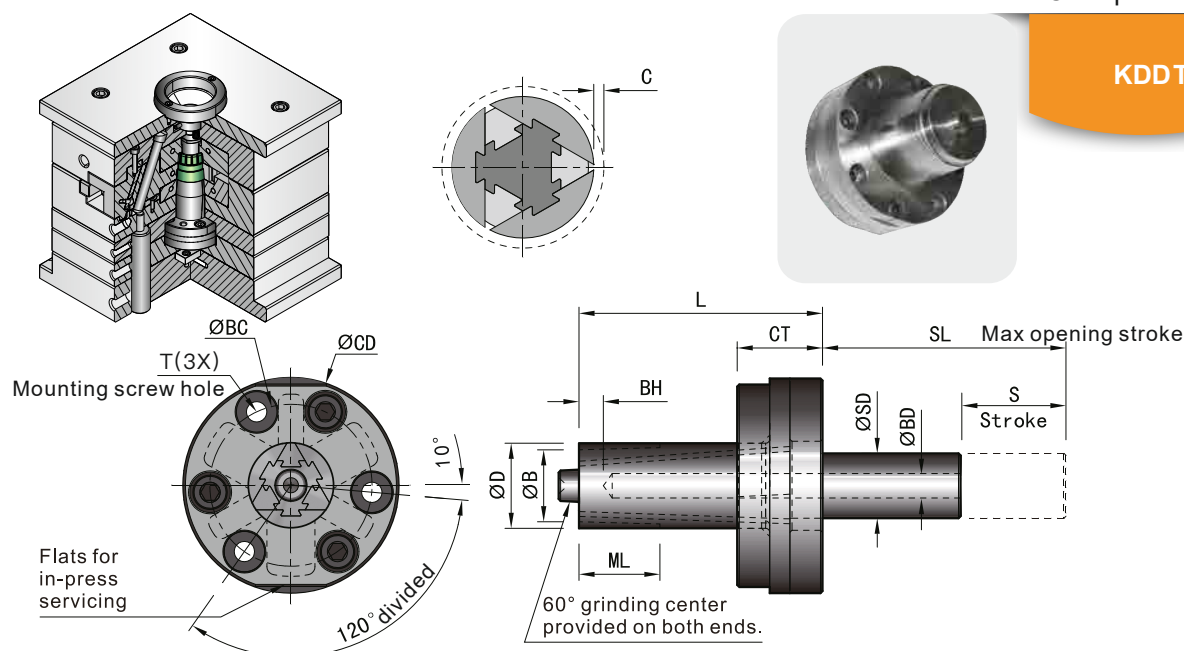


Collapsible core



D	B +3° Single side	ML	C	CD +0/-0.05	CT ±0.05	L +0.01/-0	SL
21	17	22	1.1	53	21	60	
33	25	28	1.6	60	22	67	60
42	33	43	2.1	76	28	85	
54	42	50	2.4	98	37	104	70

Code	SD +0/-0.02	BD	BH	BC	S	T	
KDDT-18	16	6	6	40	34	M5×25	
KDDT-28	20	8	8	47	38		
KDDT-38	25	10	10	60	54	M6×35	
KDDT-48	30	12	12	78	62	M8×40	



Features:

- 1.Design of scalability structure by mechanical.
- 2.Stroke:5%~7% for per side.
- 3.Instead of expensive pinion and rack.
- 4.Only needs small space for installation.
- 5.Shorten the mold manufacturing cycle.
- 6.Within waterway.
- 7.Provide a variety of standard types for choice,and also customer made
- 8.The structure is more simple than rotary unwound thread mechanism.

Collapsible core

KDDT



General thread design

Right ✓

Wrong ✗

DDT core thread design

Right ✓

Right ✓



Right ✓

Wrong ✗

Right ✓

Right ✓

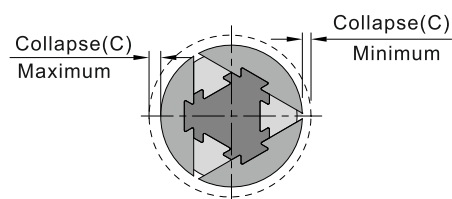
KDDT-18					
Diameter(D)		Collapse(C)		Stroke(S)	
mm.	in.	mm.	in.	mm.	in.
21	0.827	0.5	0.02	19.5	0.768
20	0.787	0.71	0.028	27	1.063
19	0.748	0.92	0.036		
18	0.709	0.98	0.039	34	1.339
17	0.669	1.05	0.041		

KDDT-28					
Diameter(D)		Collapse(C)		Stroke(S)	
mm.	in.	mm.	in.	mm.	in.
33	1.299	0.98	0.039	34.5	1.358
32	1.26	1.11	0.044		
31	1.22	1.14	0.049		
30	1.181	1.19	0.047		
29	1.141	1.23	0.048		
28	1.102	1.28	0.050	38	1.496
27	1.062	1.33	0.052		
26	1.024	1.39	0.055		
25	0.984	1.45	0.057		

Features:

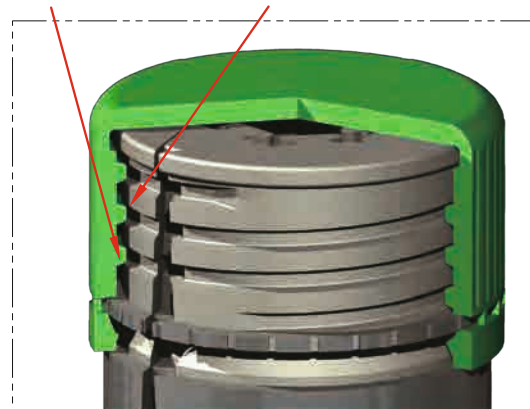
1. General threads are designed to be unscrewed out of the mold which could not position the threads accurately, DDT threads only where you need them.
2. General threads designed to be stripped snap bead that normally require large radii for release. DDT core snap bead can be flat also.

