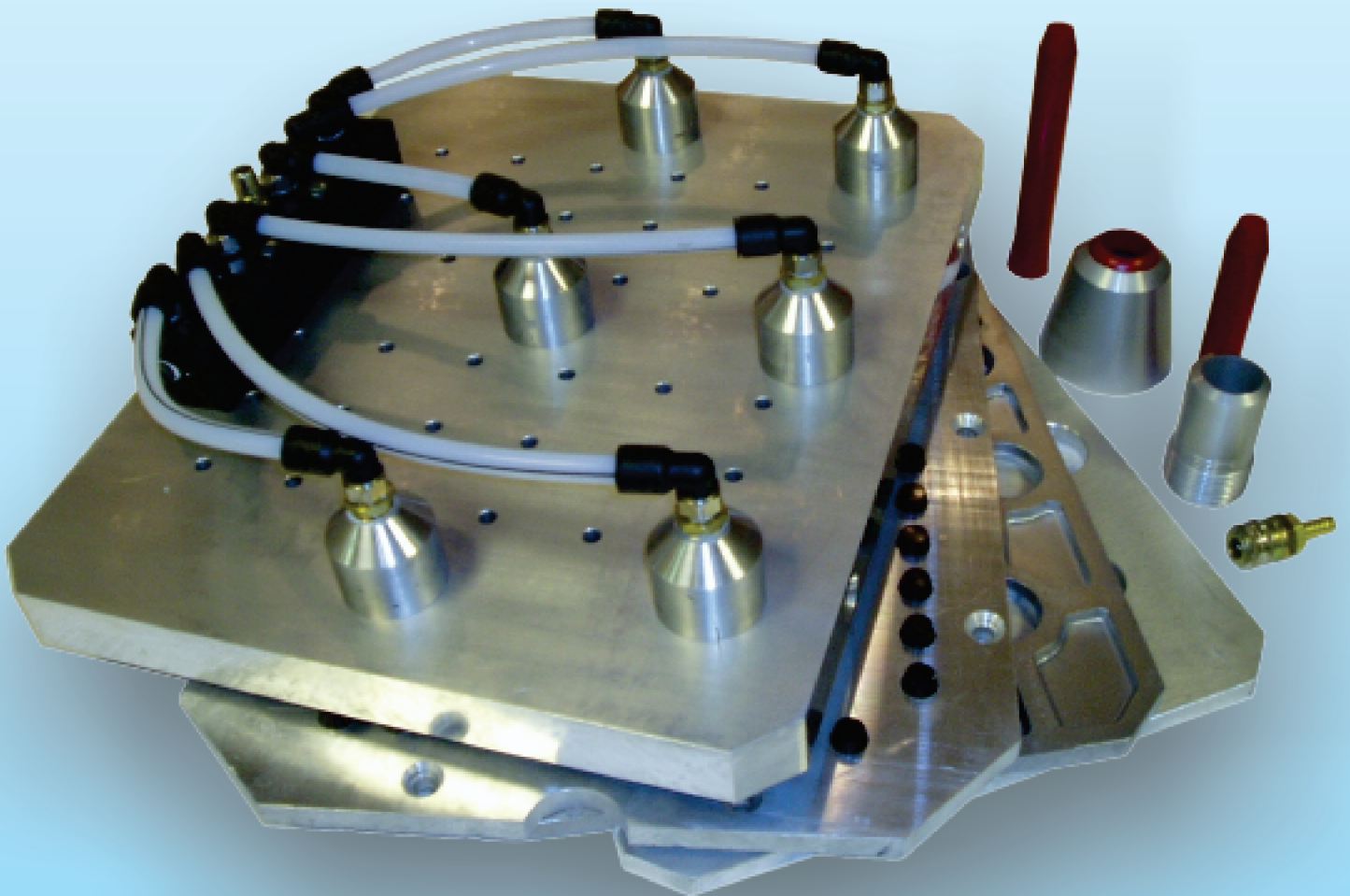




AUXILIARY PARTS CATALOG



AUXILIARY PARTS

FOR

AUTOMATED MATCHPLATE MOLDING MACHINES AND MOLD HANDLING SYSTEMS

HUNTER FOUNDRY MACHINERY CORPORATION

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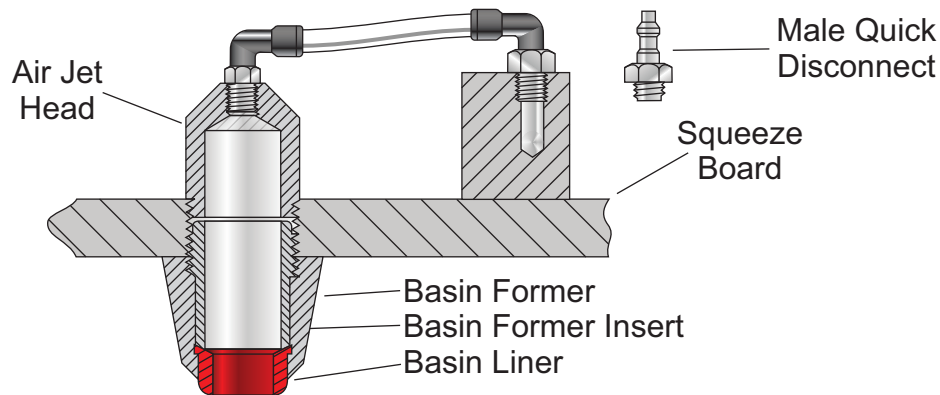
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Supersedes all other published catalogs. Hunter reserves the right to change any information contained in this catalog without notice.

