**GUIDE FOR SLIDE CORE UNITS FOR TWO-COLOR INJECTION MOLD**

**What is Slide Core Units for Two-color Injection Mold?**

When there is an undercut on the two-color injection molded product processed by outer slide, specially-structured slide core that can keep the undercut part even after the primary molding is necessary. It achieves space saving and facilitates design and assembly adjustment.

**Sequence of operating the slide core unit for two-color injection mold**

1. **Primary molding**
   - Mold opening condition
   - Mold closing (the slide core is advanced by the primary side angular cam, causing the slide core to lock), and molding of the first color
   - Mold opening while the primary molded product (undercut part) is supported
   - Mold closing (the slide core is locked by the secondary side angular cam), and molding of the second color

2. **Secondary molding**
   - The movable side mold plate rotates while the molded product is supported.
   - Mold opening (the slide core is retracted to its initial position by the secondary side angular cam), and removal of the molded product
   - Mold closing process
   - Angular Cam (a), (b)

**Part Number | ST | W**
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SCTM | 3 | 13

- **Angular Cam**
  - ST: Slide stroke amount
  - R0.3: 0.02
  - R1: 0.02

- **Slide Core**
  - ST: Slide stroke amount
  - R0.3: 0.02
  - R1: 0.02

- **Guide Rail**
  - ST: Guide stroke amount
  - R0.3: 0.02
  - R1: 0.02

**Characteristics**

1. **Compact**
   - A special construction using a lock pin was employed for maximum compactness.
   - It is possible to reduce the mold size by one rank or more.

2. **With slide core lock function**
   - Ball plunger leads to stable operation of the slide core.
   - Total cost reduction
   - The angular cam, slide core and guide rail come in a set, which does not require oblique hole boring, resulting in process cost savings. (Please procure the core part via in-house production.)
   - Eliminates the complex calculation such as the slide stroke, etc.

**Notes**

- This product is developed for injection molding die. Do not use for other purposes.
- Be sure to apply grease to the sliding surface to prevent it from burning.