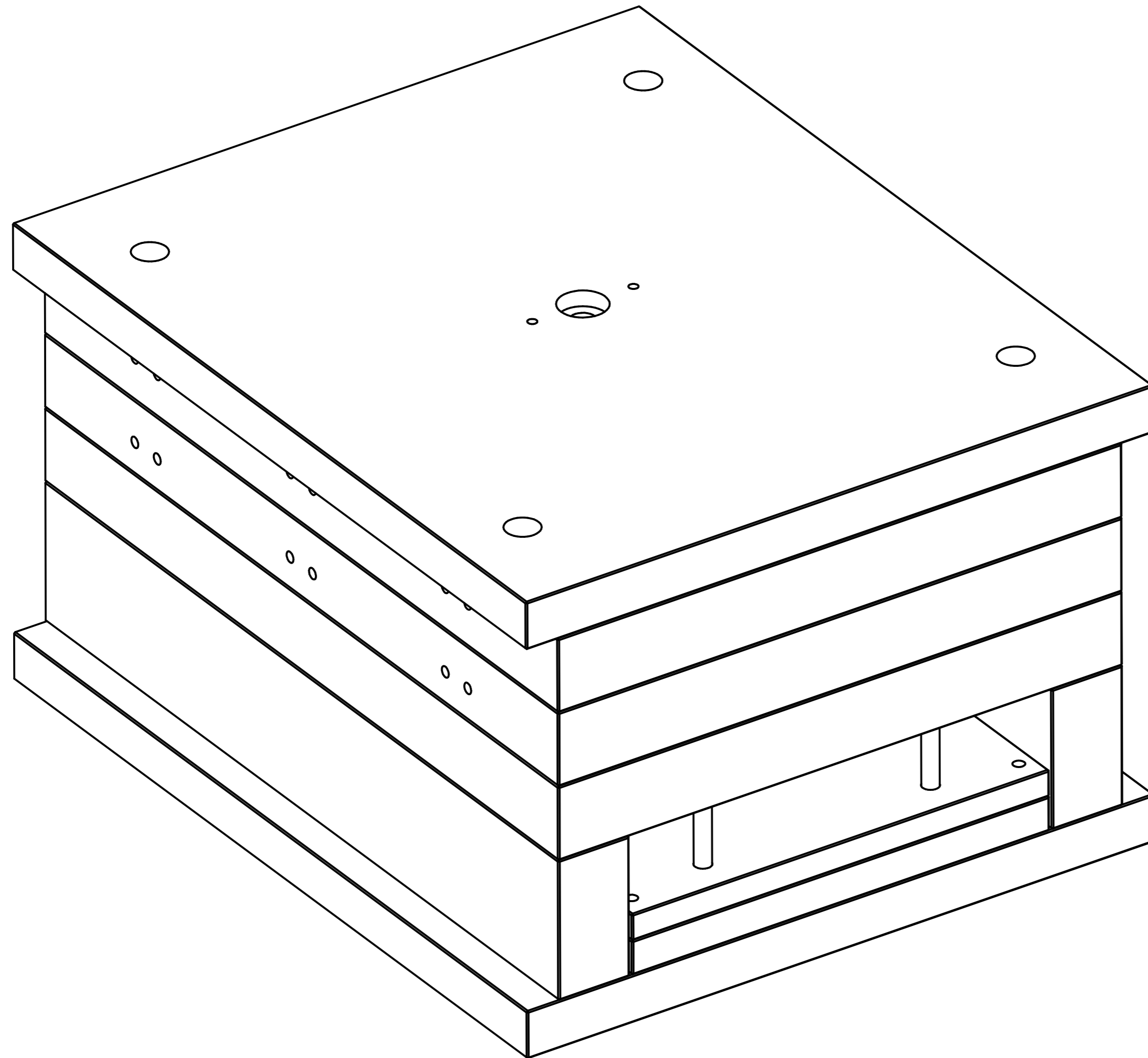


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

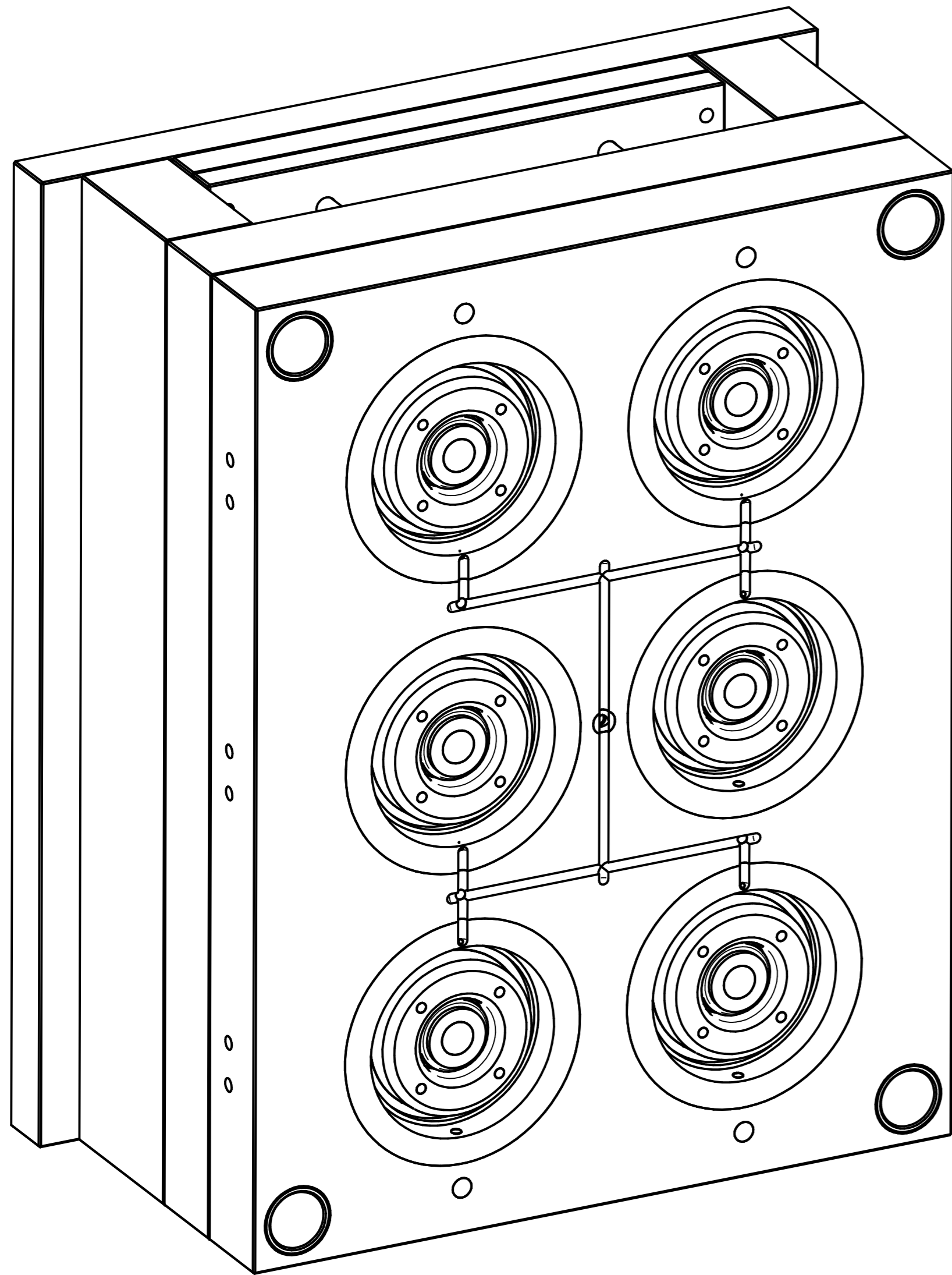


Item Number	Document Number	Title	Quantity
1	330 x 596 x 20	Ejector Plate	1
2	330 x 596 x 26	Ejector Clamping Plate	1
3	446 x 596 x 56	FH Die Plate	1
4	446 x 596 x 56	MH Die Plate	1
5	446 x 596 x 56	Support Plate	1
6	496 x 596 x 36	Fixed Clamping Plate	1
7	496 x 596 x 36	Moving Clamping Plate	1
8	56 x 596 x 106	Riser	2
9	B3-24 x 51	Sprue Bush	1
10	Dia 108 - 54	FH Mid Insert	6
11	Dia 108 -54	MH Mid Insert	6
12	Dia 12 - 200	Ejector Pin	4
13	Dia 160 - 56	FH Insert	4
14	Dia 160 - 56	FH Insert	2
15	Dia 160 - 56	MH Insert	4
16	Dia 160 - 56	MH Insert	2
17	Dia 17 -50	Square Spring	6
18	Dia 20 -200	Ejector Pin	6
19	Dia 20 x 27.1	Sprue Puller Bush	1
20	Dia 6 - 100	Vent Pin	12
21	Dia 6 - 200	Ejector Pin	1
22	Dia 6 - 200	Ejector Pin	4
23	Dia 6 - 200 B	Ejector Pin B	24
24	Dia 63 - 49	MH Inner Insert	6
25	Dia 65 - 63	FH Inner Insert	6
26	FBN34-56	Locating Bush	4
27	FSN34-56-56	Locating Pin	4