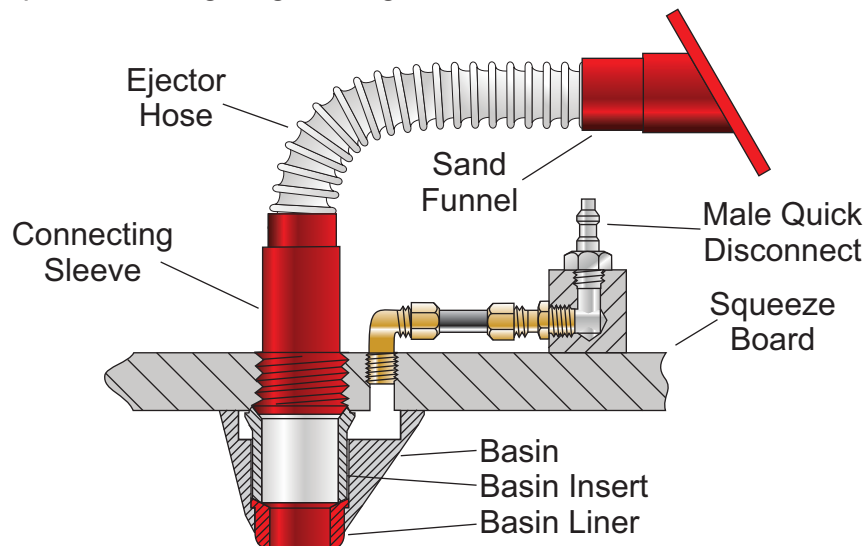
BASINS:

1. The New Ultra-Clean Basin Former Design: This new patent applied for system uses the combination of a vented (and optionally heated) squeeze board, multi-location pre-hosed air injection and an aluminum basin with a replaceable polyurethane liner. Basin location changes are made quickly and easily by simply exchanging the existing basin with the new locations existing stop off.

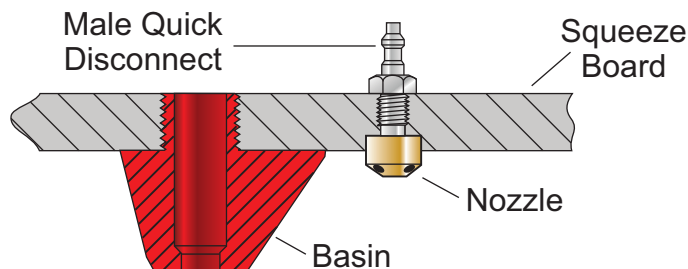
The ULTRA-CLEAN basin former will provide a clean basin and sprue as well as a clean top of mold. This system can be adapted to all existing Hunter HMP machines and is standard on the new XL Series of HMP machines.



2. The Sprue Slug Ejector Design: No longer available for retro-fit: Replaced by the Ultra-Clean Basin Former Design. To order parts for existing systems, see parts illustration and parts lists beginning on Page 6.



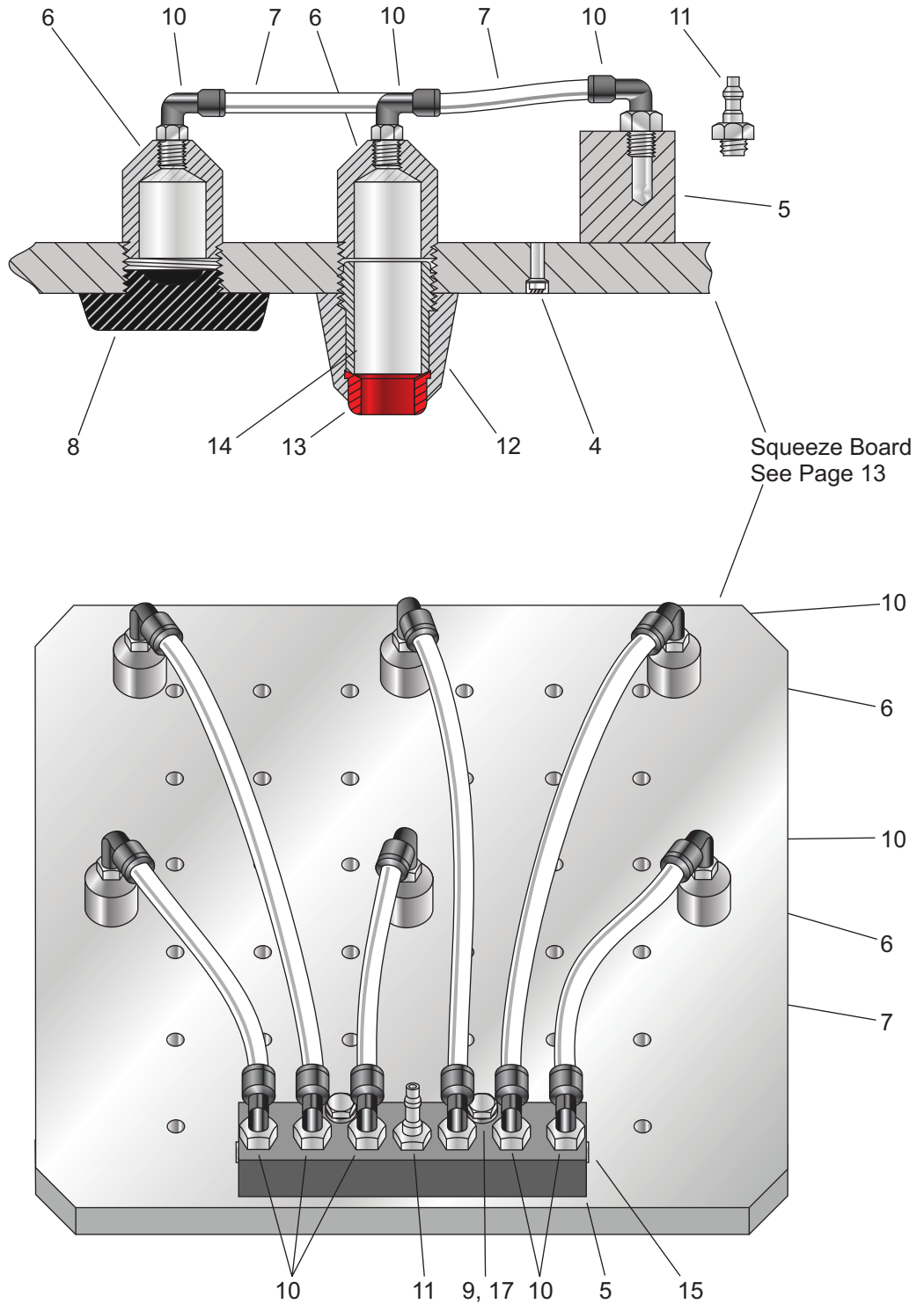
3. The Conventional Design: A polyurethane basin makes the pouring impression in the mold, while an external nozzle blows out the impression and the top of the mold. The sprue slug is pushed through the basin and sits on top of the squeeze board.



