

Cope & Drag Inserts



Style "A"

Since the invention of our inserts in 1986, we are now producing 12 different sizes of styles "A" and "B" inserts. We have sold more than 1 million inserts both in domestic and international markets. Our style "B" inserts are specially designed for matchplates and gives the automatic molding machines the edge to produce perfect castings.

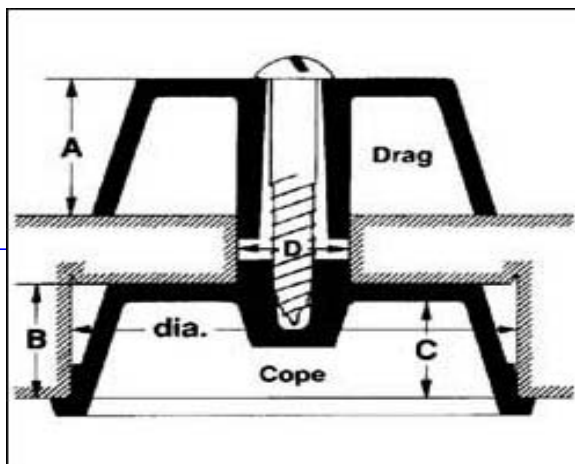


Style "B"

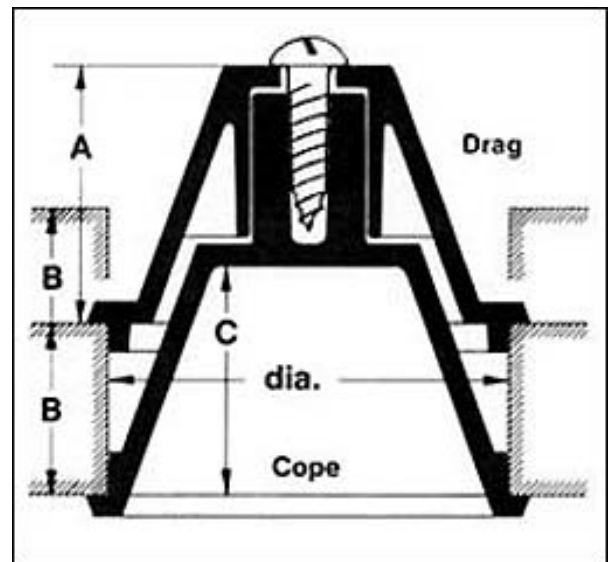
Cope & Drag Inserts create a quick, simple and accurate alignment of cope & drag mold halves. They eliminate the need for line up cores, are easily installed, and guarantee a perfect match every time. Use them on matchplates, matchboards, insert or cope & drag boards, in molding boxes for flaskless molding, on automatic molding machines for core alignment, etc....

Once you have used them, experienced the efficiency and time savings they provide, you will use them for all your mounted patterns. Two or three inserts are all it takes to correct any wear on pins or misalignment problems you may have. They work independent from alignment pins, are mounted next to patterns, and create holes and corresponding buttons in each mold half. They are used in greensand, airset/no bake molding, in vacuum molding for sand - castings, on automatic molding machines, and many other ways.

INSERT STYLE "A"



INSERT STYLE "B"



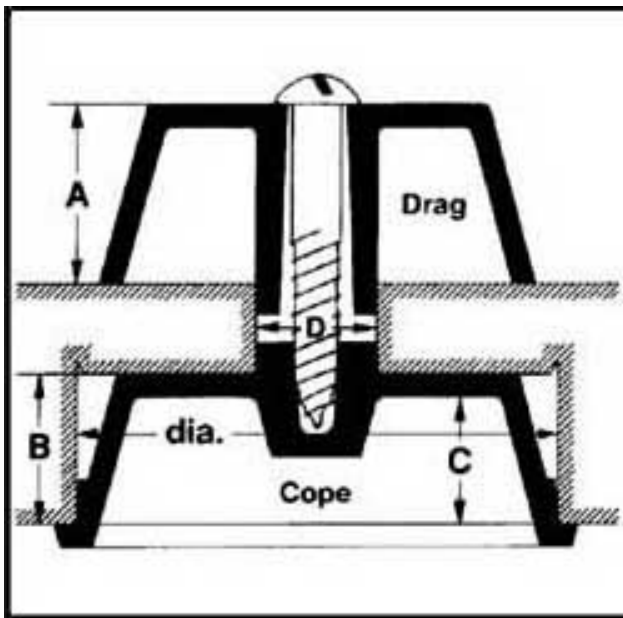
We have two different styles of inserts: style "A" and style "B". Both have mounting rims, which guarantee the correct depth of the cope insert. These rims and the additional height of the drag insert, leave impressions in the sand which become sand traps, necessary for flaskless molding. They also make it possible to use either insert half on the cope or drag side.

