

## Standard Unit Dies



### For Zinc and Aluminum Die Casting

How long does it take to remove a die from a press and replace it (die changeover)? "For small dies," die casters say, "it can take one and a half to two hours. For large dies... two days, three days, sometimes four days." Downtime like this is unacceptable for die casters. That's why so many of them are now investing in D-M-E Standard Unit Die Holders for both long and short run zinc and aluminum die casting.

### 20-MINUTE DIE CHANGEOVERS

D-M-E Standard Unit Die Holders and Replacement Units are "made for each other." They're designed and ground to such close tolerances that die casters can remove Replacement Units from the Holders and put new ones in within 20 minutes or less. This cuts downtime and enables a die caster to increase productivity and profitability on both long- and short-run jobs.

### FOUR TYPES OF HOLDERS

You can get four types of Standard Unit Die Holders from D-M-E: Single Unit; Double Unit; Single Heavy-Duty Unit; Double Heavy-Duty Unit. They are precision engineered and constructed of high quality die steels to withstand the increasingly higher pressures and injection speeds of today's die casting machines.



### STANDARD REPLACEMENT UNITS

D-M-E Standard and Standard Heavy-Duty Replacement Units are precision made and completely interchangeable when used with their matching Standard and Standard Heavy-Duty Unit Die Holders. Replacement Units are available in D-M-E No. 2, No. 3, or No. 5 Steel. The more popular sizes are carried in stock for immediate delivery.

#### D-M-E NO. 2 STEEL

An AISI 4130 type steel. It is pre-heat treated to approximately 302 Bhn (32 HRC) to withstand the peening effects of flash. Its high-strength steel is ideal for applications where cavity inserts will be used in the Replacement Units.

#### D-M-E NO. 3 STEEL

An exceptionally clean P-20 AISI 4130 (modified) type cavity steel, pre-heat treated to 277-321 Bhn (28-35 HRC). It provides high hardness, good machinability, and exceptional polishability. It also provides excellent tool life, especially for zinc die cast dies.

#### D-M-E NO. 5 STEEL

A thermal-shock resistant, hotwork die steel (H-13 type). Supplied fully annealed, approx. 200 Bhn (93 HRB), for easy machinability, it can be subsequently heat treated to the desired hardness with a minimum of deformation. Ideal for aluminum and most long run die casting applications. D-M-E No. 5 Steel meets or exceeds the acceptance criteria established by the NADCA as detailed in Technical Digest Number 01-80-01 D.

**REPLACEMENT UNITS IN ANY STEEL OR HARDNESS REQUIRED ARE AVAILABLE ON SPECIAL ORDER**

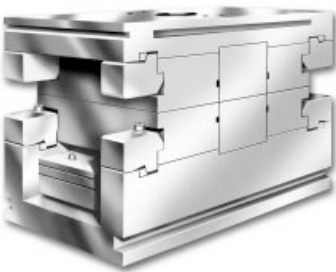
## Standard Unit Dies



D-M-E STANDARD SINGLE UNIT DIE HOLDER  
WITH REPLACEMENT UNIT



D-M-E STANDARD DOUBLE UNIT DIE HOLDER  
WITH REPLACEMENT UNITS



D-M-E STANDARD HEAVY-DUTY DOUBLE UNIT DIE  
HOLDER WITH REPLACEMENT UNITS

### For Zinc and Aluminum Die Casting

#### Pre-Engineered Design Features

- Maximum Cavity Area for Greater Range of Jobs**

Three sides of Replacement Units are open for placement of core slides or water lines

- Rigid Center Section for Longer Die Life**

Center Section is made from D-M-E No. 5 Steel (H-13 type) heat treated to 42-46 Rockwell C. Upper and lower halves are recessed for added rigidity

- Accurate Alignment for Minimum Wear**

Six Leader Pins and six Return Pins (four of each in Single Unit Holders) provide better alignment and permit uniform control of Ejector Plate

