



Mold Base Products



Standard Mold Bases
Stainless Steel Mold Bases
Aluminum Mold Bases
Special Mold Bases
F.I.T.S.[™] Fast Interchangeable Tooling Systems
Insulator Sheets



Guided Ejection
#3 Steel (A & B Plates)
Return Pins
Pry Slots
Vented Leader Pins
Hoist Ring Holes
Interchangeable Plates
Same Day Order Shipping in Most Cases

A Series
B Series
T Series
AX Series

5 Plates Stripper Series
6 Plate Stripper Series
Shuttle Bases

Plate Thicknesses (A & B Plates)

[illegible]

PCS COMPANY *Standard Aluminum Mold Bases*



Included Features

- 4.0" diameter locating ring hole
- Milled clamp slots
- Ground parting line surfaces
- Four heat treated leader pins and bushings
- Four return pins
- Vented leader pins
- Three piece assembled ejector housing
- Ejector plate includes milled rest buttons
- Beveled corners and edges
- Parting line pry slots
- 3D CAD data available

Benefits of Aluminum

- Up to 40% reduction in cycle time
- Four to five times better thermal conductivity
- Improved machinability
- Aluminum can be welded, ground and textured
- Aluminum is lightweight

Standard Aluminum Frame Sizes and Plate Thicknesses Available

<u>Available Frame Sizes</u>	<u>Plate Thicknesses (A & B Plates)</u>			
	<u>1.94"</u>	<u>2.44"</u>	<u>2.94"</u>	<u>3.44"</u>
8.0" x 8.0"	✓	✓	✓	
8.0" x 10.0"	✓	✓	✓	
8.0" x 12.0"	✓	✓	✓	
10.0" x 10.0"		✓	✓	✓
10.0" x 12.0"		✓	✓	✓
10.0" x 14.0"		✓	✓	✓
12.0" x 12.0"		✓	✓	✓
12.0" x 14.0"			✓	
12.0" x 16.0"			✓	

*Contact PCS for standard aluminum mold base lead times.



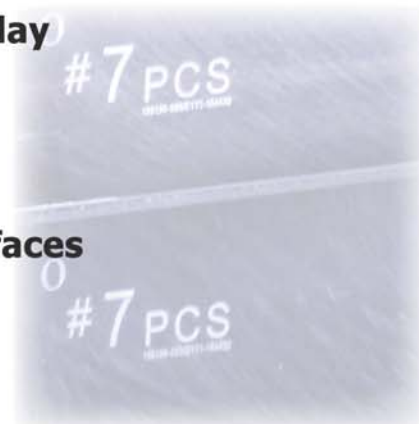


Stainless Steel Standard Mold Bases



Included Features

All plates 420 Stainless Steel (300-340BHN)
 Off the shelf availability
 Most orders ship same day
 Guided Ejection
 Locating Ring
 Sprue Bushing
 Finished stop discs
 Ground parting line surfaces
 Interchangeable Plates
 Return Pins
 Vented Leader Pins
 Hoist Ring Holes
 Pry Slots
 3D CAD Data available



Available Series

A Series

Frame Size	"A" Plate Thickness	"B" Plate Thickness	Rail Height	Part Number
7-7/8" x 7-7/8"	1-3/8"	1-7/8"	3"	88A-13-17-3-SS
			4"	88A-13-17-4-SS
		2-3/8"	3"	88A-13-23-3-SS
			4"	88A-13-23-4-SS
	1-7/8"	1-7/8"	3"	88A-17-17-3-SS
			4"	88A-17-17-4-SS
		2-3/8"	3"	88A-17-23-3-SS
			4"	88A-17-23-4-SS
7-7/8" x 11-7/8"	1-3/8"	1-7/8"	3"	812A-13-17-3-SS
			4"	812A-13-17-4-SS
		2-3/8"	3"	812A-13-23-3-SS
			4"	812A-13-23-4-SS
	1-7/8"	1-7/8"	3"	812A-17-17-3-SS
			4"	812A-17-17-4-SS
		2-3/8"	3"	812A-17-23-3-SS
			4"	812A-17-23-4-SS
9-7/8" x 11-7/8"	1-3/8"	1-7/8"	3"	1012A-13-17-3-SS
			4"	1012A-13-17-4-SS
		2-3/8"	3"	1012A-13-23-3-SS
			4"	1012A-13-23-4-SS
	1-7/8"	1-7/8"	3"	1012A-17-17-3-SS
			4"	1012A-17-17-4-SS
		2-3/8"	3"	1012A-17-23-3-SS
			4"	1012A-17-23-4-SS

PCS **COMPANY** *Special Mold Bases*



PCS Manufacturing

ISO9001:2000 certified manufacturing & quality assurance processes
State of the art modern CNC machinery & tooling
In-house wired EDM pockets with sharp corners, small radius, and tapered walls
Tightest tolerances in the industry
All machine work performed in the U.S.A.
Machined complete to customer CAD file specification
Plant Operations: 24 hours per day, 6 days per week
Materials: Steel, Stainless Steel, Aluminum

Machining Capabilities

Special Milling
Insert Pockets
Lock Pockets
Slide Pockets
Lifter Pockets
Ejector Pin Holes
Angle Pin Holes

Compound Angle Pin Holes
Knock Out Holes
Waterlines
Stripper Bolts
Deep Hole Drilling
Hot Half & Manifolds
Rough Pockets

Finished Pockets
Guided Ejection
Support Posts
Eye Bolt Holes
Pry Bar Slots
Spring Return Holes
Lock Pockets
Secondary & Reversed Leader Pins

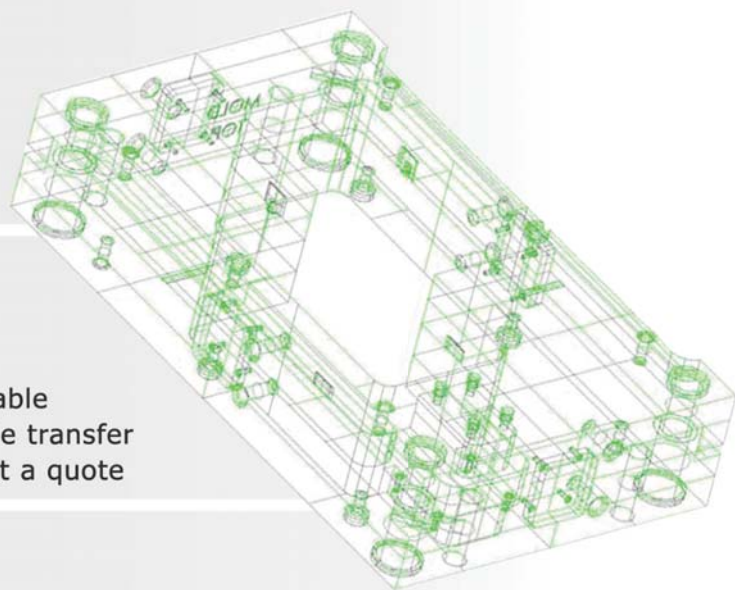
Software Capabilities

CAD Files Accepted

- Solid Works
- Pro/Engineer
- Unigraphics
- CATIA
- Auto CAD
- Cimatron

File Formats Accepted

- Parasolid, Step
- 3D Solid Models



Quotations & Design

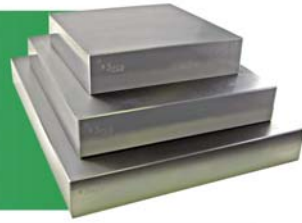
Quick quote turn around time
Mold design review and consultation
Online PCS Standard Mold Base CAD Library available
PCS File Share available for fast and easy large file transfer
E-mail PCS at moldquote@pcs-company to request a quote

Customer Service & Delivery

Knowledgeable
Experienced
Excellent ship on time performance
Customer satisfaction oriented
Utilizing PCS Standard Mold Base sizes assures fastest delivery



