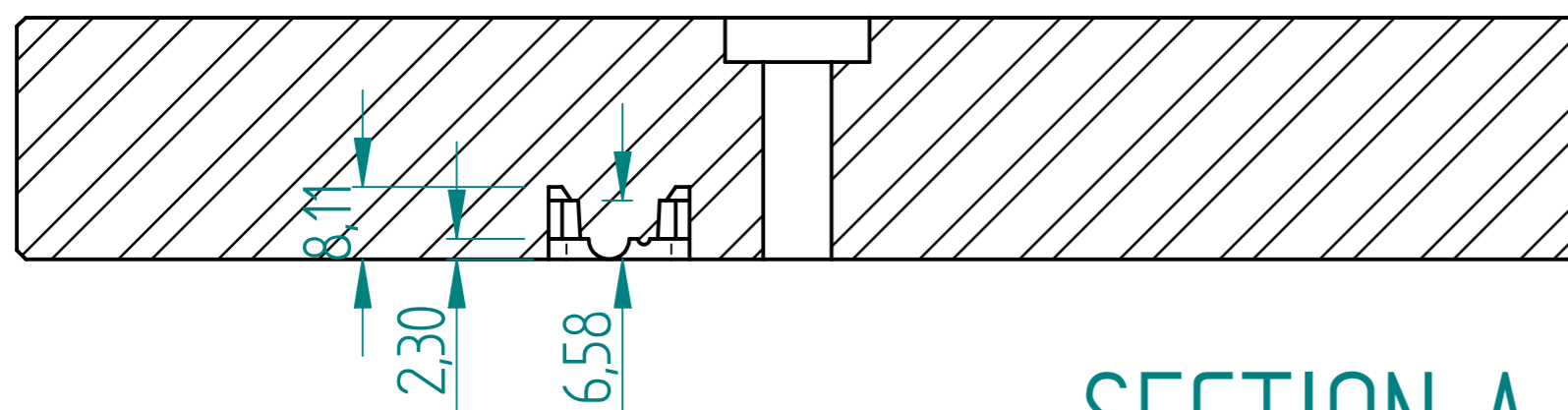
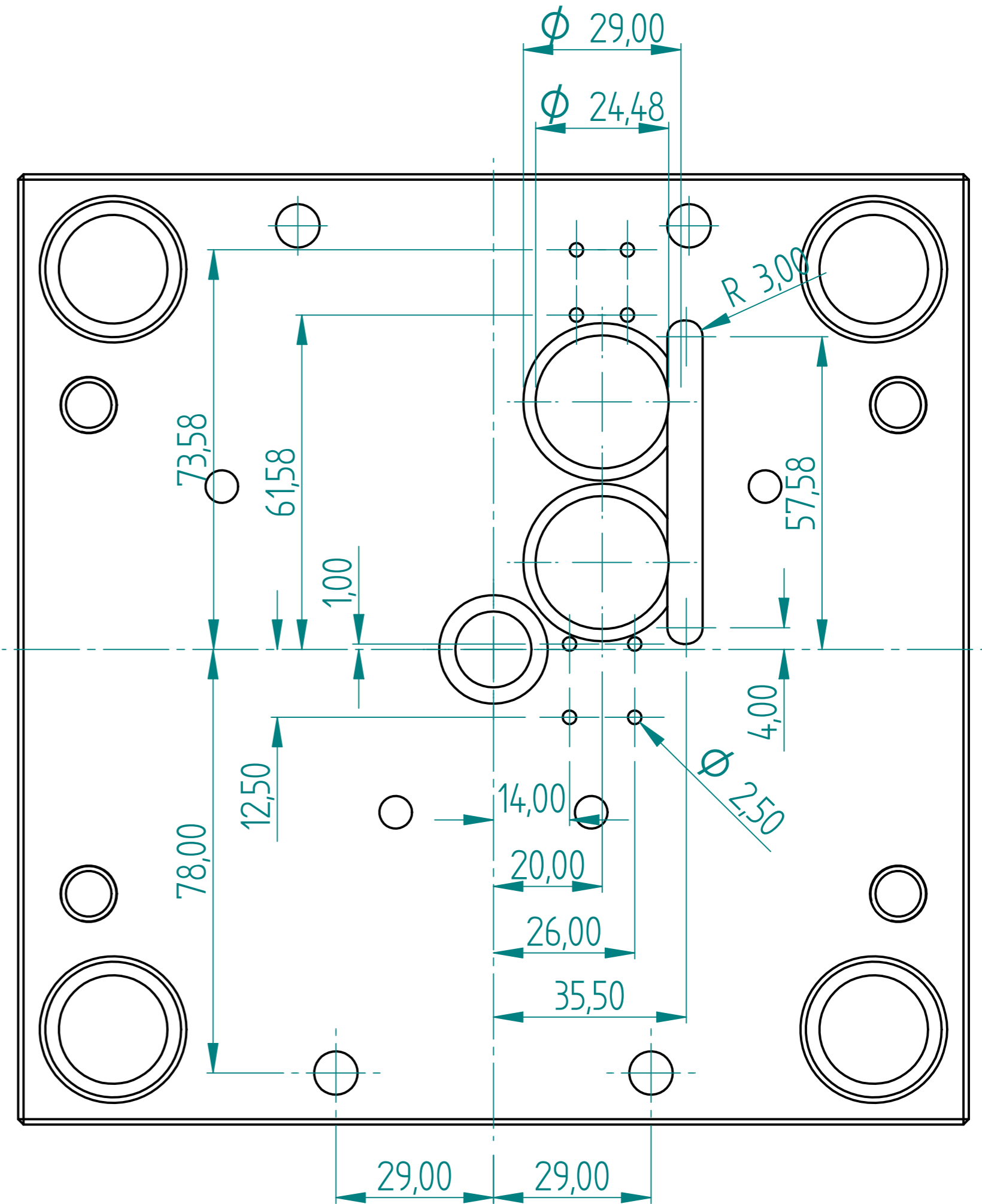
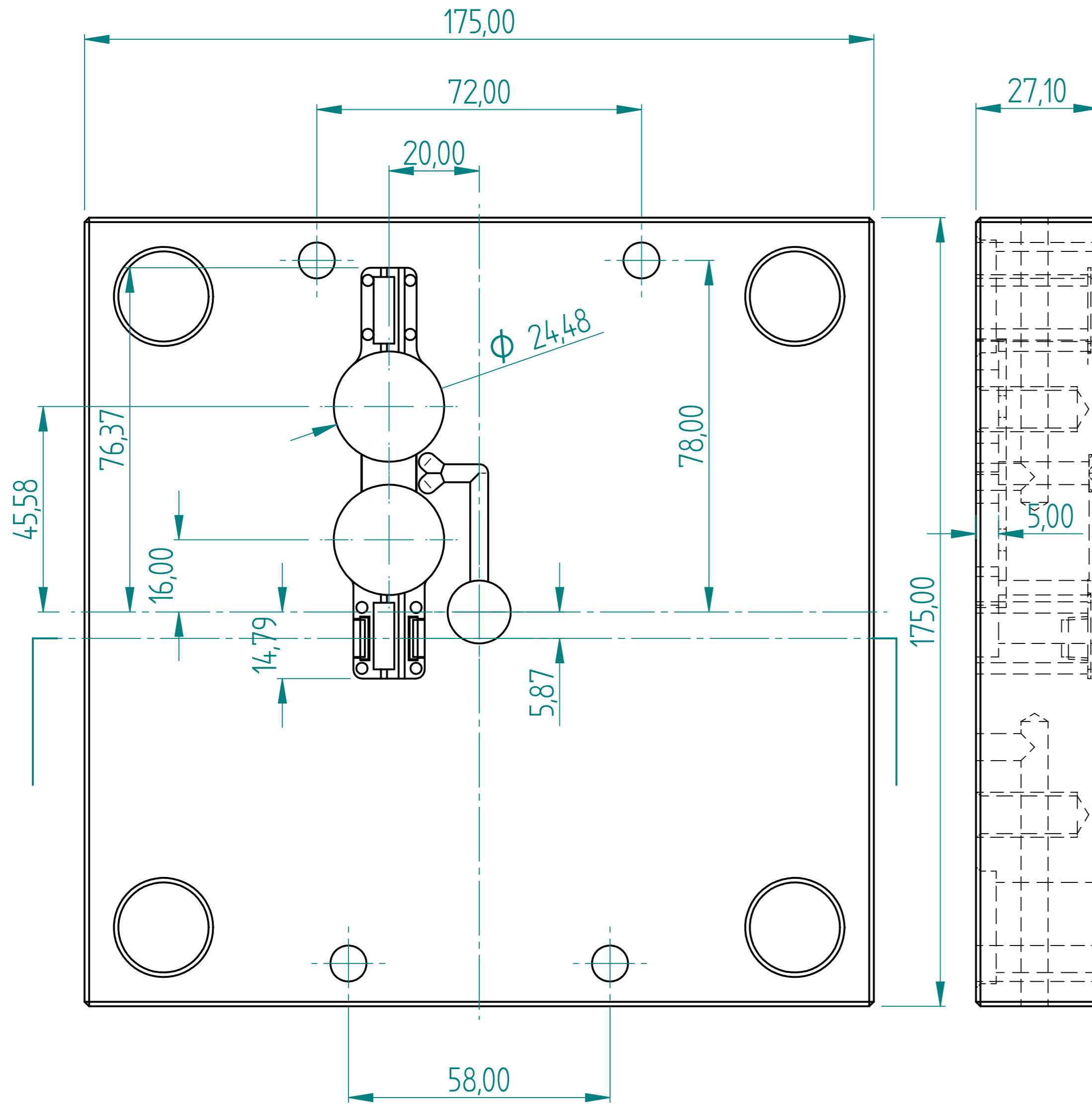


MAGNASTART MOULD

Item Number	Document Number	Title	Material	Quantity
1*			Steel	1
2*			Steel	1
3*			Steel	1
4*	CV16 x 26	Locating Bush	Steel	4
5*	Ø20 x 27.1	Sprue Puller Bush	Steel	1
6*			Steel	1
7*	175 x 26 x 70	Riser	Steel	2
8*	210 x 175 x 22	Moving Clamping Plate	Steel	1
9*	175 x 120 x 18	Ejector Clamping Plate	Steel	1
10*			Steel	1
11*			Steel	1
12*			Steel	4
13*			Steel	8
14*			Steel	1
15*			Steel	2
16*			Steel	1
17*			Steel	1
18*	GC16X26X26	Locating Pin	Steel	4
19*	210 x175 x 22	Fixed Clamping Plate	Steel	1
20*	B3-24 x 51	Sprue Bush	Steel	1
21*	LR-100	Locating Ring	steel	1
22*			Steel	2

DRAWN	NAME	DATE	PREMAC		
APPROVED	Dan	10/23/10			
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: Magnastart Mould.dft		
SCALE:		WEIGHT:	SHEET 3 OF 19		

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

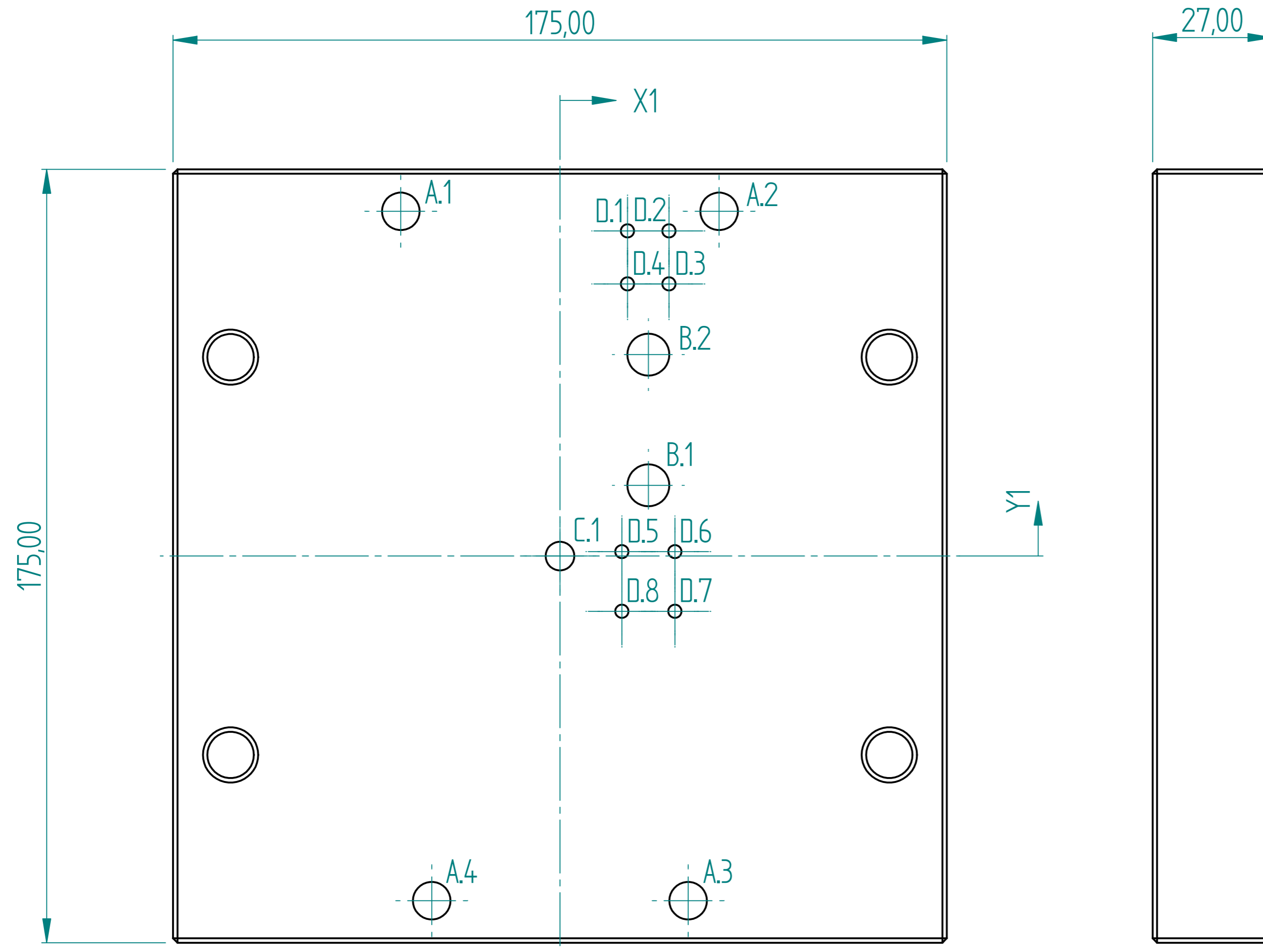


SECTION A-A

MOVING HALF DIE PLATE

DRAWN	NAME	DATE	PREMAC	
APPROVED	Dan	10/23/10		
MATERIAL			TITLE	
TREATMENT			Magnastart Mould	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
1 st ANGLE			A4	
ANGLES $\pm 0,1^\circ$			FILE NAME: Magnastart Mould.dft	
2 PL $\pm 0,02$ 3 PL $\pm 0,005$			SCALE:	WEIGHT:
			SHEET 4 OF 19	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

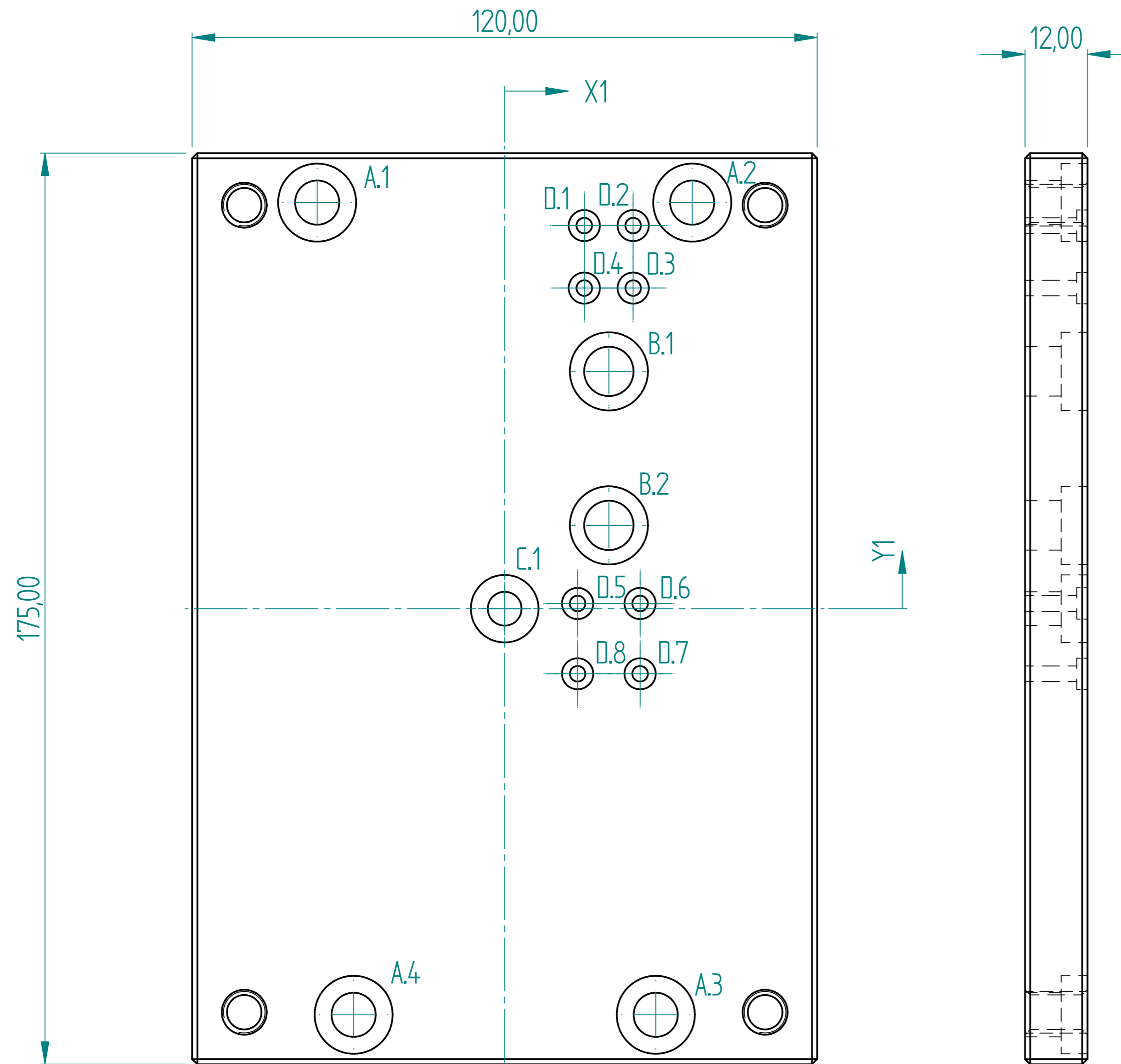


Hole Table			
Hole	X	Y	Size
A.1	-36,00	78,00	φ 8,50
A.2	36,00	78,00	φ 8,50
A.3	29,00	-78,00	φ 8,50
A.4	-29,00	-78,00	φ 8,50
B.1	20,00	16,00	φ 9,50
B.2	20,00	45,58	φ 9,50
C.1	0,00	0,00	φ 6,50
D.1	15,28	73,58	φ 3,00
D.2	24,67	73,58	φ 3,00
D.3	24,67	61,58	φ 3,00
D.4	15,28	61,58	φ 3,00
D.5	14,00	1,00	φ 3,00
D.6	26,00	1,00	φ 3,00
D.7	26,00	-12,50	φ 3,00
D.8	14,00	-12,50	φ 3,00