BASINS (CONT'D):

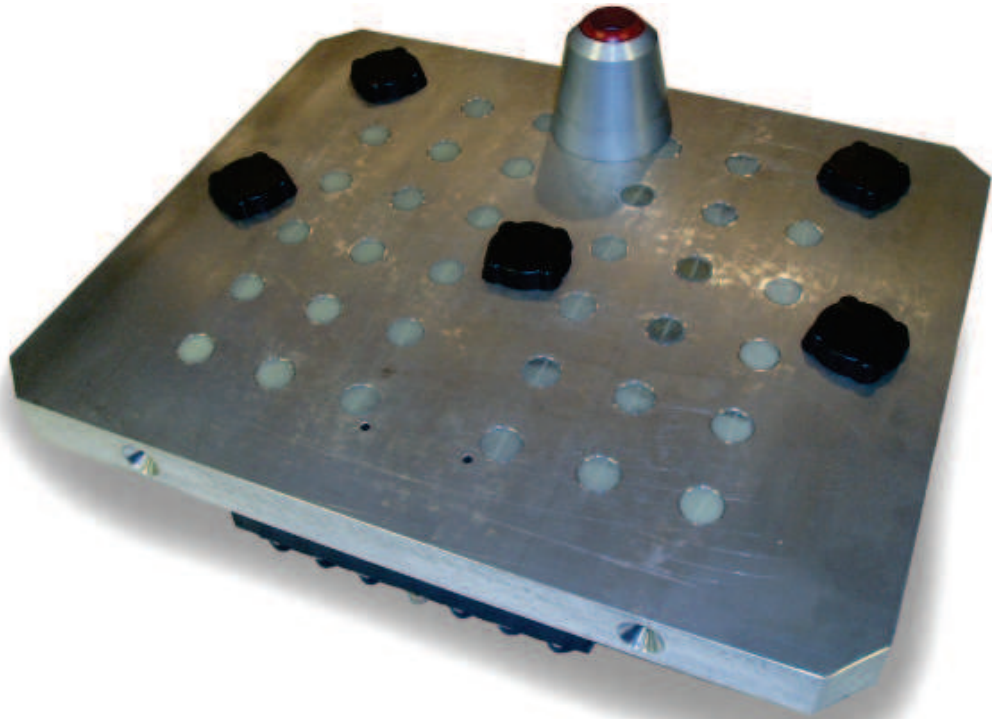
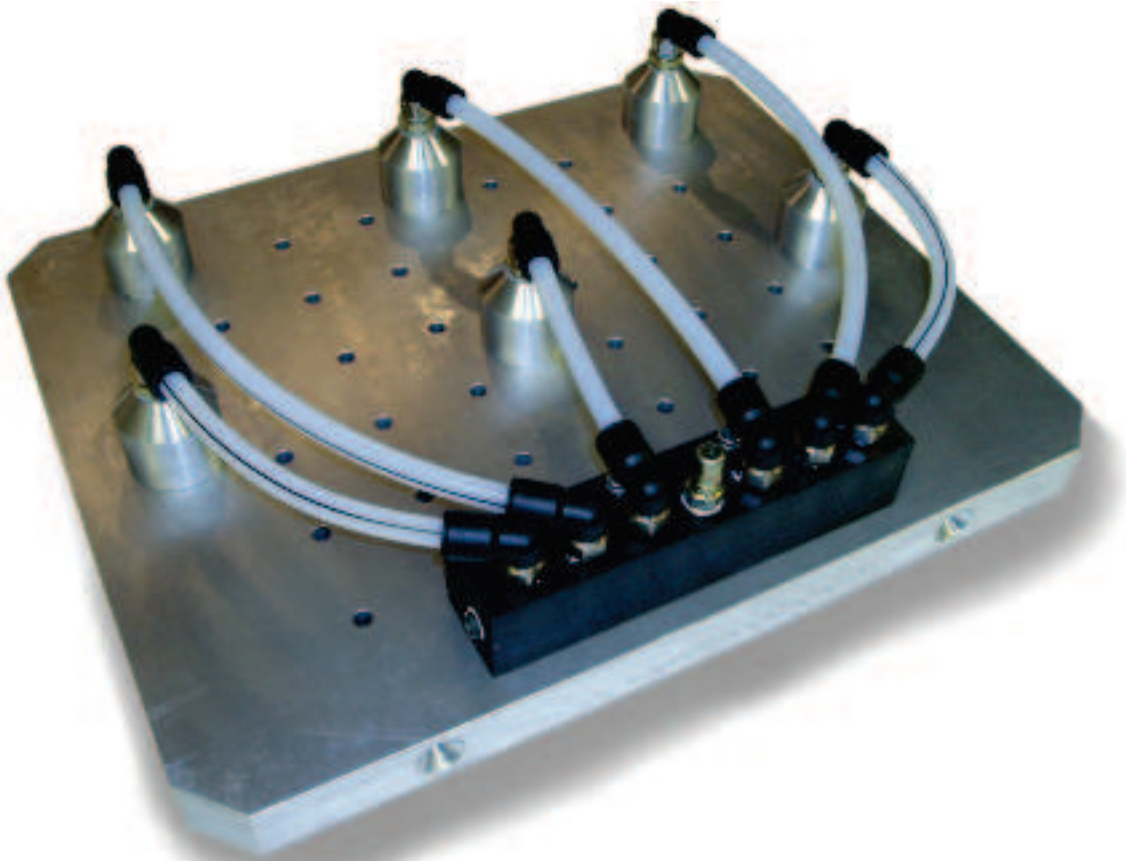
ULTRA-CLEAN BASIN FORMER DESIGN:

The Ultra-Clean Basin Former components are shown assembled on a squeeze board below. The numbers on the drawings refer to the parts lists on the following pages.



BASINS (CONT'D):

ULTRA-CLEAN BASIN FORMER DESIGN



**ULTRA-CLEAN BASIN FORMER DESIGN (CONT'D):
 ULTRA-CLEAN BASIN FORMER SUPPLIES
 FOR HMP-10 & 20, NON-C, C, D, E, G, H & XL-1419, XL-2024**

Item No. [†]	Hunter Part No.		Description	*Quantity Required:
	HMP-10 XL-1419	HMP-20 XL-2024		
	37498	37468	3/4" Ultra-Clean Basin Former Kit Complete with Squeeze Board	1
	37499	37469	7/8" Ultra-Clean Basin Former Kit Complete with Squeeze Board	1
	37500	37470	1" Ultra-Clean Basin Former Kit Complete with Squeeze Board	1
	37501	37471	1-1/4" Ultra-Clean Basin Former Kit Complete with Squeeze Board	1
	N/A	37472	1-1/2" Ultra-Clean Basin Former Kit Complete with Squeeze Board	1
4	42937		Slotted Vents	40
5	76992		Hose Connector	1
6	80379		Air Jet Head	6
7	63465		3/8" Teflon Tubing	108"
8	10680		Stop Off	5
9	80439		1/4-20NC X 2-1/2 HH Cap Screw	2
10	76191		Pushlok Male Elbow	12
11	44744		Male Half Coupling	1
12	See Table Below		Basin Former - 3-1/2" Deep	1
13	See Table Below		Basin Liner	1
14	See Table Below		Basin Former Insert	1
15	16564		Hollow Hex Plug	3
17	16370		1/4" Lock Washer	2

Note: Items 4 through 15 are included in Ultra-Clean Basin Former Kit.
 * Quantities shown are for piping 6 standard pouring basins in Squeeze Board.

Item No. [†]	Description		Size				
			3/4"	7/8"	1"	1-1/4"	1-1/2"
12	Basin Former	Deep	76941	76943	76945	80297	76947
		Shallow	83332	83334	83328	83336	83338
13	Basin Liner		45808	45809	45705	45810	45811
14	Basin Former Insert	Deep	76942	76944	76946	80298	76948
		Shallow	83333	83335	83329	83337	83339

[†] Refer to Page 2 for an assembled parts illustration.