Finish Ground Mold Plate



Frame Size	P20 (#3) STEEL PLATE THICKNESS							
	7/8"	1-3/8"	1-7/8"	2-3/8"	2-7/8"	3-3/8"	3-7/8"	4-7/8"
7-7/8" x 7-7/8"	3MP-88-07	3MP-88-13	3MP-88-17	3MP-88-23	3MP-88-27	3MP-88-33	3MP-88-37	3MP-88-47
7-7/8" x 11-7/8"	3MP-812-07	3MP-812-13	3MP-812-17	3MP-812-23	3MP-812-27	3MP-812-33	3MP-812-37	3MP-812-47
9-7/8" x 8"	3MP-108-07	3MP-108-13	3MP-108-17	3MP-108-23	3MP-108-27	3MP-108-33	3MP-108-37	3MP-108-47
9-7/8" x 11-7/8"	3MP-1012-07	3MP-1012-13	3MP-1012-17	3MP-1012-23	3MP-1012-27	3MP-1012-33	3MP-1012-37	3MP-1012-47
9-7/8" x 16"	3MP-1016-07	3MP-1016-13	3MP-1016-17	3MP-1016-23	3MP-1016-27	3MP-1016-33	3MP-1016-37	3MP-1016-47
10-7/8" x 12"	3MP-1112-07	3MP-1112-13	3MP-1112-17	3MP-1112-23	3MP-1112-27	3MP-1112-33	3MP-1112-37	3MP-1112-47
10-7/8" x 14"	3MP-1114-07	3MP-1114-13	3MP-1114-17	3MP-1114-23	3MP-1114-27	3MP-1114-33	3MP-1114-37	3MP-1114-47
10-7/8" x 18"	3MP-1118-07	3MP-1118-13	3MP-1118-17	3MP-1118-23	3MP-1118-27	3MP-1118-33	3MP-1118-37	3MP-1118-47
11-7/8" x 12"	3MP-1212-07	3MP-1212-13	3MP-1212-17	3MP-1212-23	3MP-1212-27	3MP-1212-33	3MP-1212-37	3MP-1212-47
11-7/8" x 15"	3MP-1215-07	3MP-1215-13	3MP-1215-17	3MP-1215-23	3MP-1215-27	3MP-1215-33	3MP-1215-37	3MP-1215-47
11-7/8" x 20"	3MP-1220-07	3MP-1220-13	3MP-1220-17	3MP-1220-23	3MP-1220-27	3MP-1220-33	3MP-1220-37	3MP-1220-47
11-7/8" x 23-1/2"	3MP-1223-07	3MP-1223-13	3MP-1223-17	3MP-1223-23	3MP-1223-27	3MP-1223-33	3MP-1223-37	3MP-1223-47
13-3/8" x 15"	3MP-1315-07	3MP-1315-13	3MP-1315-17	3MP-1315-23	3MP-1315-27	3MP-1315-33	3MP-1315-37	3MP-1315-47
13-3/8" x 18"	3MP-1318-07	3MP-1318-13	3MP-1318-17	3MP-1318-23	3MP-1318-27	3MP-1318-33	3MP-1318-37	3MP-1318-47
13-3/8" x 20-3/4"	3MP-1321-07	3MP-1321-13	3MP-1321-17	3MP-1321-23	3MP-1321-27	3MP-1321-33	3MP-1321-37	3MP-1321-47
13-3/8" x 26"	3MP-1326-07	3MP-1326-13	3MP-1326-17	3MP-1326-23	3MP-1326-27	3MP-1326-33	3MP-1326-37	3MP-1326-47
14-7/8" x 17-7/8"	3MP-1518-07	3MP-1518-13	3MP-1518-17	3MP-1518-23	3MP-1518-27	3MP-1518-33	3MP-1518-37	3MP-1518-47
14-7/8" x 23-3/4"	3MP-1524-07	3MP-1524-13	3MP-1524-17	3MP-1524-23	3MP-1524-27	3MP-1524-33	3MP-1524-37	3MP-1524-47
15-7/8" x 16"	3MP-1616-07	3MP-1616-13	3MP-1616-17	3MP-1616-23	3MP-1616-27	3MP-1616-33	3MP-1616-37	3MP-1616-47
15-7/8" x 20"	3MP-1620-07	3MP-1620-13	3MP-1620-17	3MP-1620-23	3MP-1620-27	3MP-1620-33	3MP-1620-37	3MP-1620-47
15-7/8" x 23-1/2"	3MP-1623-07	3MP-1623-13	3MP-1623-17	3MP-1623-23	3MP-1623-27	3MP-1623-33	3MP-1623-37	3MP-1623-47
15-7/8" x 29-1/2"	3MP-1629-07	3MP-1629-13	3MP-1629-17	3MP-1629-23	3MP-1629-27	3MP-1629-33	3MP-1629-37	3MP-1629-47
17-7/8" x 18"	3MP-1818-07	3MP-1818-13	3MP-1818-17	3MP-1818-23	3MP-1818-27	3MP-1818-33	3MP-1818-37	3MP-1818-47
17-7/8" x 20"	3MP-1820-07	3MP-1820-13	3MP-1820-17	3MP-1820-23	3MP-1820-27	3MP-1820-33	3MP-1820-37	3MP-1820-47
17-7/8" x 23-1/2"	3MP-1823-07	3MP-1823-13	3MP-1823-17	3MP-1823-23	3MP-1823-27	3MP-1823-33	3MP-1823-37	3MP-1823-47
19-1/2" x 23-3/4"	3MP-1924-07	3MP-1924-13	3MP-1924-17	3MP-1924-23	3MP-1924-27	3MP-1924-33	3MP-1924-37	3MP-1924-47
19-1/2" x 29-1/2"	3MP-1929-07	3MP-1929-13	3MP-1929-17	3MP-1929-23	3MP-1929-27	3MP-1929-33	3MP-1929-37	3MP-1929-47
23-3/4" x 23-3/4"	3MP-2424-07	3MP-2424-13	3MP-2424-17	3MP-2424-23	3MP-2424-27	3MP-2424-33	3MP-2424-37	3MP-2424-47
23-3/4" x 29-1/2"	3MP-2429-07	3MP-2429-13	3MP-2429-17	3MP-2429-23	3MP-2429-27	3MP-2429-33	3MP-2429-37	3MP-2429-47

