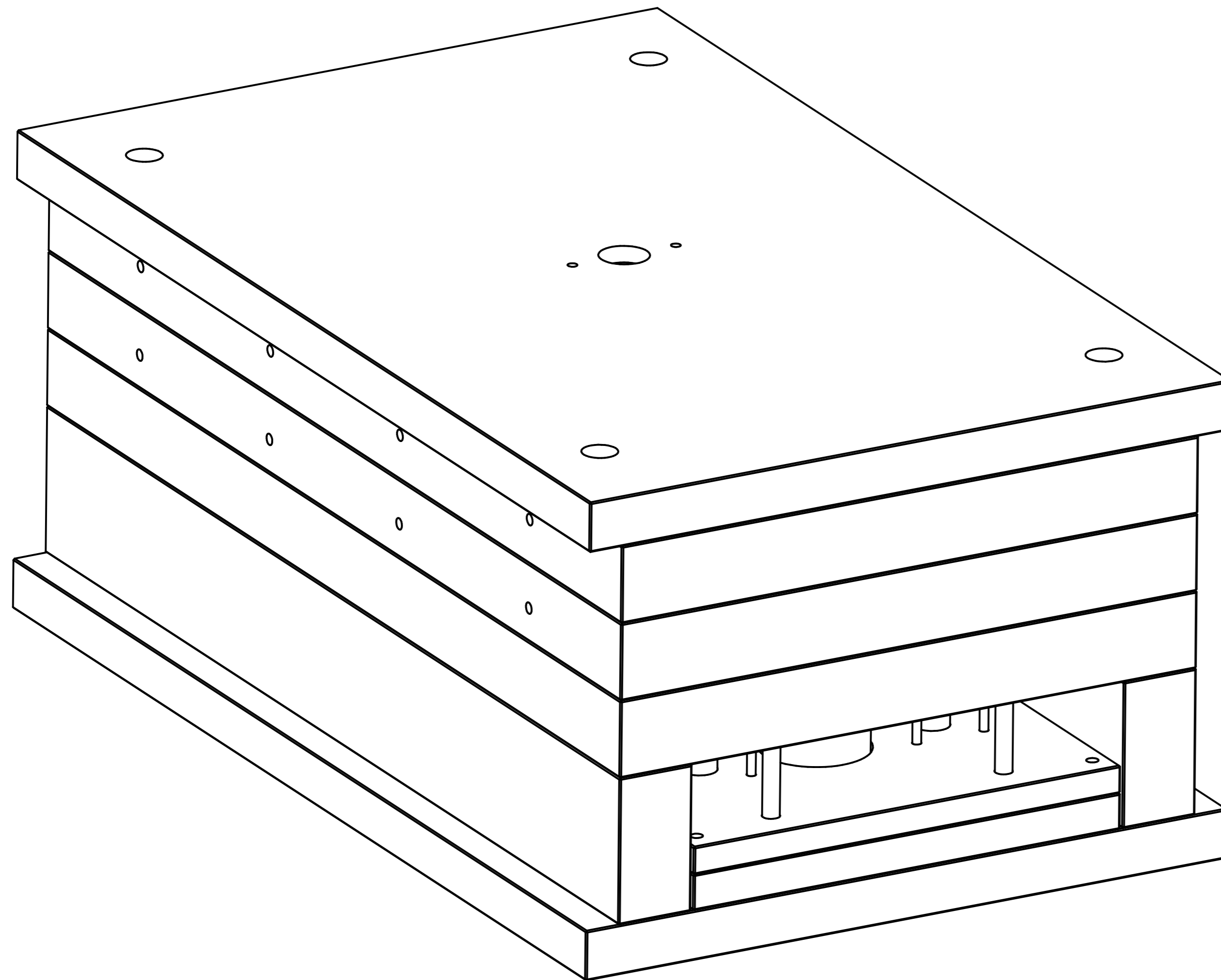


REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

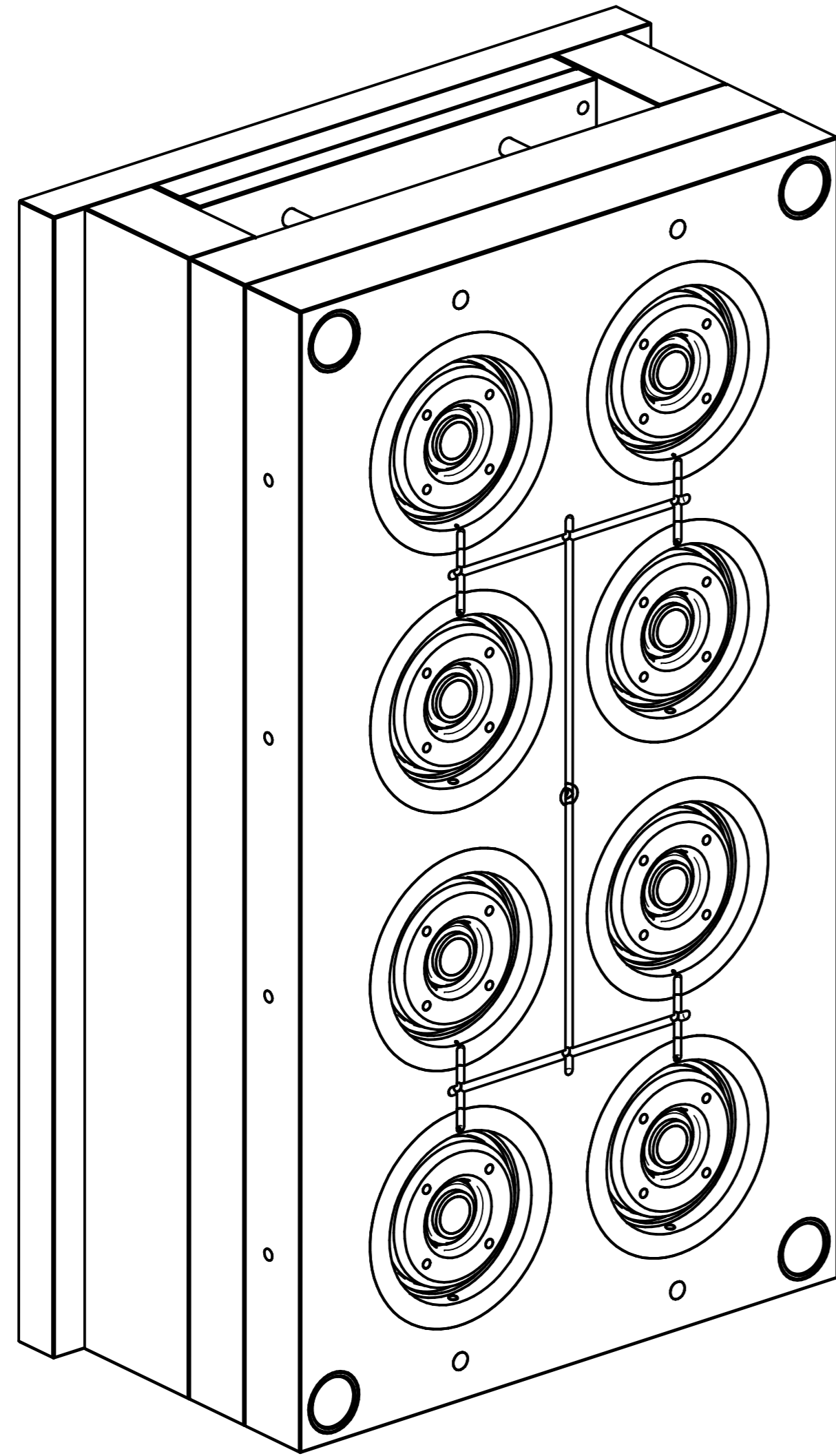


Wheel Centre Mould PJP125X32H35H45
MOULD BASE 4580

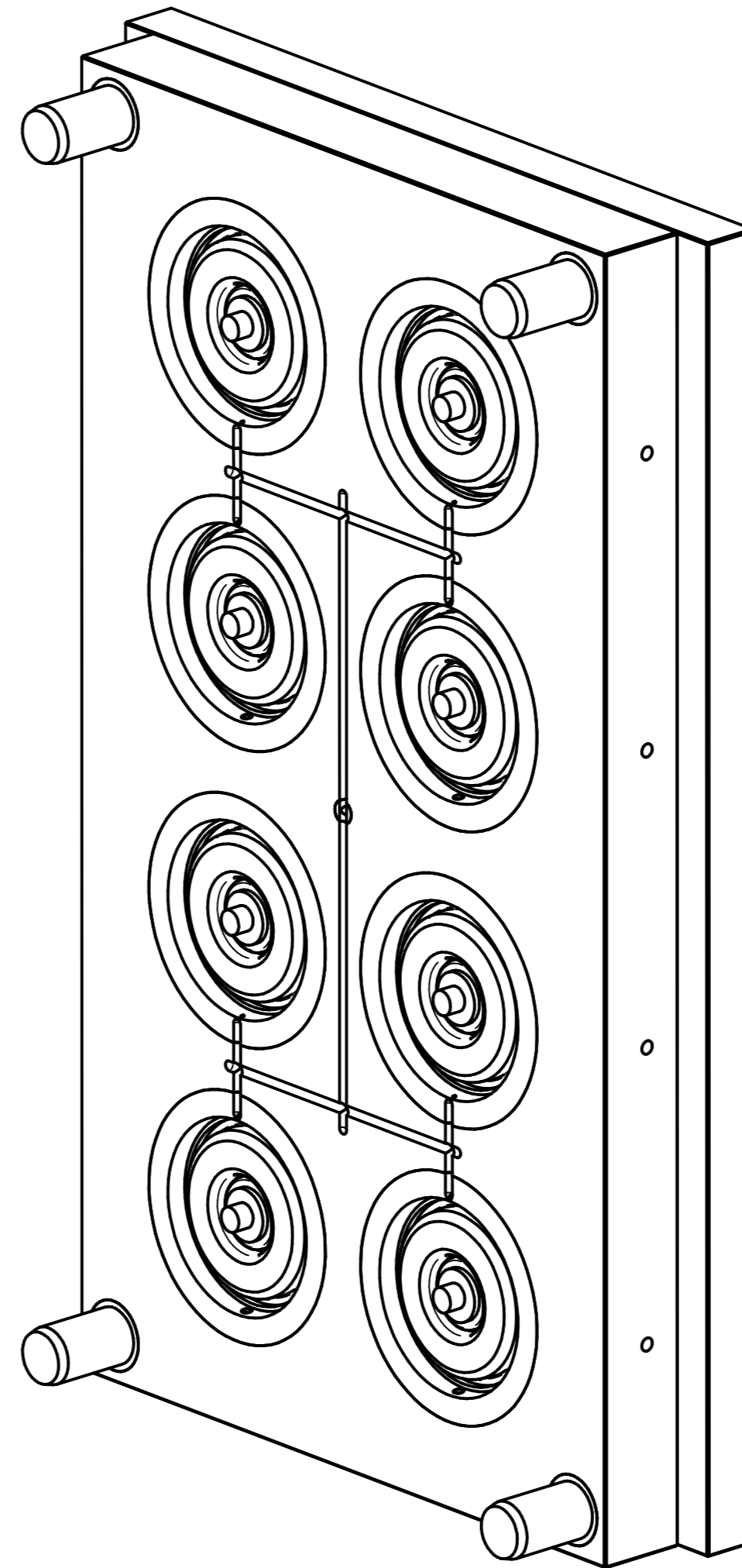
Item Number	Document Number	Title	Quantity
1	330 x 796 x 16	Ejector Plate	1
2	330 x 796 x 26	Ejector Clamping Plate	1
3	446 x 796 x 56	FH Die Plate	1
4	446 x 796 x 56	MH Die Plate	1
5	446 x 796 x 56	Support Plate	1
6	496 x 796 x 36	Fixed Clamping Plate	1
7	496 x 796 x 36	Moving Clamping Plate	1
8	56 x 796 x 106	Riser	2
9	B3-24 x 51	Sprue Bush	1
10	Dia 12 - 200	Ejector Pin	4
11	Dia 120 -54	FH Mid Insert	8
12	Dia 120 -54	MH Mid Insert	8
13	Dia 160 - 56	FH Insert A	4
14	Dia 160 - 56	FH Insert B	4
15	Dia 160 - 56	MH Insert	4
16	Dia 160 - 56	MH Insert B	4
17	Dia 17 -50	Square Spring	8
18	Dia 20 x 27.1	Sprue Puller Bush	1
19	Dia 25 - 200	Ejector Pin	8
20	Dia 54 - 51	MH Inner Insert	8
21	Dia 54 - 62	FH Inner Insert	8
22	Dia 6 - 100	Vent Pin	16
23	Dia 6 - 200 A	Ejector Pin	1
24	Dia 6 - 200 B	Ejector Pin	6
25	Dia 6 - 200 C	Ejector Pin	32
26	Dia 75 - 106	Support Pillar	4
27	FBN34-56	Locating Bush	4
28	FSN34-56-56	Locating Pin	4