**ULTRA-CLEAN BASIN FORMER DESIGN (CONT'D):
 ULTRA-CLEAN BASIN FORMER SUPPLIES
 FOR HMP-32, NON-C, C, D, E, G, H, & XL2430**

Item No.†	Hunter Part No.		Description	*Quantity Required:
	XL 2430	HMP-32		
	37483	TBD	1" Ultra-Clean Basin Former Kit Complete with Squeeze Board	1
	37484	37581	1-1/4" Ultra-Clean Basin Former Kit Complete with Squeeze Board	1
	37485	TBD	1-1/2" Ultra-Clean Basin Former Kit Complete with Squeeze Board	1
4	42937 +		Slotted Vents	40
5	76992		Hose Connector	1
6	80379		Air Jet Head	6
7	63465		3/8" Teflon Tubing	108"
8	10680		Stop Off	5
9	80439		1/4-20NC X 2-1/2 HH Cap Screw	2
10	76191		Pushlok Male Elbow	12
11	44744		Male Half Coupling	1
12	See Table Below		Basin Former - 3-1/2" Deep	1
13	See Table Below		Basin Liner	1
14	See Table Below		Basin Former Insert	1
15	16564		Hollow Hex Plug	3
17	16370		1/4" Lock Washer	2

Note: Items 4 through 15 are included in Ultra-Clean Basin Former Kit.

* Quantities shown are for piping 6 standard pouring basins in Squeeze Board.

+ Not used on HMP-32 Ultra-Clean

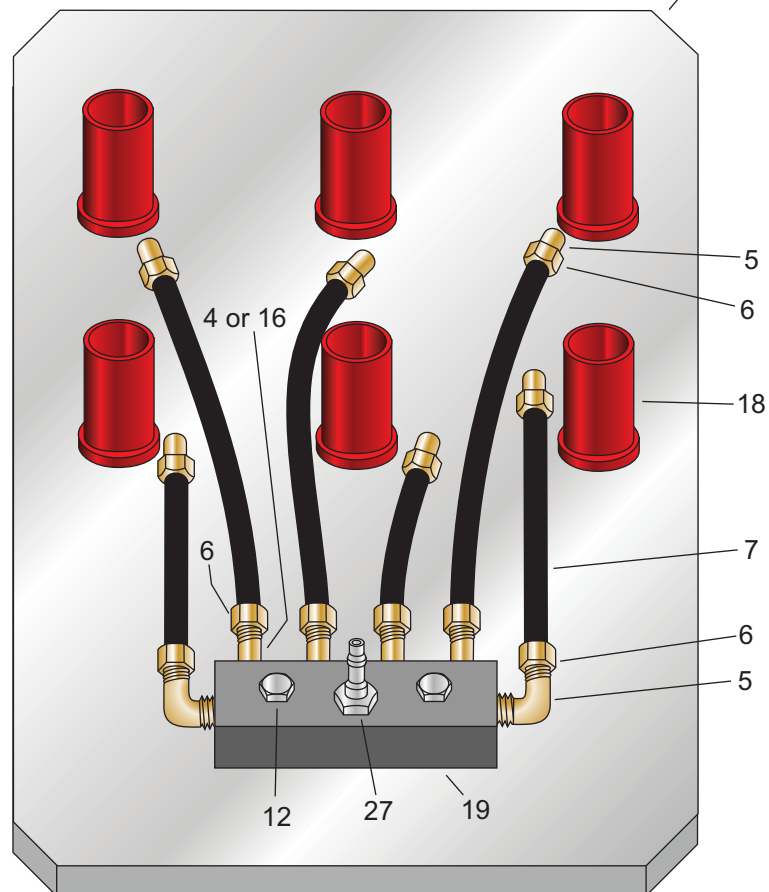
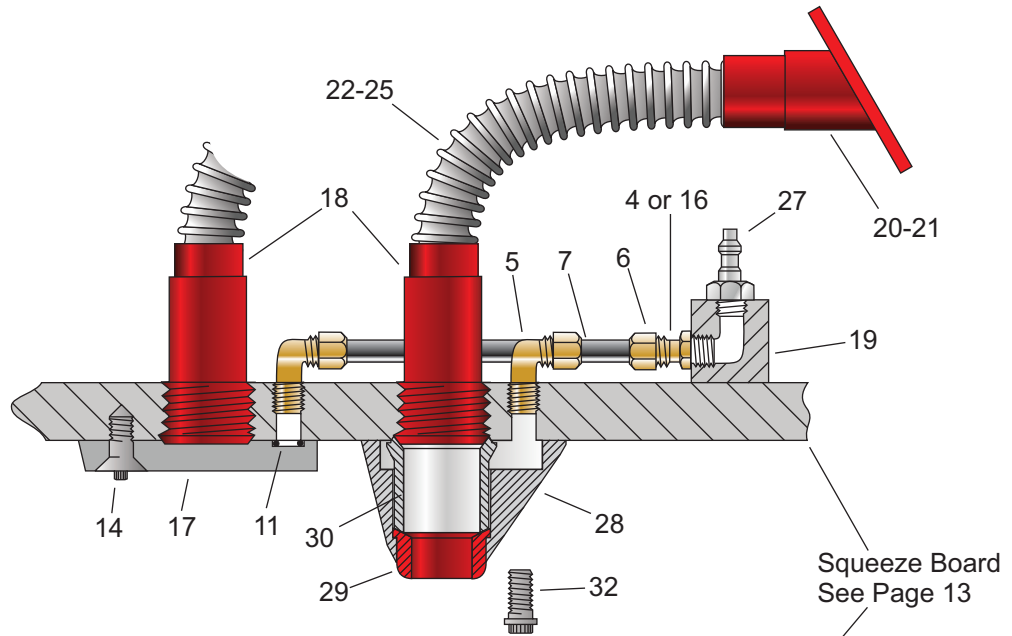
Item No.†	Description		Size				
			3/4"	7/8"	1"	1-1/4"	1-1/2"
12	Basin Former	Deep	76941	76943	76945	80297	76947
		Shallow	83332	83334	83328	83336	83338
13	Basin Liner		45808	45809	45705	45810	45811
14	Basin Former Insert	Deep	76942	76944	76946	80298	76948
		Shallow	83333	83335	83329	83337	83339

† Refer to Page 2 for an assembled parts illustration.