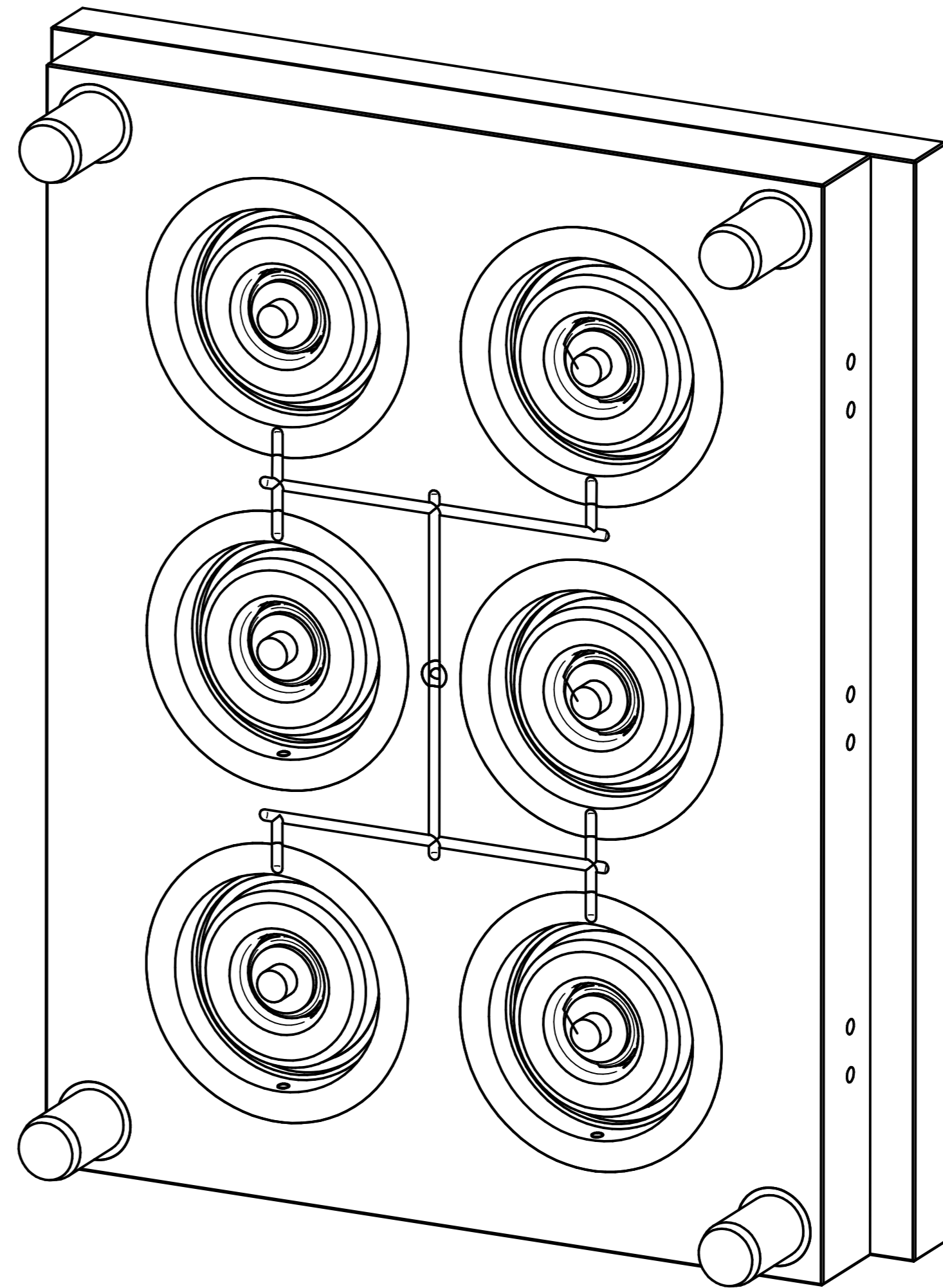
PJR 125X40H60 Wheel Inner Mould  
 4560 MOULD BASE 106 RISER  
 6 CAVITY MOULD

	NAME	DATE	<b>PREMAC</b>	
DRAWN	Dan	02/14/12		
APPROVED			TITLE Wheel Inner Mould	
MATERIAL				
TREATMENT			SIZE A4	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS				
1 <sup>st</sup> ANGLE ANGLES ±0.1°			PJR 125x40H60	
2 PL ±0.02 3 PL ±0.005			FILE NAME: Wheel Inner Mould.dft	
			SCALE:	WEIGHT:
			SHEET 1 OF 9	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



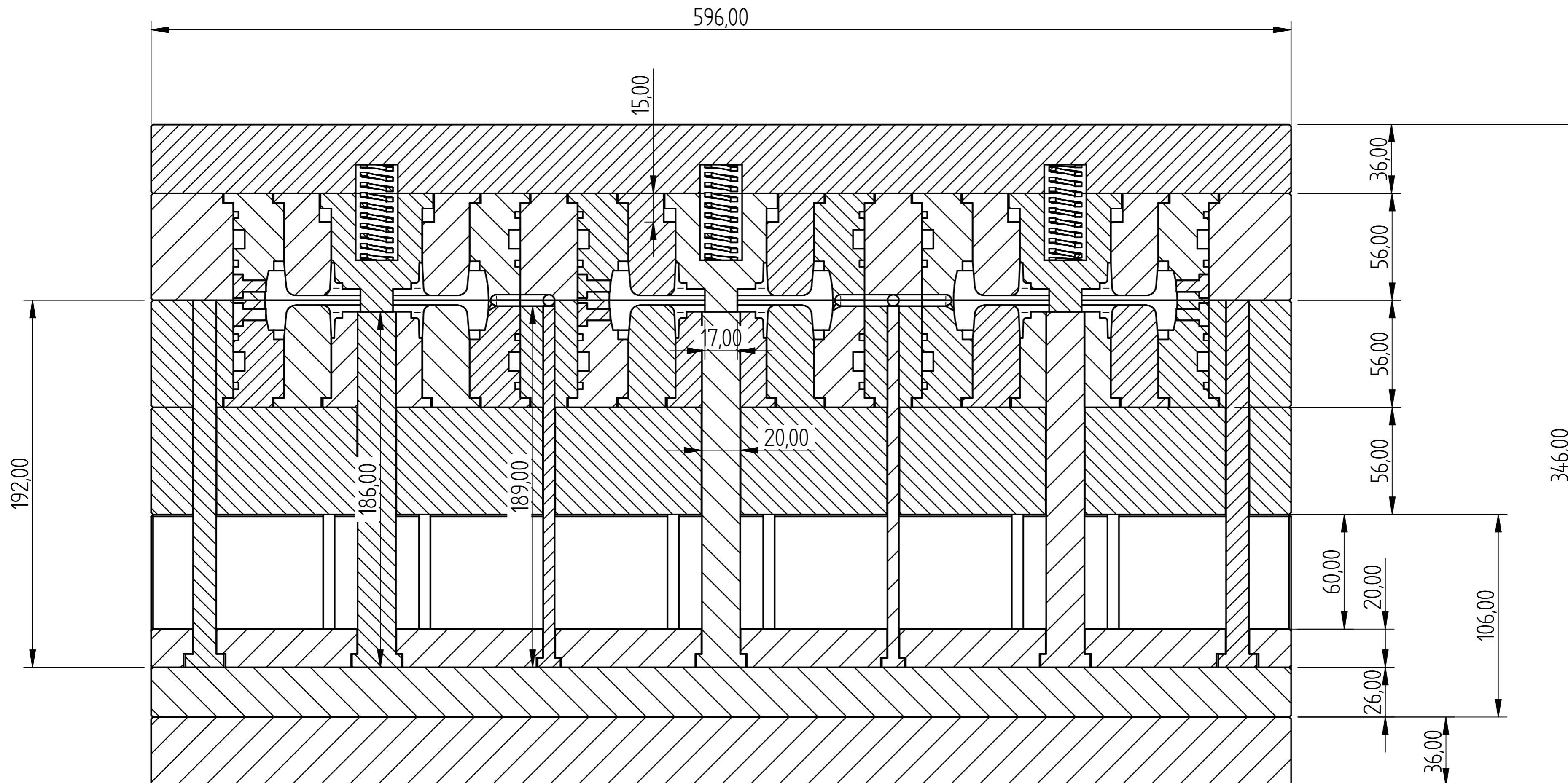
Moving Half



Fixed Half

	NAME	DATE	<b>PREMAC</b>	
DRAWN	Dan	02/14/12		
APPROVED				
MATERIAL				
TREATMENT			TITLE	Wheel Inner Mould
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
1 <sup>st</sup> ANGLE			A4	PJR 125x40H60
2 PL ±0.02 3 PL ±0.005			FILE NAME:	Wheel Inner Mould.dft
			SCALE:	WEIGHT:
			SHEET 2 OF 9	