KDDT-38					
Diameter(D)		Collapse(C)		Stroke(S)	
mm.	in.	mm.	in.	mm.	in.
42	1.654	1.16	0.046	41	1.614
41	1.614	1.37	0.054	48	1.89
40	1.575	1.57	0.062		
39	1.535	1.61	0.063		
38	1.496	1.66	0.065		
37	1.457	1.71	0.067	54	2.126
36	1.417	1.76	0.069		
35	1.378	1.82	0.072		
34	1.339	1.88	0.074		
33	1.299	1.94	0.076		



Calculating required collapse vs undercut depth:

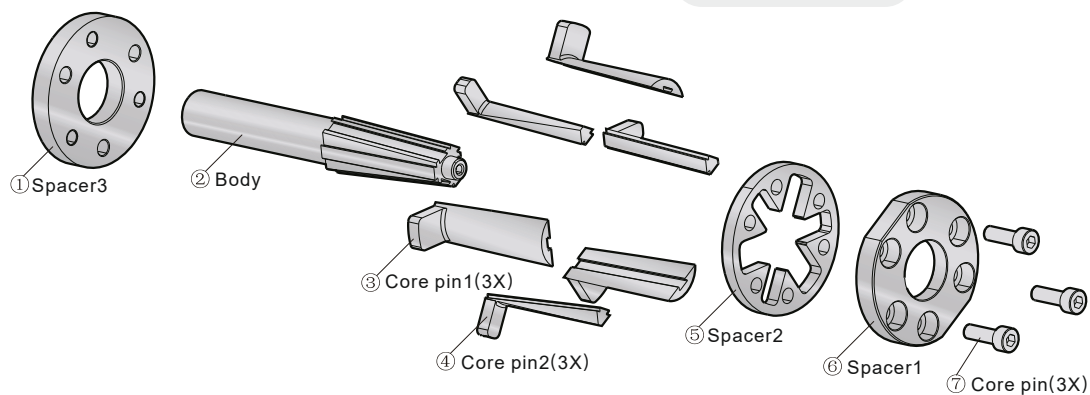
$$\bullet \text{ Undercut} + \text{Shrink} + \text{Clearance} = \text{Total Collapse Req'd}$$



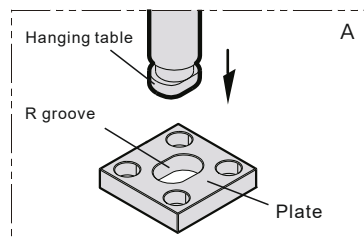
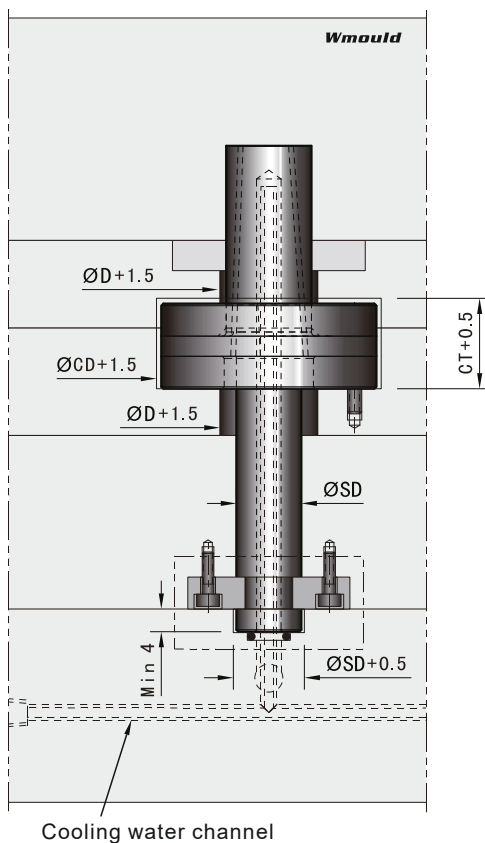
Collapsible core

KDDT

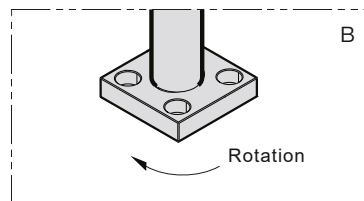
Product space chart:



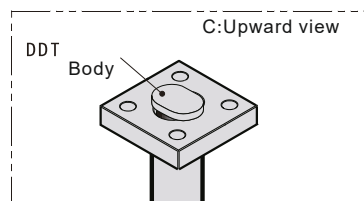
Installation Diagram:



A: The hang of the body will be inserted in R groove of plate.



B: The body will be rotated 90°, and make it lock with plate.



C: The position which the hang lock plate as show on the left.

Body quickly install diagram

Collapsible core

KDDT

Installation Guidelines:

- MUST confirm proper sequence with mold builder.
- NOTE: If DDT Core is shutting off on steel to form a feature (ie: hole), the shut off must be separated prior to DDT Core collapse. Also, the DDT Core must be fully expanded before shut off comes into position.
- Confirm press is capable of achieving proper sequence.
- Confirm plates are staging forward without binding while on the bench. Verify DDT center pin is flush to slightly proud of segments and verify stack heights.

Functional chart:

