

Technical News Bulletin

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DG 4 -1/4 Mold Holder Inserts

The entire range of the DG 4-1/4 Mold Holder Inserts has been redesigned to enhance performance. Additional upper inserts are now also available for 127 mm (5") mold band diameter to permit full utilization of double row drilling on Verti-Flow blow molds. These new inserts feature:

- Relieved lip design and standardized insert/mold diameter clearance for controlled mold float
- 19 mm (3/4") locating block slot width for increased bearing area of insert lip
- Improved material and hardness for prolonged insert life
- Greater hub support area for reduced wear between insert and mold holder arm
- New shape to distinguish the new inserts from previous ones

The new inserts are directly interchangeable with the previous ones and do not require any alteration of the mold holder arms or mold equipment.

The Selection Table below provides the part number cross reference between the new and superseded inserts. As soon as the new inserts become commercially available, the superseded ones will no longer be manufactured and supplied. Orders for inserts which cite superseded numbers will be automatically updated with new numbers.

Selection Table (Table 1)

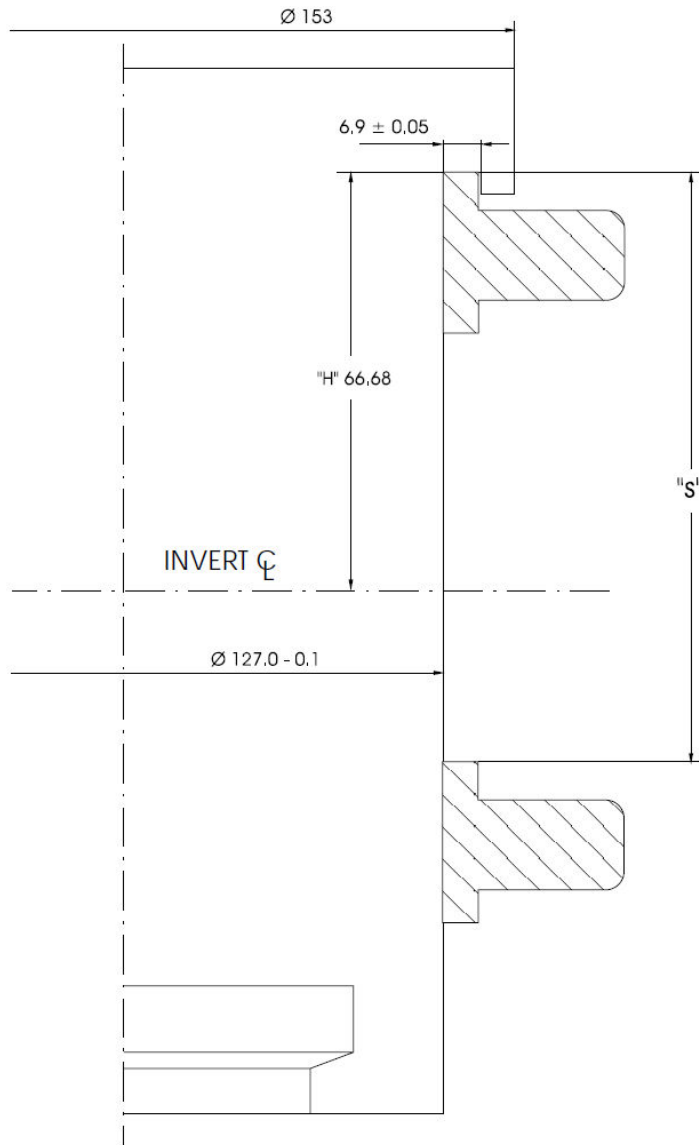
New Part no.	Description	Used on Mtg. Assy. no.	Superseded Part no.
200-127-1	3 3/8" Ø Center Mounted	1	191-5810-20 191-5810-39
200-127-2	3 7/8" Ø Center Mounted	2	191-5810-24
200-127-3	3 7/8" Ø Double Deck, Upper	12, 14, 15	191-5810-17 191-5810-37
200-127-4	3 7/8" Ø Center Mounted, 1 1/2" Offset	4, 5	191-5810-19 191-5810-38

New Part no.	Description	Used on Mtg. Assy. no.	Superseded Part no.
200-127-5	4 5/8" Ø Center Mounted	3	191-5810-23
200-127-6	4 5/8" Ø Double Deck, Upper	13, 16, 17	191-5810-14 191-5810-35
200-127-7	4 5/8" Ø Triple Deck, Upper	19, 21, 25, 26	191-5810-29
200-127-8	4 5/8" Ø Center Mounted, 1/2" Offset	8	191-5810-22
200-127-9	4 5/8" Ø Center Mounted, 1" Offset	11, 22	191-5810-41
200-127-10	4 5/8" Ø Center Mounted, 1 1/2" Offset	6, 7	191-5810-16 191-5810-36 191-5810-44
200-127-11	4 5/8" Ø Center Mounted, 2" Offset	9, 10, 18, 20	191-5810-42
200-127-12	5" Ø Double Deck, Upper	28, 29	-
200-127-13	5" Ø Triple Deck, Upper	30, 31	-
200-127-15	3 7/8" Ø Double Deck, Lower	12, 14, 15	191-5810-18
200-127-16	4 5/8" Ø Double Deck, Lower	13, 16, 17, 18, 20, 22	191-5810-15
200-127-17	4 5/8" Ø Triple Deck, Lower	19, 21	191-5810-34
200-127-18	4 5/8" Ø Triple Deck, Lower	25, 26	191-5810-43
200-128-1	4 5/8" Ø Upper, Tall Ware	27	191-9569-1&2
200-128-2	4 5/8" Ø Lower, Tall Ware	27	191-9570-1&2

All new inserts are furnished with a 19mm (3/4") wide locating block. A special locating block, part no. 191-14004, is available for existing blank or blow molds with a 32.5 mm (1.280") wide locating slot. To benefit from the enlarged bearing area of the inserts, it is recommended that new blank and blow molds be manufactured with a 19.8 mm (0.780") wide locating slot.

The inserts are supplied with a loose bushing. This bushing must be installed on the mold holder inserts which are used on new mold holder arms, part nos. 191-8456 and 191-8504 to correspond with the smaller float limiting pin diameter.

Refer to the *DG 4 -1/4 Mold Design Manual ZG 384/0294* or *Mold Holder Selection Manual ES 145* for the mounting assembly numbers listed in **Table 1**. The new mounting assembly numbers 28 - 31 specifically for the 127 mm (5") mold diameter which are not listed in these manuals correspond in terms of design to the mounting assembly numbers 13, 17, 19 and 21 as indicated in **Fig. 1**.



Mounting Assy. no.	Description	"S" Dimension	Reference Mtg. Assy. no.
28	Double Deck	120.7	13
29	Double Deck	146.1	17
30	Triple Deck	120.7	19
31	Triple Deck	146.1	21