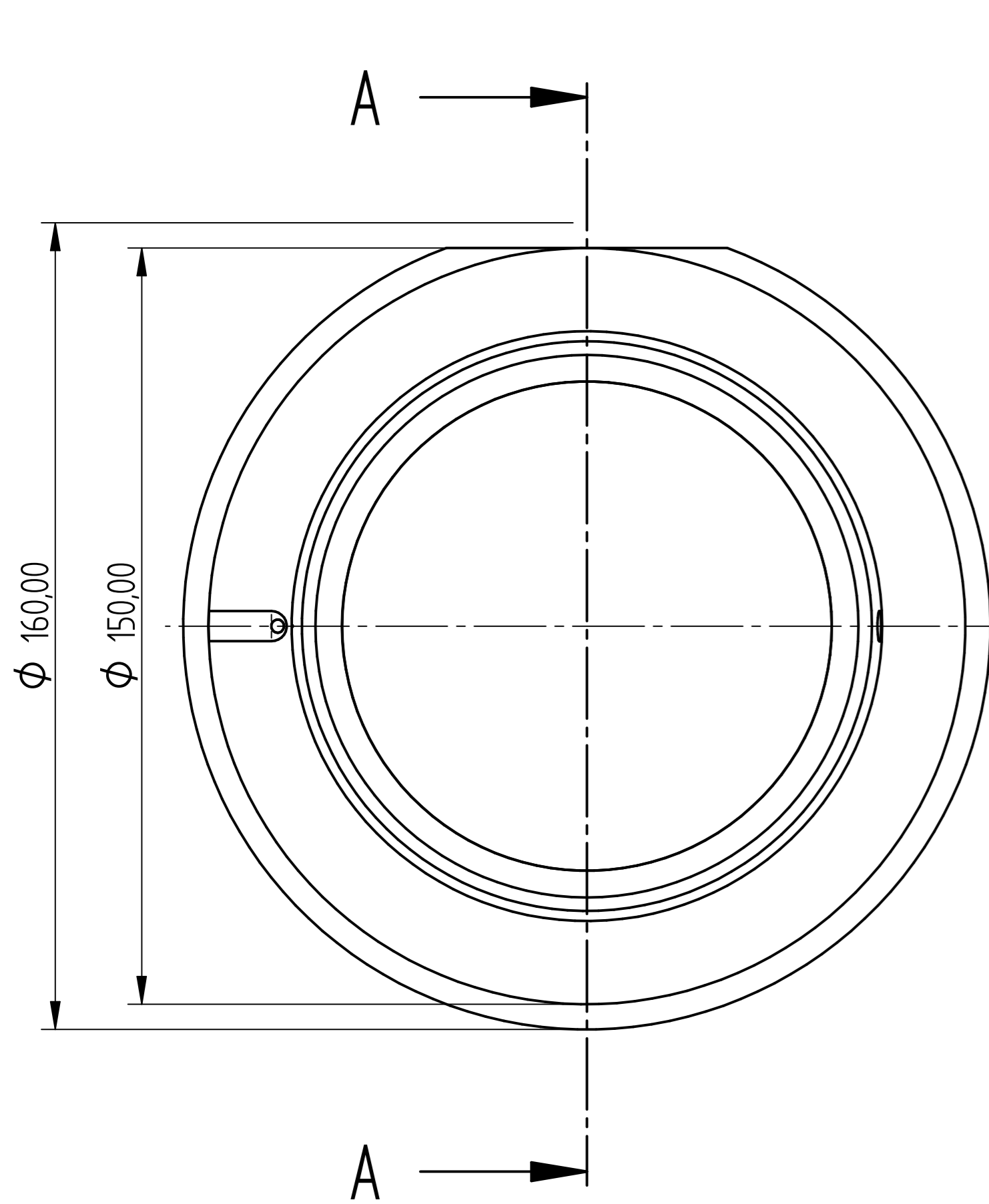
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



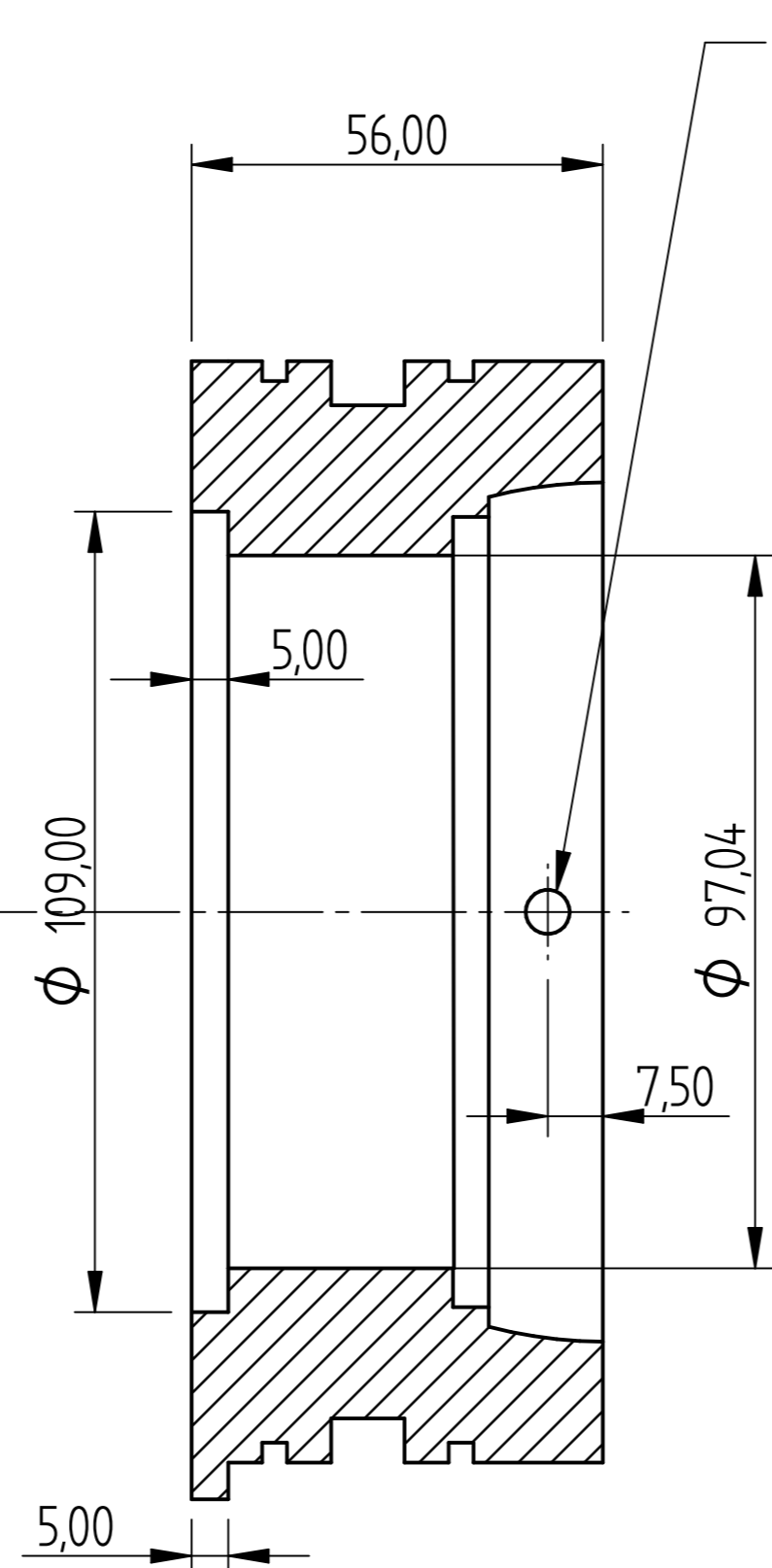
## PJR 125X40H60 Wheel Inner Mould

	NAME	DATE	<b>PREMAC</b>		
DRAWN	Dan	02/14/12			
APPROVED			TITLE Wheel Inner Mould		
MATERIAL					
TREATMENT			SIZE A4	DWG NO PJR 125x40H60	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS ANGLES ±0.1° 1st ANGLE			FILE NAME: Wheel Inner Mould.dft		
			SCALE:	WEIGHT:	SHEET 3 OF 9

