



NOTES

- MOLD HEIGHT: MINIMUM = 5", MAXIMUM = 7-1/2"
- SPRUE SEAT OR BUSHING: USE 1" DIA BALL END MILL, BORE 3/32" TO 1/8" DEEP, OR UNTIL "DIMPLE" IS 5/8" DIA.
- SPRUE DIAMETER: 7/32" AT NOZZLE END FOR "B" OR ANTI-DROOL, 5/32" AT NOZZLE END FOR "A".
- NOZZLES: ALL BALL NOZZLES HAVE 1/2" SPHERICAL RADIUS
 STD "A" NOZZLE = 1/8" DIA ORIFICE
 STD "B" NOZZLE = ANTI-DROOL NOZZLE = 3/16" DIA ORIFICE
 STD "C" NOZZLE = 1/4" DIA ORIFICE

UPPER PLATEN ASSEMBLY WITH SEMI-AUTO MOLD
SET-UP FOR MORGAN PRESS

SCALE: 1/4	APPROVED BY:	DRAWN BY STT
DATE: 4/78		REVISED 10/5/81
		REVISED 6/22/84
MORGAN INDUSTRIES, INC.		DRAWING NUMBER