	NAME	DATE	AGRIGEL	
DRAWN	Dan	04/11/12		
APPROVED			TITLE Wheel Centre Mould	
MATERIAL				
TREATMENT			SIZE A4	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS				
1 st ANGLE ANGLES ±0.1°			PJP125X32H35H45	
2 PL ±0.02 3 PL ±0.005			FILE NAME: Wheel Centre Mould.dft	
			SCALE:	WEIGHT:
			SHEET 1 OF 12	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



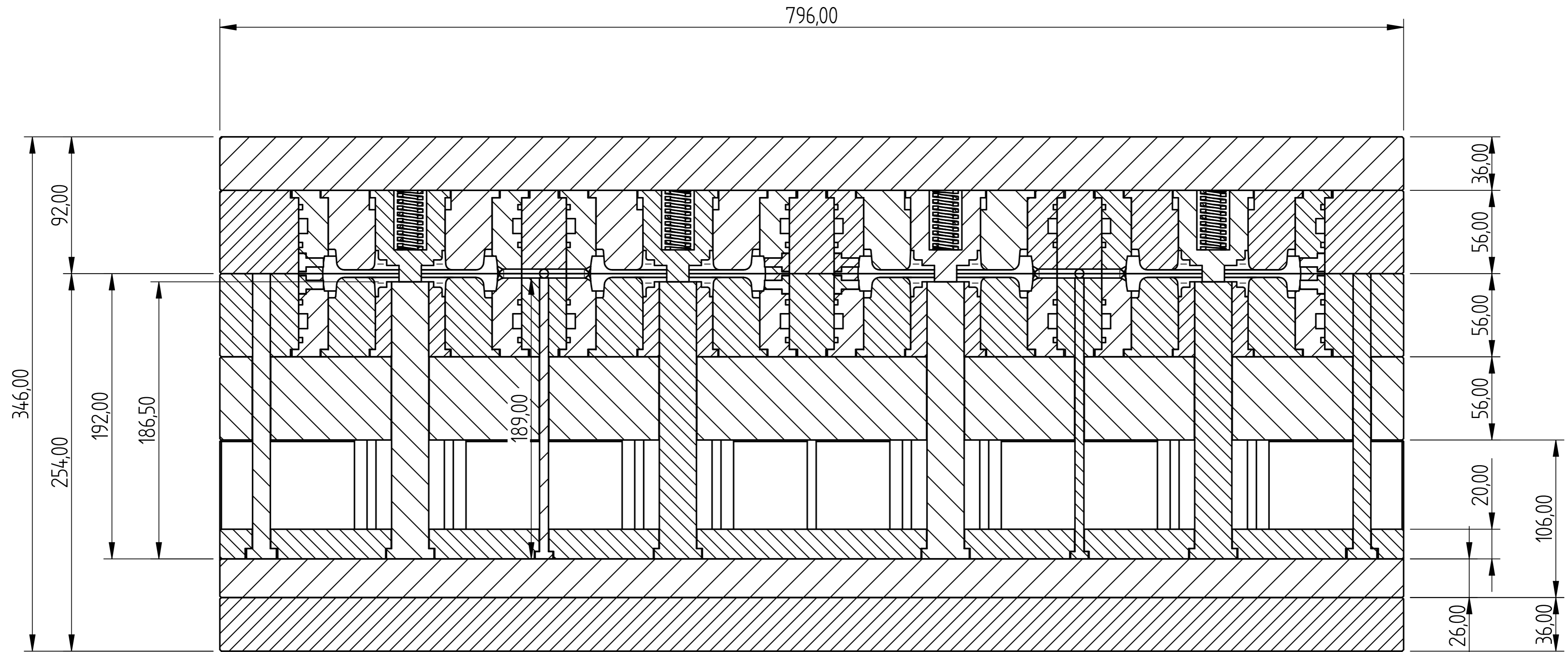
MOVING HALF



FIXED HALF

	NAME	DATE	AGRIGEL	
DRAWN	Dan	04/11/12		
APPROVED				
MATERIAL				
TREATMENT			TITLE Wheel Centre Mould	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO PJP125X32H35H45
1 st ANGLE ANGLES ±0.1°			FILE NAME: Wheel Centre Mould.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT: SHEET 2 OF 12

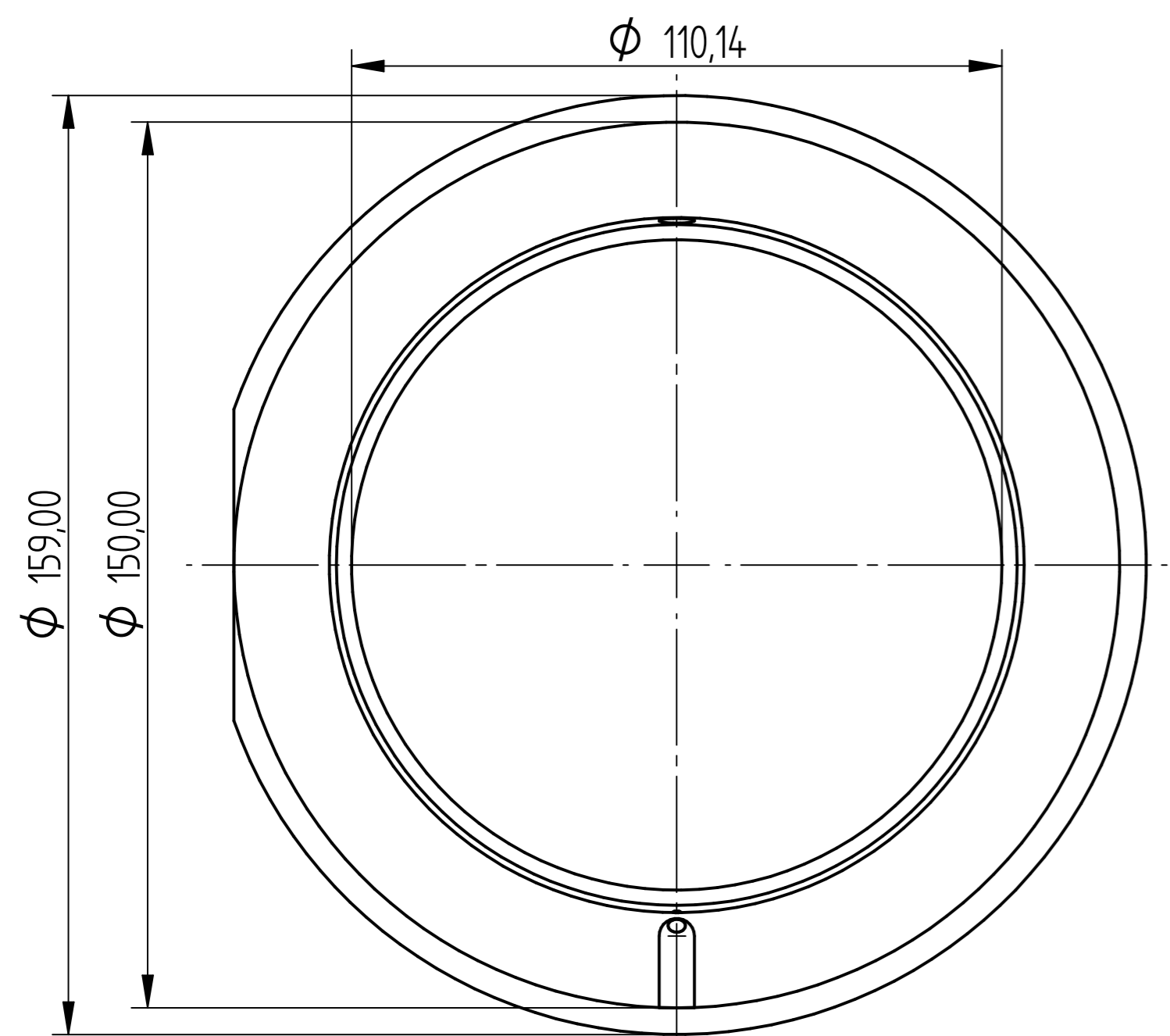
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