- Positive Locking of Interchangeable Units**

Precision made center section has solid horizontal and vertical keys for positive locking of Replacement Units. Pry-bar slots facilitate removal of units

- Wedge Clamps and Solid Steel Wedge Locks "Beef Up" Safety**

To "beef up" safety and speed die changeovers, D-M-E Single and Double Unit Die Holders are equipped with wedge clamps with heavy-duty socket screws. D-M-E Single and Double Heavy-Duty Unit Die Holders have solid steel wedge locks for the same purposes

On the smaller D-M-E Single and Double Unit Die Holders a specially developed "space-saver" design with heavy-duty socket screws makes equally fast die changeovers possible

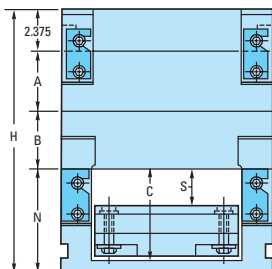
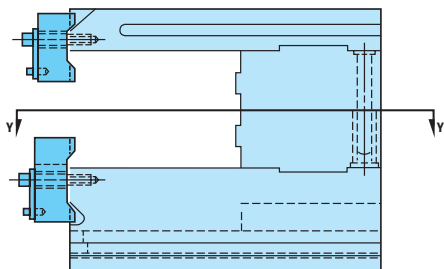
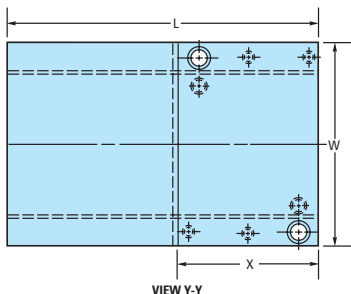
- Designed for Zinc or Aluminum Applications**

Available with Water-cooled Sprue Spreader and Bushing installed for zinc or with shot-sleeve hole bored to specifications for aluminum die casting

# Single Unit Die Holders

## For Zinc and Aluminum Die Casting

U.S. Pat. No. 2956321  
Can. Pat. No. 620895



### DCS-1012, DCS-1215 and DCS-1518 SINGLE UNIT DIE HOLDERS

#### CENTER SECTION

No. 5 Steel (H-13 type), pre-heat treated to approx. 200 Bhn (94 HRB)

#### TOP CLAMPING PLATE

No. 2 Steel (AISI 4130 type), pre-heat treated to 369-321 Bhn (28-34 HRC)

#### EJECTOR HOUSING

1012 and 1215: High Carbon Steel, pre-heat treated to approx. 300 Bhn (32 HRC)

1518: No. 2 Steel (AISI 4130 type), pre-heat treated to 271-321 Bhn (28-34 HRC)

#### FOR ZINC

Spreader and Bushing specified will be installed. Cost of Spreader, Bushing and installation included in List Prices.

#### FOR ALUMINUM

Straight shot sleeve bored to your specifications included in List Prices. (Please supply a dimensioned drawing.)

ITEM NUMBER	W	L	H	N	C	S	X	A	B	NET WEIGHT	REPLACEMENT UNIT SIZE
DCS-1012-A DCS-1012-Z	11.875	17.875	15.125	6.000	5.125	2.0625	8.000	3.375	3.375	535	9.875 x 11.875
DCS-1215-A DCS-1215-Z	14.875	21.000	16.250	6.125	5.250	2.0625	9.125	3.875	3.875	835	11.875 x 14.875
DCS-1518-A DCS-1518-Z	17.875	24.000	18.125	7.000	5.625	2.3125	9.125	4.375	4.375	1296	14.875 x 17.875

ITEM NUMBERS SHOWN ARE FOR UNIT HOLDERS ONLY AND DO NOT INCLUDE THE REPLACEMENT UNITS, SEE PAGE 17.  
FOR OTHER REPLACEMENT PARTS, SEE PAGE 19.