BASINS (CONT'D):

SPRUE SLUG EJECTOR DESIGN:

The Sprue Slug Ejector components are shown assembled on a squeeze board below. The numbers on the drawings refer to the parts lists on the following pages.



**SPRUE SLUG EJECTOR DESIGN (CONT'D):
QUICK CHANGE BASIN SUPPLIES FOR HMP-10 & 20, NON-C, C, D, E, G & H**

Item No.†	Hunter Part No.	Description	Quantity Required For:			
			HV-10	HV-20	HLH-10 HMH-210	HLH-20 HMH-220
4	10394	Male Connector		4		4
5	10395	90° Male Elbow	8	8	8	8
6	10397	3/8" Swivel Female Fitting	12	12	12	12
7	10412	3/8" Air Hose	72	72	72	72
8	21260	5/8" Air Hose	25	25	25	25
9	11250	1/2" Swivel Female Fitting	1	1	1	1
10	16432	1/2" Hose Clamp	1	1	1	1
11	13935	O-Ring	5	5	5	5
12	16004	1/4-20NC X 1-1/2 Hex Cap Screw	2	2	2	2
13	16020	3/8-16NC X 1-3/4 Hex Cap Screw	4	4	4	4
14	64522	Insert Assembly - Cover Only	5	5	5	5
15	16355	3/8" Flat Washer	4	4	4	4
16	19318	45° Male Elbow	4		4	
17	39896	Basin Cover	5	5	5	5
18	64171	Connecting Sleeve	6	6	6	6
19	41302	Squeeze Board Hose Connector	1	1	1	1
20	41891	Sand Return Tube		6		6
21	46175	Sand Return Tube Bracket	1		1	
22	44147	1" ID X 28" Hose Assembly		6		4
23	44308	1" ID X 35" Hose Assembly				2
24	44405	3/4" ID X 31-1/2" Hose Assembly	3		4	
25	44419	3/4" ID X 28" Hose Assembly	3		2	
26	44743	Half Coupling Socket	1	1	1	1
27	44744	Male Half Coupling	1	1	1	1
28	See Table Below	Basin	1	1	1	1
29	See Table Below	Basin Liner	4	4	4	4
30	See Table Below	Basin Insert	1	1	1	1
31	45222	Quick Change Basin Drill Fixture	1	1	1	1
32	64906	Screw, Hi-Torque - Basin Only	3	3	3	3
33	18056	Male Connector	1	1	1	1
	16592	1/4-20NC X 3/4 Butt Hd Cap Screw	10	10	10	10
	64592	Spinner Handle W/12 Point Socket	1	1	1	1

Item No.†	Description	Size				
		3/4"	7/8"	1"	1-1/4"	1-1/2"
28	Basin	45817	45818	45819	45820	45821
29	7/8" Basin Liner	45808	45809	45705	45810	45811
30	7/8" Basin Insert	45812	45813	45814	45815	45816

† Refer to Page 6 for an assembled parts illustration.

**SPRUE SLUG EJECTOR DESIGN (CONT'D):
QUICK CHANGE BASIN SUPPLIES FOR HMP-32, NON-C, C, D, E, G & H**

Item No.†	Hunter Part No.	Description	Quantity Required For:			
			HV-32		HLH-32 & HMH-232	
			Deep	Shallow	Deep	Shallow
4	10394	Male Connector		4		4
5	10395	90° Male Elbow	8	8	8	8
6	10397	3/8" Swivel Female Fitting	12	12	12	12
7	10412	3/8" Air Hose	72	72	72	72
8	21260	5/8" Air Hose	25	25	25	25
9	11250	1/2" Swivel Female Fitting	1	1	1	1
10	16432	1/2" Hose Clamp	1	1	1	1
11	13935	O-Ring	5	5	5	5
12	16004	1/4-20NC X 1-1/2 Hex Cap Screw	2	2	2	2
13	16020	3/8-16NC X 1-3/4 Hex Cap Screw	4	4	4	4
14	64522	Insert Assembly - Cover Only	5	5	5	5
15	16355	3/8" Flat Washer	4	4	4	4
16	19318	45° Male Elbow	4		4	
17	39896	Basin Cover	5	5	5	5
18	64171	Connecting Sleeve	6	6	6	6
19	41302	Squeeze Board Hose Connector	1	1	1	1
20	41891	Sand Return Tube		6		6
21	46175	Sand Return Tube Bracket	1		1	
22	44147	1" ID X 28" Hose Assembly		6		4
23	44308	1" ID X 35" Hose Assembly				2
24	44405	3/4" ID X 31-1/2" Hose Assembly	3		4	
25	44419	3/4" ID X 28" Hose Assembly	3		2	
26	44743	Half Coupling Socket	1	1	1	1
27	44744	Male Half Coupling 1" Basin	1	1	1	1
28	See Table Below	Basin	1	1	1	1
29	See Table Below	Basin Liner	4	4	4	4
30	See Table Below	Basin Insert	1	1	1	1
31	45222	Quick Change Basin Drill Fixture	1	1	1	1
32	64906	Screw, Hi-Torque - Basin Only	3	3	3	3
33	18056	Male Connector	1	1	1	1
	16592	1/4-20NC X 3/4 Butt Hd Cap Screw	10	10	10	10
	64592	Spinner Handle W/12 Point Socket	1	1	1	1