SUPPORT PLATE

	NAME	DATE	PREMAC	
DRAWN	Dan	10/23/10		
APPROVED				
MATERIAL				
TREATMENT			TITLE	Magnastart Mould
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
1 st ANGLE ANGLES ±0,1°			A4	
2 PL ±0,02 3 PL ±0,005			FILE NAME:	Magnastart Mould.dft
			SCALE:	WEIGHT:
			SHEET 6 OF 19	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

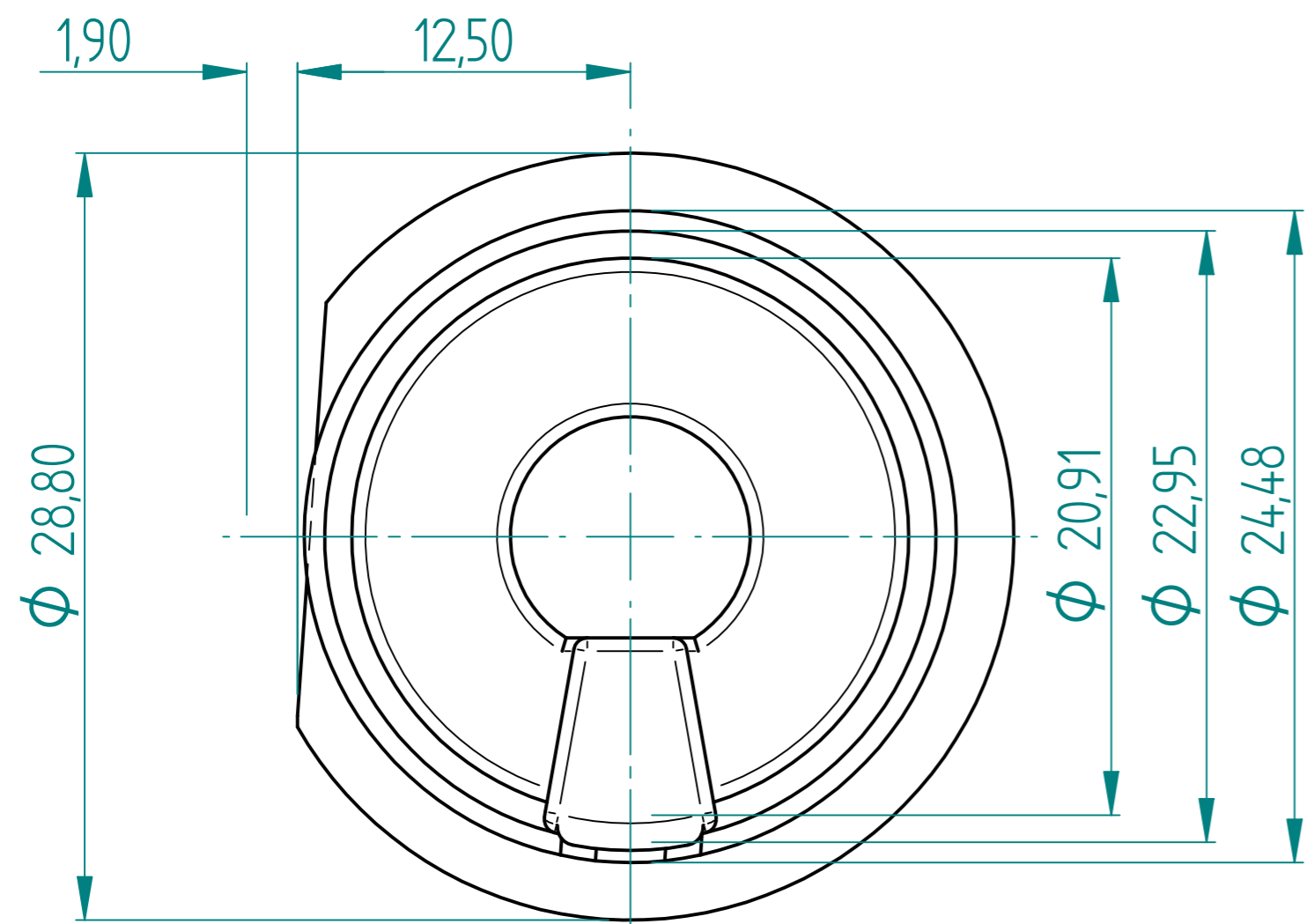


Hole Table				
Hole	X	Y	Size	CounterBore
A.1	-36,00	78,00	φ 8,50	φ15,00-5,05
A.2	36,00	78,00	φ 8,50	φ15,00-5,05
A.3	29,00	-78,00	φ 8,50	φ15,00-5,05
A.4	-29,00	-78,00	φ 8,50	φ15,00-5,05
B.1	20,00	45,58	φ 9,50	φ15,00-5,05
B.2	20,00	16,00	φ 9,50	φ15,00-5,05
C.1	0,00	0,00	φ 6,50	φ13,00-5,05
D.1	15,28	73,58	φ 3,00	φ6,00-2,05
D.2	24,67	73,58	φ 3,00	φ6,00-2,05
D.3	24,67	61,58	φ 3,00	φ6,00-2,05
D.4	15,28	61,58	φ 3,00	φ6,00-2,05
D.5	14,00	1,00	φ 3,00	φ6,00-2,05
D.6	26,00	1,00	φ 3,00	φ6,00-2,05
D.7	26,00	-12,50	φ 3,00	φ6,00-2,05
D.8	14,00	-12,50	φ 3,00	φ6,00-2,05

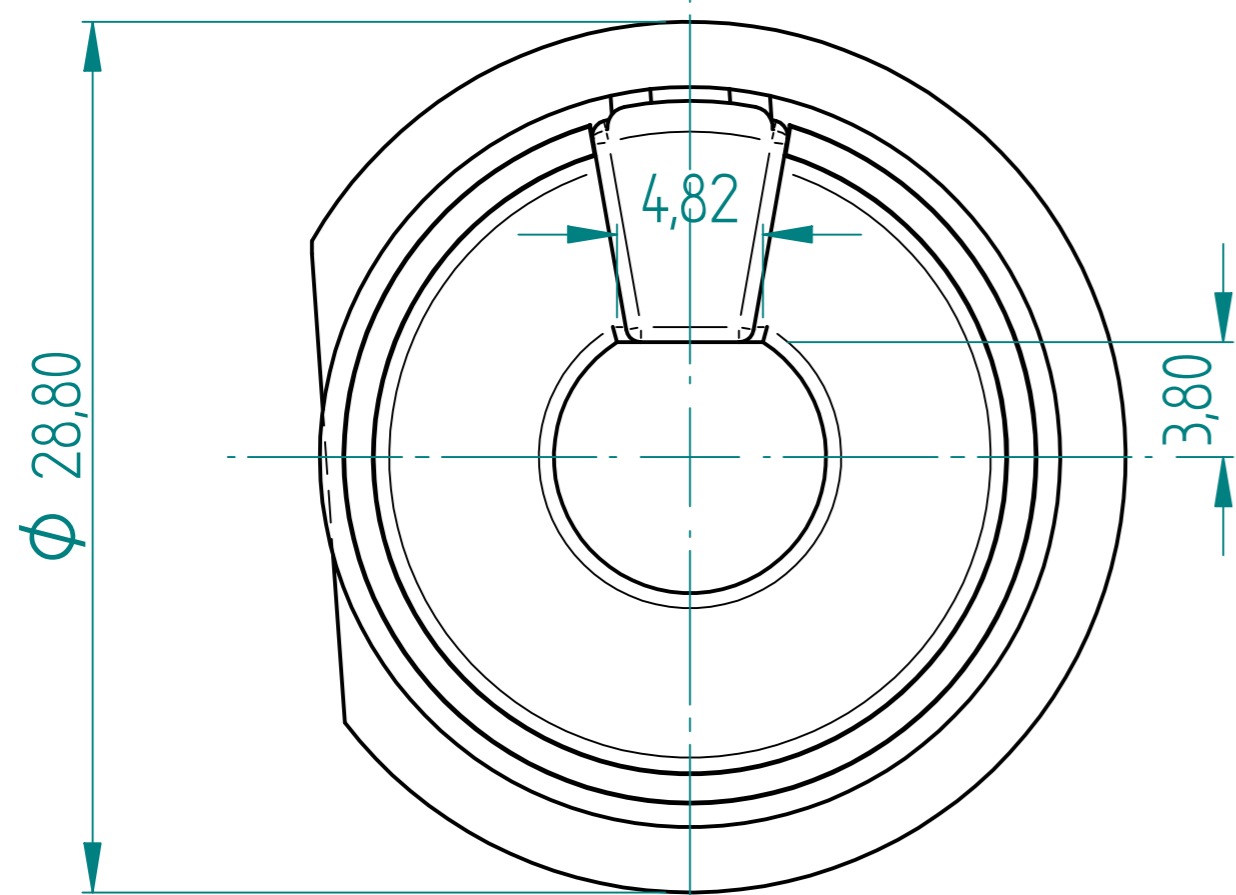
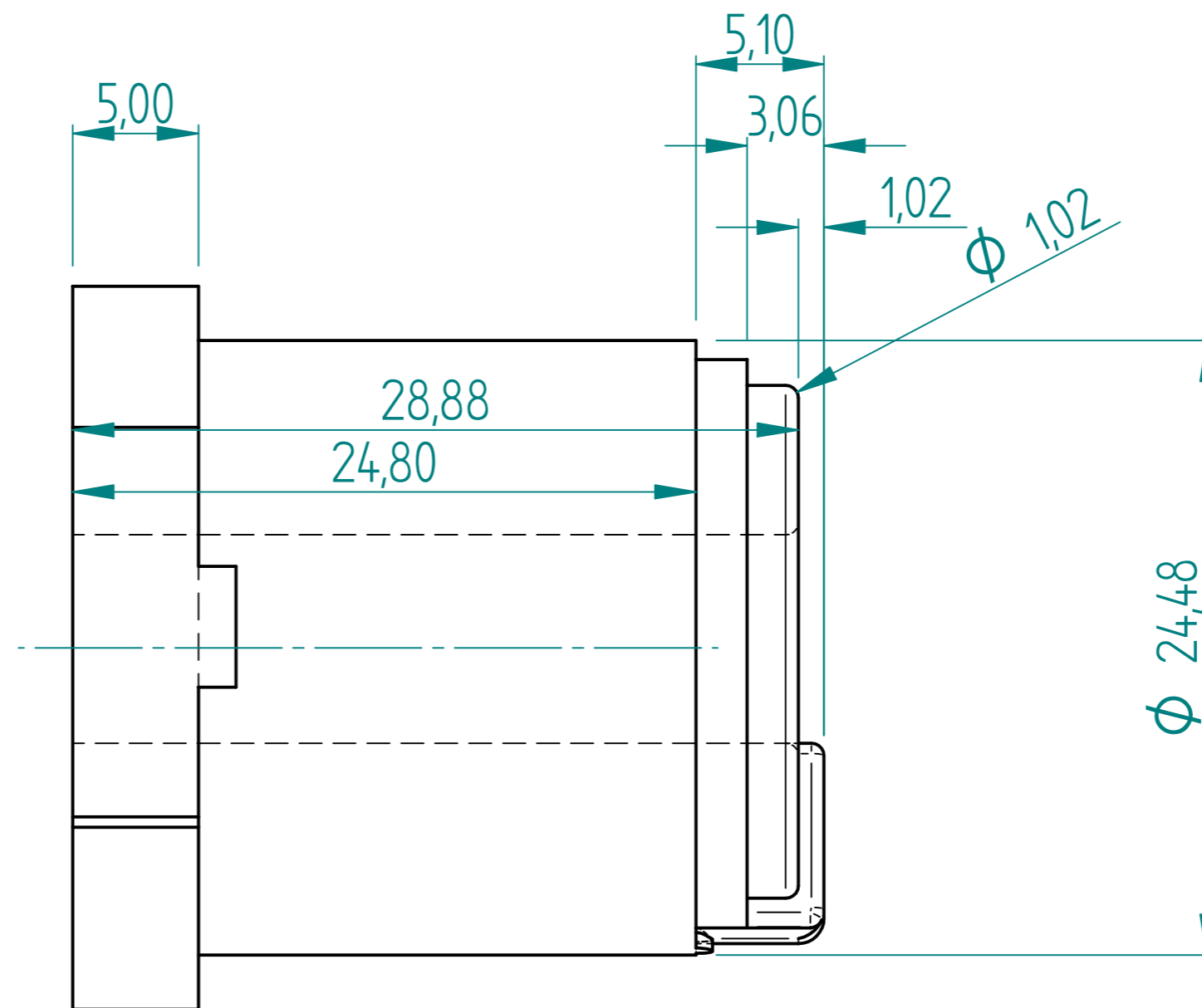
EJECTOR PLATE

	NAME	DATE	PREMAC		
DRAWN	Dan	10/23/10			
APPROVED					
MATERIAL					
TREATMENT			TITLE	Magnastart Mould	
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: Magnastart Mould.dft	SCALE:	WEIGHT:
					SHEET 7 OF 19

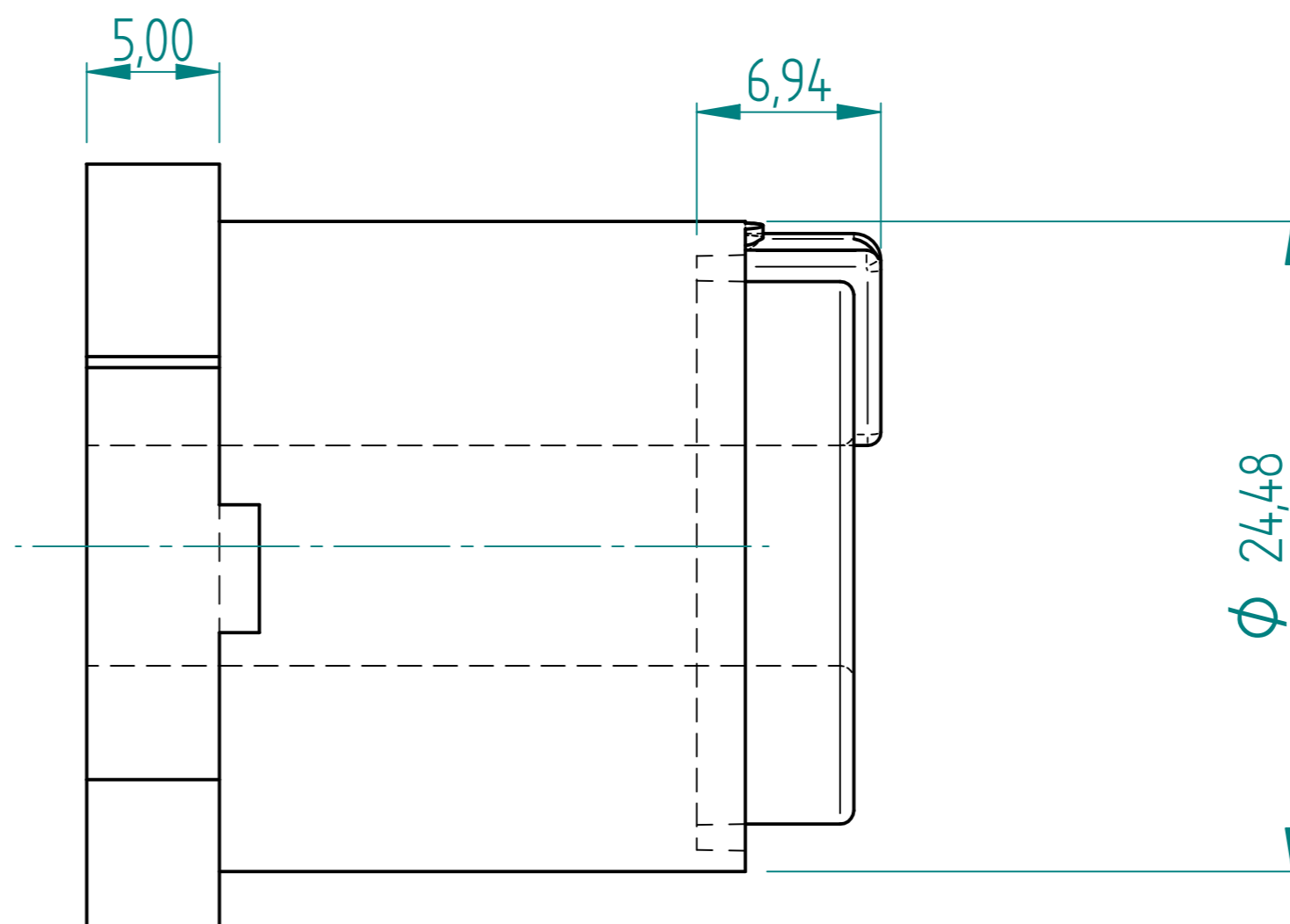
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



