EXP

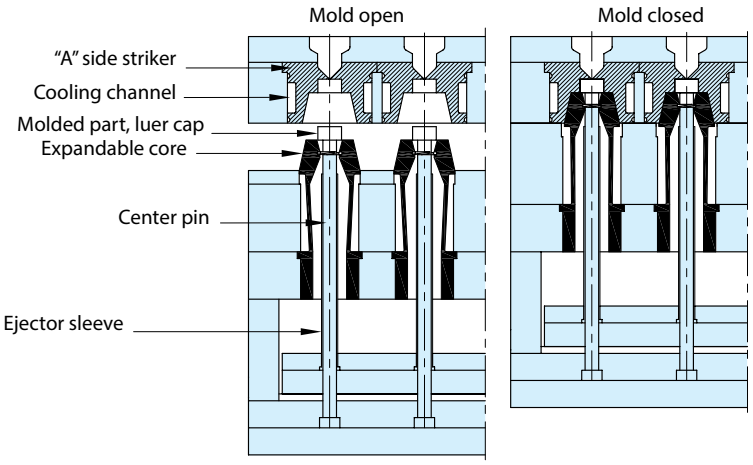
Info EXP

Expandable Core
The Expandable Core is typically made of 1.2363 tool steel, hardened to 54-58 HRC. The typical tool has 4 segments.

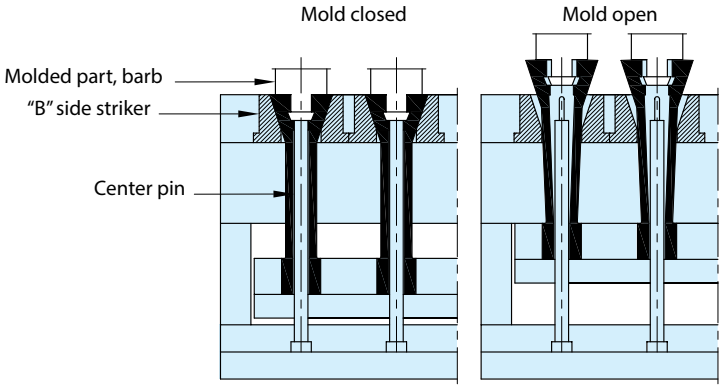
Striker Insert
The Striker Insert is made from different types of tool steel. It is hardened to 32-45 HRC scale, depending on the application. The Striker Insert has a lower hardness than the Expandable Core to ensure the eventual wear will occur on the Striker Insert. Depending on the part configuration, the Striker Insert can be used in the "A" or "B" side of the mold.(See figure 1 and 2 for details). The Striker Insert must be closely fit to the Expandable Core to ensure that in the mold closed position the segments are completely sealed against one another. The tolerance on this fit must be held to ± 0.013 mm. This will ensure flash free molding. When the mold is closed, the exterior of the Expandable Core must be supported by the Striker Insert at least 7/8 of the molded length plus the shut-off, to ensure no flash conditions. Allow for 5 mm of shut-off length below the molding length, any more is excessive.

Interchangeable Center Pin
The solid center mandrel is the most common type of center pin. It may have an inner cooling channel depending on its size. The center pin provides an internal shut-off with the Expandable Core.

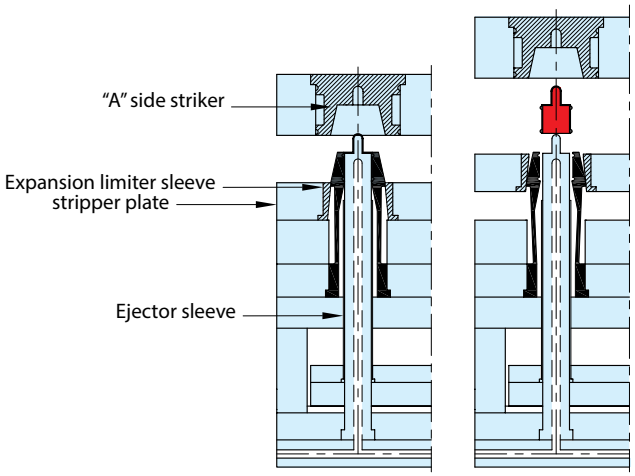
Typical application with"A" side striker insert



Typical application with "B" side striker insert



With "A" striker insert and expansion limiter sleeve



CAD reference point