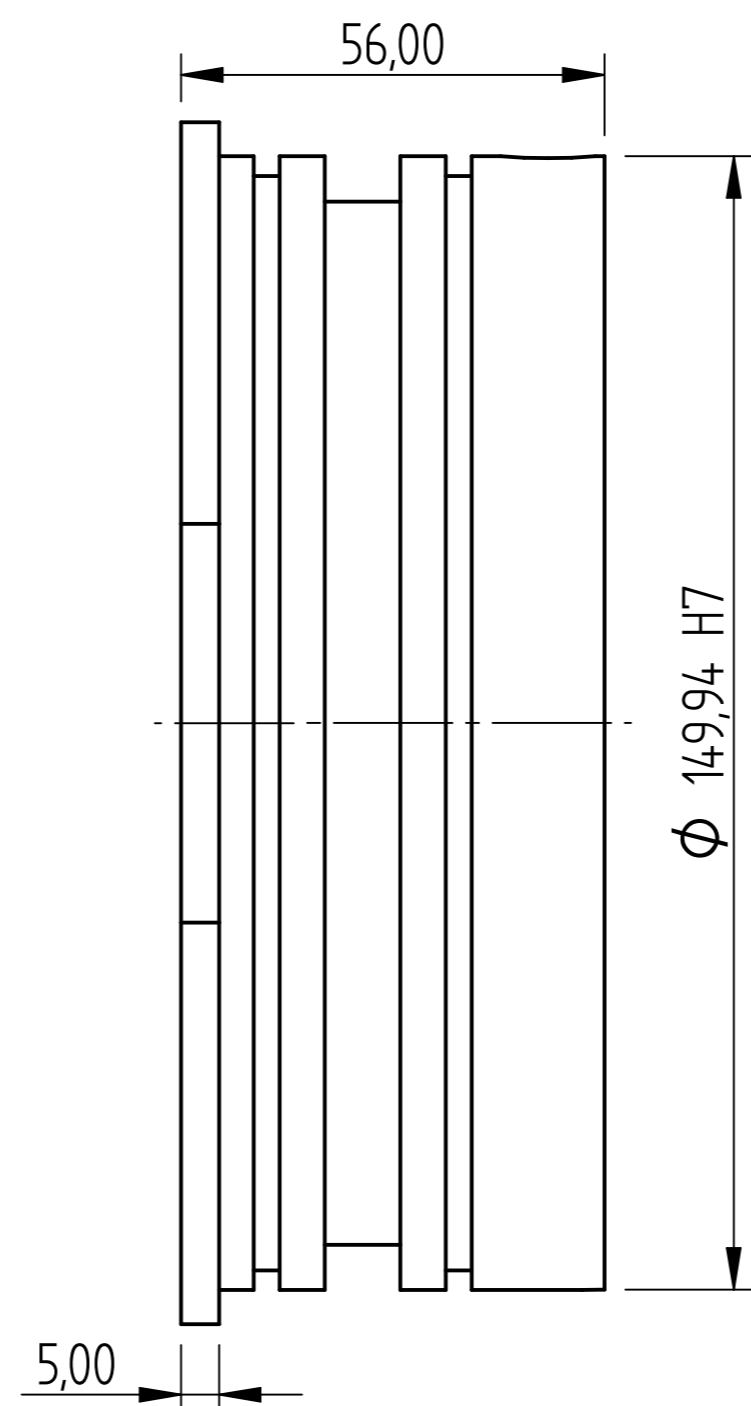
Wheel Centre Mould PJP125X32H35H45

	NAME	DATE	AGRIGEL		
DRAWN	Dan	04/11/12			
APPROVED			TITLE Wheel Centre Mould		
MATERIAL					
TREATMENT			SIZE A4	DWG NO PJP125X32H35H45	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: Wheel Centre Mould.dft		
1st ANGLE 2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:	SHEET 3 OF 12

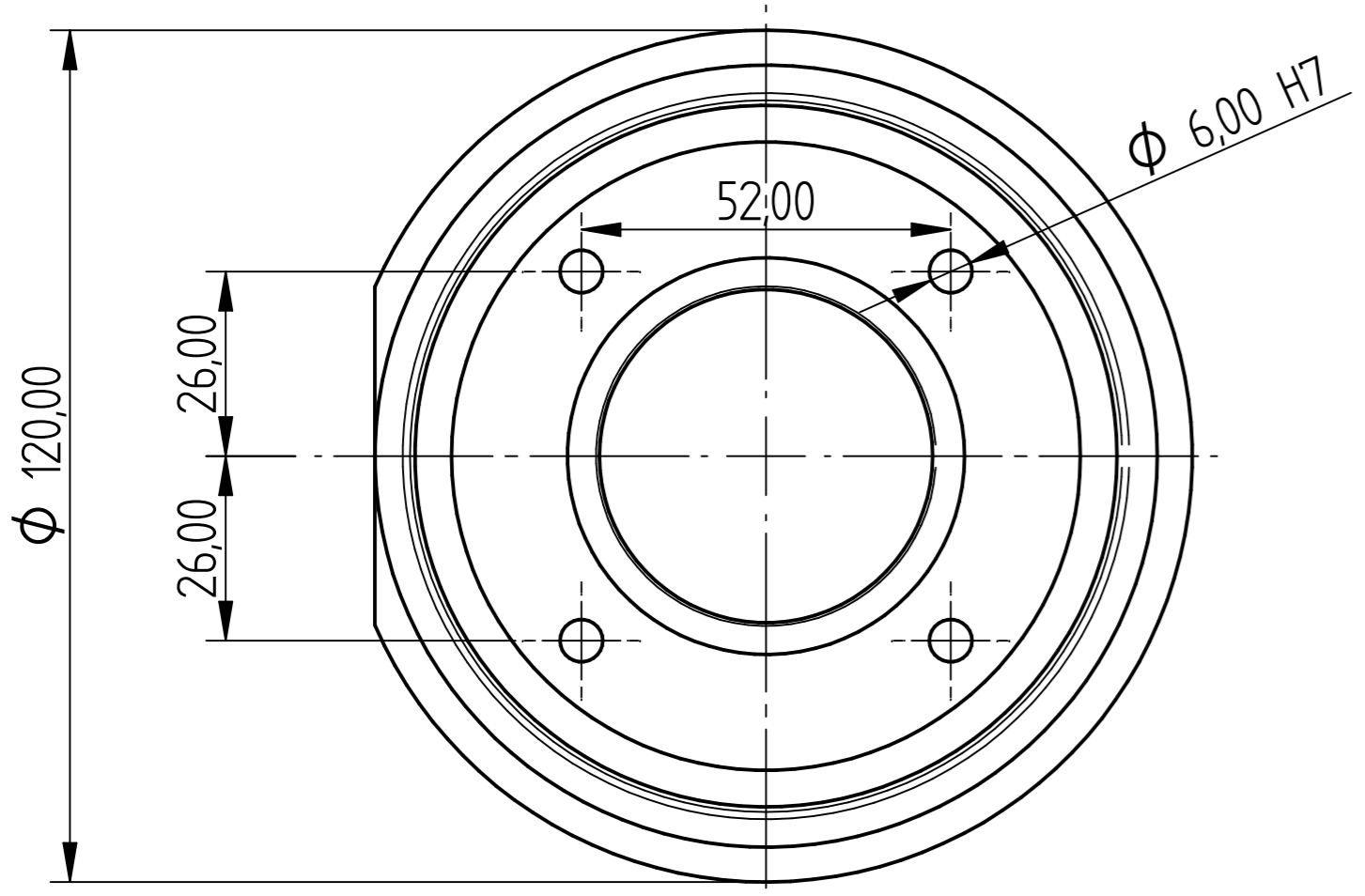
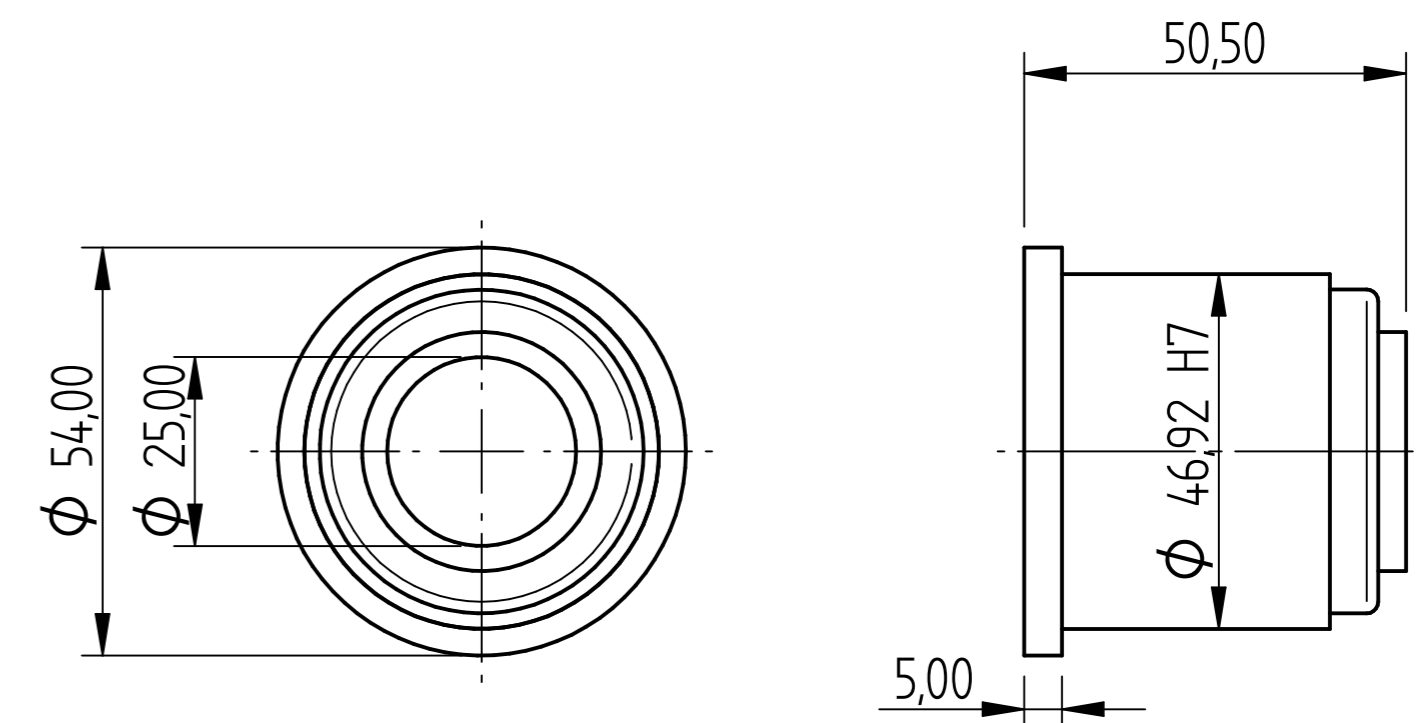
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



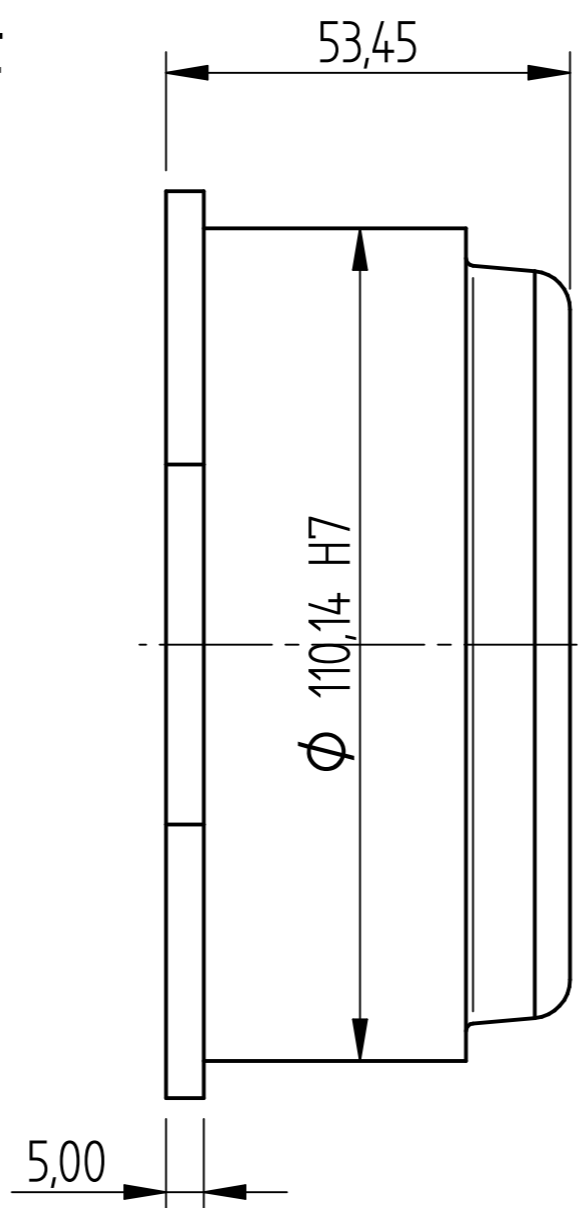
FIXED & MOVING OUTER INSERT
EACH DIA 160 x 81 16 OF