Frame Size	STAINLESS STEEL PLATE THICKNESS				
	7/8"	1-3/8"	1-7/8"	2-3/8"	2-7/8"
7-7/8" x 7-7/8"	7MP-88-07	7MP-88-13	7MP-88-17	7MP-88-23	7MP-88-27
7-7/8" x 11-7/8"	7MP-812-07	7MP-812-13	7MP-812-17	7MP-812-23	7MP-812-27
9-7/8" x 8	7MP-108-07	7MP-108-13	7MP-108-17	7MP-108-23	7MP-108-27
9-7/8" x 11-7/8"	7MP-1012-07	7MP-1012-13	7MP-1012-17	7MP-1012-23	7MP-1012-27
10-7/8" x 14"	7MP-1114-07	7MP-1114-13	7MP-1114-17	7MP-1114-23	7MP-1114-27
11-7/8" x 12"	7MP-1212-07	7MP-1212-13	7MP-1212-17	7MP-1212-23	7MP-1212-27
11-7/8" x 15	7MP-1215-07	7MP-1215-13	7MP-1215-17	7MP-1215-23	7MP-1215-27



Customer Benefits

Fast Tooling Changeovers
In Stock with Same Day Shipment
Lower Tooling Costs
Increased Productivity
Reduced Operating Costs