Item No.†	Description	Size			
		7/8"	1"	1-1/4"	1-1/2"
28	Basin	45818	45819	45820	45821
29	Basin Liner	45809	45705	45810	45811
30	Basin Insert	45813	45814	45815	45816

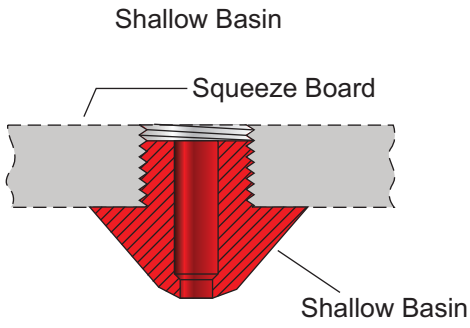
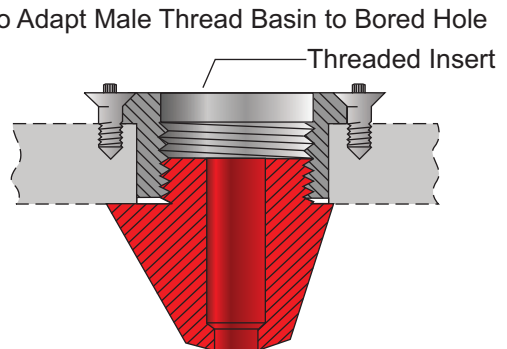
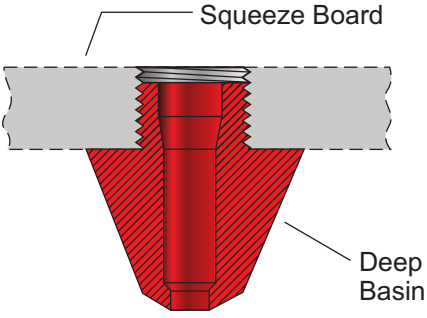
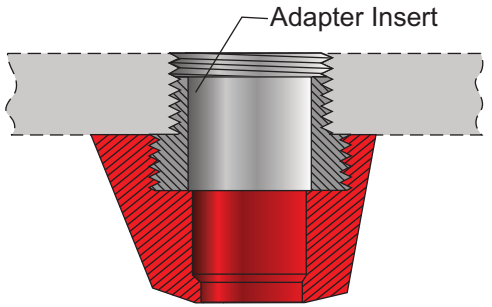
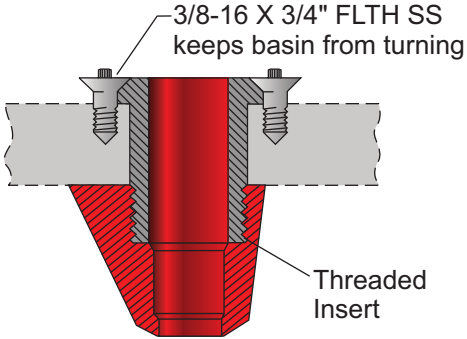
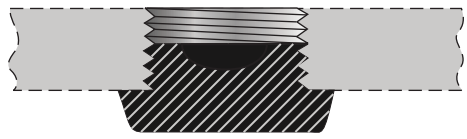
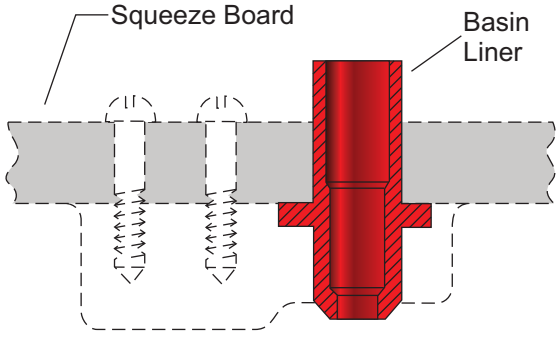
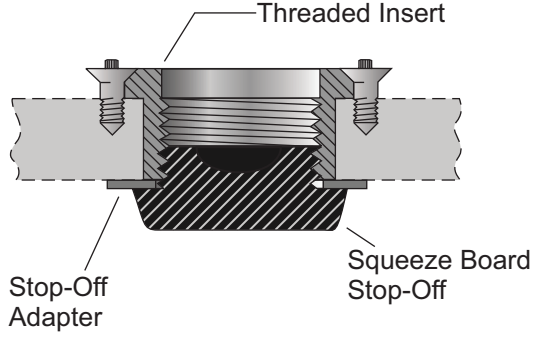
† Refer to Page 6 for an assembled parts illustration.

