

5. Temperature control channels to be in cavities and cores wherever possible.
6. Molding details should be plated for protection unless stainless steel is used.
7. Electroless nickel plating of all water channels is recommended.
8. Taper locks or other similar interlocking devices are required on inserts where extremely tight tolerances must be maintained.
9. Inserts must have leader pins and bushings or some similar guidance system.
10. It is recommended that the entire insert be electroless nickel plated, parkerized or in some similar way protected from rust or corrosion.

CLASS II UNIT INSERT

1. Detailed tool design recommended. Should be approved by customer prior to start of production.
2. Insert retainer to be uniform hardness of at least 165 BHN.
3. Cavities and cores must be of 300 BHN or higher.
4. All other extras are optional.

CLASS III UNIT INSERT

1. Can be constructed from aluminum, cast metal, cast epoxy or any material with sufficient strength to produce at least 500 injection molded pieces.

Additional PURCHASING AIDS available from the SPI Moldmakers Division:

Mold Quotation Forms: Check-box triplicate form simplifies request to quote on new molds for both purchaser and moldmaker . . . \$15.00 per 100.

Directory of Moldmaker Services: Listing of SPI Moldmakers, capabilities and specialities. \$5.00 per copy.

Customs and Practices of the Moldmaking Industry: Practices of the trade, information on the moldmaking industry \$3.00 per copy.

Orders for the above materials should be sent directly to:

Moldmakers Division
 The Society of the Plastics Industry, Inc.
 3150 Des Plaines Avenue
 Des Plaines, IL 60018

Please enclose check payable to SPI.

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