

Common Specification Table–MT version

The draft angle is 1° -1.5° per thousandth of an inch

Mold-Tech A			Mold-Tech B		
Ptn. #	Depth	Angle	Ptn. #	Depth	Angle
MT-11000	0.0004	1°	MT-11200	0.003	4.5°
MT-11010	0.001	1.5°	MT-11205	0.0025	4°
MT-11020	0.0015	2.5°	MT-11210	0.0035	5.5°
MT-11030	0.002	3°	MT-11215	0.0045	6.5°
MT-11040	0.003	4.5°	MT-11220	0.005	7.5°
MT-11050	0.0045	6.5°	MT-11225	0.0045	6.5°
MT-11060	0.003	4.5°	MT-11230	0.0025	4°
MT-11070	0.003	4.5°	MT-11235	0.004	6°
MT-11080	0.002	3°	MT-11240	0.0015	2.5°
MT-11090	0.0035	5.5°	MT-11245	0.002	3°
MT-11100	0.006	9°	MT-11250	0.0025	4°
MT-11110	0.0025	4°	MT-11255	0.002	3°
MT-11120	0.002	3°	MT-11260	0.004	6°
MT-11130	0.0025	4°	MT-11265	0.005	7°
MT-11140	0.0025	4°	MT-11270	0.004	6°
MT-11150	0.00275	4°	MT-11275	0.0035	5°
MT-11160	0.004	6°	MT-11280	0.0055	8°

Mold-Tech C			Mold-Tech D		
Ptn. #	Depth	Angle	Ptn. #	Depth	Angle
MT-11300	0.0025	3.5°	MT-11400	0.002	3°
MT-11305	0.005	7.5°	MT-11405	0.0025	4°
MT-11310	0.005	7.5°	MT-11410	0.0035	5.5°
MT-11315	0.001	1.5°	MT-11415	0.002	3°
MT-11320	0.0025	4°	MT-11420	0.0025	4°
MT-11325	0.003	4.5°	MT-11425	0.0035	5.5°
MT-11330	0.002	3°	MT-11430	0.007	10°
MT-11335	0.002	3°	MT-11435	0.010	15°
MT-11340	0.003	4.5°	MT-11440	0.0005	1.5°
MT-11345	0.003	4.5°	MT-11445	0.0015	2.5°
MT-11350	0.0035	5.5°	MT-11450	0.0025	4°
MT-11355	0.0025	4°	MT-11455	0.003	4.5°
MT-11360	0.0035	5.5°	MT-11460	0.0035	5.5°

MT-11365	0.0045	7°	MT-11465	0.005	7.5°
MT-11370	0.004	6°	MT-11470	0.002	3°
MT-11375	0.004	6°	MT-11475	0.002	3°
MT-11380	0.004	6°	MT-11480	0.003	4.5°

Plaque #6		Plaque #7		Plaque #8		Plaque #10	
Ptn. #	Depth	Ptn. #	Depth	Ptn. #	Depth	Ptn. #	Depth
MT229	0.003	MT325	0.003	MT588	0.0085	MT980	0.004
MT392	0.004	MT964	0.003	MT888	0.013	MT901	0.003
MT585	0.0035	MT1038	0.002	MT1028	0.0035	MT945	0.0065
MT889	0.004	MT1043	0.002	MT1067	0.013	MT970	0.002
MT1013	0.003	MT1170	0.0025	MT1149	0.013	MT972	0.0025
MT1015	0.0055	MT1192	0.0015	MT1153	0.0075	MT973	0.0035
MT1039	0.003	MT1239	0.003	MT1211	0.0095	MT974	0.0025
MT1055	0.0055	MT1240	0.003	MT1226	0.0035	MT978	0.003
MT1068	0.0055	MT1241	0.002	MT1227	0.0035	MT985	0.0025
MT1070	0.007	MT1242	0.002	MT1228	0.0095	MT1055-1	0.0001
MT1074	0.0055	MT1243	0.002	MT1230	0.013	MT1055-2	0.0045
MT1129	0.003	MT1244	0.0025	MT1232	0.003	MT1055-3	0.0005
MT1159	0.008	MT1250	0.003	MT1233	0.0035	MT1055-4	0.0075
MT1122	0.0015	MT2019	0.0025	MT1234	0.0035	MT1055-5	0.001
MT1125	0.006	MT2020	0.002	MT1235	0.0035	MT1055	0.0015
MT1126	0.0065	MT2028	0.0025	MT1236	0.0035	MT1055-6	0.0017
MT1127	0.0025	23053	0.002	MT1238	0.0045	MT1055-7	0.0225
MT1526	0.0135	23064	0.0015	23031	0.0085		

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Texture No.	Draft angle	AVG μ	Brightness	Processing type
HN-DS11	1°	5 ~ 7	800	Sandblasting
HN-DS12	1.5°	10 ~ 13	600 ~ 800	
HN-DS13	2°	12 ~ 15	600 ~ 800	