As a pattern maker for over 55 years with quality and reliability in mind, I have designed, tested, and retested our inserts, and I guarantee them to be the fastest and easiest way of creating perfect alignment of mold halves for the best quality castings possible!" - Adolf

Our Products are 100% Guaranteed and

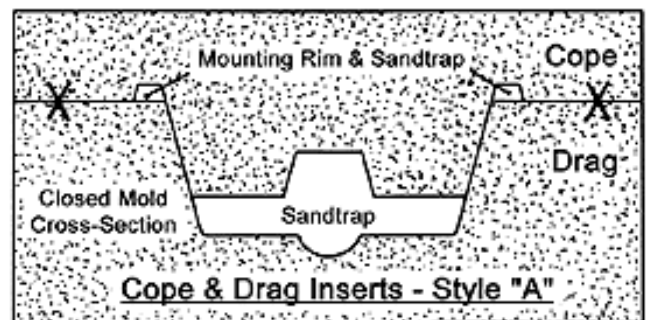
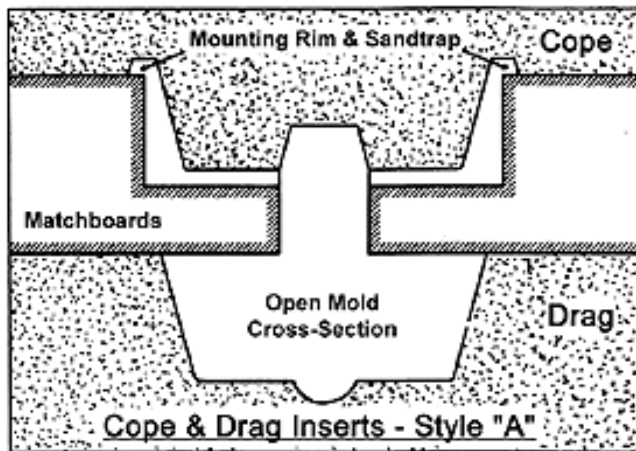
C&D Inserts - Style "A"

Style "A" Inserts consist of two parts: one drag and one cope half. They are used in two ways: mounted on matchboards one above the other, or separated like on cope & drag boards or molding boxes. They are available in 4 sizes and 3 different depths, and are made out of ABS plastic.



Style "A" Sizes					
#	1.5A	2A	2.5AA	2.5A	3.5A
dia.	1.5	2	2.5	2.5	3.5
A	.5	.750	1.25	1.25	1.25
B	.5	.625	.625	1	1
C	.437	.531	.531	.906	.906
D	.375	.5	.5	.5	.5

NOTE: The 2.5A drag insert halves are also used for 2.5AA size inserts.

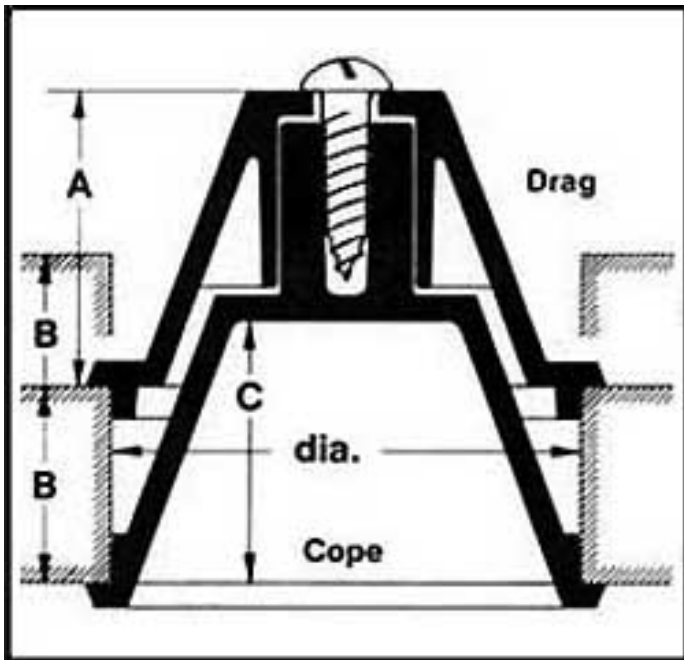


Cross-section of Mold Halves showing Cope & Drag Insert alignment system.