T-Style



Laminated



Solid



Customer Selected Options

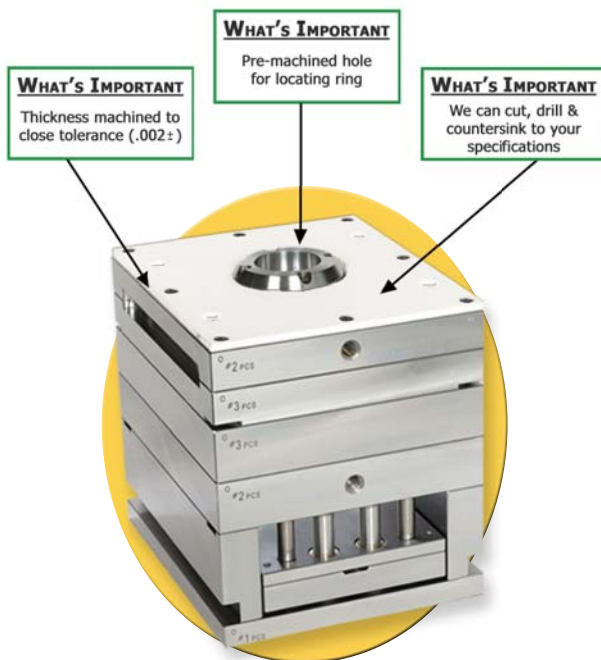
F.I.T.S.™ units are available without guided ejection
Special machining is available (water lines, pockets, ejection, etc)
Replacement components available
Styles: Solid, Laminated & T-Style
Stainless Steel and Aluminum available as special orders

PCS Features

A & B Plates: #3 Steel (All other plates #2 Steel)
Guided ejection included at no extra charge
Plus Style F.I.T.S.™ units include return pins and additional leader pins
Compatible with MUD Quick-Change™ U-Frame Systems.

Series, Size & Style

<u>Series</u>	<u>Insert Size</u>	<u>Style</u>
08/09	5" x 8"	Solid Plus
08/09	5" x 8"	Laminated Plus
08/09	5" x 8"	Solid
08/09	5" x 8"	Laminated
08/09	7.85" x 9"	T-Style
08/10	5" x 9"	Solid
08/10	5" x 9"	Laminated
08/10	7.85" x 9"	T-Style
84/90	6.5" x 8"	Solid
84/90	6.5" x 8"	Laminated
84/90	8.4" x 9"	T-Style
10/12	7" x 10.9"	Solid
10/12	7" x 10.9"	Laminated



Material

Glastherm™

Reinforced Mineral Filled Fiberglass
 Thermosetting Heat Resistant Bonded
 Flame Resistance: UL Subject 94, V-O
 High Compression Strength
 Low Thermal Conductivity
 Asbestos Free
 Oil and Water Resistant
 OE Factory Color: White
 (Often private labeled in blue and orange)
 Machinable With High Speed Cutting Tools
 Thickness Machined to $\pm .002$ "

Options

Pre-Cut Insulator Sheets

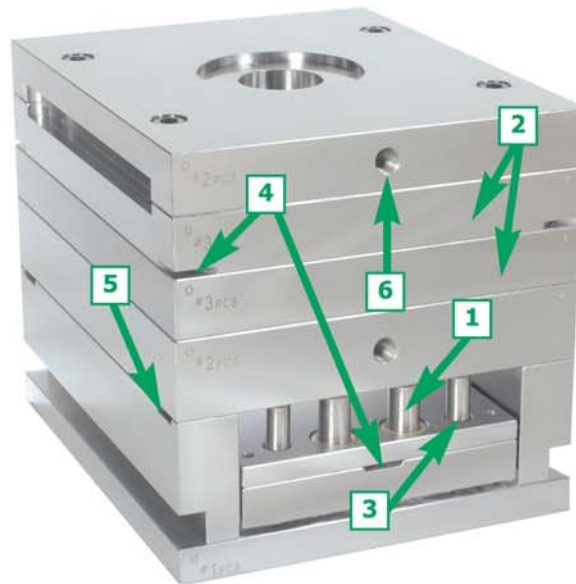
Material: Glastherm™
 Sizes: Available in all PCS Standard Mold Base Sizes
 Thickness: 1/4" or 1/2"
 Available with or without center hole
 In Stock Same Day Shipment

Blank Insulator Sheets

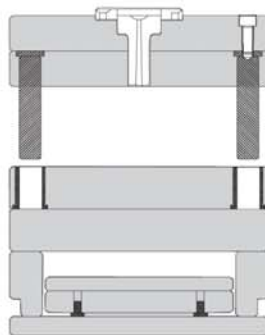
Material: Glastherm™
 Sizes Available: 18"x36", 24"x36", 36"x36"
 Thickness: 1/4" and 1/2"
 In Stock Same Day Shipment

Custom Insulator Sheets

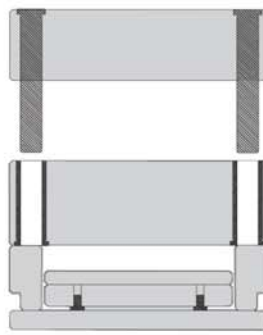
Material: Glastherm™
 Customer Specified Width, Length & Thickness
 Special Machining Available (counter bores, taps, etc)
 Customer Provided Information: 2D Auto CAD DWG File
 7-10 Day Shipment



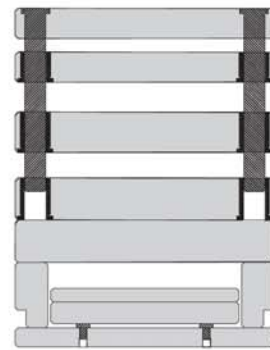
- | | |
|-----------------------------------|-----------------------------|
| 1 Guided Ejection Included | 4 Pry Slots |
| 2 #3 Steel A & B Plates | 5 Vented Leader Pins |
| 3 Relocated Return Pins | 6 Hoist Ring Holes |