CORE PIN A

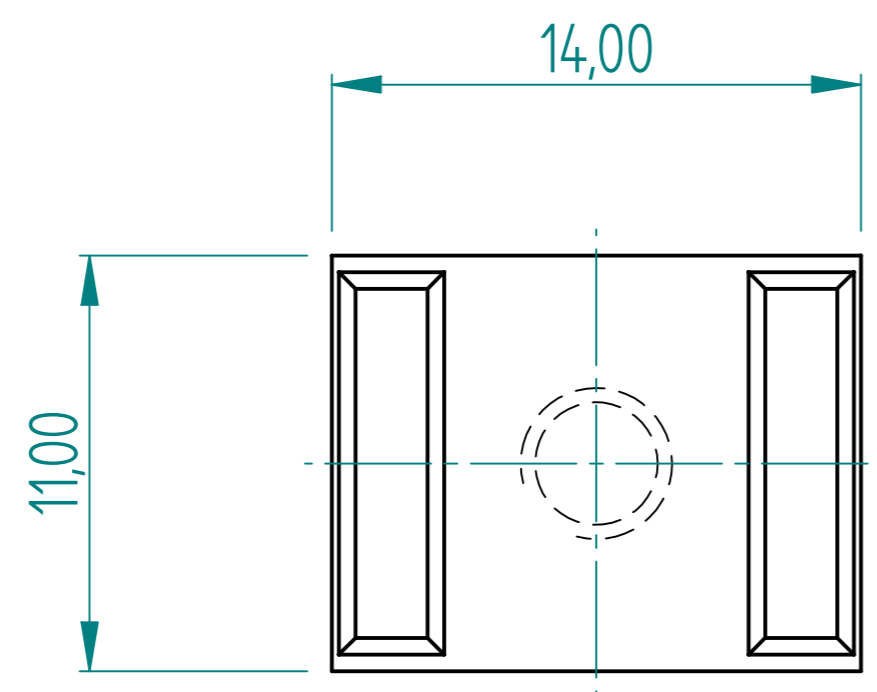
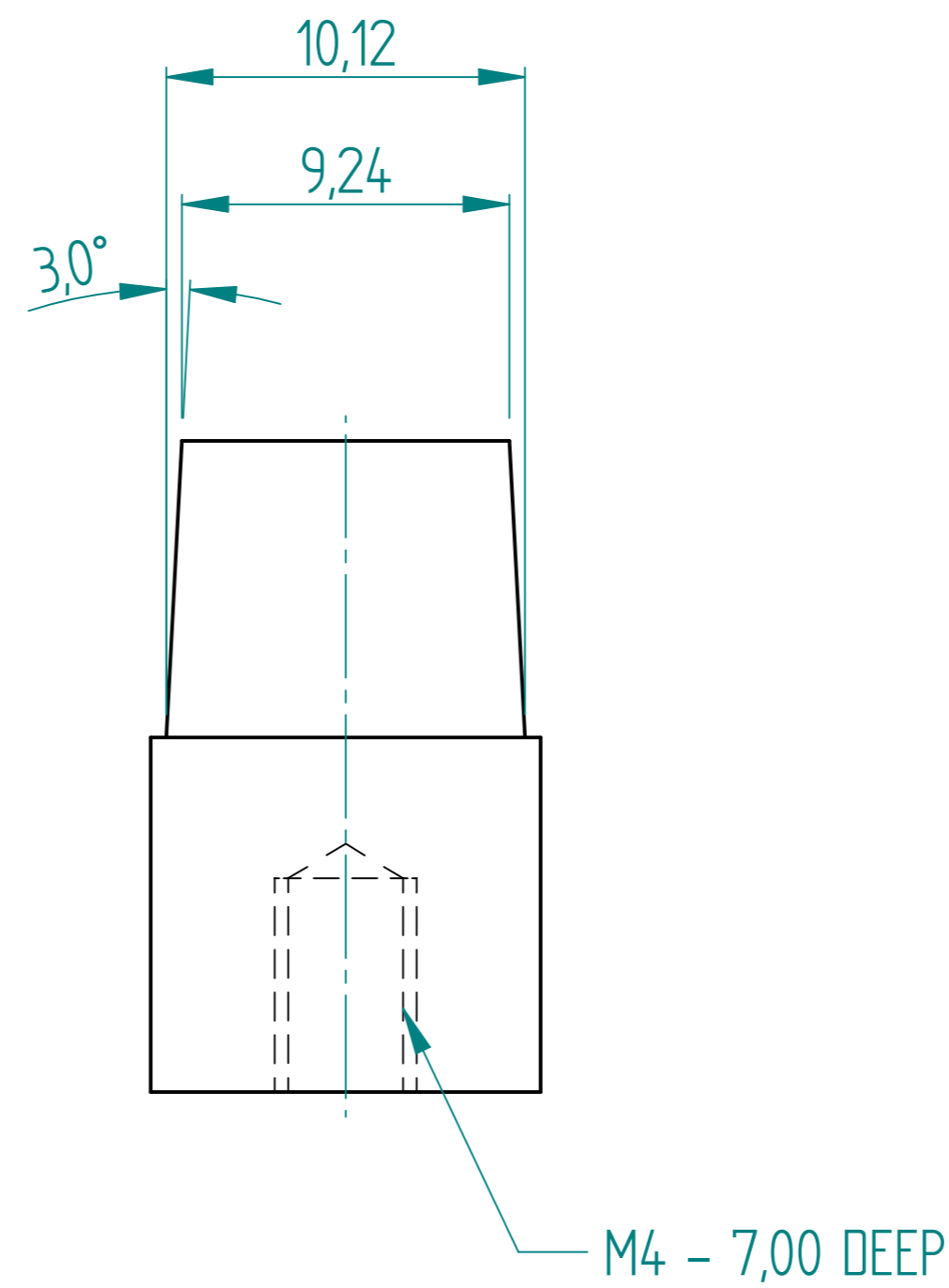
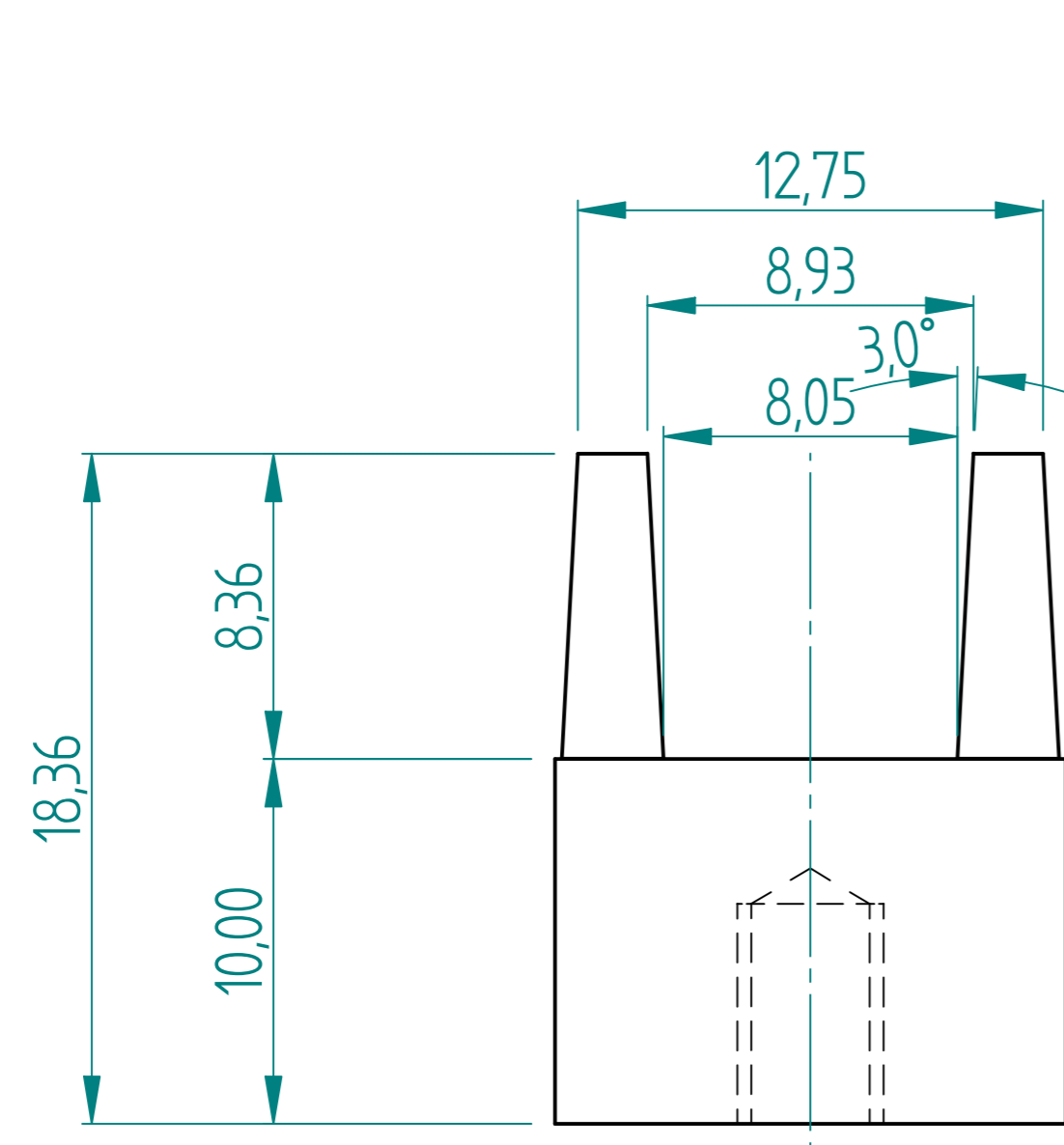


CORE PIN B



DRAWN	NAME	DATE	PREMAC			
APPROVED	Dan	10/23/10				
MATERIAL					TITLE	Magnastart Mould
TREATMENT					SIZE	A4
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			DWG NO	REV		
1 st ANGLE ANGLES ±0,1°			FILE NAME: Magnastart Mould.dft			
2 PL ±0,02 3 PL ±0,005			SCALE:	WEIGHT:		
			SHEET 8 OF 19			

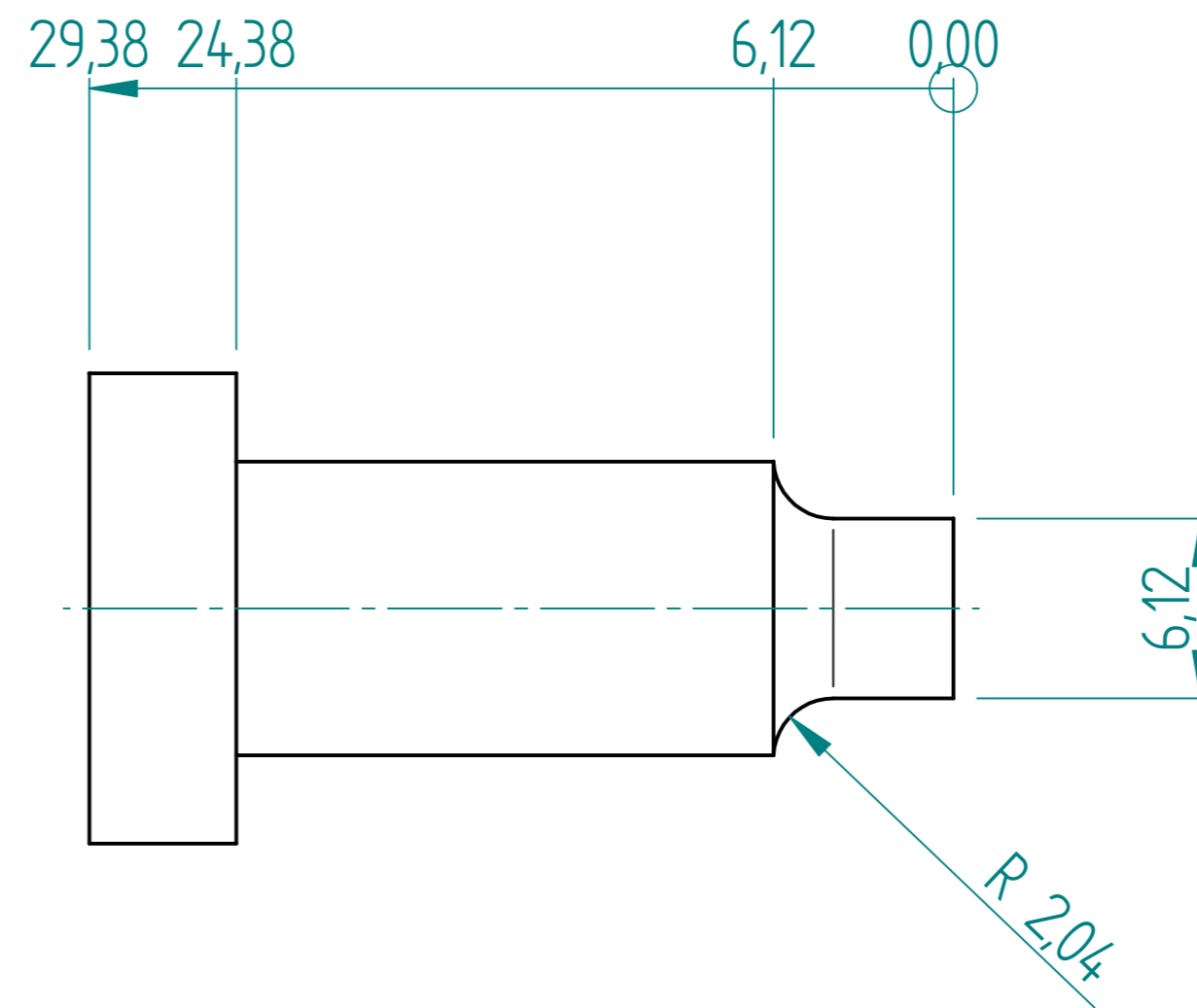
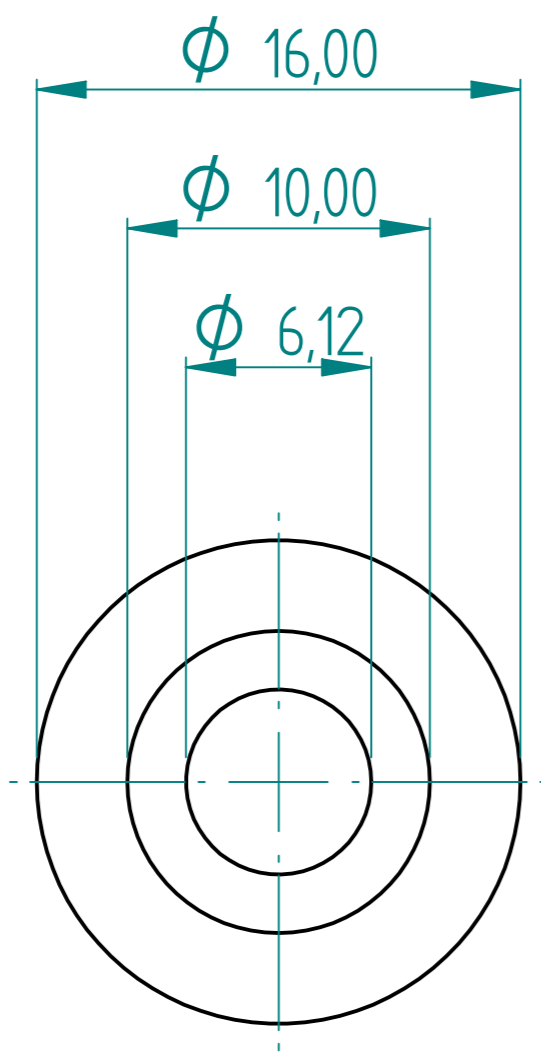
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