HN-DS14	2°	13 ~ 19	600 ~ 800	Chemical texture
HN-DS01	3°	25 ~ 30	320	
HN-DS02	4°	35 ~ 40	320	
HN-DS03	4°	36 ~ 42	320	
HN-DS04	4.5°	38 ~ 43	320	
HN-DS05	1.5°	9 ~ 13	800	
HN-DS06	2°	14 ~ 19	800	
HN-DS07	2.5°	19 ~ 24	600	
HN-DS08	3°	25 ~ 30	400	
NO. 1	2°	8~9	#400	
NO. 2	2.5°	15~16	#400	
NO. 3	3°	15~17	#400	
NO. 4	3.5°	16~18	#400	
NO. 5	4°	20~23	#400	
NO. 6	4.5°	25~30	#400	
NO. 7	6°	40~42	#320	
NO. 8	6°	57~60	#320	
NO. 9	6°	60~66	#320	
NO. 1	1°	1.7	Mirror surface	
NO. 2	1°	1	Mirror surface	
NO. 3	1°	1.4	Mirror surface	
NO. 4	1°	1.8	1000	
NO. 5	1°	2.9	1000	
NO. 6	1.5°	4	1000	
NO. 7	1.5°	6.5	#800	
NO. 8	2°	7	#800	
NO. 9	2.5°	7.7	#800	
NO. 10	3°	10~11	#600	
NO. 11	3~4°	12~15	#600	
NO. 12	4~5°	16~18	#600	
HN20	2.5°	12~14	#400	
HN21	3°	15~17	#400	
HN22	3~4°	23~25	#400	
HN23	4~5°	33~37	#320	
HN24	4°	19~21	#320	
HN25	4°	23~25	#320	

HN26	4°	26~30	#320	
HN27	5°	37~40	#320	
HN28	5~6°	41~43	#320	
HN29	5~6°	45~50	#320	
HN30	6°	58~63	#320	
HN31	6°	65~73	#320	
HN1000	1°	4~5	#800	
HN1001	1°	5~6	#800	
HN1002	1.5°	8~	#800	
HN1003	1°	3~4	#800	
HN1004	1°	4~5	#800	
HN1005	1°	5~6	#800	
HN1006	2°	10~11	#600	
HN1007	2.5°	12~13	#600	
HN1008	3°	17~19	#600	
HN1009	1.5°	6~7	#600	
HN1010	2°	7~8	#600	
HN1011	3°	13~14	#600	
HN1012	3.5°	25~27	#400	
HN1013	4°	33~37	#400	
HN1014	5°	43~50	#400	
HN1015	3°	19~21	#400	
HN1016	4°	32~~33	#320	
HN1017	5°	36~~38	#320	
HN2000	1.5°	8~9	#600	
HN2001	2°	13~15	#600	
HN2002	2.5°	22~34	#400	
HN2003	3.5°	40~44	#400	
HN2004	4°	44~47	#400	
HN2005	5.5°	61~65	#400	
HN2006	5.5°	60~63	#400	
HN2007	5°	61~64	#400	
HN2008	5°	63~66	#400	
HN2009	3°	33~35	#400	
HN2010	3.5°	43~46	#400	
HN2011	2°	20~21	#400	
HN2012	3°	28~32	#400	
HN2013	3.5°	30~35	#400	

HN2014	2.5°	19~22	#400	
HN2015	2.5°	25~29	#400	
HN2016	3°	33~38	#400	
HN2017	4°	38~41	#400	
HN2018	4°	50~58	#400	
HN2019	5°	70~75	#400	
HN2020	2°	16~23	#400	
HN2021	2.5°	23~26	#400	
HN2022	3°	25~27	#400	
HN2023	4°	30~34	#400	
HN2024	4.5°	42~50	#400	
HN2025	5°	52~56	#400	
HN2026	5°	62~70	#400	
HN3000	1.5°	4~5	#800	
HN3001	1.5°	5~6	#800	
HN3002	1.5°	7~9	#800	
HN3003	2.5°	8~11	#800	
HN3004	3°	10~15	#600	
HN3005	3°	16~18	#600	
HN3006	3.5°	17~20	#600	
HN3007	1.5°	7~9	#600	
HN3008	2°	9~11	#600	
HN3009	2.5°	12~14	#600	
HN3010	2.5°	15~18	#600	
HN3011	3°	18~22	#600	
HN3012	3.5°	24~28	#600	
HN3013	3.5°	27~31	#600	

Surface roughness of Charmilles EDM marks:

VDI0 Ra0.1

VDI4 Ra0.16

VDI8 Ra0.25

VDI10 Ra0.32

VDI12 Ra0.40

VDI14 Ra0.50

VDI18 Ra0.80

VDI20 Ra1.0

VDI22 Ra1.26

VDI24 Ra1.62

VDI26 Ra2.0

VDI28 Ra2.5

VDI30 Ra3.2