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

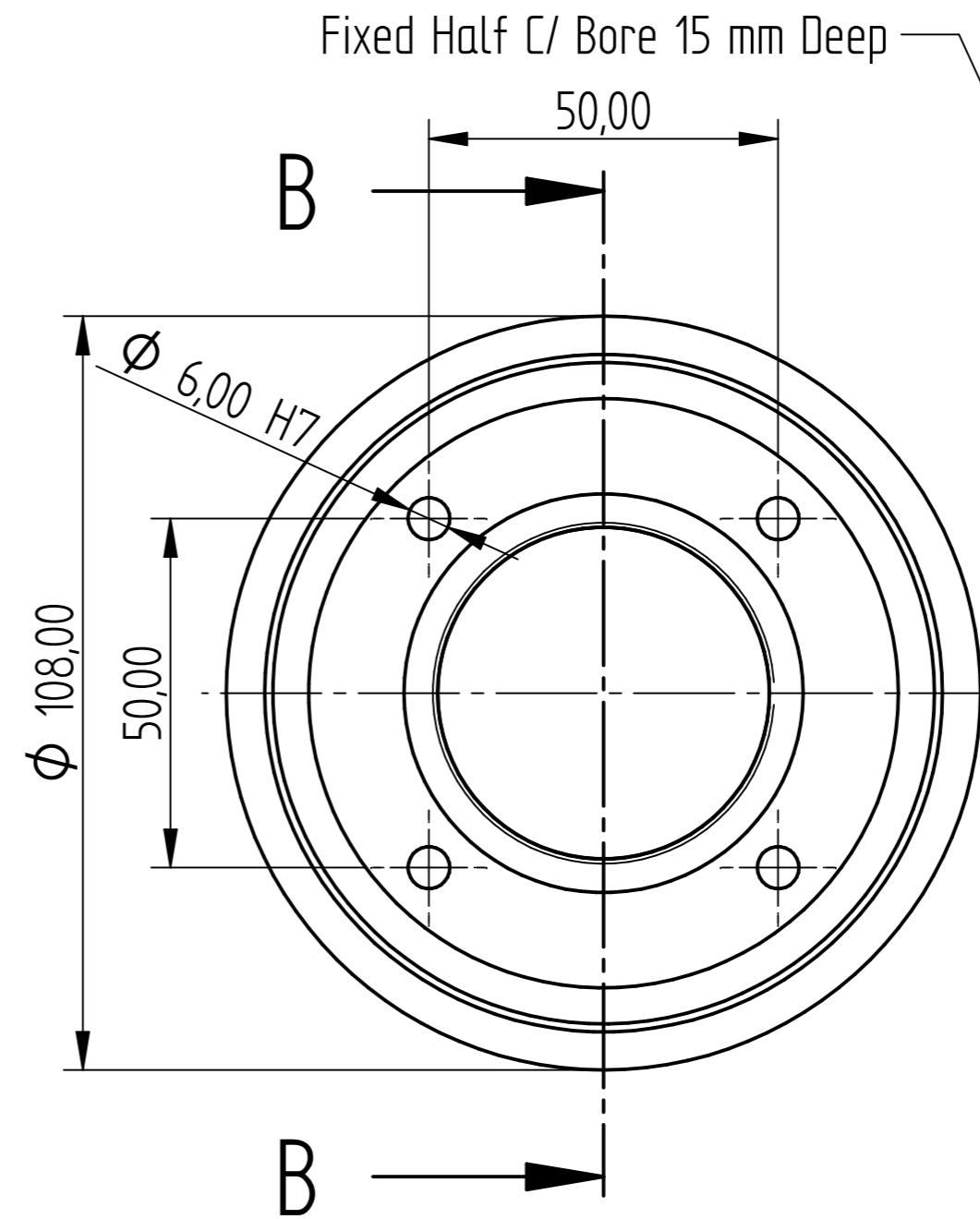


MH Insert 12 OF  
Each Dia 160 X 81 12 of



SECTION A-A

$\phi$  6,00  
C'BORE  $\phi$  12,50 - 5,00 DEEP



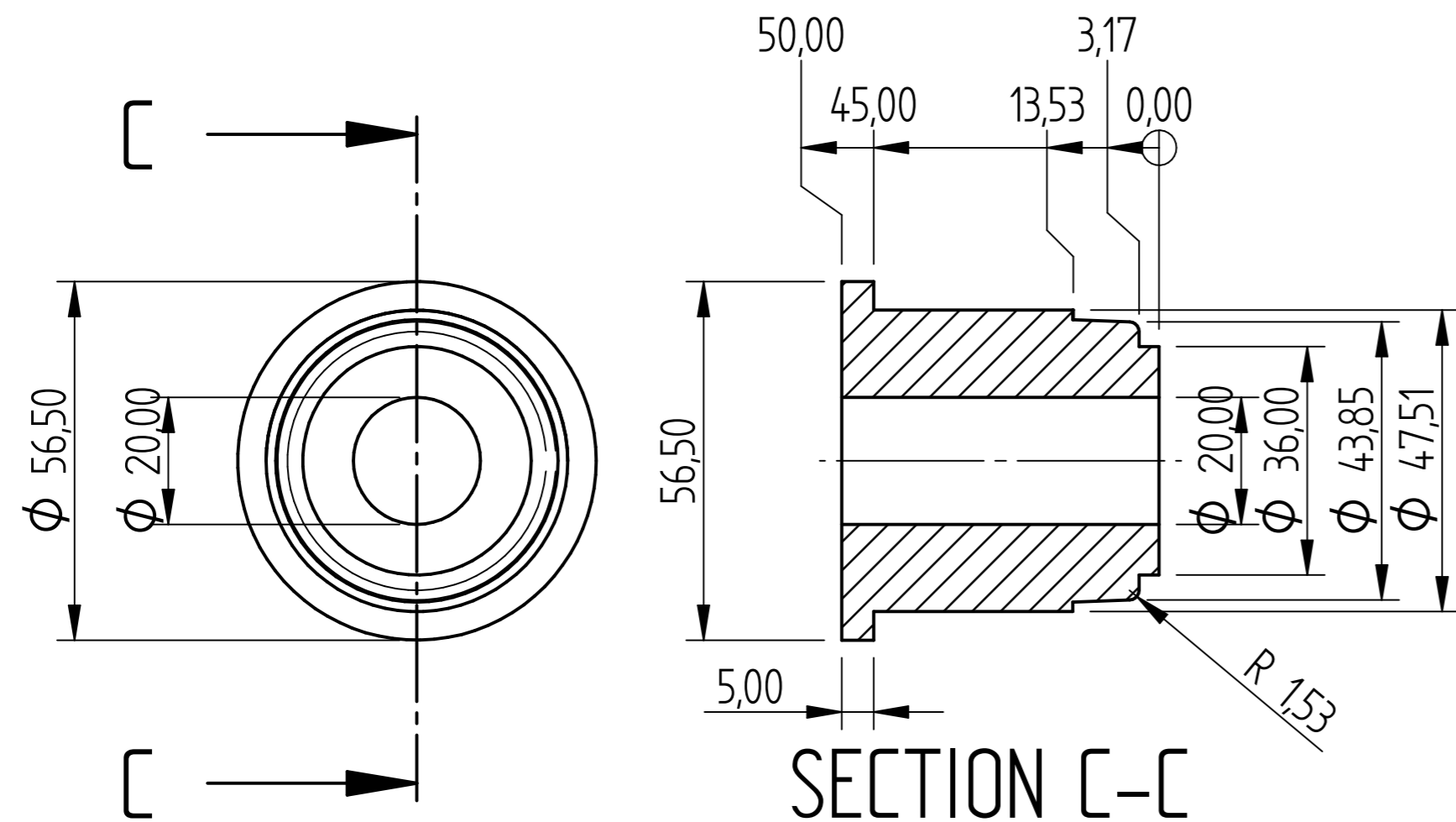
MH Mid Insert

SECTION B-B

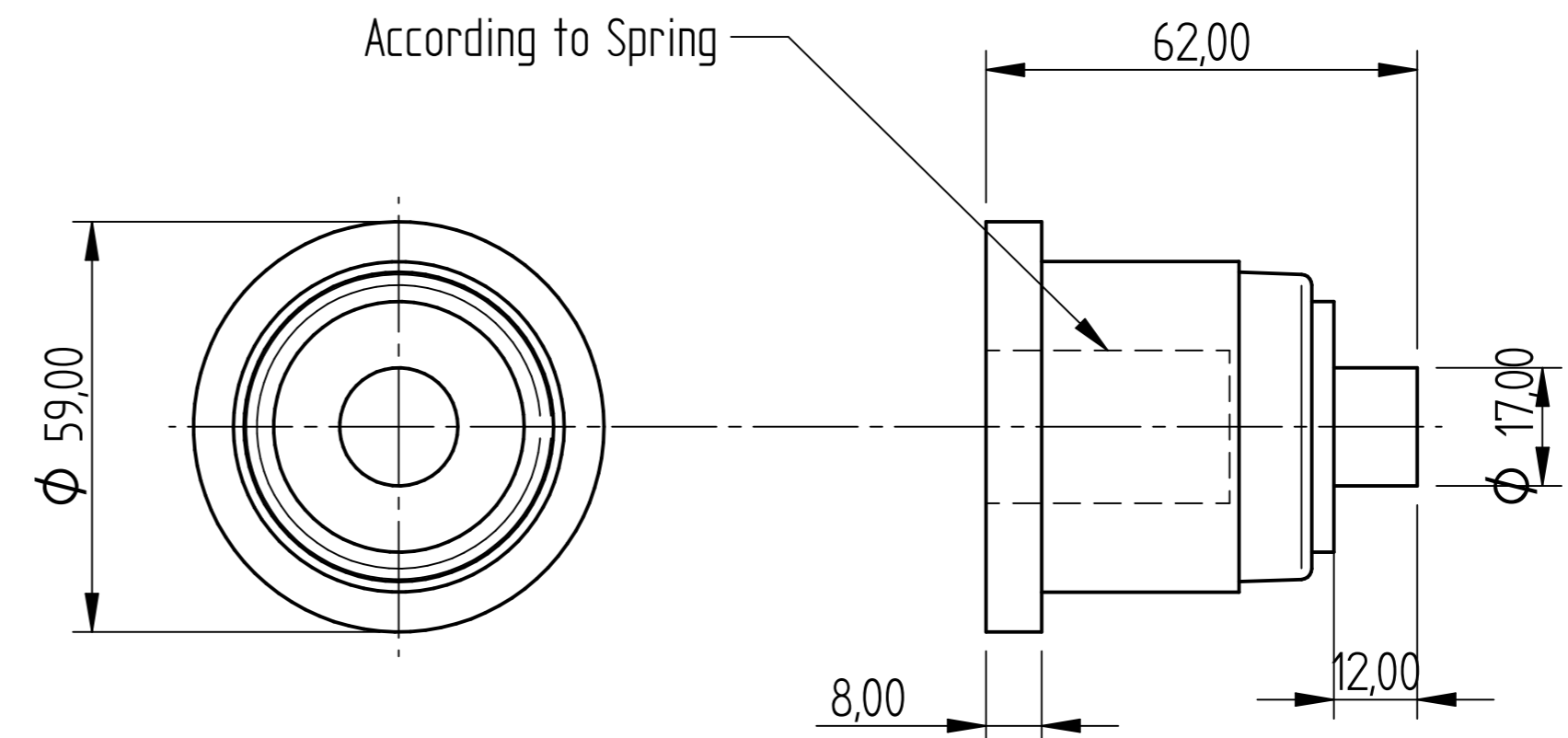
Fixed Half no Ejector Holes  
Each Dia 108 X 83 12 of

	NAME	DATE	<b>PREMAC</b>		