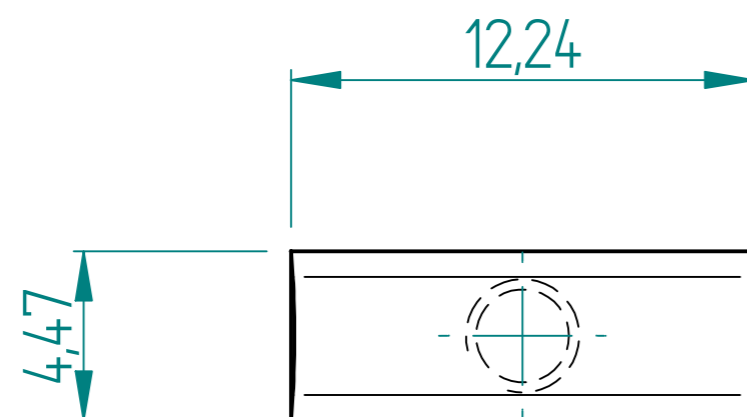
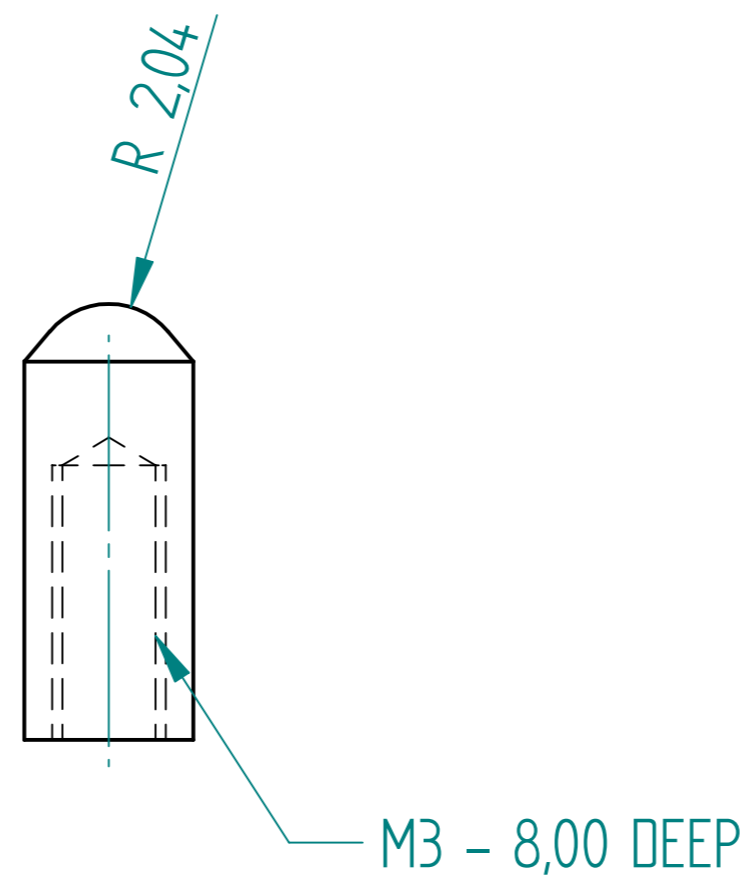
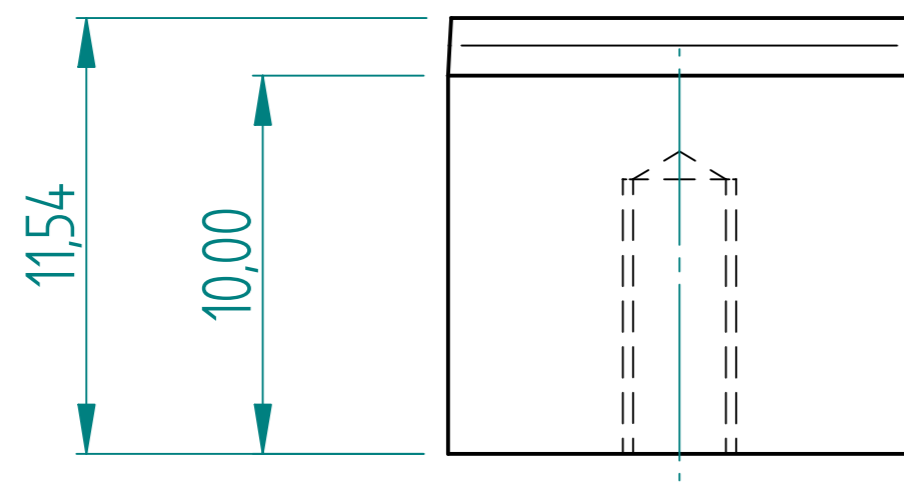
CLIP INSERT

	NAME	DATE	PREMAC	
DRAWN	Dan	10/23/10	TITLE	
APPROVED			Magnastart Mould	
MATERIAL			SIZE	DWG NO
TREATMENT			A4	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: Magnastart Mould.dft	REV
1st ANGLE ANGLES ±0,1°			SCALE:	WEIGHT:
2 PL ±0.02 3 PL ±0.005				SHEET 9 OF 19

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



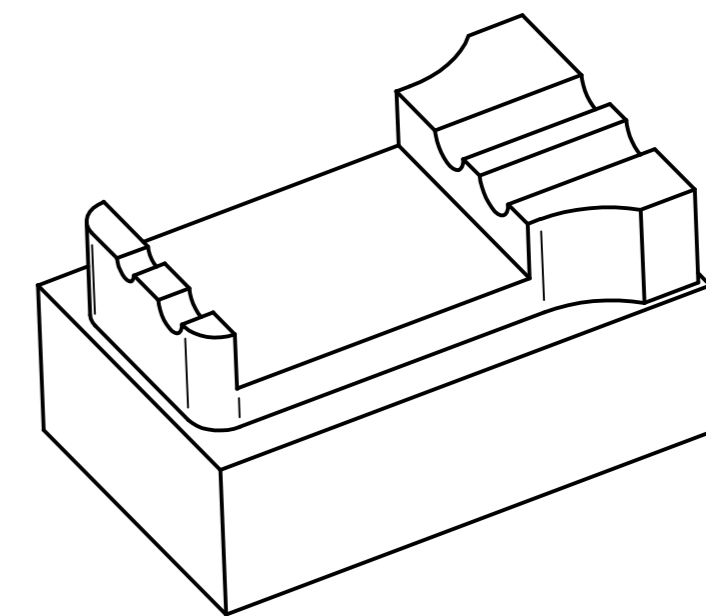
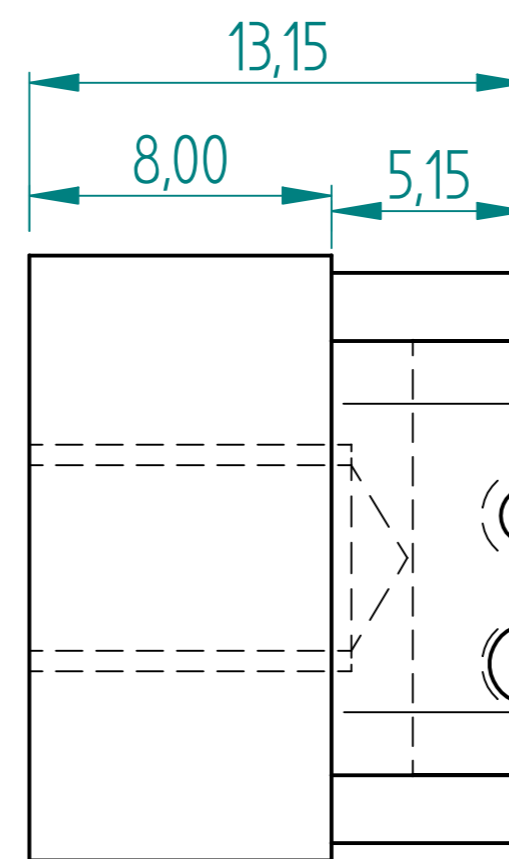
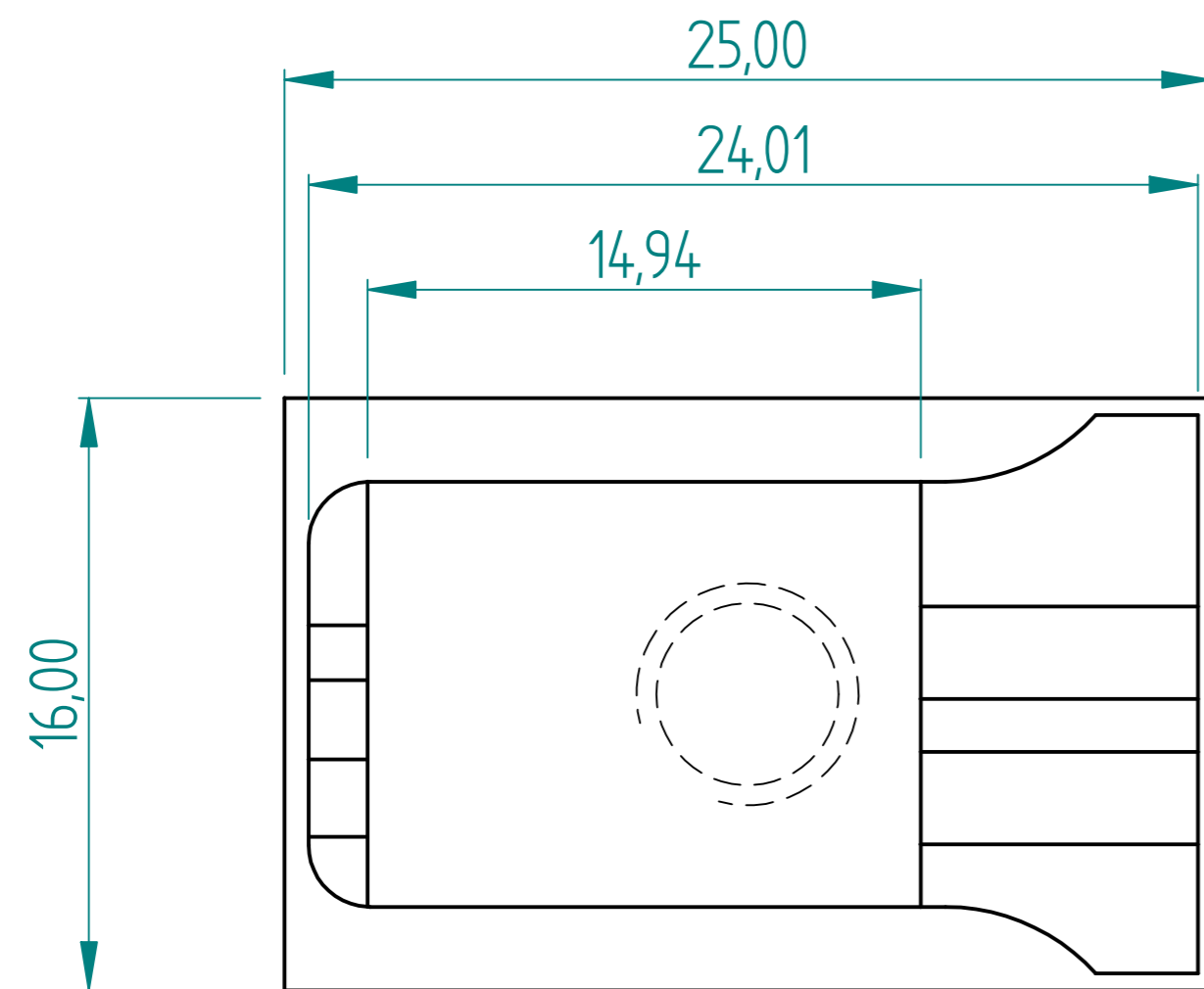
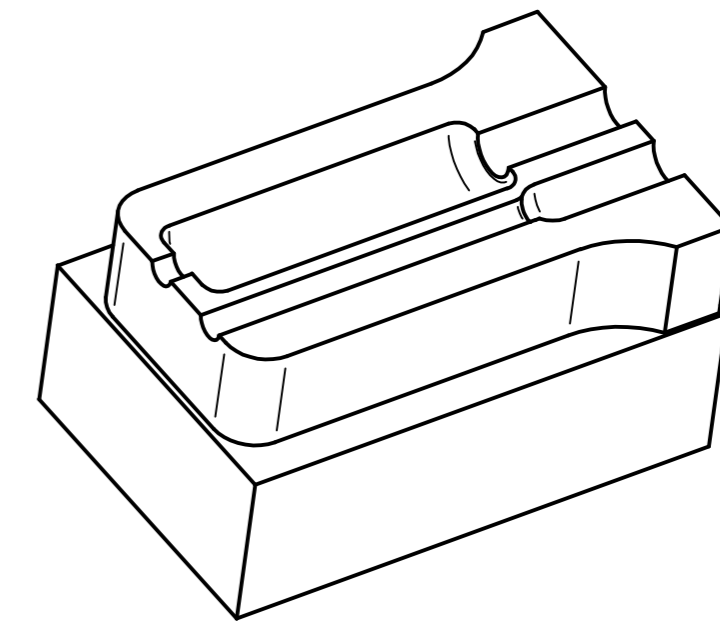
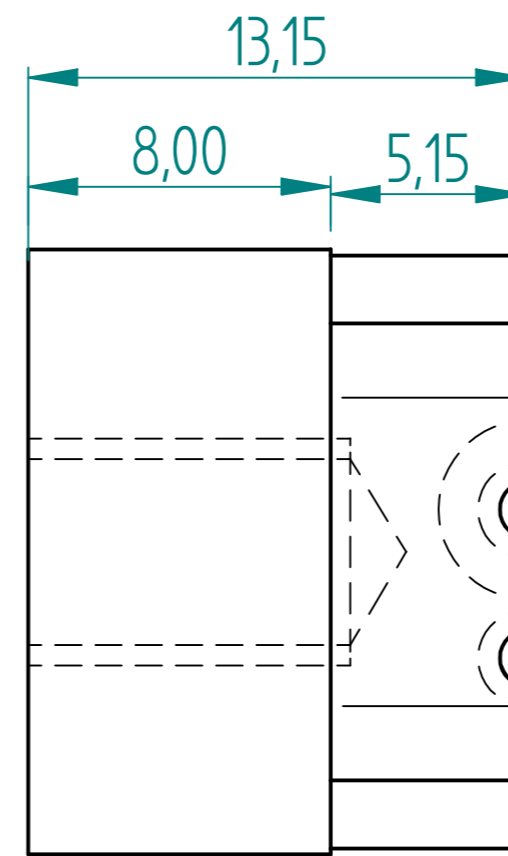
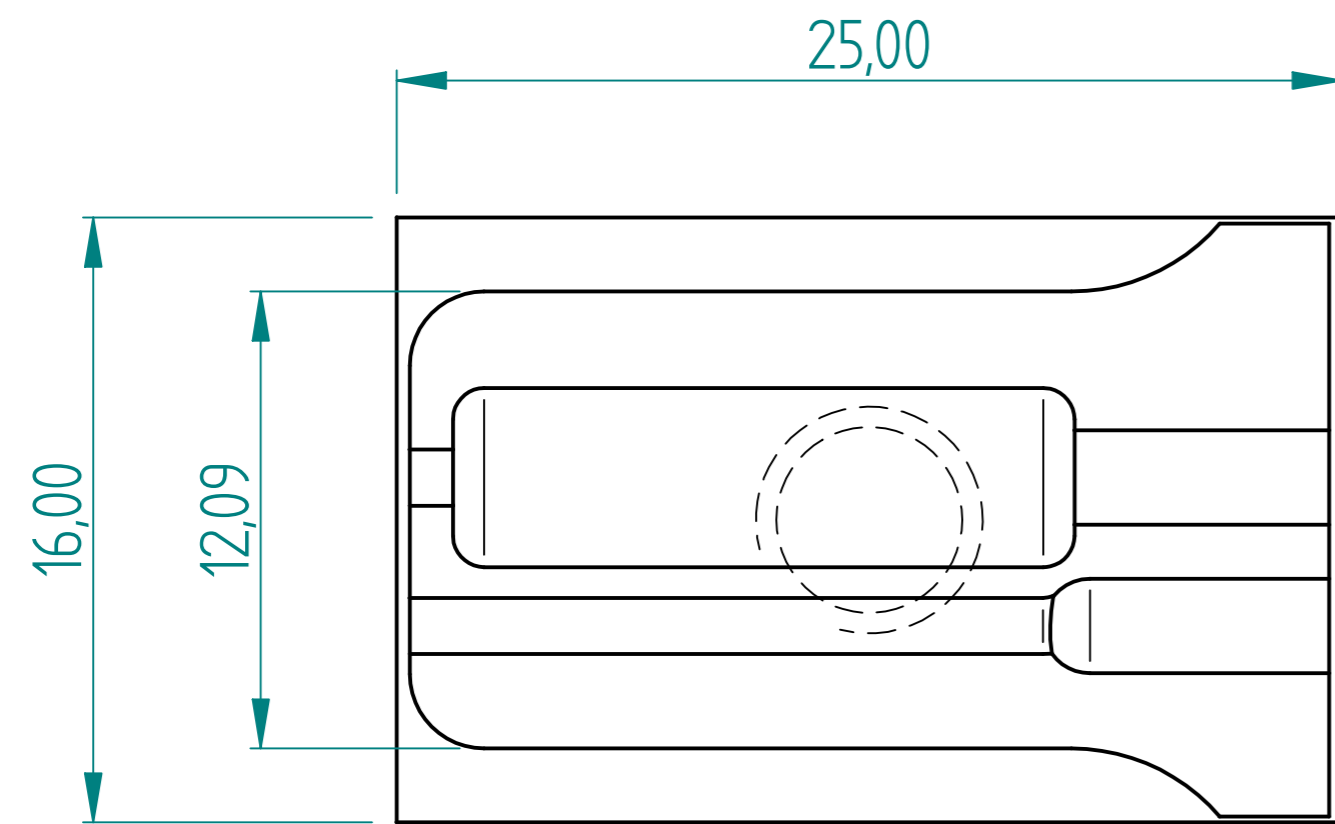
CORE PIN DIA 10



BEND INSERT

	NAME	DATE	PREMAC	
DRAWN	Dan	10/23/10	TITLE	
APPROVED			Magnastart Mould	
MATERIAL			SIZE	DWG NO
TREATMENT			A4	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: Magnastart Mould.dft	REV
1 st ANGLE ANGLES ±0,1°			SCALE:	WEIGHT:
2 PL ±0,02 3 PL ±0,005				SHEET 10 OF 19