C&D Inserts - Style "B"

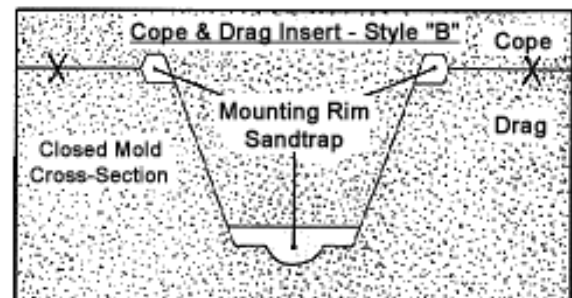
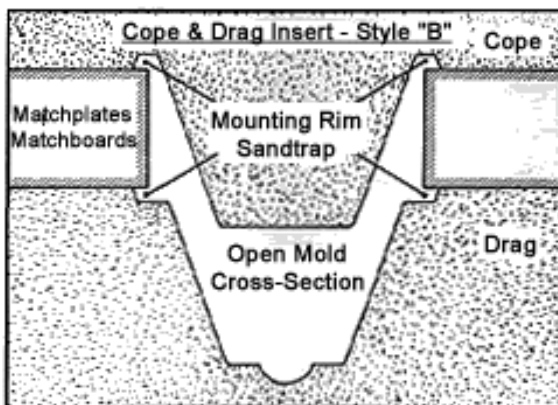
Style "B" Inserts consist of two parts specifically designed for matchplates and matchboards including automatic molding machines. Both halves telescope together, and interlock at the parting lines in a hole through plates or boards of various thickness.

Their interlocking creates the deepest matching buttons possible. On 3/8" or 1/2" thick plates they produce 3/4" or 1" deep buttons. They can be mounted from either side, and one screw will keep both halves securely mounted. **Style "B" Inserts** are made out of a **tough new, non-sticking and acid-resisting plastic** and are available in 4 different sizes and 3 different depths.



Style "B" Sizes				
#	1.12B	1.5B	1.75B	2.5B
dia.	1.12	1.5	1.75	2.5
A	1	.875	1.125	1.125
B	.5 - 1.125	.5 - 1.125	.625 - 1.125	.75 - 1.25
C	.875	.75	1	1

Style "B" Inserts are usable on materials of various thickness. Note the above chart.



Cross-section of Mold Halves showing Cope & Drag Insert alignment system.

Our Products are 100% Guaranteed

How to Modify Style "B" Inserts for Thinner Plates or Boards

Inserts #1.5B are produced for plates of 1/2" and thicker. Remove 1/8" from the length of the stem of the cope insert halves, and it will fit on 3/8" plates. Then hold the drag insert half in a jig in a lathe, and remove .010" from the inside wall. Also reduce the height of the collet and ribs by 1/8".

Inserts #1.75B are produced for plates of 5/8" and thicker. We have changed our drag die, so that only the stem of the cope insert half needs to be reduced by 1/8", and both halves are ready for 1/2" plates. We left the stem 1/8" longer than they originally for 5/8" plates for better interlocking on thicker plates or boards.

Inserts #2.5B are produced for plates or boards of 3/4" and thicker. To make them fit on thinner plates remove just like for #1.5 "B" Inserts the amount of material needed (minimum 1/2" plates).

All our style "B" inserts are made out of a tough new, non-sticking and acid resistant plastic, and are available in 4 sizes and 3 different depths.

To install our inserts easily into wood we designed a cutterholder with a long 1/2" diameter pilot, and with interchangeable cutting blades for all sizes of our inserts.

Also available is a short video tape explaining the advantages of our insert. Showing how to install them, and when to use style "A" or style "B" inserts.



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