DRAWN	Dan	02/14/12			
APPROVED			TITLE Wheel Inner Mould		
MATERIAL					
TREATMENT			SIZE A4	DWG NO PJR 125x40H60	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: Wheel Inner Mould.dft		
1 <sup>st</sup> ANGLE ANGLES $\pm 0.1^\circ$			SCALE:	WEIGHT:	SHEET 4 OF 9
2 PL $\pm 0.02$ 3 PL $\pm 0.005$					

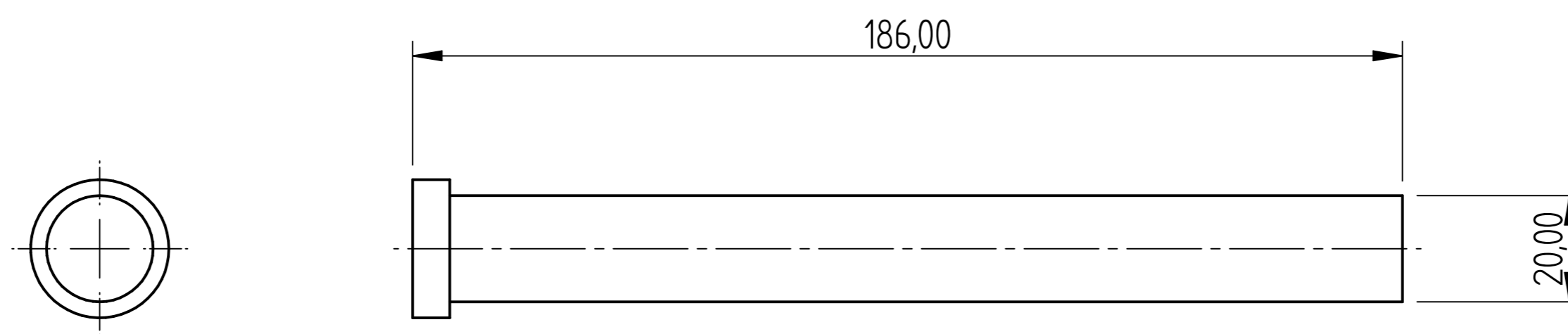
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