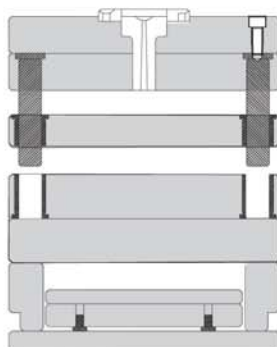
A Series



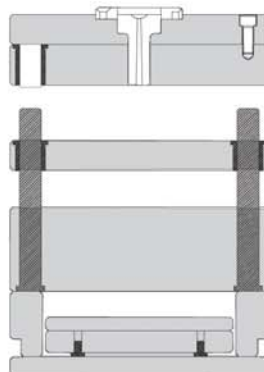
B Series



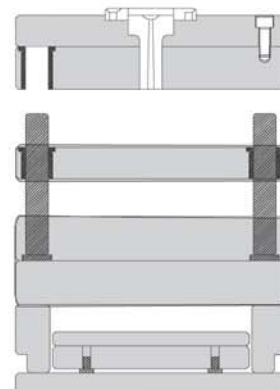
T Series



AX Series



5 Plate Stripper Series



6 Plate Stripper Series

PCS

COMPANY Conversion Charts

Fraction	Decimal	MM
1/64	0.0156	0.3968
1/32	0.0312	0.7937
3/64	0.0468	1.1906
1/16	0.0625	1.5875
5/64	0.0781	1.9843
3/32	0.0937	2.3812
7/64	0.1093	2.7781
1/8	0.1250	3.1750
9/64	0.1406	3.5718
5/32	0.1562	3.9687
11/64	0.1718	4.3656
3/16	0.1875	4.7625
13/64	0.2031	5.1593
7/32	0.2187	5.5562
15/64	0.2343	5.9531
1/4	0.2500	6.3500
17/64	0.2656	6.7468
9/32	0.2812	7.1437
19/64	0.2968	7.5406
5/16	0.3125	7.9375
21/64	0.3281	8.3343
11/32	0.3437	8.7312
23/64	0.3593	9.1281
3/8	0.3750	9.5250
25/64	0.3906	9.9218
13/32	0.4062	10.3187
27/64	0.4218	10.7156
7/16	0.4375	11.1250
29/64	0.4531	11.5093
15/32	0.4687	11.9062
31/64	0.4843	12.3031
1/2	0.5000	12.7000
33/64	0.5156	13.0968
17/32	0.5312	13.4937
35/64	0.5468	13.8906
9/16	0.5625	14.2875
37/64	0.5781	14.6843
19/32	0.5937	15.0812
39/64	0.6093	15.4781
5/8	0.6250	15.8750
41/64	0.6406	16.2718
21/32	0.6562	16.6687
43/64	0.6718	17.0656
11/16	0.6875	17.4625
45/64	0.7031	17.8593
23/32	0.7187	18.2562
47/64	0.7343	18.6531
3/4	0.7500	19.0500
49/64	0.7656	19.4468
25/32	0.7812	19.8437
51/64	0.7968	20.2406
13/16	0.8125	20.6375
53/64	0.8281	21.0343
27/32	0.8437	21.4312
55/64	0.8593	21.8281
7/8	0.8750	22.2250
57/64	0.8906	22.6218
29/32	0.9062	23.0187
59/64	0.9218	23.4156
15/16	0.9375	23.8125
61/64	0.9531	24.2093
31/32	0.9687	24.6062
63/64	0.9843	25.0031
1	1.0000	25.4000

Inch	Metric
1	25.4
2	50.8
3	76.2
4	101.6
5	127.0
6	152.4
7	177.8
8	203.2
9	228.6
10	254.0
11	279.4
12	304.8
13	330.2
14	355.6
15	381.0
16	406.4
17	431.8
18	457.2
19	482.6
20	508.0
21	533.4
22	558.8
23	584.2
24	609.6
25	635.0
26	660.4
27	685.8
28	711.2
29	736.6
30	762.0
31	787.4
32	812.8
33	838.2
34	863.6
35	889.0
36	914.4
37	939.8
38	965.2
39	990.6
40	1016.0
41	1041.4
42	1066.8
43	1092.2
44	1117.6
45	1143.0
46	1168.4
47	1193.8
48	1219.2
49	1244.6
50	1270.0
51	1295.4
52	1320.8
53	1346.2
54	1371.6
55	1397.0
56	1422.4
57	1447.8
58	1473.2
59	1498.6
60	1524.0
61	1549.4
62	1574.8
63	1600.2
64	1625.6
65	1651.0
66	1676.4

QUALITY STEEL SPECIFICATIONS

ISO 9001 CERTIFIED #3 STEEL

NO. 3 STEEL

#3 STEEL IS AN EXTREMELY HIGH QUALITY STEEL (AISI P20) IT IS PRE-HEAT TREATED TO A BHN 280 - 320 (31 - 36Rc). THIS STEEL IS USED IN PCS (A) AND (B) PLATES FOR ITS' DURABILITY AND STRENGTH AS WELL AS GOOD MACHINABILITY .

TYPICAL ANALYSIS

C	MN	P	S	SI	MO	Cr	V
.37%	1.44%	.02%	.008%	.25%	.19%	1.90%	.07%

NO. 2 STEEL

#2 STEEL IS A HIGH STRENGTH, HIGH QUALITY STEEL (AISI 4142) PRE-HEAT TREATED TO A BHN 270 - 300 (30 - 35Rc). IT IS USED IN TOP CLAMP PLATES AND SUPPORT PLATES

TYPICAL ANALYSIS

C	MN	P	S	SI	MO	Cr
.43%	1.44%	.02%	.001%	.30%	.19%	1.0%

NO. 1 STEEL

#1 STEEL IS A MEDIUM CARBON STEEL (SAE 1050) BHN 170 - 220. IT IS A STRONG AND EASY TO MACHINE STEEL USED IN BOTTOM CLAMP PLATES, RAILS AND EJECTOR PLATES

STEEL CERTIFICATIONS AVAILABLE UPON REQUEST!