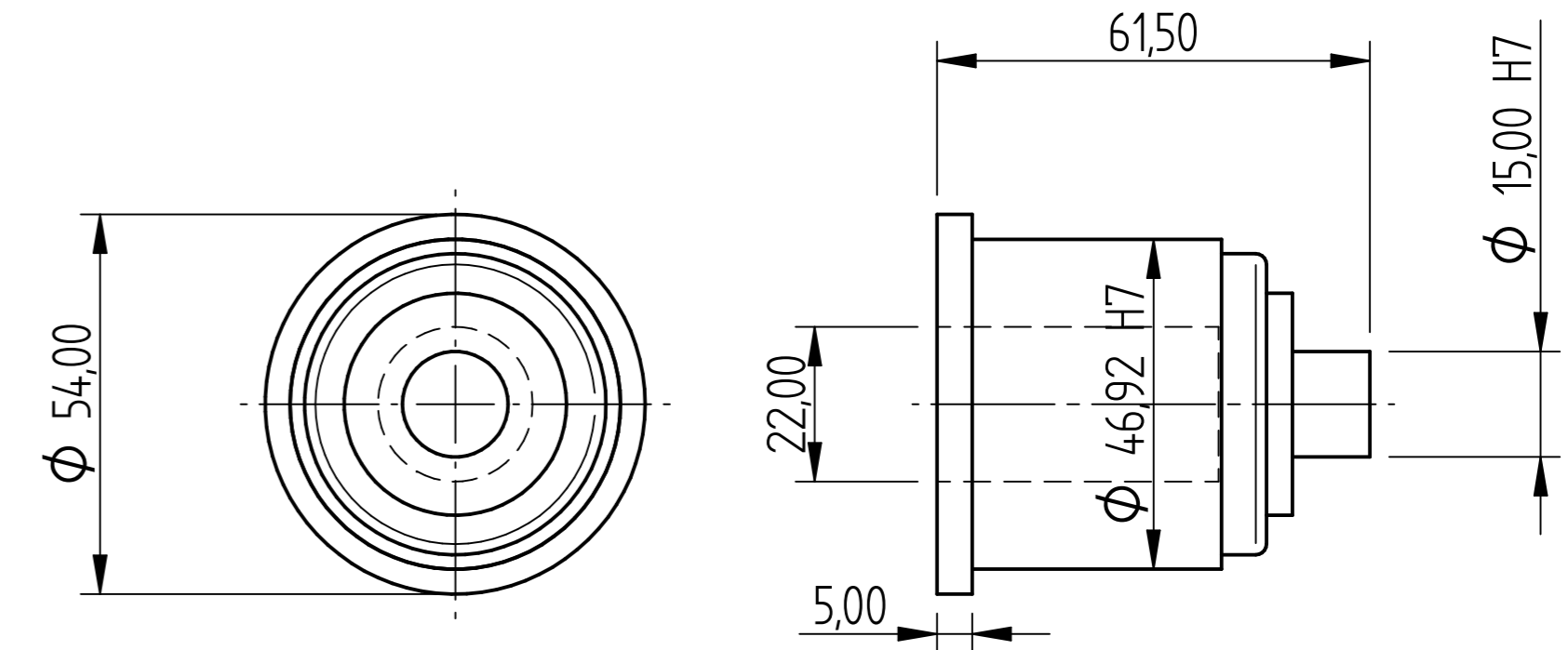
MOVING INNER INSERT
EACH DIA 54 x 81 8 OF



FIXED & MOVING MID INSERT
EACH DIA 120 x 79 16 OF 8 OF EACH
Only the MH has the Dia 6 hole

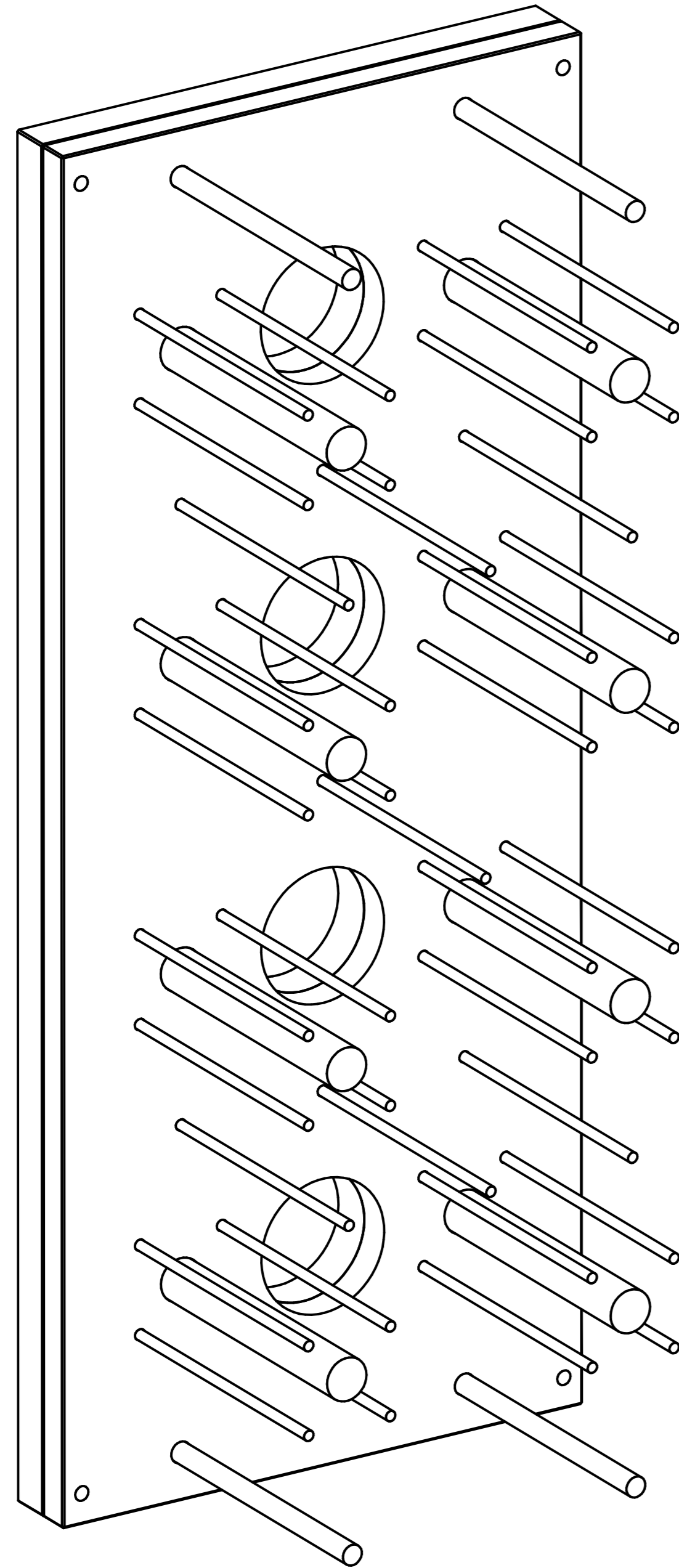


FIXED INNER INSERT
EACH DIA 54 x 92 8 OF



DRAWN	NAME	DATE	AGRIGEL	
APPROVED	Dan	04/11/12	TITLE	
MATERIAL			Wheel Centre Mould	
TREATMENT			SIZE	DWG NO
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			A4	PJP125X32H35H45
1st ANGLE			FILE NAME:	REV
2 PL ±0.02 3 PL ±0.005			Wheel Centre Mould.dft	
SCALE:		WEIGHT:	SHEET 4 OF 12	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

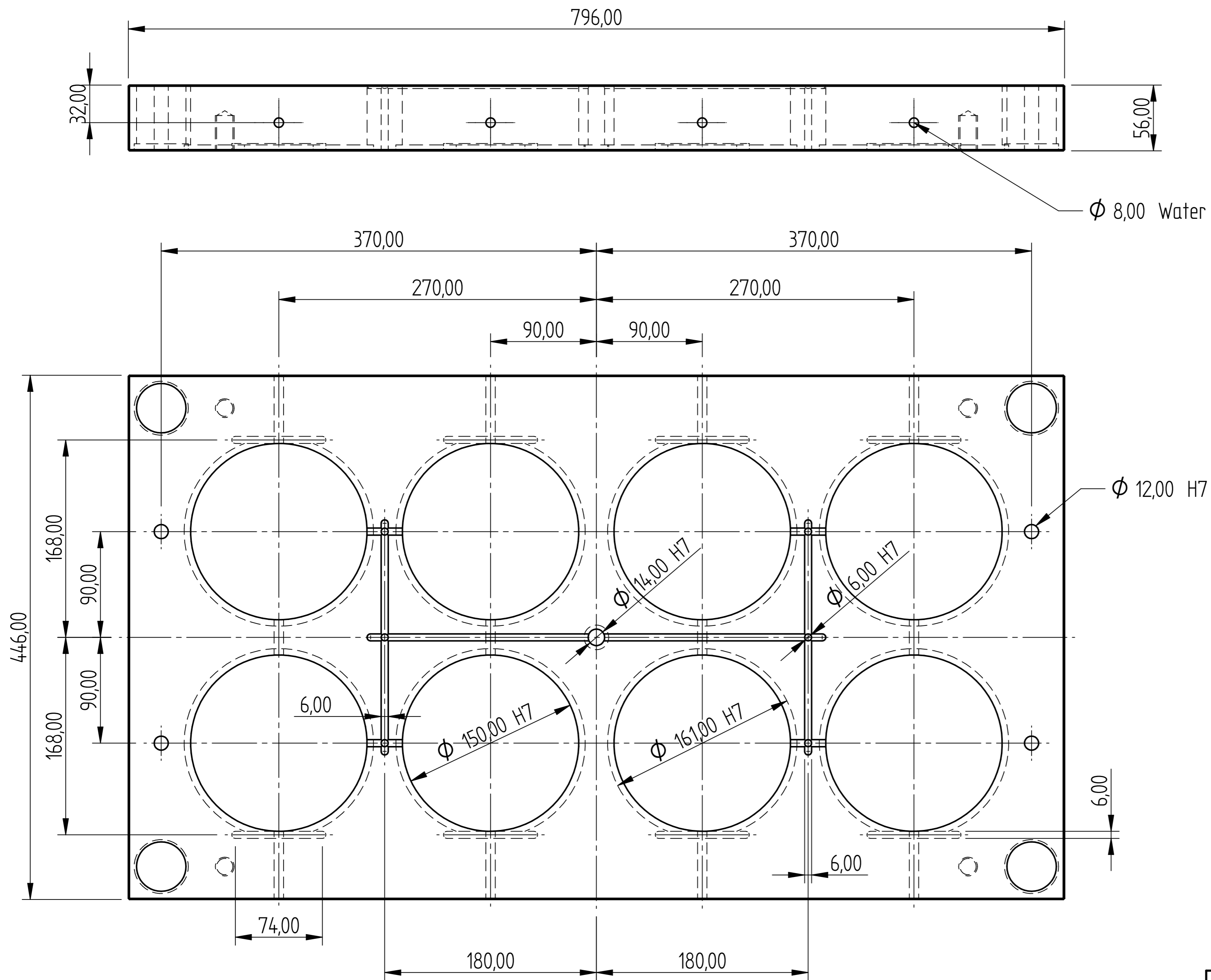


Item Number	Document Number	Title	Quantity
1	330 x 796 x 16	Ejector Plate	1
2	330 x 796 x 26	Ejector Clamping Plate	1
3	Dia 12 - 200	Ejector Pin	4
4	Dia 25 - 200	Ejector Pin	8
5	Dia 6 - 200 A	Ejector Pin	1
6	Dia 6 - 200 B	Ejector Pin	6
7	Dia 6 - 200 C	Ejector Pin	32