MH Inner Insert 6 OF  
Each Dia 63 X 80 6 of



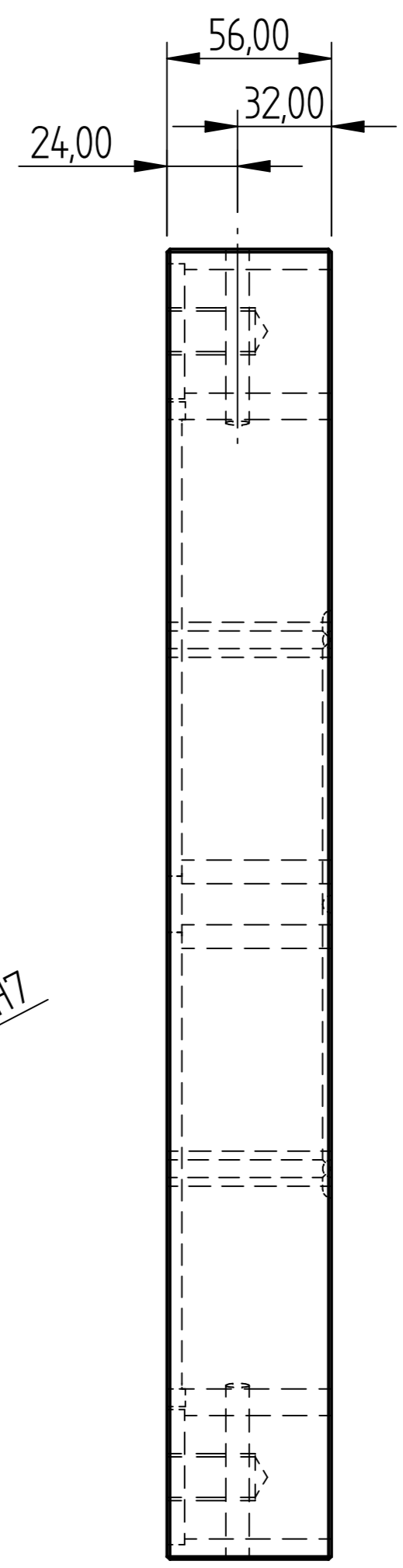
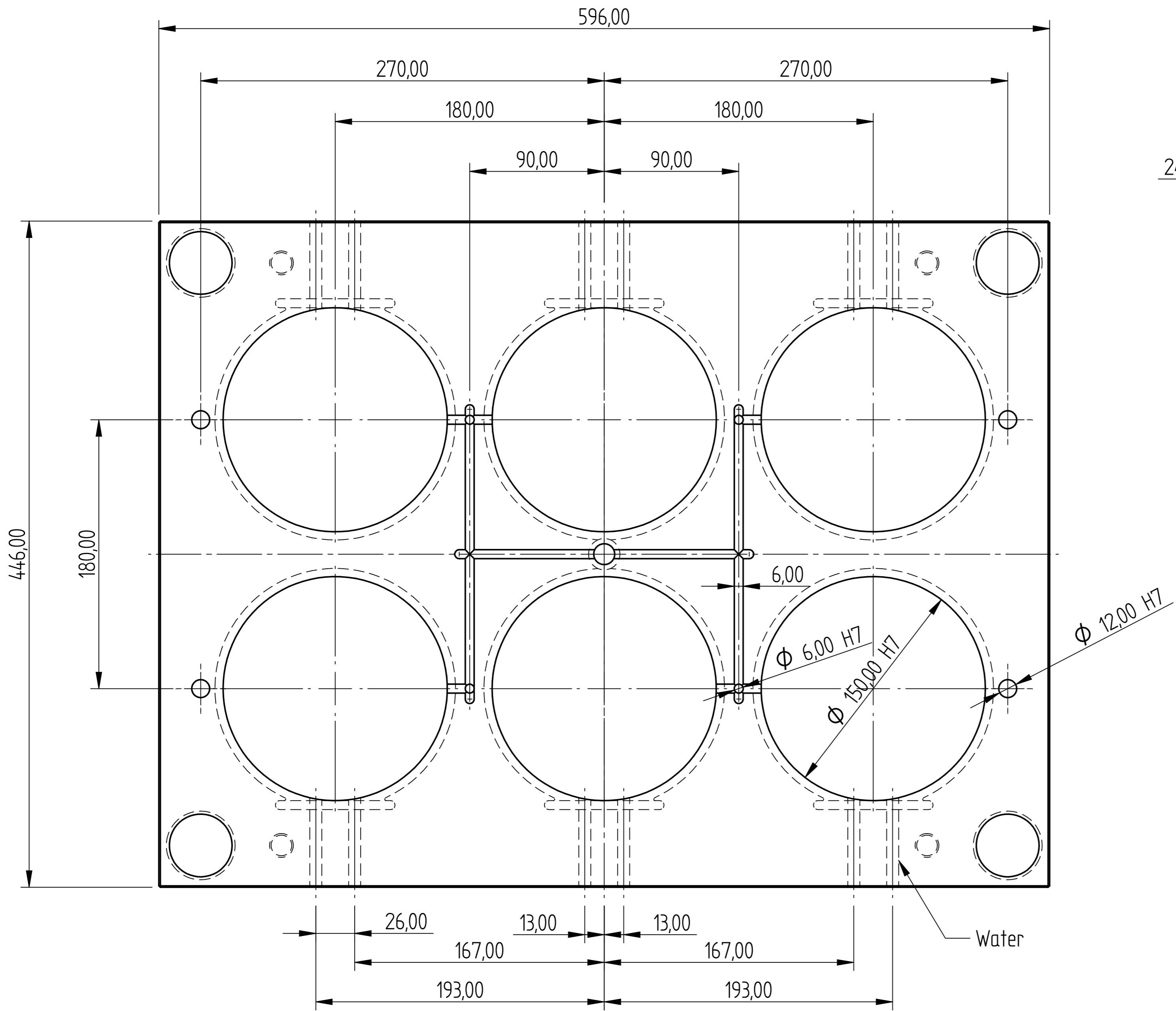
FH Inner Insert 6 OF  
Each Dia 65 X 93 6 of



Dia 20 -200

	NAME	DATE	<b>PREMAC</b>		
DRAWN	Dan	02/14/12			
APPROVED			TITLE Wheel Inner Mould		
MATERIAL					
TREATMENT			SIZE A4	DWG NO PJR 125x40H60	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: Wheel Inner Mould.dft		
1 <sup>st</sup> ANGLE 2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:	SHEET 5 OF 9

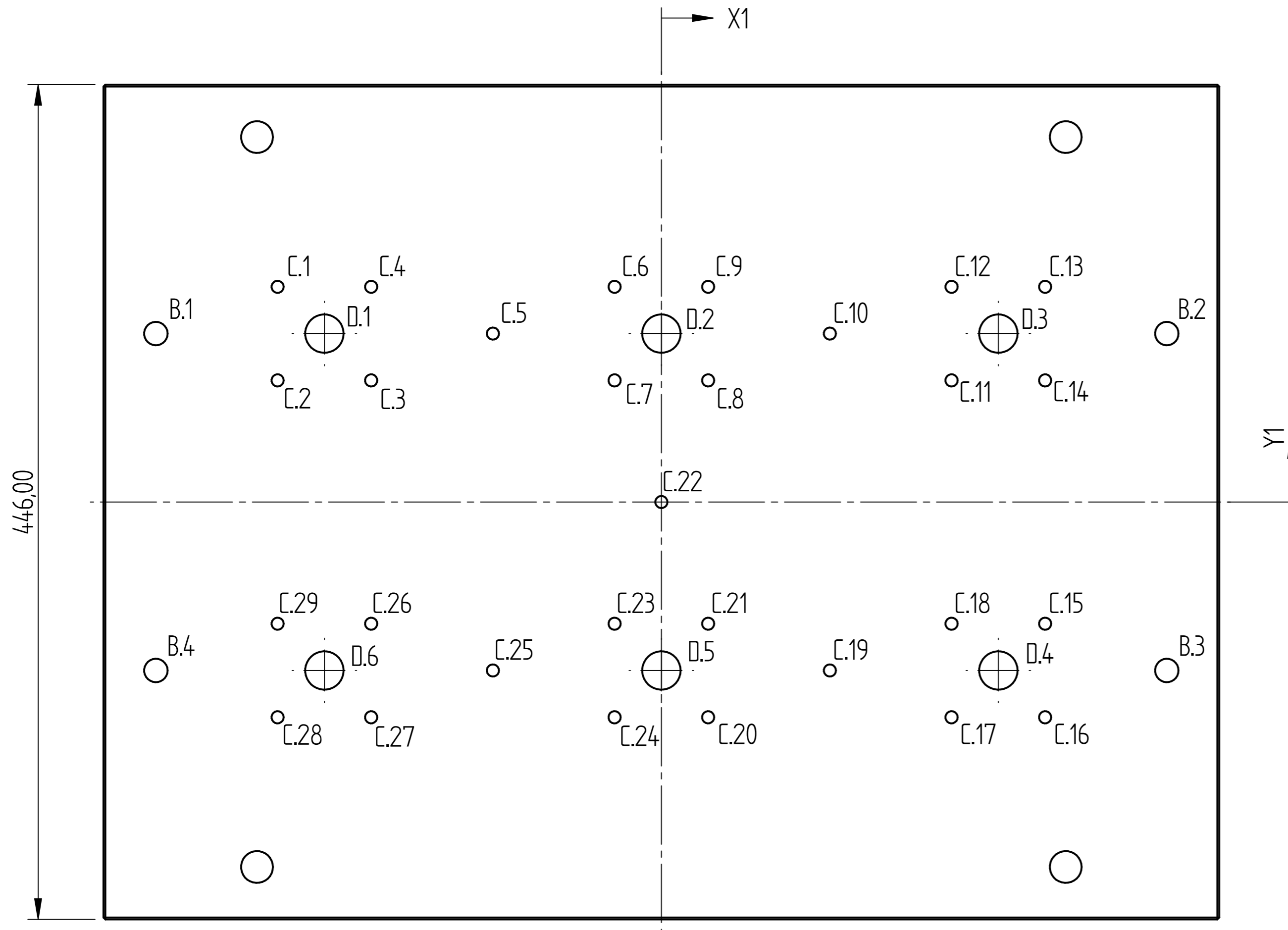
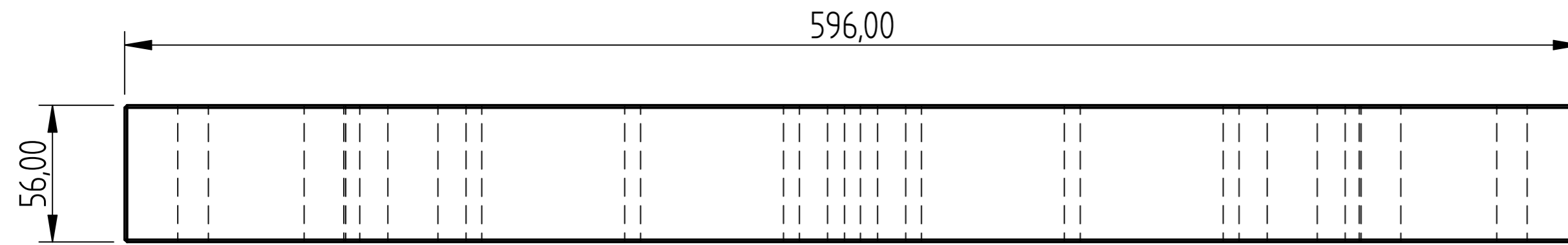
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