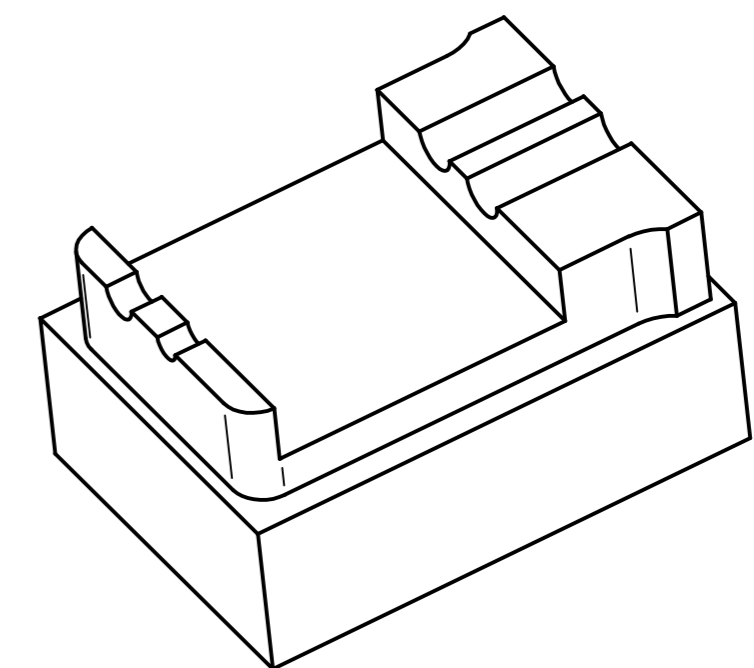
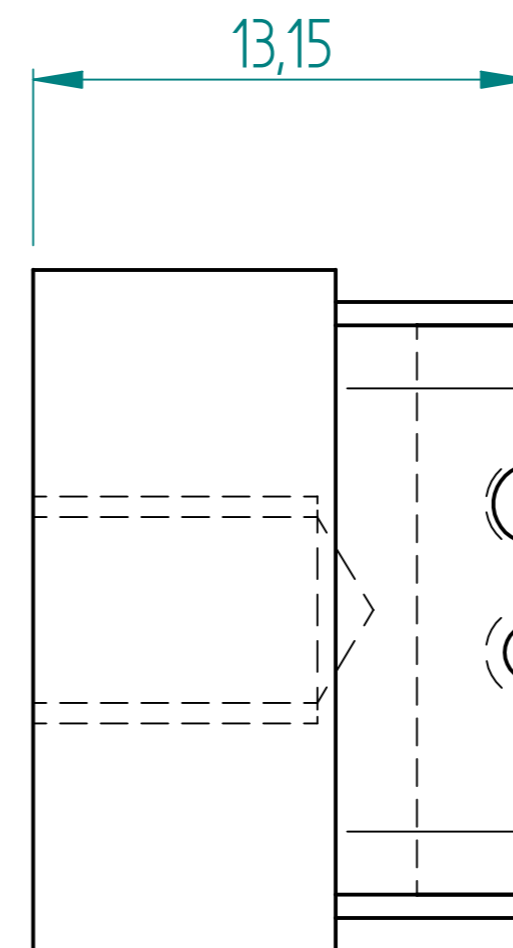
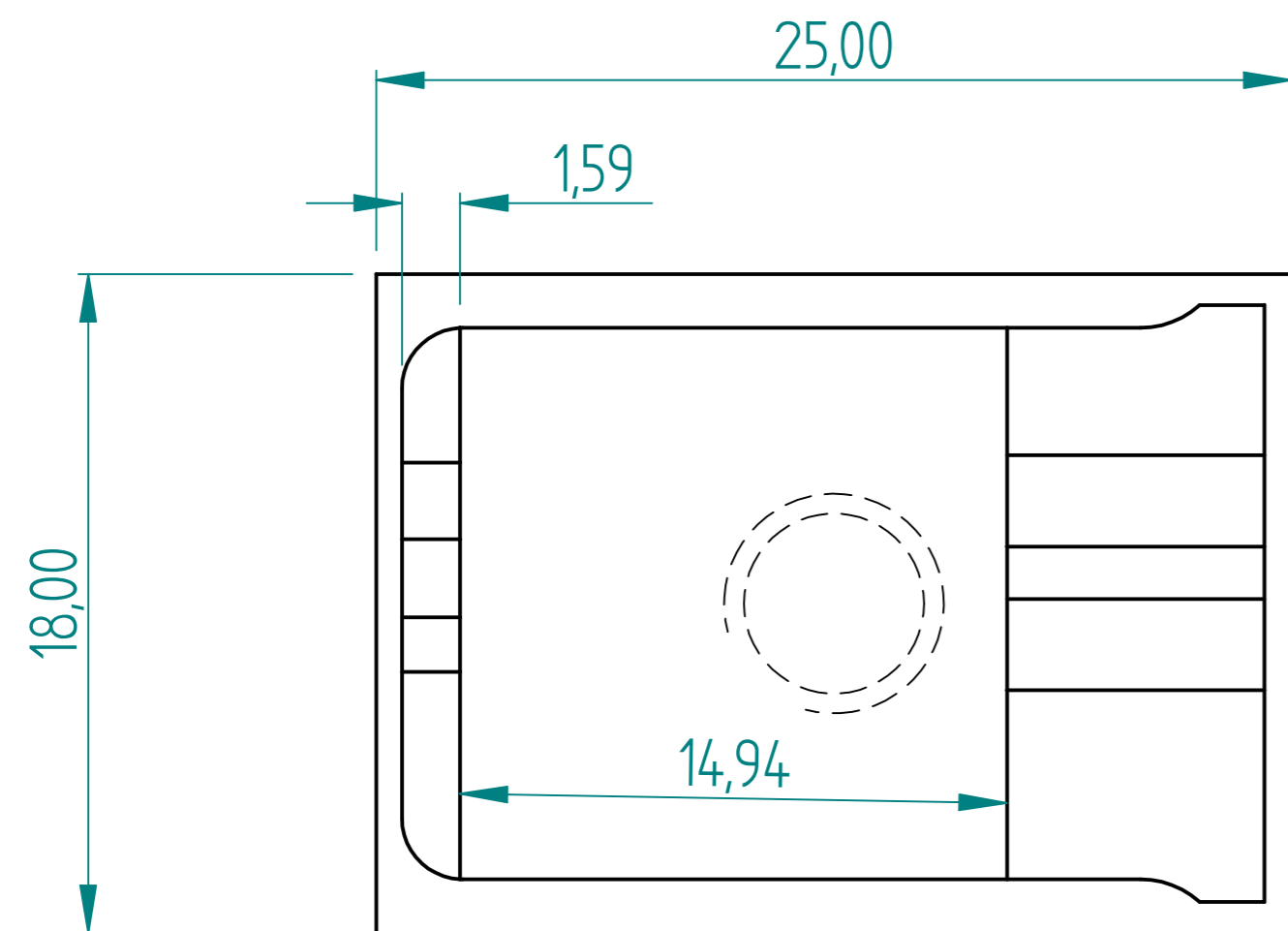
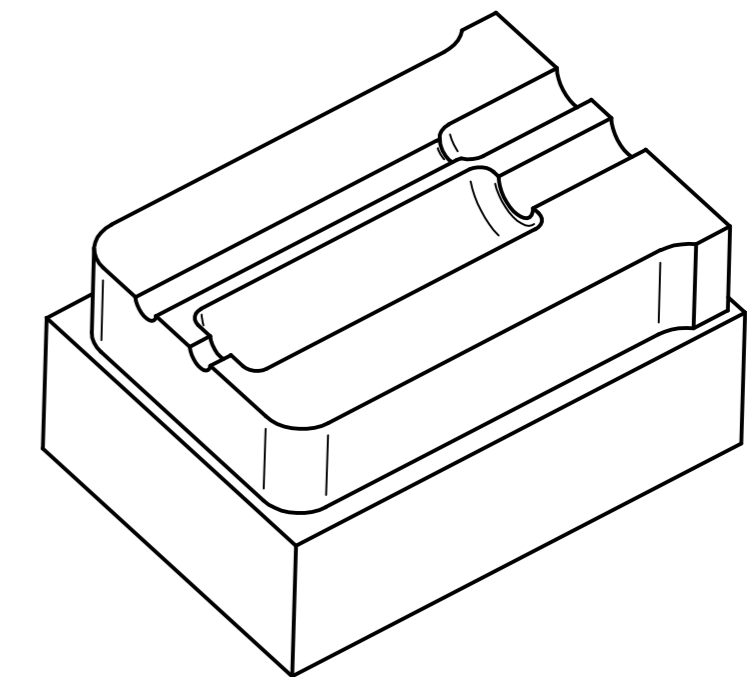
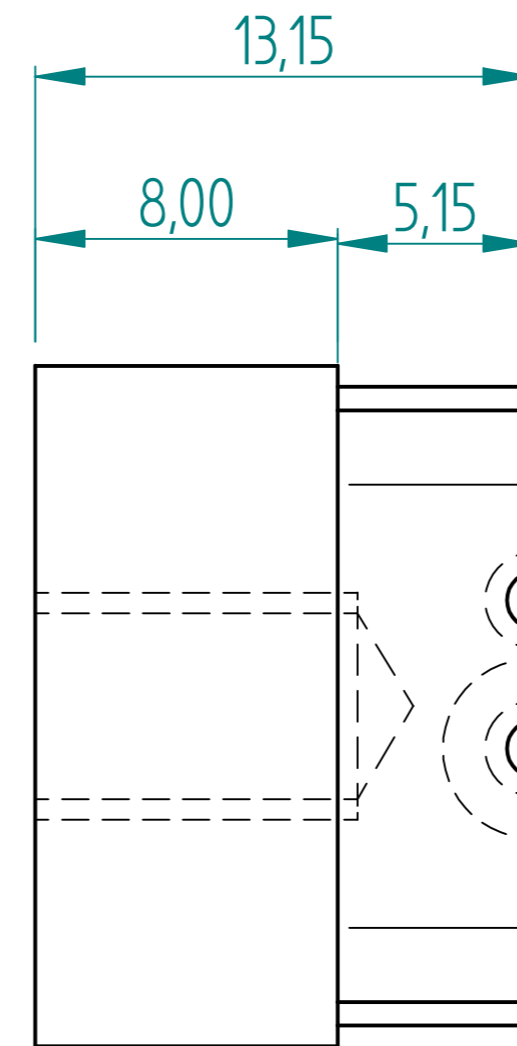
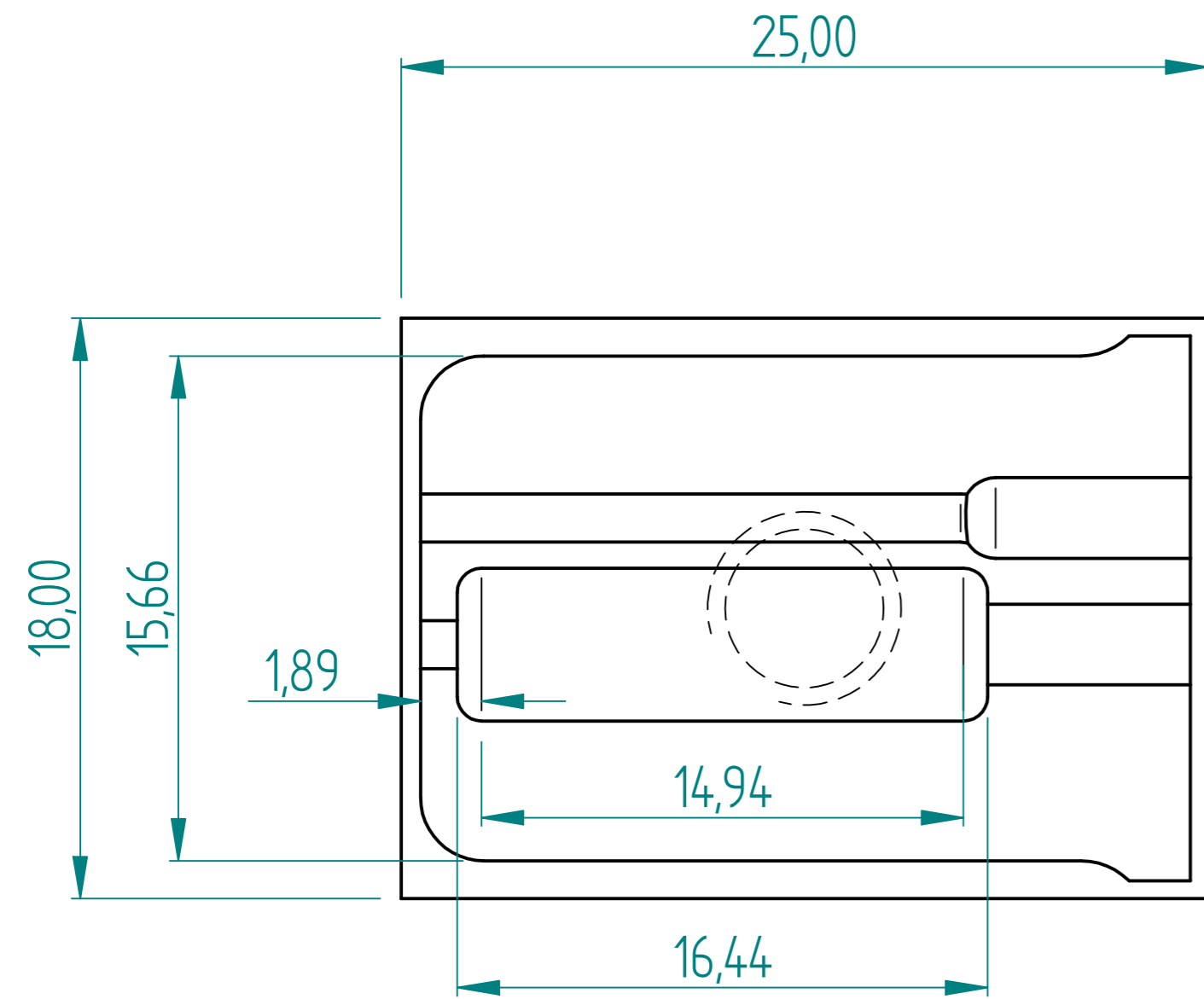
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



ELECTRODE SIDE B

DRAWN	NAME	DATE	PREMAC	
APPROVED	Dan	10/23/10		
MATERIAL			TITLE	
TREATMENT			Magnastart Mould	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
ANGLES ±0.1°			A4	REV
1 st ANGLE			FILE NAME: Magnastart Mould.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:
			SHEET 11 OF 19	

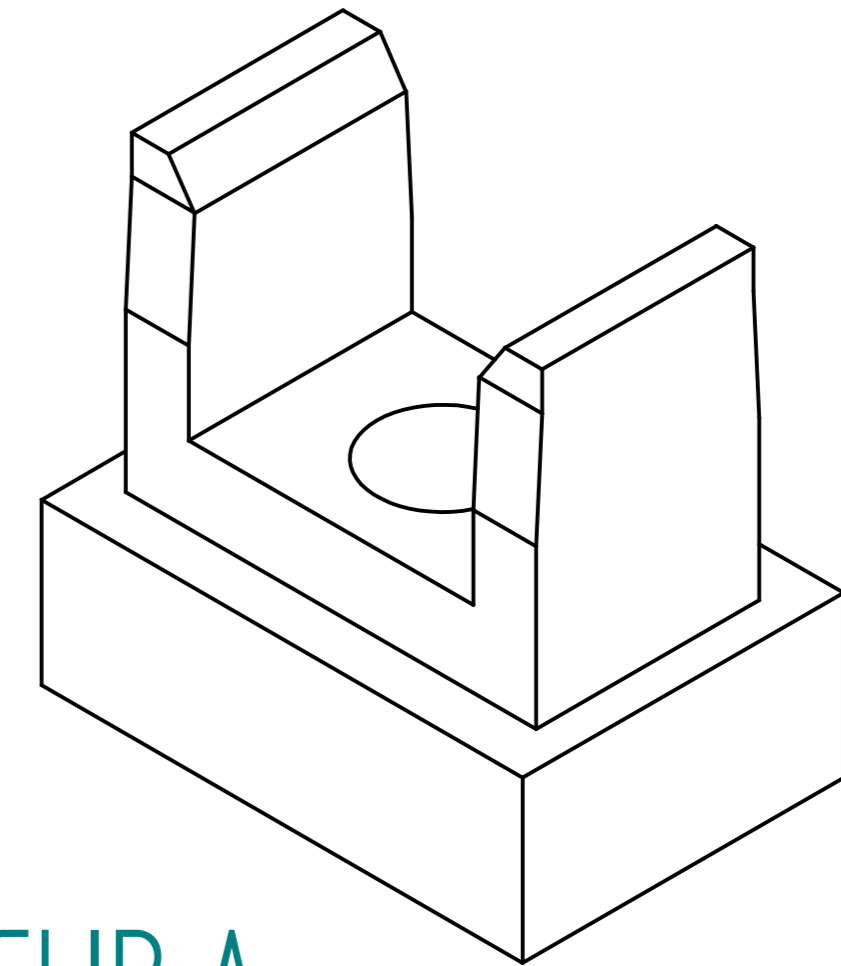
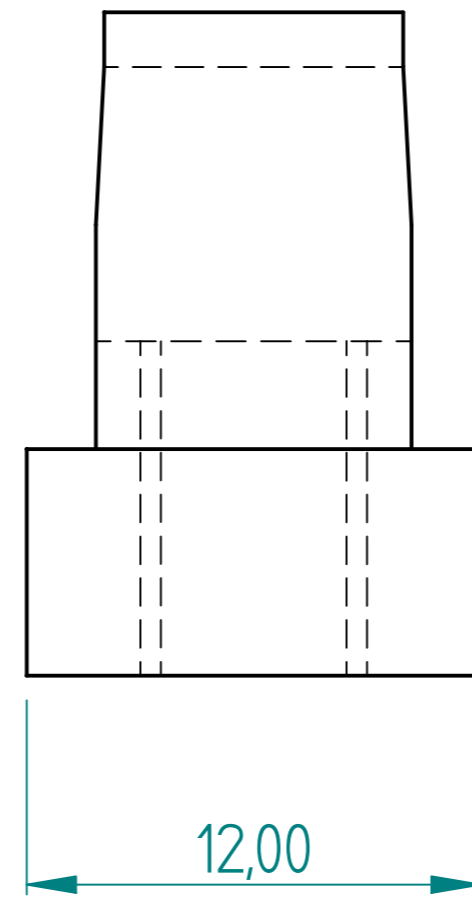
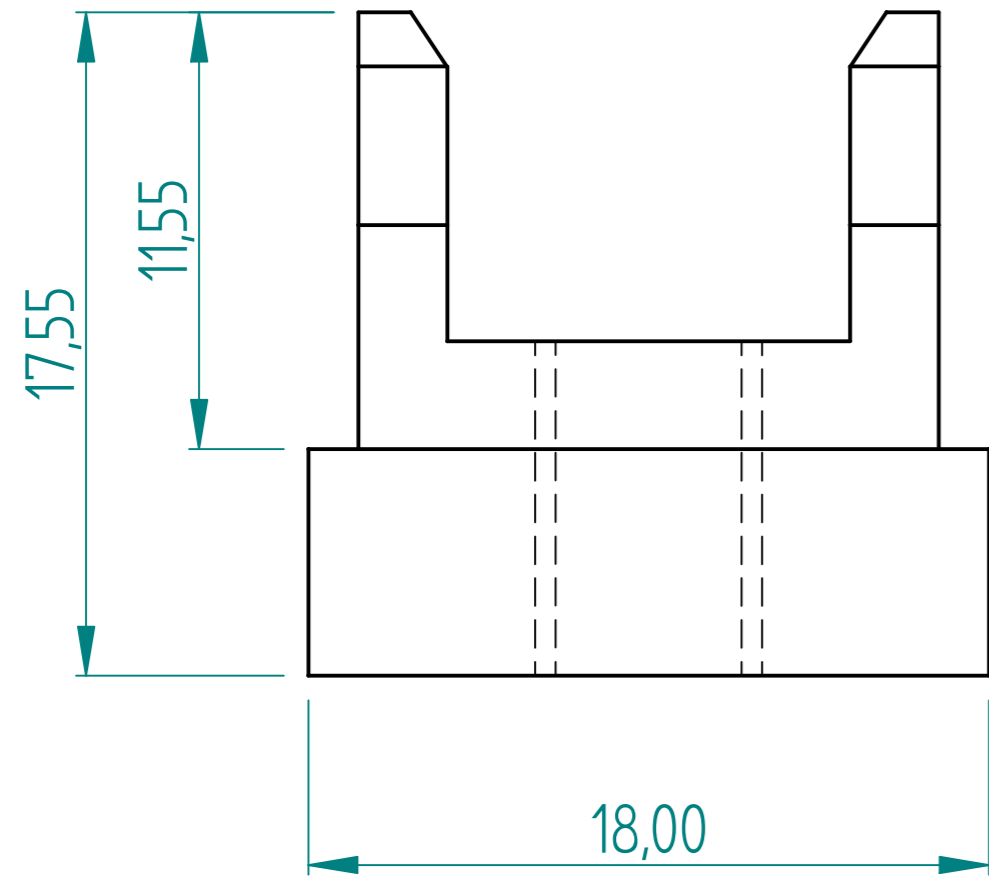
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