Ejector Assembly

	NAME	DATE	AGRIGEL	
DRAWN	Dan	04/11/12		
APPROVED				
MATERIAL				
TREATMENT			TITLE	Wheel Centre Mould
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE A4	DWG NO PJP125X32H35H45
1 st ANGLE ANGLES ±0.1°			FILE NAME: Wheel Centre Mould.dft	REV
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:
			SHEET 5 OF 12	

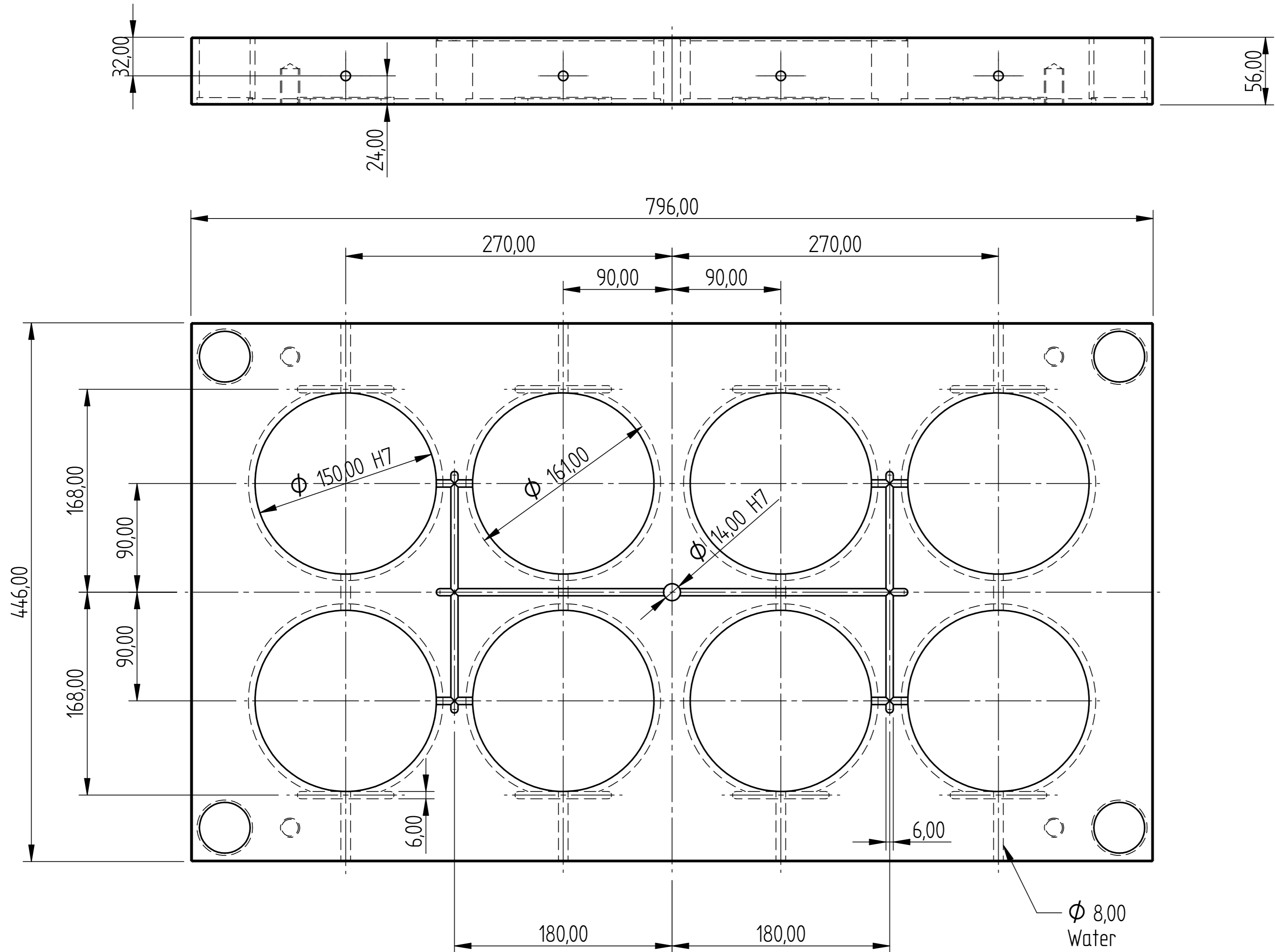
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



MH Die Plate

	NAME	DATE	AGRIGEL	
DRAWN	Dan	04/11/12	TITLE	
APPROVED			Wheel Centre Mould	
MATERIAL			SIZE	DWG NO
TREATMENT			A4	PJP125X32H35H45
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME:	REV
1 st ANGLE ANGLES $\pm 0,1^\circ$			Wheel Centre Mould.dft	
2 PL $\pm 0,02$ 3 PL $\pm 0,005$			SCALE:	WEIGHT:
				SHEET 6 OF 12

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

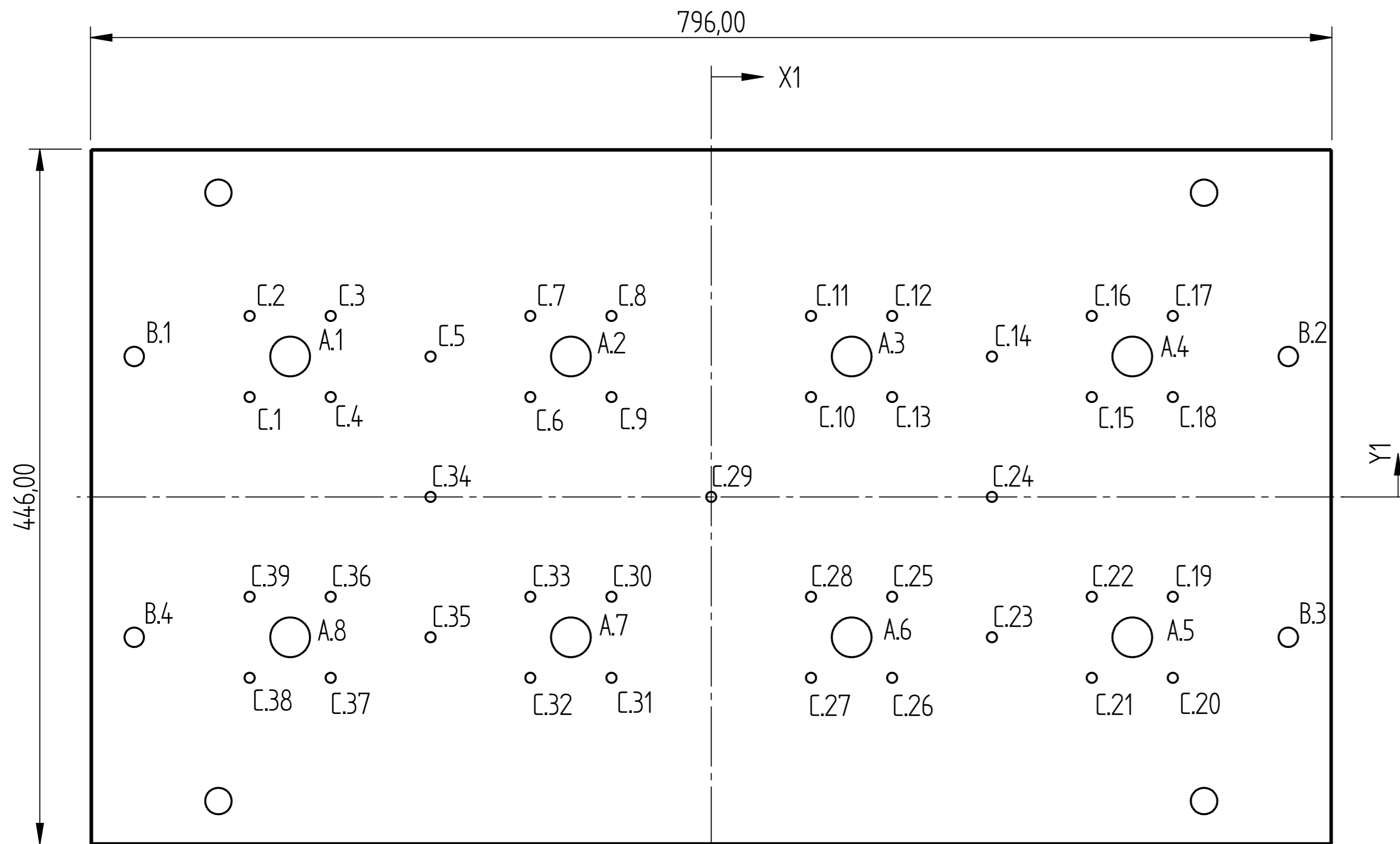


FH Die Plate

Ø 8,00
Water

DRAWN	NAME	DATE	AGRIGEL	
APPROVED	Dan	04/11/12		
MATERIAL			TITLE	
TREATMENT			Wheel Centre Mould	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
1 st ANGLE			A4	PJP125X32H35H45
2 PL ±0.02 3 PL ±0.005			FILE NAME: Wheel Centre Mould.dft	REV
			SCALE:	WEIGHT:
			SHEET 7 OF 12	