MH Die Plate  
 Fixed Half no Push Back or Ejector Holes  
 & Runner Mirrored

DRAWN	NAME	DATE	<b>PREMAC</b>	
APPROVED	Dan	02/14/12	TITLE	
MATERIAL			Wheel Inner Mould	
TREATMENT			SIZE	DWG NO
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			A4	PJR 125x40H60
1st ANGLE			SCALE:	WEIGHT:
2 PL ±0.02 3 PL ±0.005			FILE NAME: Wheel Inner Mould.dft	REV
			SHEET 6 OF 9	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

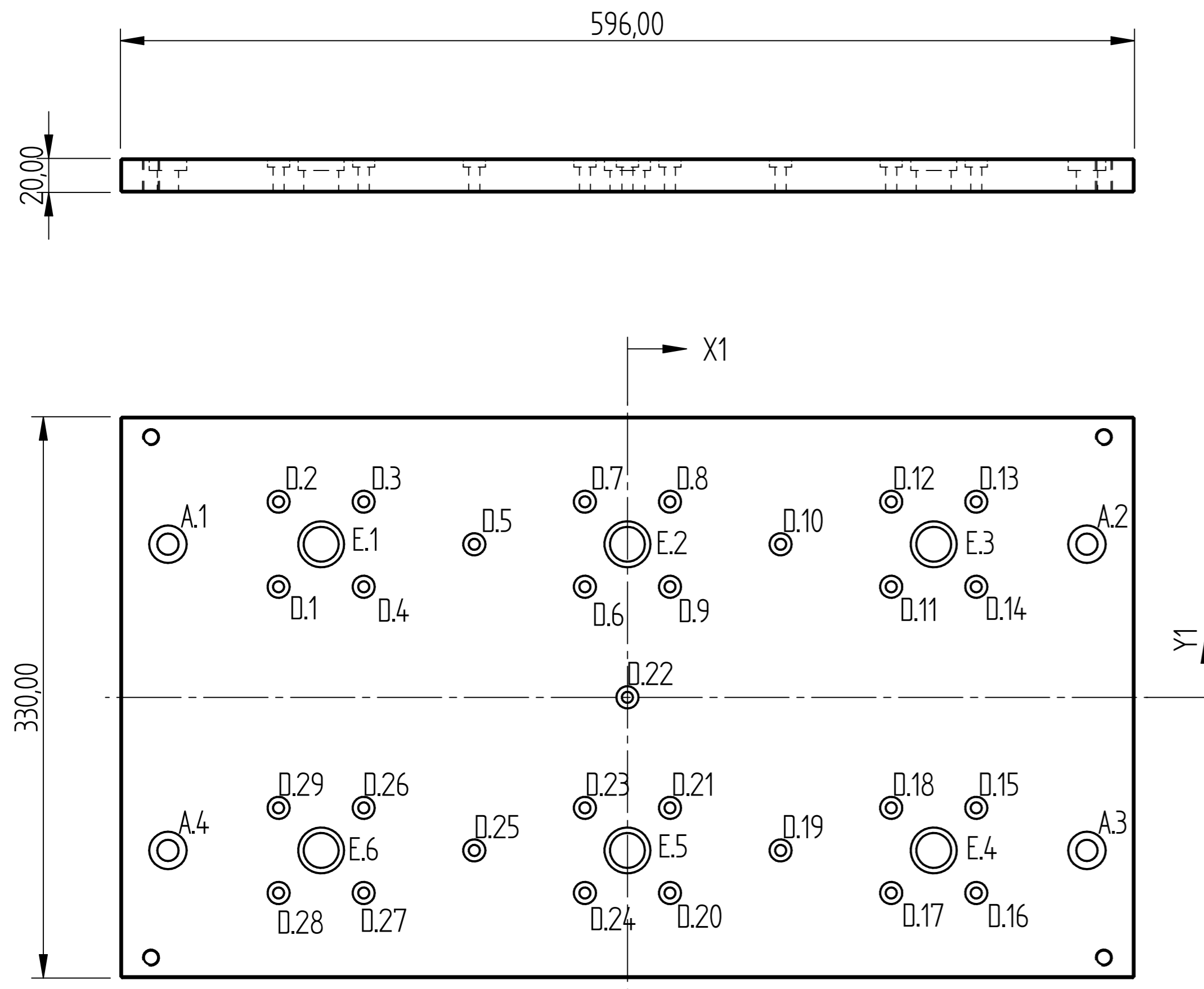


Hole Table				Hole Table			
Hole	X	Y	Size	Hole	X	Y	Size
B.1	-270,00	90,00	φ 12,50	C.17	155,00	-115,00	φ 6,50
B.2	270,00	90,00	φ 12,50	C.18	155,00	-65,00	φ 6,50
B.3	-270,00	-90,00	φ 12,50	C.19	90,00	-90,00	φ 6,50
B.4	270,00	-90,00	φ 12,50	C.20	25,00	-115,00	φ 6,50
C.1	-205,00	115,00	φ 6,50	C.21	25,00	-65,00	φ 6,50
C.2	-155,00	65,00	φ 6,50	C.22	0,00	0,00	φ 6,50
C.3	-90,00	90,00	φ 6,50	C.23	-25,00	-65,00	φ 6,50
C.4	-25,00	115,00	φ 6,50	C.24	-25,00	-115,00	φ 6,50
C.5	-25,00	65,00	φ 6,50	C.25	-90,00	-90,00	φ 6,50
C.6	25,00	115,00	φ 6,50	C.26	-155,00	-65,00	φ 6,50
C.7	90,00	90,00	φ 6,50	C.27	-155,00	-115,00	φ 6,50
C.8	155,00	65,00	φ 6,50	C.28	-205,00	-115,00	φ 6,50
C.9	205,00	115,00	φ 6,50	C.29	-205,00	-65,00	φ 6,50
C.10	205,00	65,00	φ 6,50	D.1	-180,00	90,00	φ 20,50
C.11	205,00	-65,00	φ 6,50	D.2	0,00	90,00	φ 20,50
C.12	205,00	-115,00	φ 6,50	D.3	180,00	90,00	φ 20,50
C.13	205,00	-115,00	φ 6,50	D.4	180,00	-90,00	φ 20,50
C.14	205,00	-65,00	φ 6,50	D.5	0,00	-90,00	φ 20,50
C.15	205,00	-115,00	φ 6,50	D.6	-180,00	-90,00	φ 20,50

# Support Plate

DRAWN	NAME	DATE	<b>PREMAC</b>		
APPROVED	Dan	02/14/12			
MATERIAL					
TREATMENT					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO	REV
1 <sup>st</sup> ANGLE			A4	PJR 125x40H60	
2 PL ±0.02 3 PL ±0.005			FILE NAME: Wheel Inner Mould.dft		
			SCALE:	WEIGHT:	SHEET 7 OF 9

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

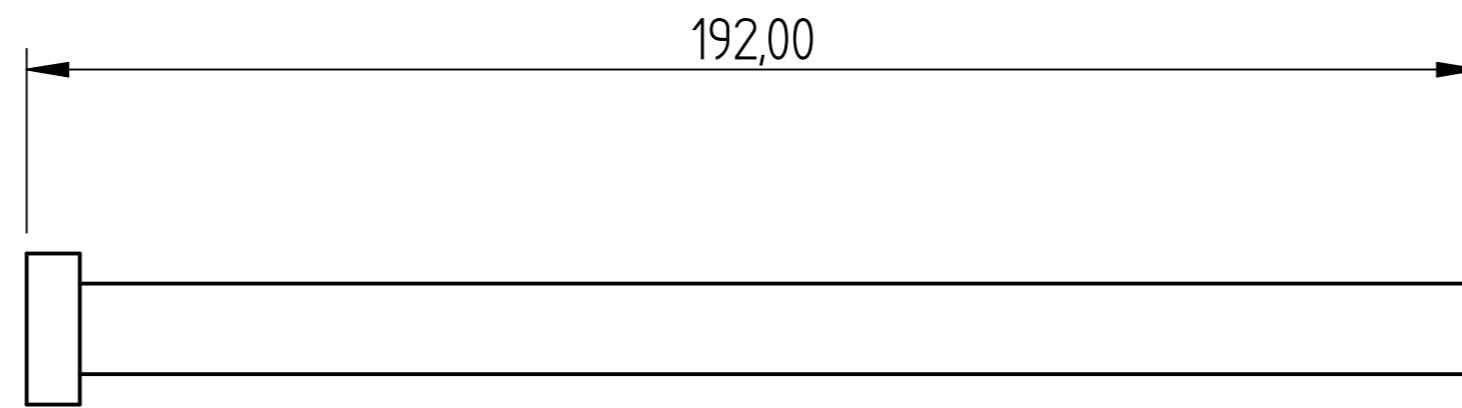
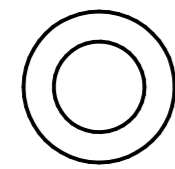