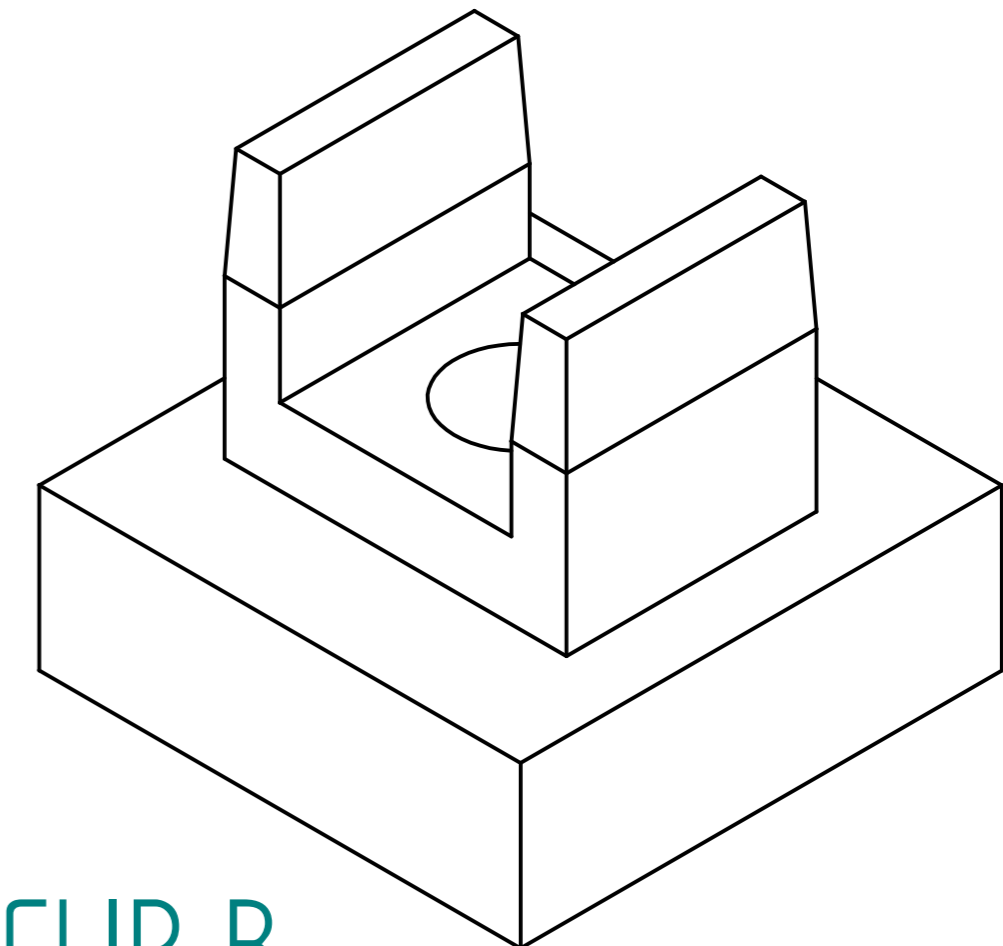
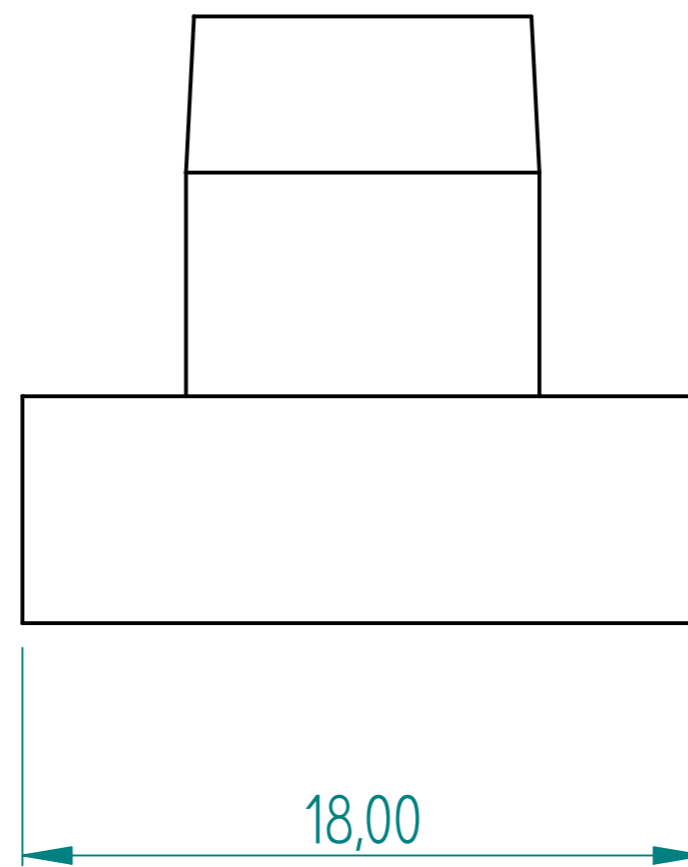
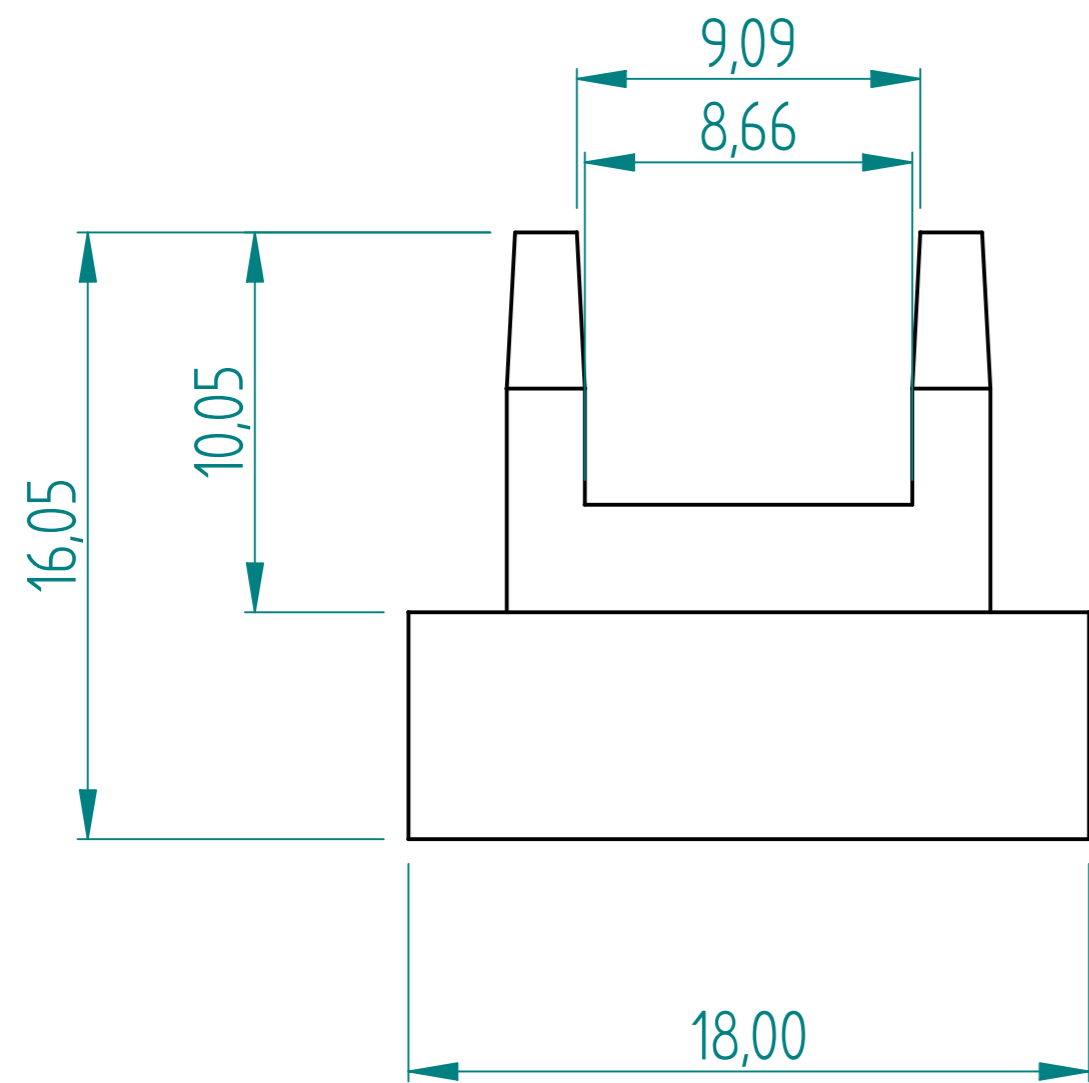
ELECTRODE SIDE A

	NAME	DATE	PREMAC		
DRAWN	Dan	10/23/10			
APPROVED			TITLE Magnastart Mould		
MATERIAL					
TREATMENT			SIZE A4	DWG NO	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: Magnastart Mould.dft		
1 st ANGLE ANGLES ±0,1°			SCALE:	WEIGHT:	SHEET 12 OF 19
2 PL ±0.02 3 PL ±0.005					

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



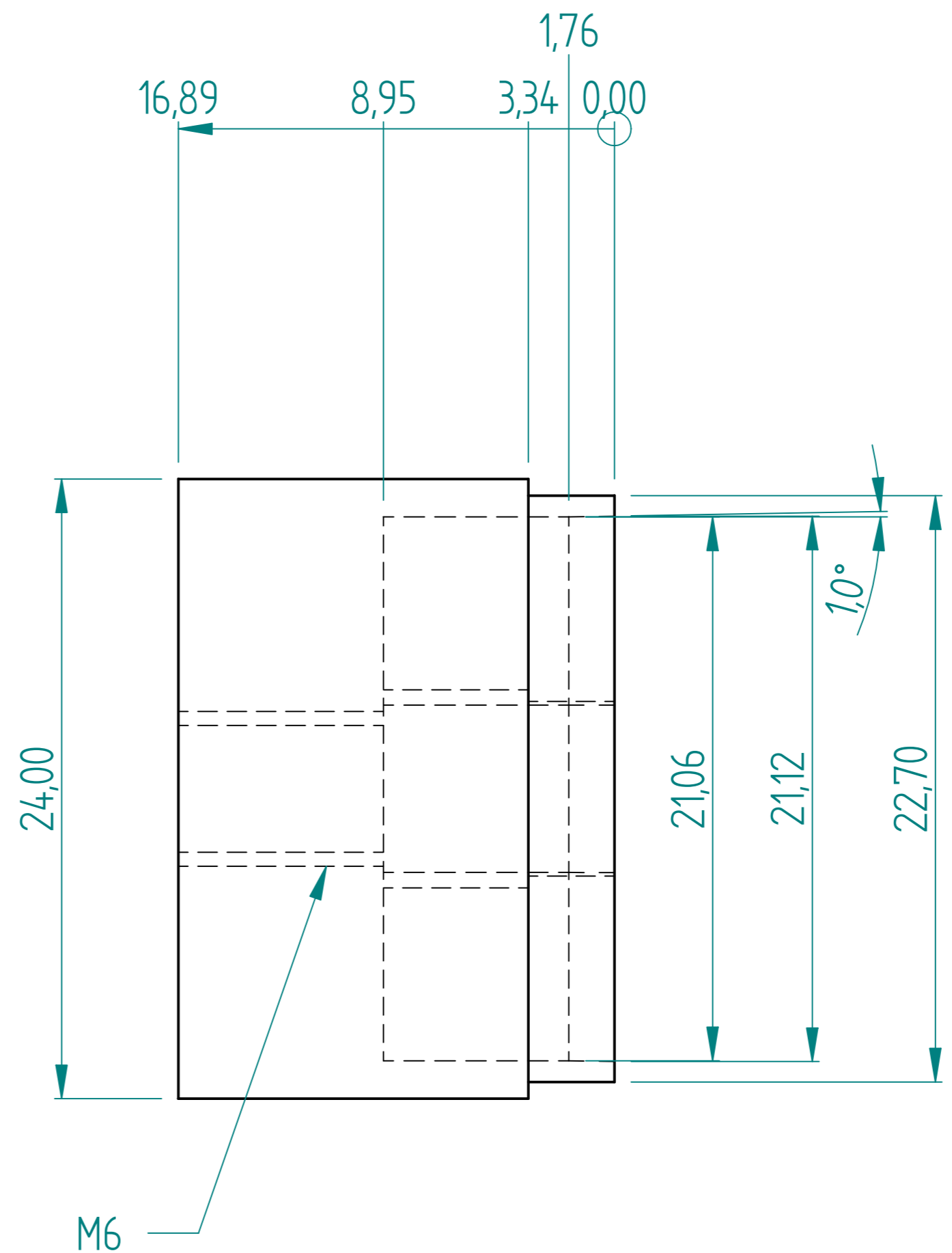
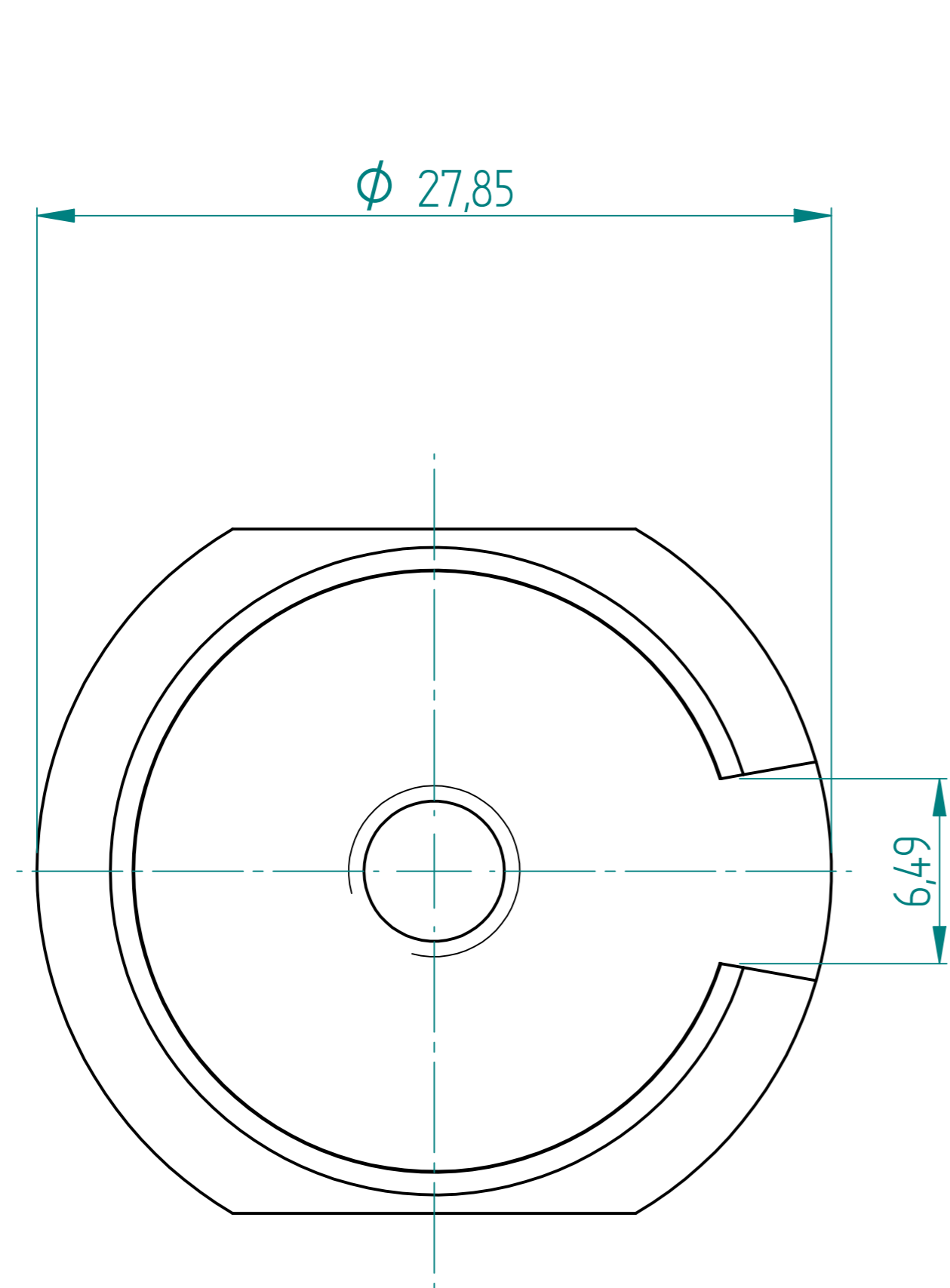
ELECTRODE CLIP A