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

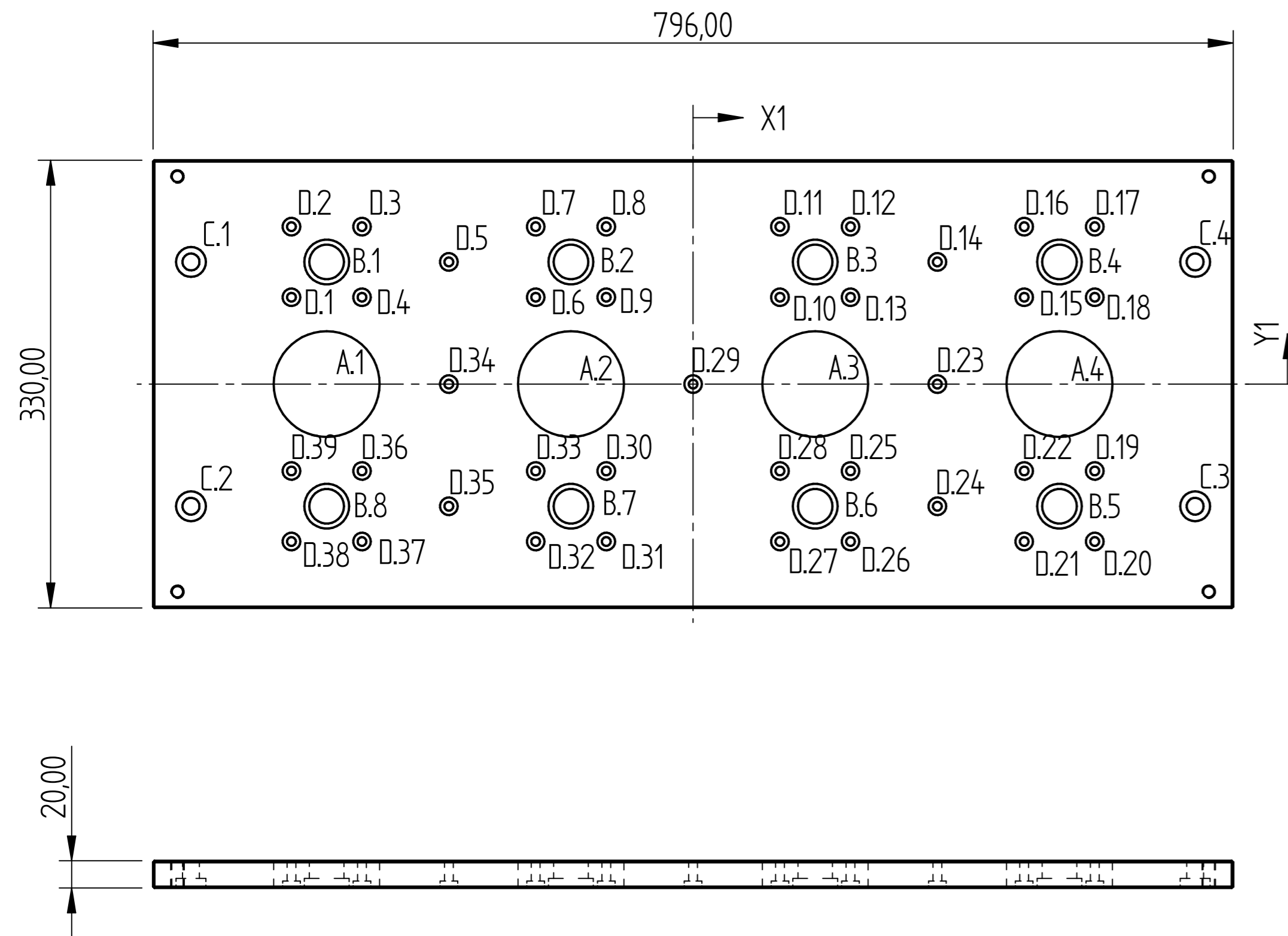


Hole Table				Hole Table			
Hole	X	Y	Size	Hole	X	Y	Size
A.1	-270,00	90,00	φ 25,50	C.15	244,00	64,00	φ 6,50
A.2	-90,00	90,00	φ 25,50	C.16	244,00	116,00	φ 6,50
A.3	90,00	90,00	φ 25,50	C.17	296,00	116,00	φ 6,50
A.4	270,00	90,00	φ 25,50	C.18	296,00	64,00	φ 6,50
A.5	270,00	-90,00	φ 25,50	C.19	296,00	-64,00	φ 6,50
A.6	90,00	-90,00	φ 25,50	C.20	296,00	-116,00	φ 6,50
A.7	-90,00	-90,00	φ 25,50	C.21	244,00	-116,00	φ 6,50
A.8	-270,00	-90,00	φ 25,50	C.22	244,00	-64,00	φ 6,50
B.1	-370,00	90,00	φ 12,50	C.23	180,00	-90,00	φ 6,50
B.2	370,00	90,00	φ 12,50	C.24	180,00	0,00	φ 6,50
B.3	370,00	-90,00	φ 12,50	C.25	116,00	-64,00	φ 6,50
B.4	-370,00	-90,00	φ 12,50	C.26	116,00	-116,00	φ 6,50
C.1	-296,00	64,00	φ 6,50	C.27	64,00	-116,00	φ 6,50
C.2	-296,00	116,00	φ 6,50	C.28	64,00	-64,00	φ 6,50
C.3	-244,00	116,00	φ 6,50	C.29	0,00	0,00	φ 6,50
C.4	-244,00	64,00	φ 6,50	C.30	-64,00	-64,00	φ 6,50
C.5	-180,00	90,00	φ 6,50	C.31	-64,00	-116,00	φ 6,50
C.6	-116,00	64,00	φ 6,50	C.32	-116,00	-116,00	φ 6,50
C.7	-116,00	116,00	φ 6,50	C.33	-116,00	-64,00	φ 6,50
C.8	-64,00	116,00	φ 6,50	C.34	-180,00	0,00	φ 6,50
C.9	-64,00	64,00	φ 6,50	C.35	-180,00	-90,00	φ 6,50
C.10	64,00	64,00	φ 6,50	C.36	-244,00	-64,00	φ 6,50
C.11	64,00	116,00	φ 6,50	C.37	-244,00	-116,00	φ 6,50
C.12	116,00	116,00	φ 6,50	C.38	-296,00	-116,00	φ 6,50
C.13	116,00	64,00	φ 6,50	C.39	-296,00	-64,00	φ 6,50
C.14	180,00	90,00	φ 6,50				

Support Plate

DRAWN	NAME	DATE	AGRIGEL		
APPROVED	Dan	04/11/12			
MATERIAL					
TREATMENT					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO	REV
1 st ANGLE			A4	PJP125X32H35H45	
2 PL ±0.02 3 PL ±0.005			FILE NAME: Wheel Centre Mould.dft		
			SCALE:	WEIGHT:	SHEET 8 OF 12

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED

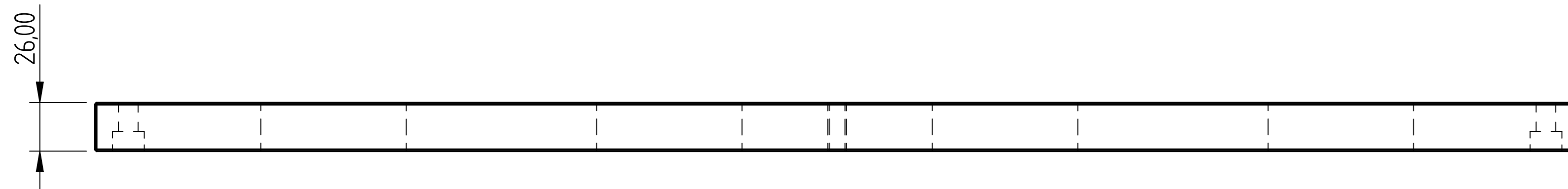
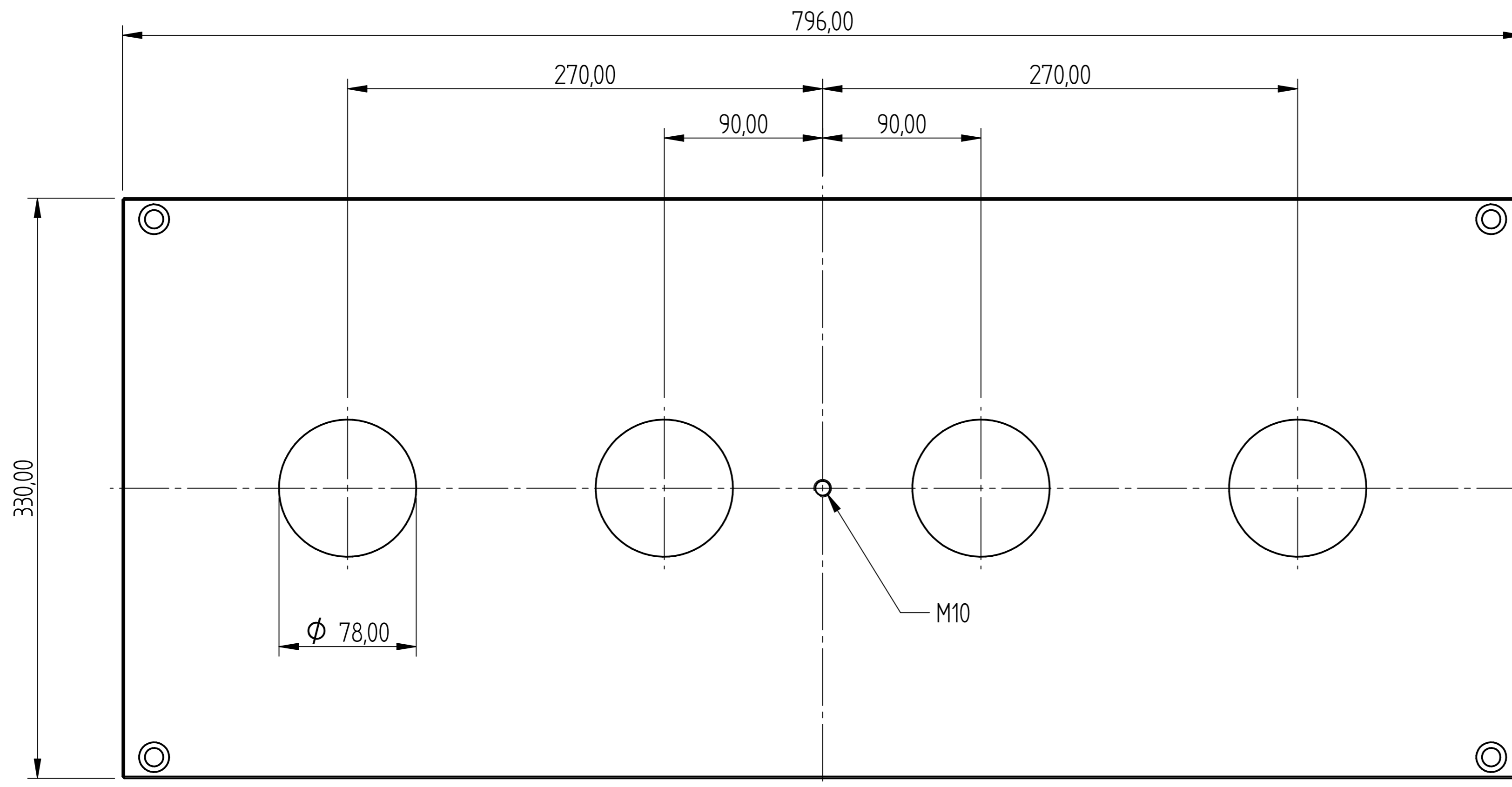


