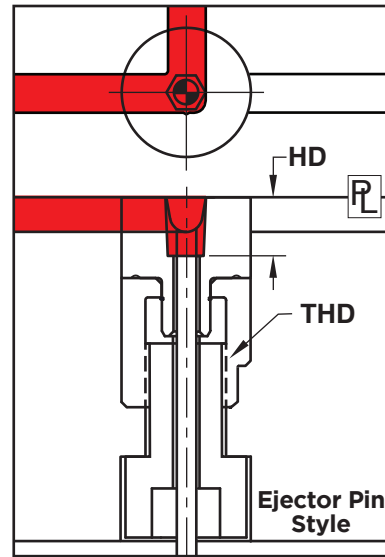
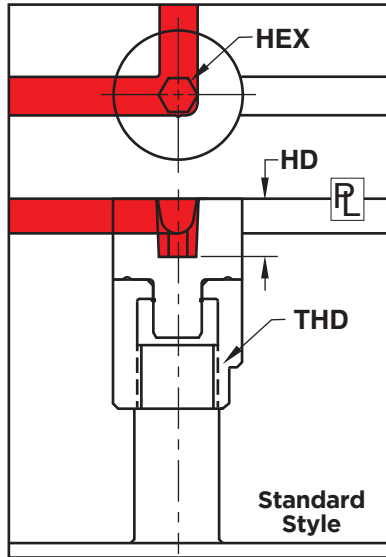




RUNNER TURN OFF

APPLICATION GUIDELINES

- Runner Turn Off inserts provide a reliable position of material flow.
- Hex with 2° taper provided for rotating insert.
- Runner Turn Offs utilize detents positioned in 45° increments.
- Machining is straightforward with two flats provided on top and bottom rings to hold in place without risk of spinning.
- Press fit flat (PF) is provided for orientation during installation.
- Recommended runner guidelines are provided on the following page.
- Ejector Pin version is supplied with 5/8-11 x 2" SHCS. Modify the length to suit.
- For removal, a spare 5/8-11 bolt must be used to strike from back in order to overcome the press fit.

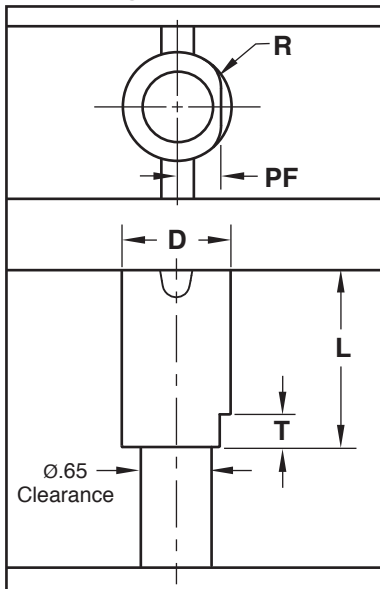


M 420 Stainless **H** 30-34 HRC

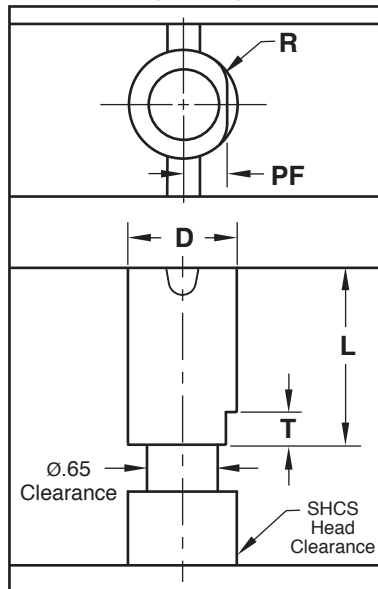
EJ PIN SIZE	D	L	T	R	PF	HD HEX DEPTH	HEX	THD
-	1.000	1.625	.300	.312	.400	.45	1/4	5/8-11
3/16								

▶ CAD insertion point

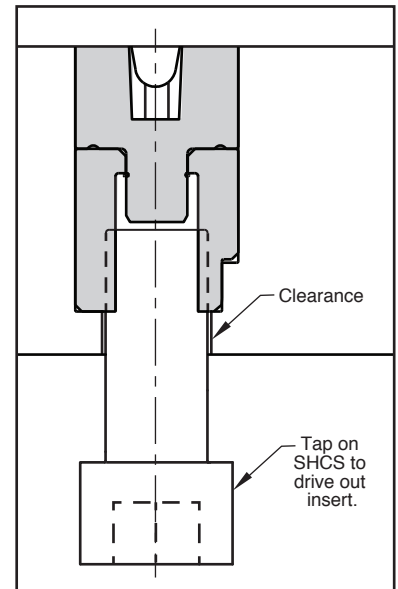
Machining for Standard RTO



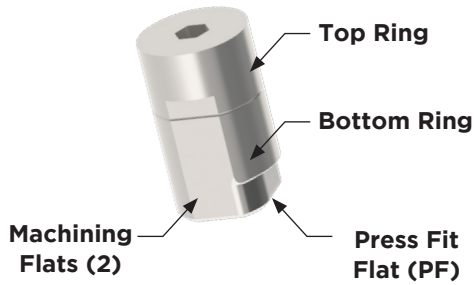
Machining for Ej Pin RTO



Removal

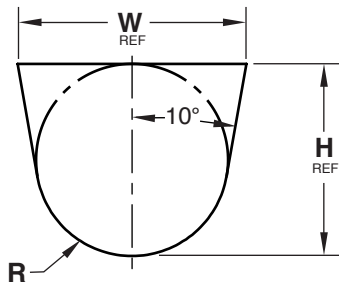


RUNNER TURN OFF



RUNNER MACHINING GUIDELINES

- Runner Turn Offs have two machining flats to prevent spinning when holding the assembly in a vise.
- Refer to the table below for recommended runner geometry.
- Maximum machining depth (H) is .313.



RUNNER SIZE	H	R	W	AREA (SQ. INCH)
3/32	.094	.047	.112	.008
1/8	.125	.063	.149	.015
5/32	.156	.078	.186	.023
3/16	.188	.094	.223	.033
7/32	.219	.109	.261	.045
1/4	.250	.125	.298	.059
9/32	.281	.140	.335	.075
5/16	.313	.156	.372	.092

Possible Runner Configurations