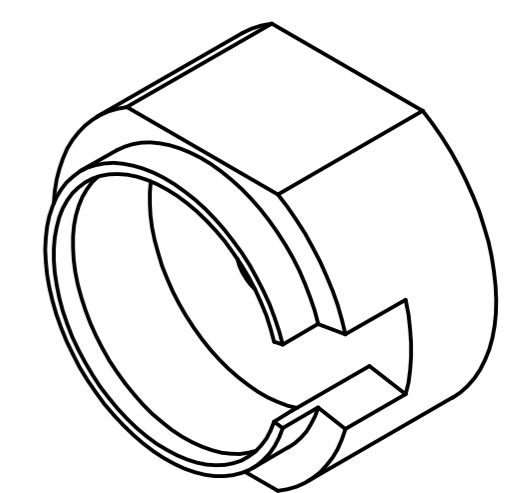
ELECTRODE CLIP B

	NAME	DATE	PREMAC	
DRAWN	Dan	10/23/10		
APPROVED				
MATERIAL				
TREATMENT			TITLE	Magnastart Mould
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
1 st ANGLE ANGLES ±0,1°			A4	
2 PL ±0,02 3 PL ±0,005			FILE NAME: Magnastart Mould.dft	REV
			SCALE:	WEIGHT:
			SHEET 13 OF 19	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

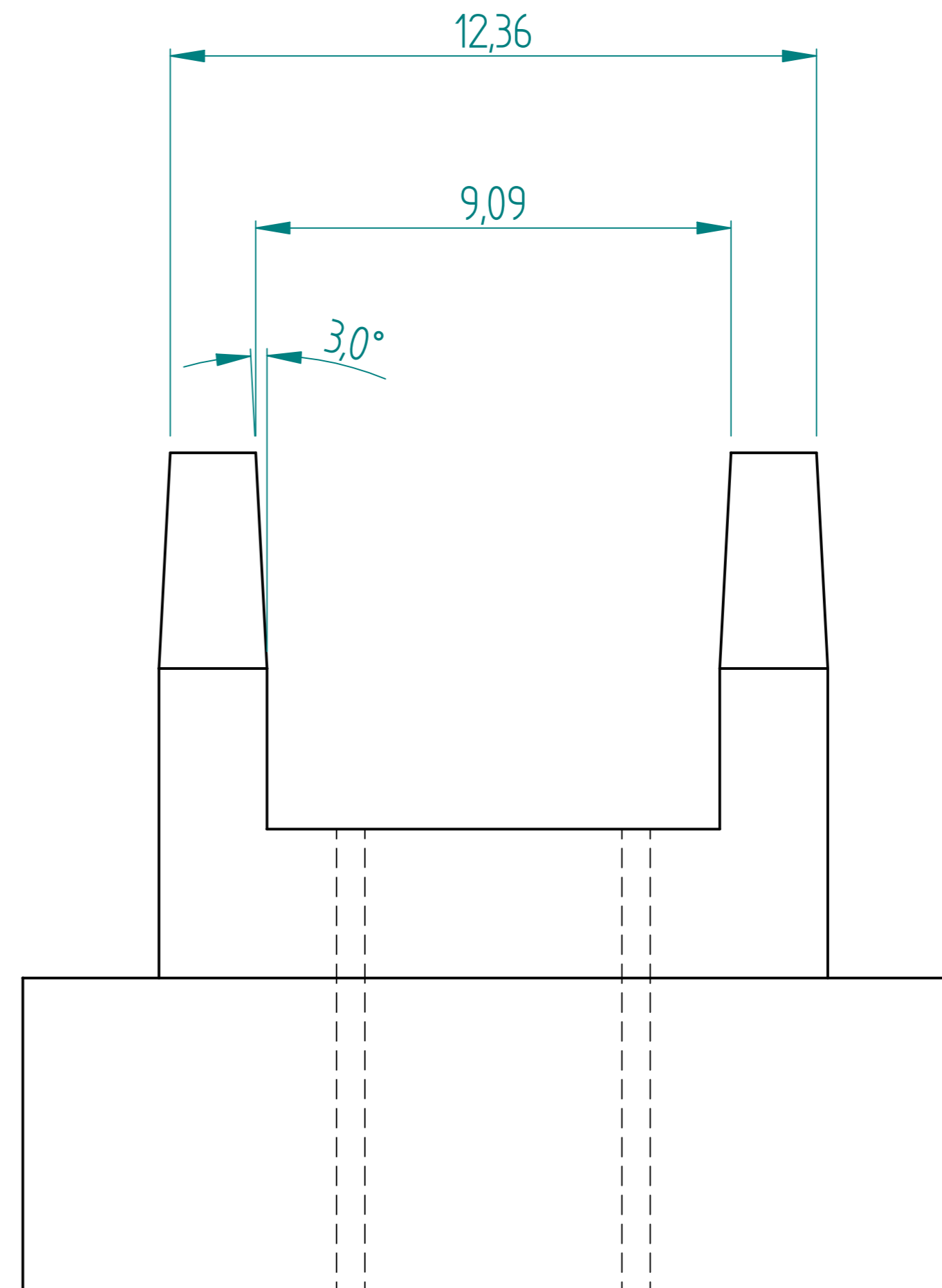
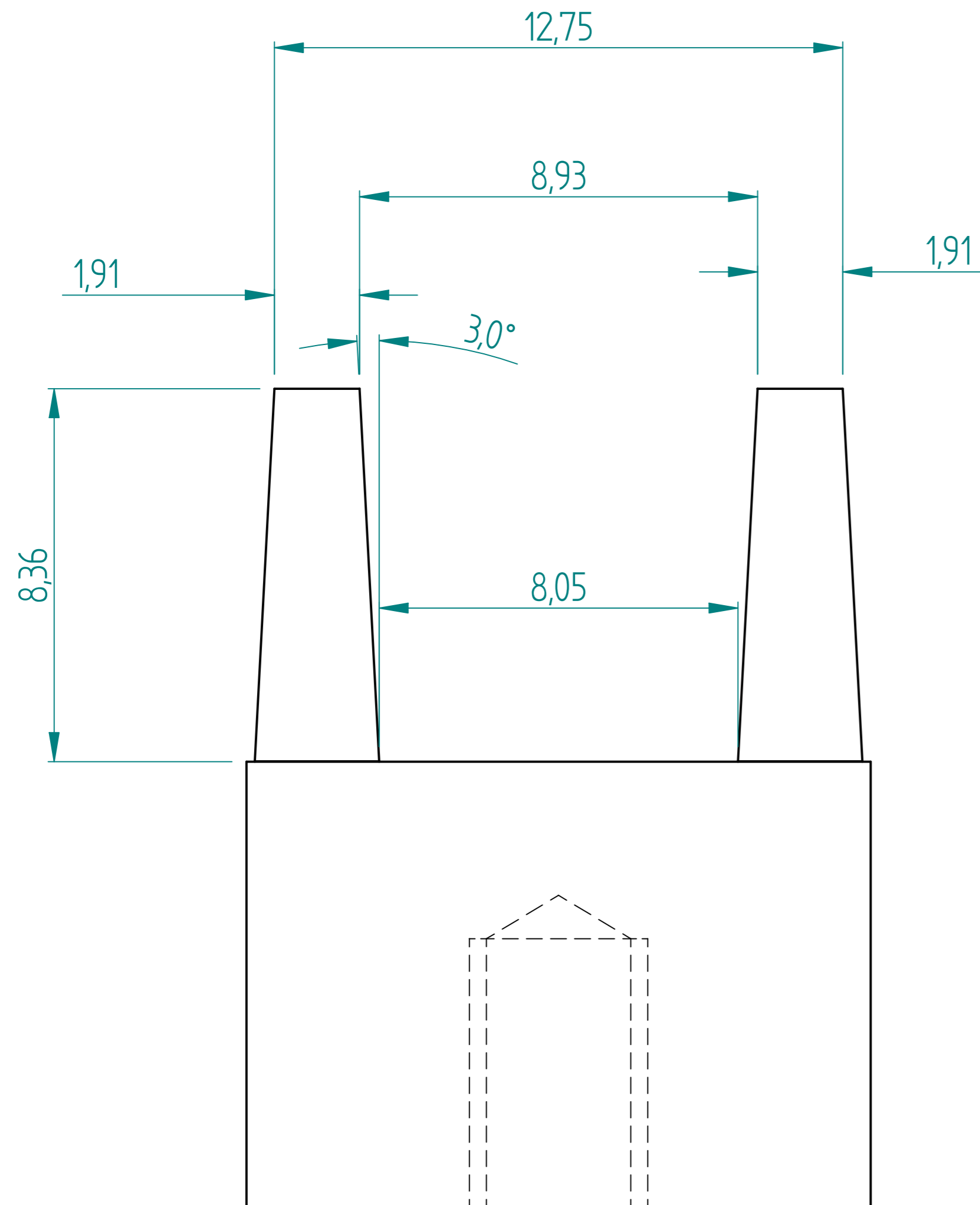


M6



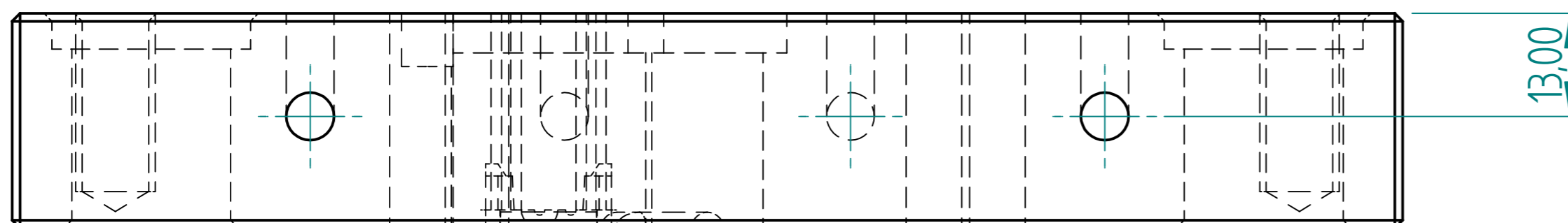
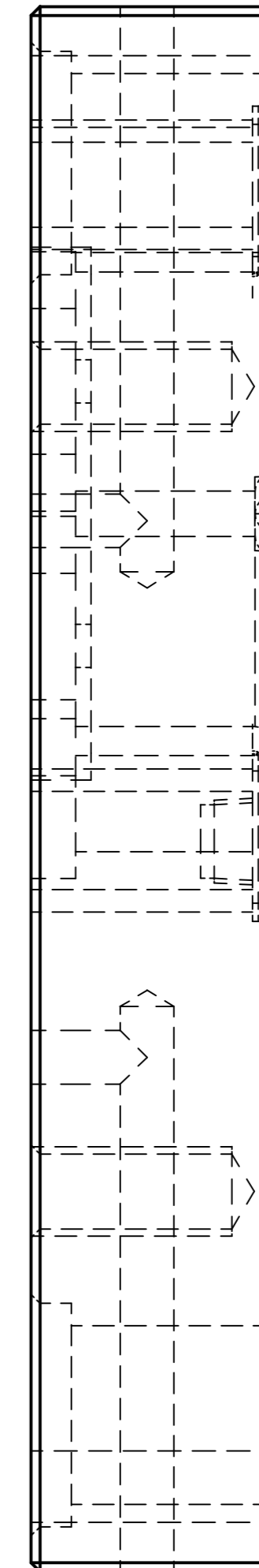
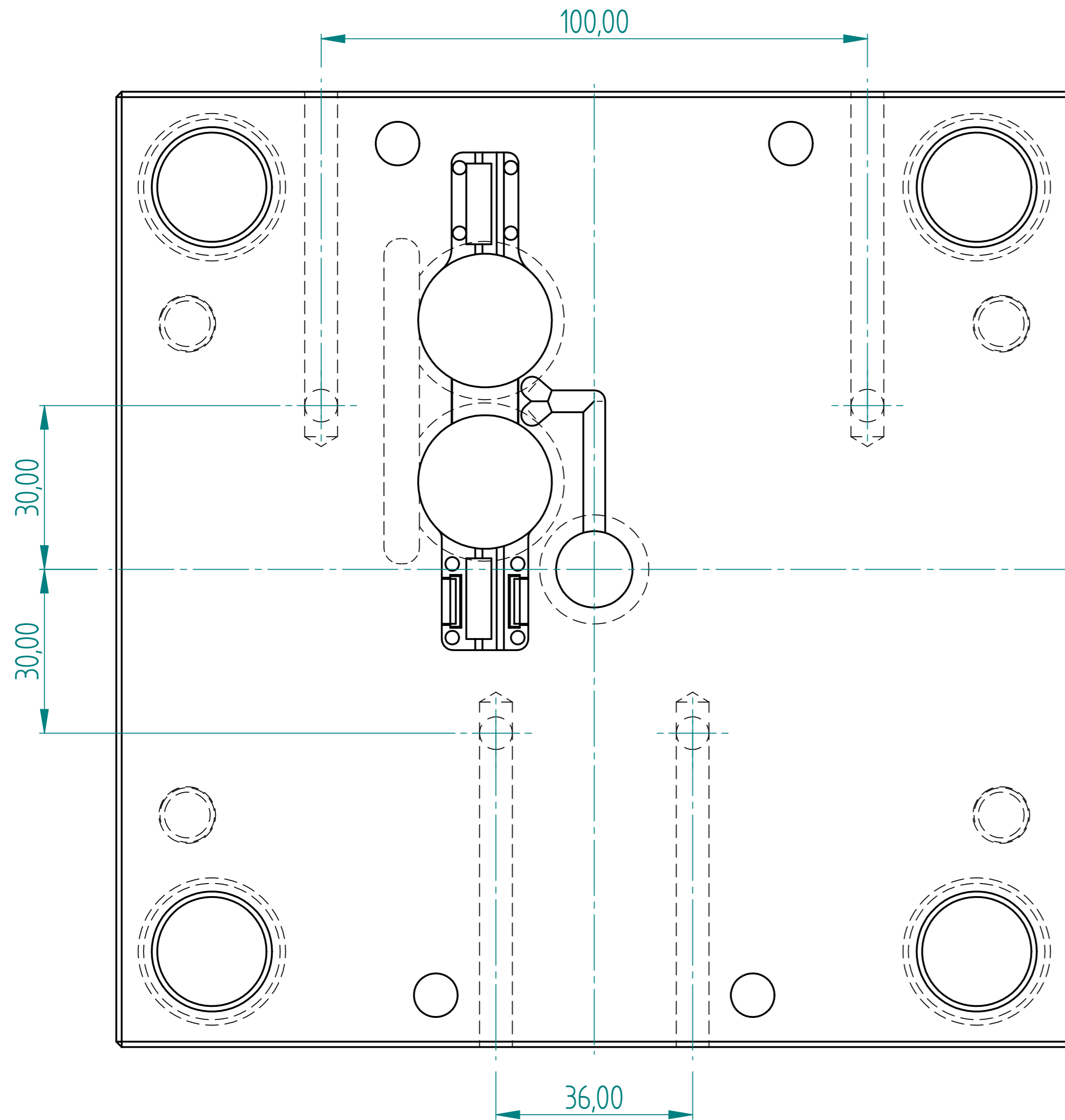
DRAWN	NAME	DATE	PREMAC		
APPROVED	Dan	10/23/10			
MATERIAL					
TREATMENT					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO	REV
1 st ANGLE ANGLES $\pm 0,1^\circ$			A4		
2 PL $\pm 0,02$ 3 PL $\pm 0,005$			FILE NAME: Magnastart Mould.dft		
SCALE:		WEIGHT:	SHEET 14 OF 19		

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



	NAME	DATE	PREMAC	
DRAWN	Dan	10/23/10		
APPROVED				
MATERIAL				
TREATMENT			TITLE Magnastart Mould	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO
1st ANGLE ANGLES ±0.1°			FILE NAME: Magnastart Mould.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT: SHEET 15 OF 19