Ejector Plate

Hole Table					Hole Table				
Hole	X	Y	Size	C / Bore	Hole	X	Y	Size	C / Bore
A.1	-270,00	0,00	φ 78,00		D.13	116,00	64,00	φ 6,50	φ13,00-5,05
A.2	-90,00	0,00	φ 78,00		D.14	180,00	90,00	φ 6,50	φ13,00-5,05
A.3	90,00	0,00	φ 78,00		D.15	244,00	64,00	φ 6,50	φ13,00-5,05
A.4	270,00	0,00	φ 78,00		D.16	244,00	116,00	φ 6,50	φ13,00-5,05
B.1	-270,00	90,00	φ 25,50	φ33,00-7,05	D.17	296,00	116,00	φ 6,50	φ13,00-5,05
B.2	-90,00	90,00	φ 25,50	φ33,00-7,05	D.18	296,00	64,00	φ 6,50	φ13,00-5,05
B.3	90,00	90,00	φ 25,50	φ33,00-7,05	D.19	296,00	-64,00	φ 6,50	φ13,00-5,05
B.4	270,00	90,00	φ 25,50	φ33,00-7,05	D.20	296,00	-116,00	φ 6,50	φ13,00-5,05
B.5	270,00	-90,00	φ 25,50	φ33,00-7,05	D.21	244,00	-116,00	φ 6,50	φ13,00-5,05
B.6	90,00	-90,00	φ 25,50	φ33,00-7,05	D.22	244,00	-64,00	φ 6,50	φ13,00-5,05
B.7	-90,00	-90,00	φ 25,50	φ33,00-7,05	D.23	180,00	0,00	φ 6,50	φ13,00-5,05
B.8	-270,00	-90,00	φ 25,50	φ33,00-7,05	D.24	180,00	-90,00	φ 6,50	φ13,00-5,05
C.1	-370,00	90,00	φ 12,50	φ22,00-7,05	D.25	116,00	-64,00	φ 6,50	φ13,00-5,05
C.2	-370,00	-90,00	φ 12,50	φ22,00-7,05	D.26	116,00	-116,00	φ 6,50	φ13,00-5,05
C.3	370,00	-90,00	φ 12,50	φ22,00-7,05	D.27	64,00	-116,00	φ 6,50	φ13,00-5,05
C.4	370,00	90,00	φ 12,50	φ22,00-7,05	D.28	64,00	-64,00	φ 6,50	φ13,00-5,05
D.1	-296,00	64,00	φ 6,50	φ13,00-5,05	D.29	0,00	0,00	φ 6,50	φ13,00-5,05
D.2	-296,00	116,00	φ 6,50	φ13,00-5,05	D.30	-64,00	-64,00	φ 6,50	φ13,00-5,05
D.3	-244,00	116,00	φ 6,50	φ13,00-5,05	D.31	-64,00	-116,00	φ 6,50	φ13,00-5,05
D.4	-244,00	64,00	φ 6,50	φ13,00-5,05	D.32	-116,00	-116,00	φ 6,50	φ13,00-5,05
D.5	-180,00	90,00	φ 6,50	φ13,00-5,05	D.33	-116,00	-64,00	φ 6,50	φ13,00-5,05
D.6	-116,00	64,00	φ 6,50	φ13,00-5,05	D.34	-180,00	0,00	φ 6,50	φ13,00-5,05
D.7	-116,00	116,00	φ 6,50	φ13,00-5,05	D.35	-180,00	-90,00	φ 6,50	φ13,00-5,05
D.8	-64,00	116,00	φ 6,50	φ13,00-5,05	D.36	-244,00	-64,00	φ 6,50	φ13,00-5,05
D.9	-64,00	64,00	φ 6,50	φ13,00-5,05	D.37	-244,00	-116,00	φ 6,50	φ13,00-5,05
D.10	64,00	64,00	φ 6,50	φ13,00-5,05	D.38	-296,00	-116,00	φ 6,50	φ13,00-5,05
D.11	64,00	116,00	φ 6,50	φ13,00-5,05	D.39	-296,00	-64,00	φ 6,50	φ13,00-5,05
D.12	116,00	116,00	φ 6,50	φ13,00-5,05					

	NAME	DATE	AGRIGEL	
DRAWN	Dan	04/11/12		
APPROVED				
MATERIAL				
TREATMENT			TITLE	Wheel Centre Mould
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			SIZE	DWG NO
1 st ANGLE			A4	PJP125X32H35H45
2 PL ±0.02 3 PL ±0.005			FILE NAME:	Wheel Centre Mould.dft
			SCALE:	WEIGHT:
			SHEET 9 OF 12	

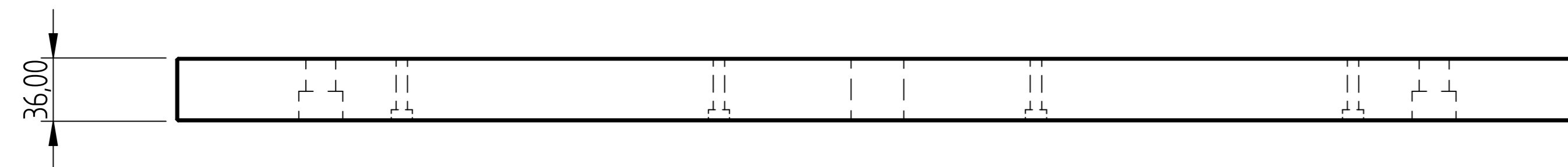
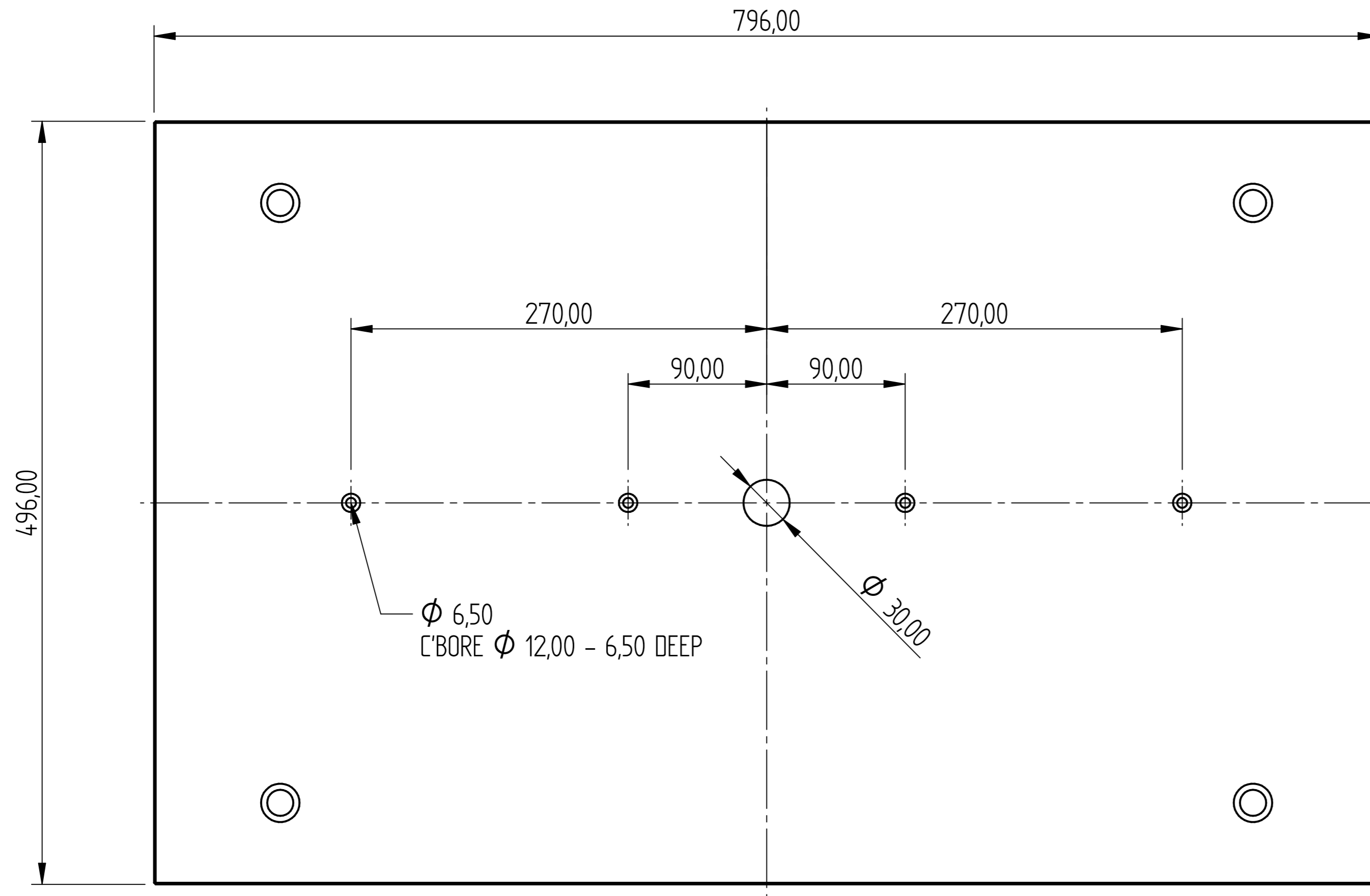
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



Ejector Clamping Plate

	NAME	DATE	AGRIGEL	
DRAWN	Dan	04/11/12	TITLE	
APPROVED			Wheel Centre Mould	
MATERIAL			SIZE	DWG NO
TREATMENT			A4	PJP125X32H35H45
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME:	REV
1 st ANGLE			Wheel Centre Mould.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:
				SHEET 10 OF 12

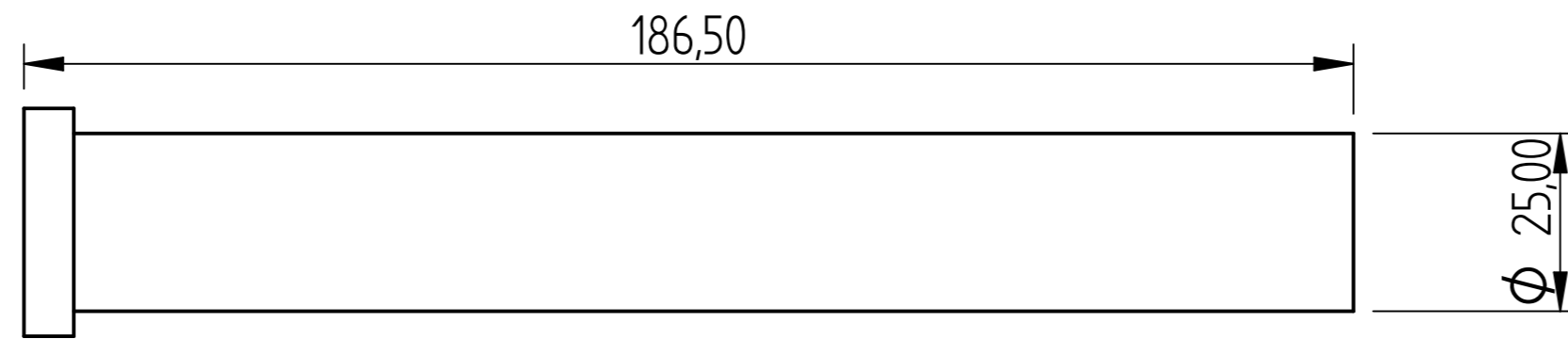
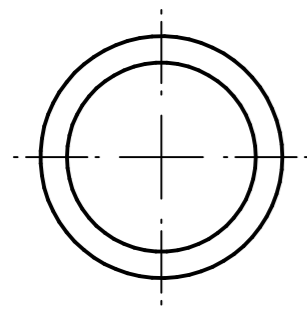
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