Ejector Plate

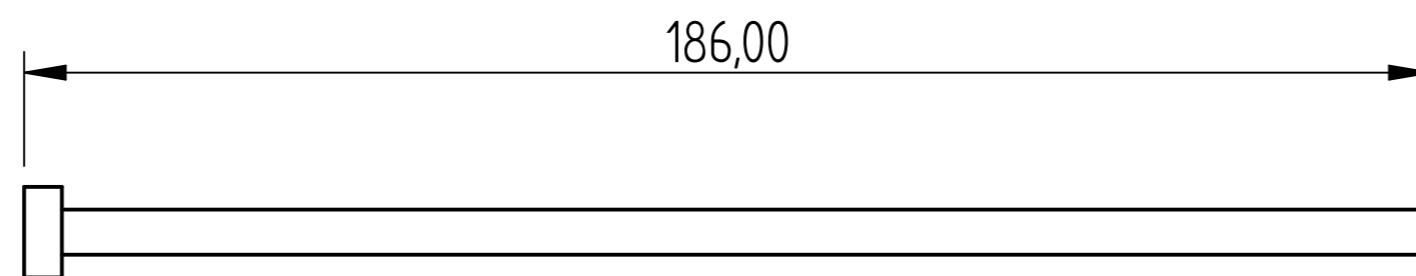
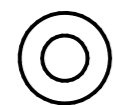
Hole Table					Hole Table				
Hole	X	Y	Size	Ɔ / Bore	Hole	X	Y	Size	Ɔ / Bore
A.1	-270,00	90,00	φ 12,50	φ22,00-7,05	D.17	155,00	-115,00	φ 6,50	φ13,00-5,05
A.2	270,00	90,00	φ 12,50	φ22,00-7,05	D.18	155,00	-65,00	φ 6,50	φ13,00-5,05
A.3	270,00	-90,00	φ 12,50	φ22,00-7,05	D.19	90,00	-90,00	φ 6,50	φ13,00-5,05
A.4	-270,00	-90,00	φ 12,50	φ22,00-7,05	D.20	25,00	-115,00	φ 6,50	φ13,00-5,05
D.1	-205,00	65,00	φ 6,50	φ13,00-5,05	D.21	25,00	-65,00	φ 6,50	φ13,00-5,05
D.2	-205,00	115,00	φ 6,50	φ13,00-5,05	D.22	0,00	0,00	φ 6,50	φ13,00-5,05
D.3	-155,00	115,00	φ 6,50	φ13,00-5,05	D.23	-25,00	-65,00	φ 6,50	φ13,00-5,05
D.4	-155,00	65,00	φ 6,50	φ13,00-5,05	D.24	-25,00	-115,00	φ 6,50	φ13,00-5,05
D.5	-90,00	90,00	φ 6,50	φ13,00-5,05	D.25	-90,00	-90,00	φ 6,50	φ13,00-5,05
D.6	-25,00	65,00	φ 6,50	φ13,00-5,05	D.26	-155,00	-65,00	φ 6,50	φ13,00-5,05
D.7	-25,00	115,00	φ 6,50	φ13,00-5,05	D.27	-155,00	-115,00	φ 6,50	φ13,00-5,05
D.8	25,00	115,00	φ 6,50	φ13,00-5,05	D.28	-205,00	-115,00	φ 6,50	φ13,00-5,05
D.9	25,00	65,00	φ 6,50	φ13,00-5,05	D.29	-205,00	-65,00	φ 6,50	φ13,00-5,05
D.10	90,00	90,00	φ 6,50	φ13,00-5,05	E.1	-180,00	90,00	φ 20,50	φ27,00-7,05
D.11	155,00	65,00	φ 6,50	φ13,00-5,05	E.2	0,00	90,00	φ 20,50	φ27,00-7,05
D.12	155,00	115,00	φ 6,50	φ13,00-5,05	E.3	180,00	90,00	φ 20,50	φ27,00-7,05
D.13	205,00	115,00	φ 6,50	φ13,00-5,05	E.4	180,00	-90,00	φ 20,50	φ27,00-7,05
D.14	205,00	65,00	φ 6,50	φ13,00-5,05	E.5	0,00	-90,00	φ 20,50	φ27,00-7,05
D.15	205,00	-65,00	φ 6,50	φ13,00-5,05	E.6	-180,00	-90,00	φ 20,50	φ27,00-7,05
D.16	205,00	-115,00	φ 6,50	φ13,00-5,05					

DRAWN	NAME	DATE	<b>PREMAC</b>	
APPROVED	Dan	02/14/12		
MATERIAL				
TREATMENT				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
1 <sup>st</sup> ANGLE ANGLES ±0.1°			A4	PJR 125x40H60
2 PL ±0.02 3 PL ±0.005			FILE NAME: Wheel Inner Mould.dft	REV
			SCALE:	WEIGHT:
			SHEET 8 OF 9	

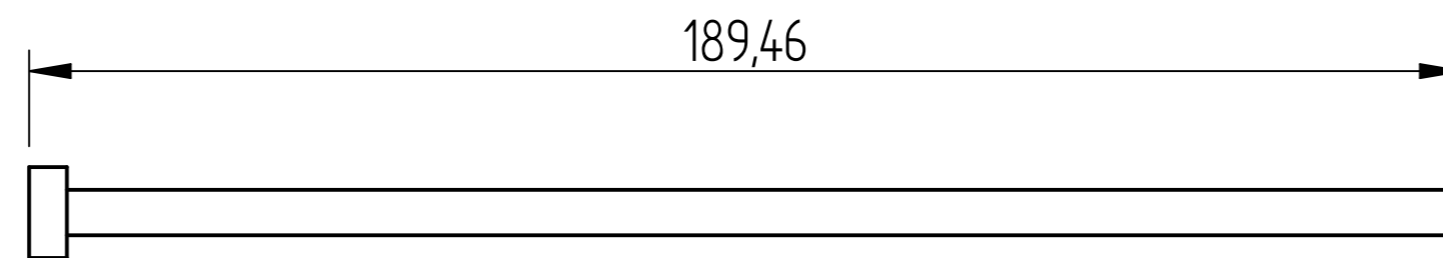
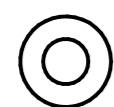
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



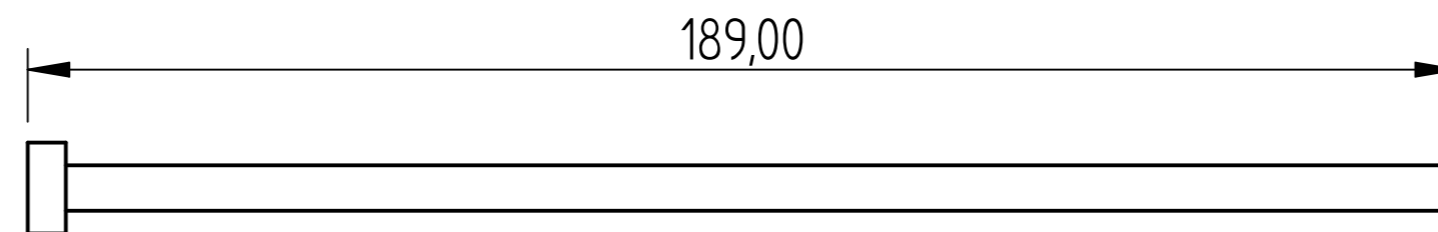
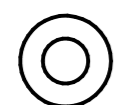
Dia 12 - 200 4 of



Dia 6 - 200 1 of



Dia 6 - 200 B 24 of



Dia 6 - 200 4 of

	NAME	DATE	<b>PREMAC</b>	
DRAWN	Dan	02/14/12		
APPROVED				
MATERIAL				
TREATMENT			TITLE Wheel Inner Mould	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO PJR 125x40H60
1 <sup>st</sup> ANGLE 2 PL ±0.02 3 PL ±0.005			FILE NAME: Wheel Inner Mould.dft	REV
			SCALE:	WEIGHT:
			SHEET 9 OF 9	