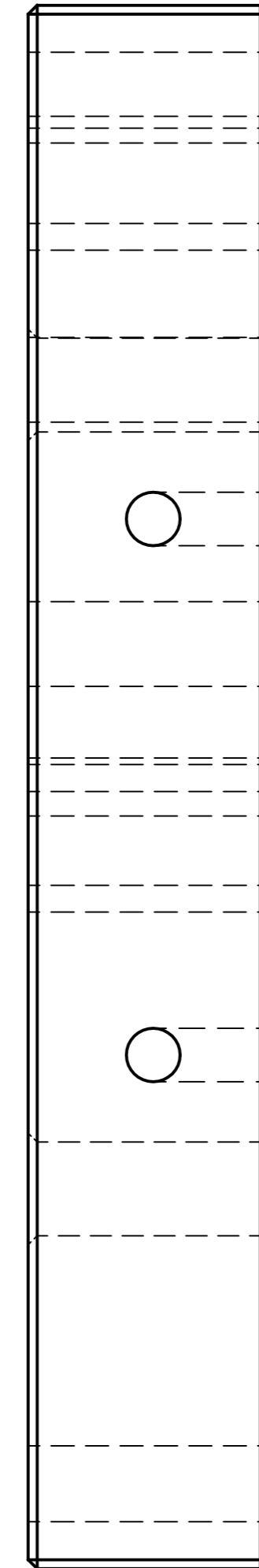
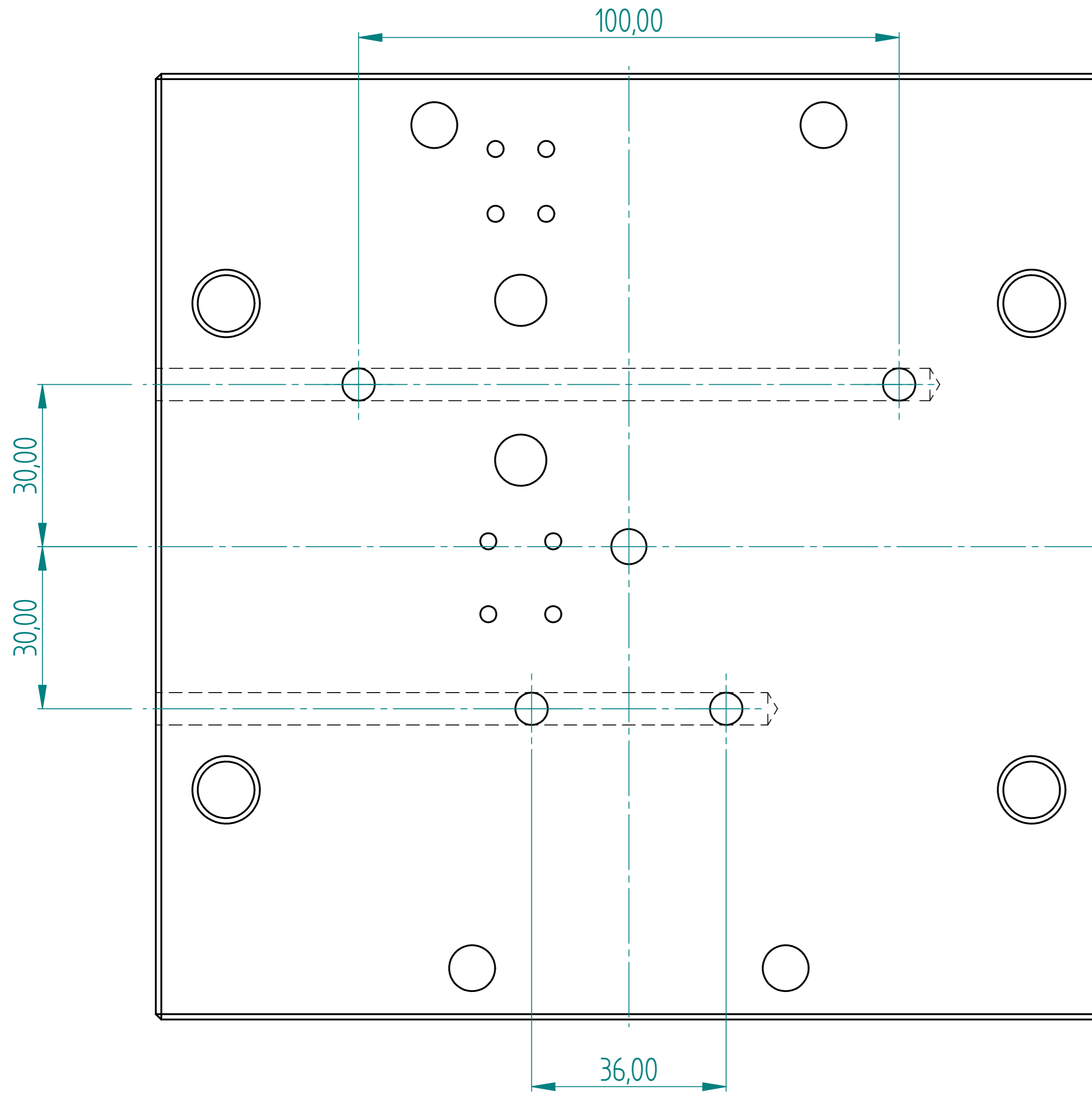
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



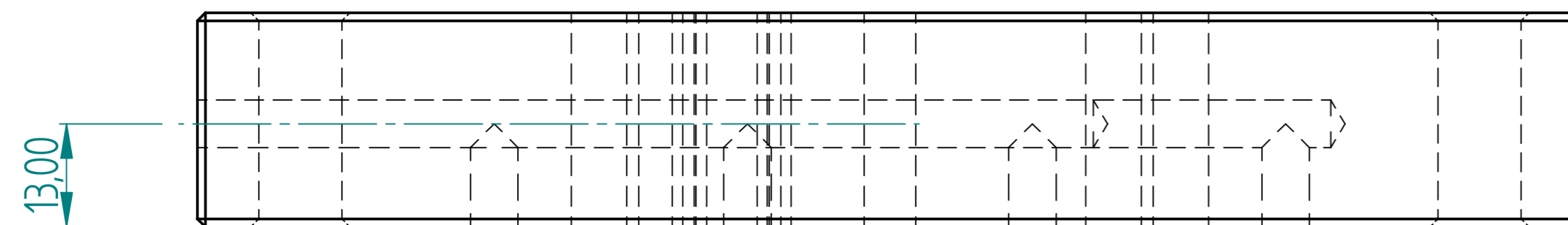
MOVING DIE PLATE WATER

DRAWN	NAME	DATE	PREMAC	
APPROVED	Dan	10/23/10		
MATERIAL			TITLE	
TREATMENT			Magnastart Mould	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
1 st ANGLE			A4	
ANGLES ±0.1°			FILE NAME: Magnastart Mould.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:
			SHEET 16 OF 19	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

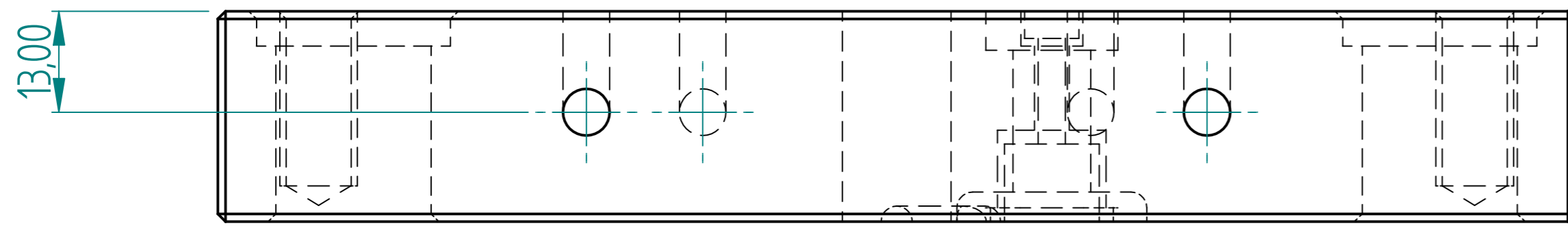
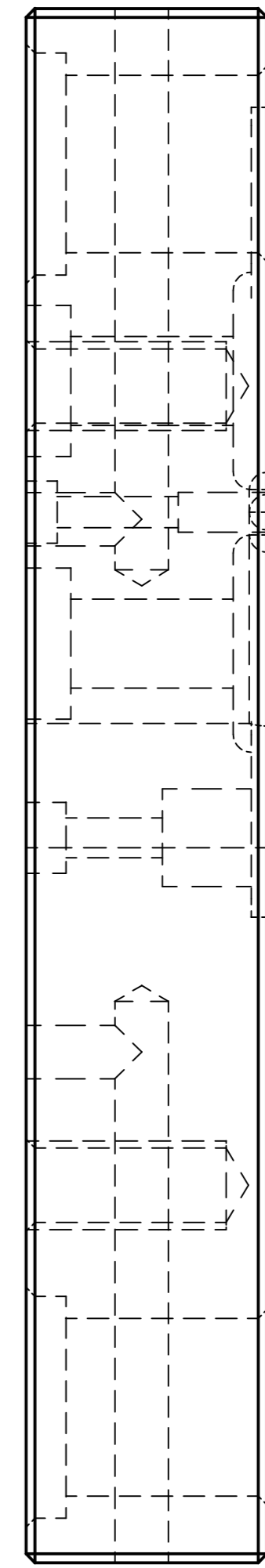
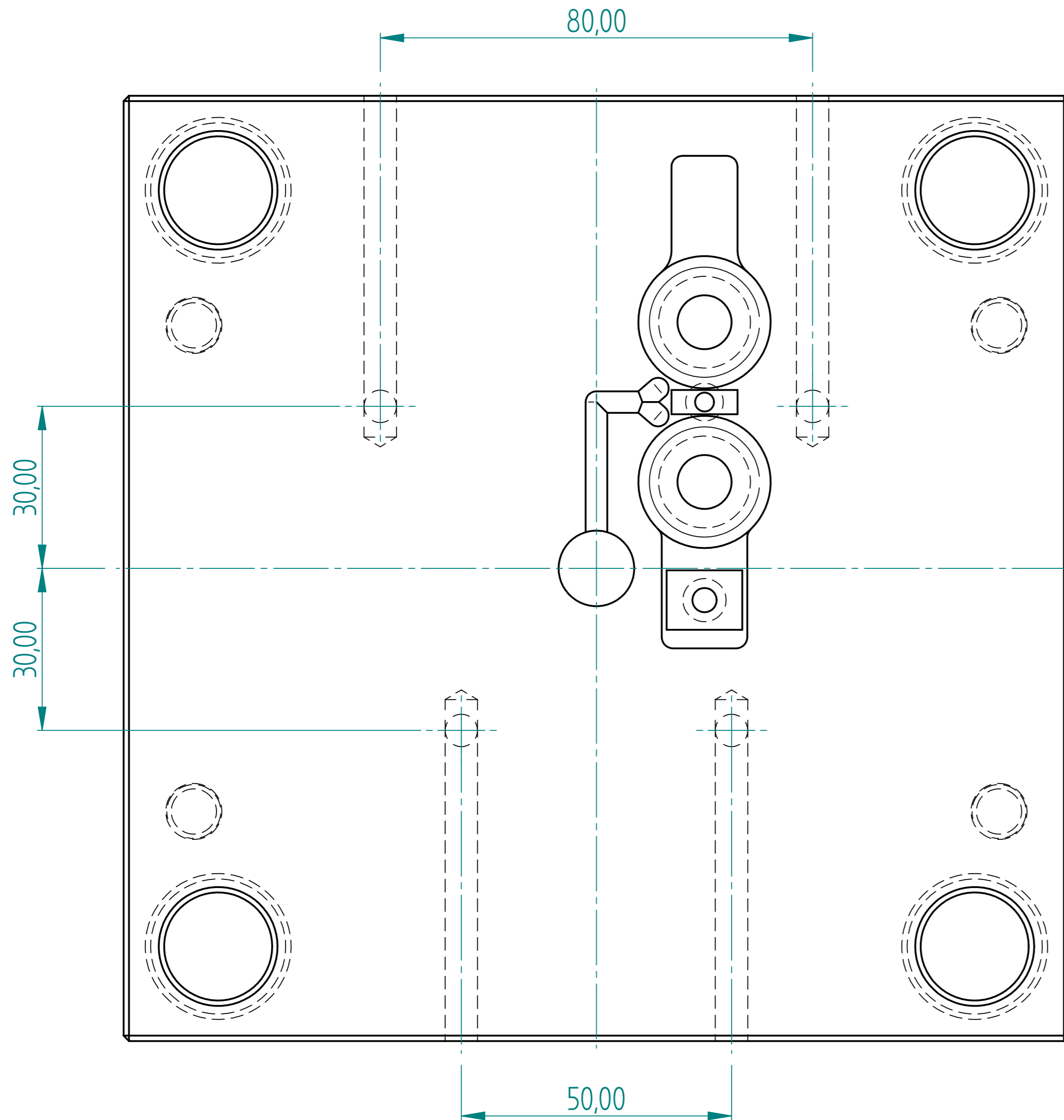


SUPPORT PLATE WATER



DRAWN	NAME	DATE	PREMAC			
APPROVED	Dan	10/23/10				
MATERIAL					TITLE	Magnastart Mould
TREATMENT					SIZE	A4
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			DWG NO	REV		
1 st ANGLE ANGLES ±0.1°			FILE NAME: Magnastart Mould.dft			
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:		
			SHEET 17 OF 19			

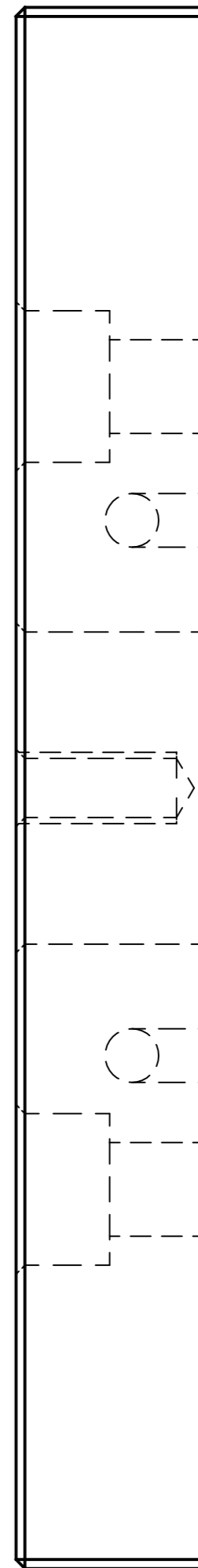
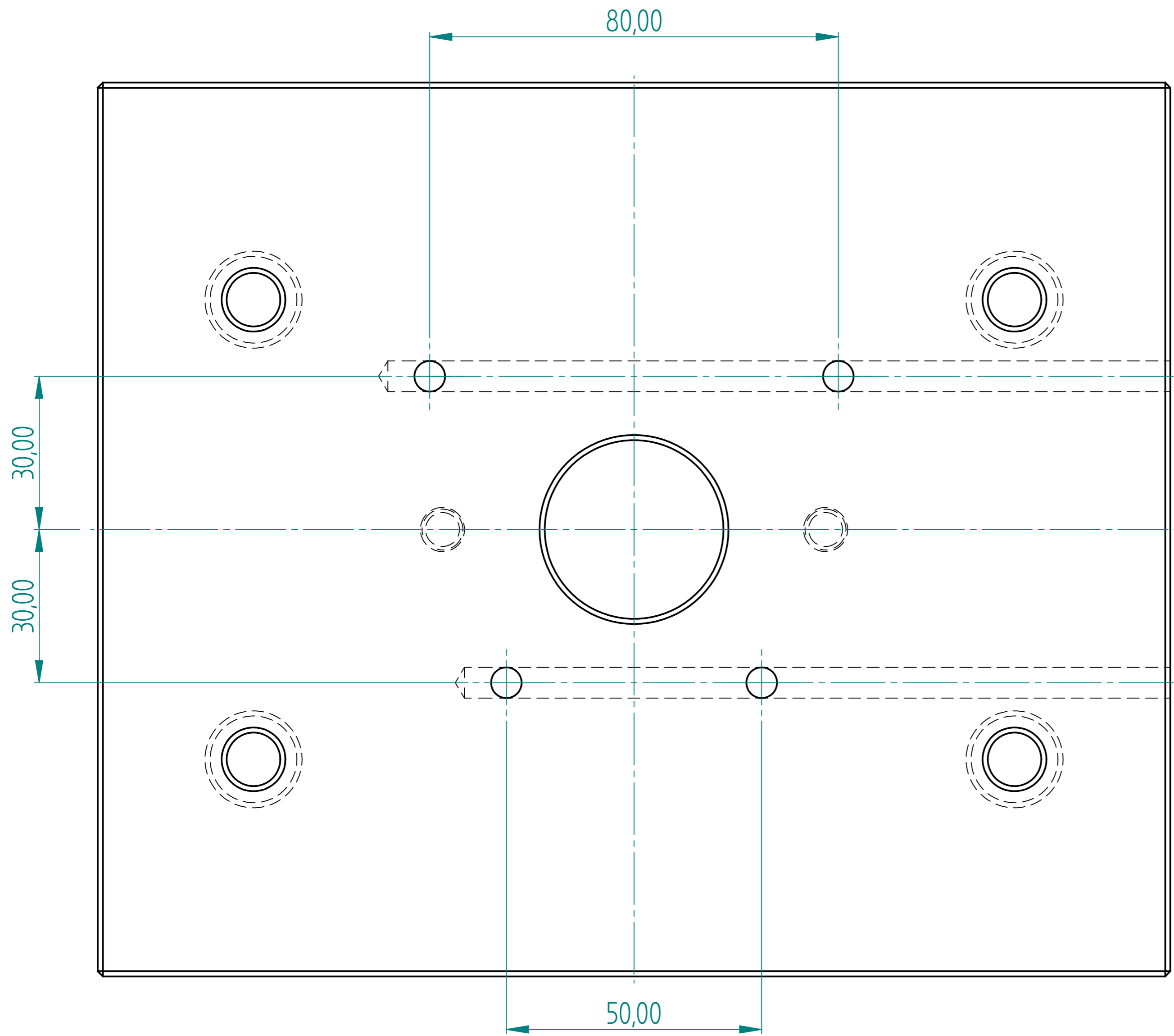
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



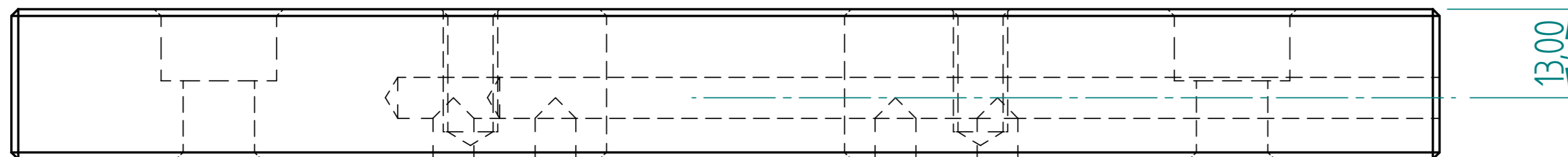
FH DIE PLATE WATER

DRAWN	NAME	DATE	PREMAC	
APPROVED	Dan	10/23/10		
MATERIAL			TITLE	
TREATMENT			Magnastart Mould	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
1 st ANGLE			A4	REV
ANGLES ±0.1°			FILE NAME: Magnastart Mould.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:
			SHEET 18 OF 19	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



FH CLAMPING PLATE



DRAWN	NAME	DATE	PREMAC	
APPROVED	Dan	10/23/10		
MATERIAL			TITLE Magnastart Mould	
TREATMENT			SIZE A4	DWG NO
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: Magnastart Mould.dft	REV
1 st ANGLE ANGLES ±0,1°			SCALE:	WEIGHT:
2 PL ±0,02 3 PL ±0,005			SHEET 19 OF 19	