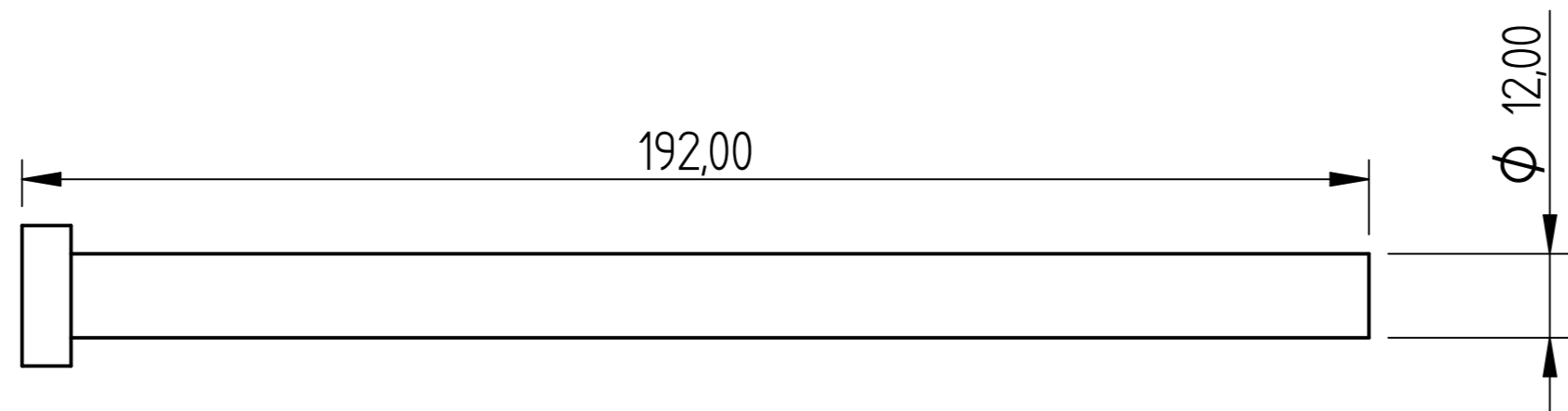
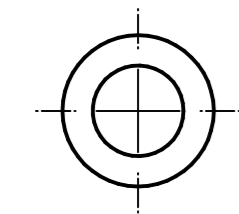
Moving Clamping Plate

	NAME	DATE	AGRIGEL		
DRAWN	Dan	04/11/12			
APPROVED			TITLE Wheel Centre Mould		
MATERIAL					
TREATMENT			SIZE A4	DWG NO PJP125X32H35H45	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME: Wheel Centre Mould.dft		
1 st ANGLE ANGLES ±0,1°			SCALE:	WEIGHT:	SHEET 11 OF 12
2 PL ±0,02 3 PL ±0,005					

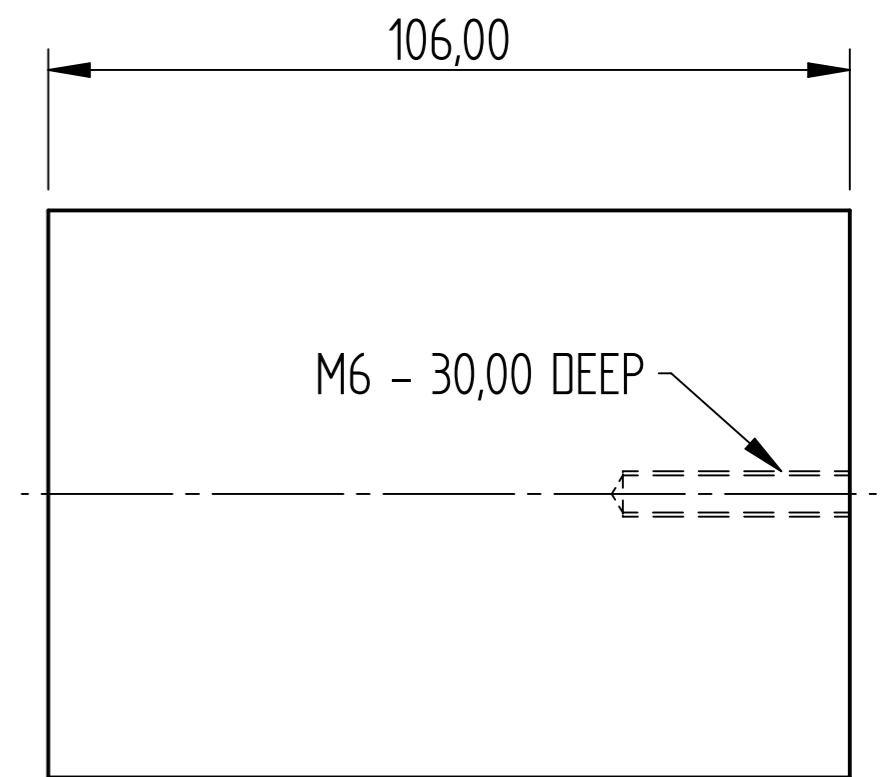
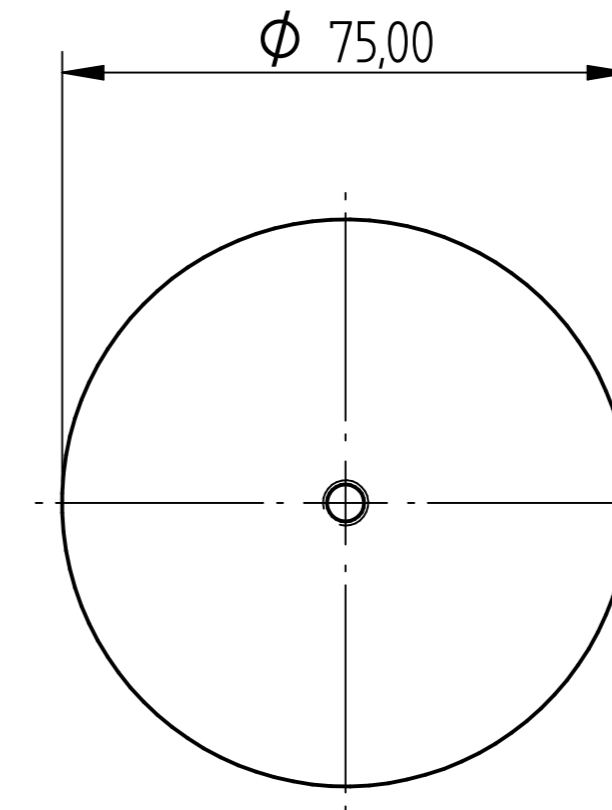
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED



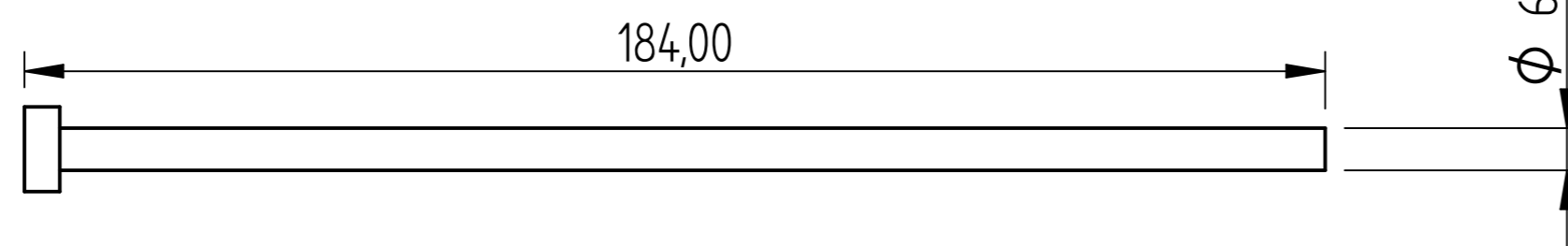
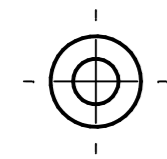
Dia 25 - 200



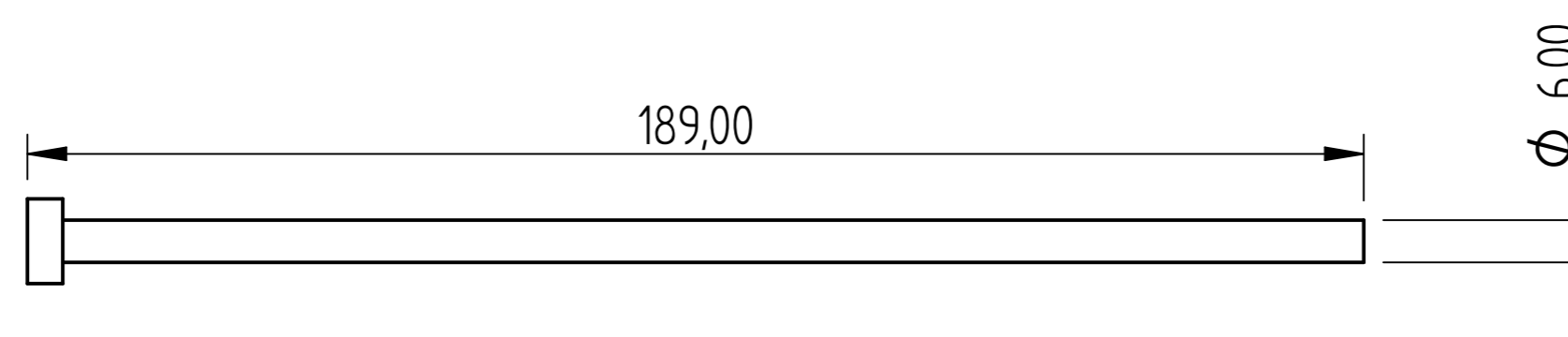
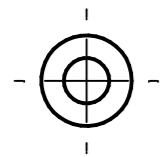
Dia 12 - 200



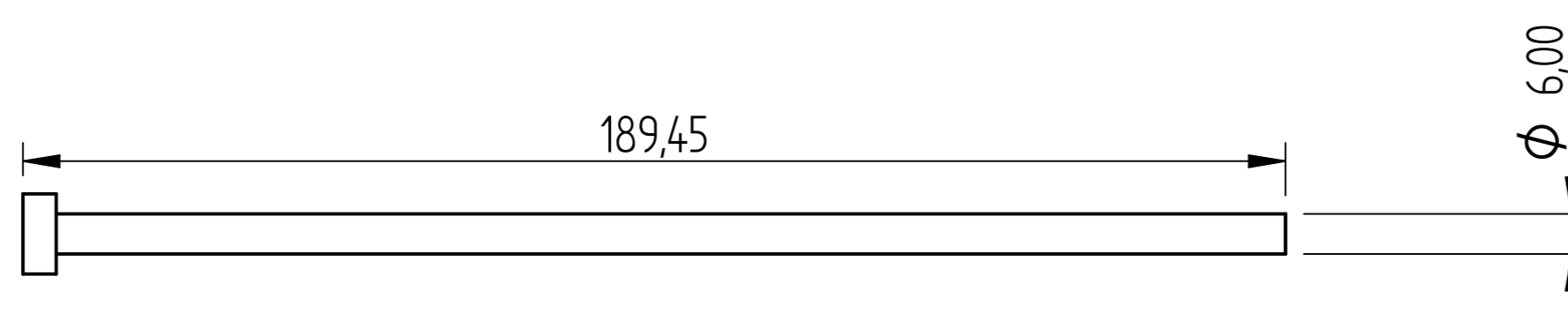
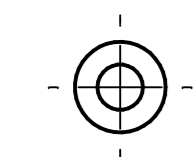
Support Pillar



Dia 6 - 200 A



Dia 6 - 200 B



Dia 6 - 200 C

	NAME	DATE	AGRIGEL	
DRAWN	Dan	04/11/12	TITLE	
APPROVED			Wheel Centre Mould	
MATERIAL			SIZE	DWG NO
TREATMENT			A4	PJP125X32H35H45
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS			FILE NAME:	REV
1 st ANGLE			Wheel Centre Mould.dft	
2 PL ±0.02 3 PL ±0.005			SCALE:	WEIGHT:
			SHEET 12 OF 12	