BASINS (CONT'D):

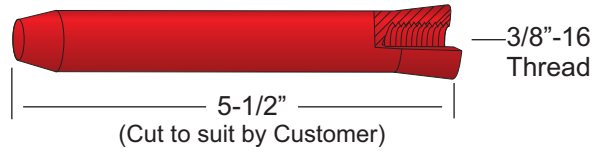
CONVENTIONAL DESIGN:

Illustration		Description	Recom. Qty. For 1st Order			Part No.
			HMP-10	HMP-18/20	HMP-30/32	
 2"-8UNC Thread	 1-3/16"	1" Dia. Shallow Basin	4	1	0	10236
		7/8" Dia. Shallow Basin	2	1	0	10238
		3/4" Dia. Shallow Basin	1	0	0	10240
	 1-1/2"	5/8" Dia. Shallow Basin	0	0	0	11892
		1/2" Dia. Shallow Basin	0	0	0	11891
Deep Basin with Flat Side  2"-8UNC Thread	 2-1/4"	1-1/4" Dia. Deep Basin	1	4	1	11316
		1" Dia. Deep Basin	2	4	1	10676
		7/8" Dia. Deep Basin	2	4	0	10677
		3/4" Dia. Deep Basin	1	0	0	10678
 2-1/2"-8UNC Female Thread	 2-1/4"	2" Dia. Deep Basin	0	1	4	14424
		1-3/4" Dia. Deep Basin	0	1	4	14423
		1-1/2" Dia. Deep Basin	0	1	4	14422
 2-1/2"-8UNC Thread		Threaded Insert (To mount female thread basin into 2-1/2" drilled hole)	0	0	4	14476
 2"-8UNC Thread 2-1/2"-8UNC Thread Note: Used on 1-1/2" Dia. Deep Basin		Adapter Insert (To mount female thread basin into 2"-8UNC threaded hole)	0	1	4	14477
 2"-8UNC Female Thread		Threaded Insert (To mount male thread into 2-1/2" drilled hole - allows alignment of flat side if required.)	0	0	4	14478

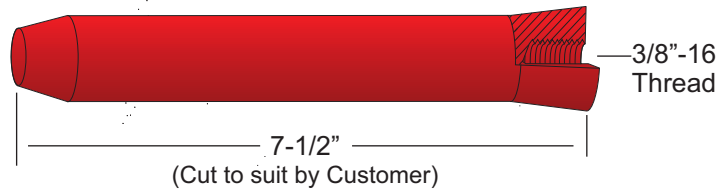
CONVENTIONAL DESIGN (CONT'D):

POURING BASIN ARRANGEMENTS	
<p>Shallow Basin</p> 	<p>To Adapt Male Thread Basin to Bored Hole</p> 
<p>Deep Basin (Male Thread)</p> 	<p>To Adapt Female Thread Basin to Threaded Hole Mounts 1-1/2" Dia. Deep Basin on 2"-8UN Tapped Hole</p> 
<p>Deep Basin (Female Thread) Mounts Female Thread Basins on HMP-30 & 32 3/8-16 X 3/4" FLTH SS keeps basin from turning</p> 	<p>Squeeze Board Stop-Off for Threaded Hole</p> 
<p>Basin Liner (To Customize Basin Shape)</p> 	<p>Squeeze Board Stop-Off for Bored Hole</p> 

SPRUES:

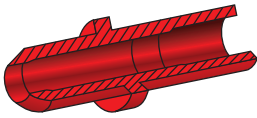
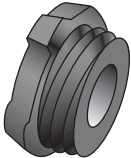



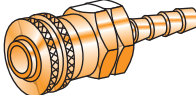
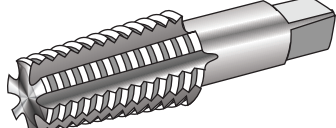
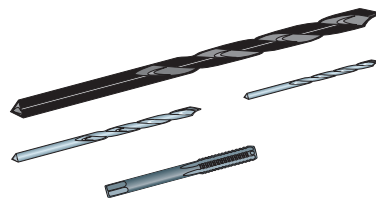


Sprue Diameter	Recommended Qty. For 1st Order				Part No.
	HMP-10	HMP-18/20 XL-2024	HMP-26	HMP-30/32 XL-2430	
1"	4	0	0	0	10235
7/8"	4	0	0	0	10237
3/4"	2	0	0	0	10239

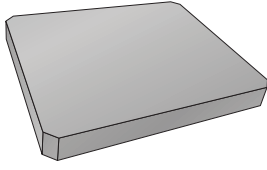
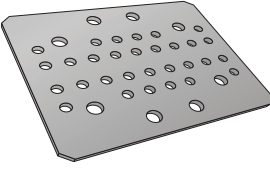
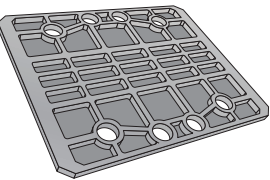
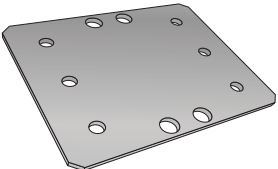
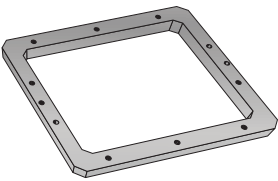



Sprue Diameter	Recommended Qty. For 1st Order				Part No.
	HMP-10	HMP-18/20 XL-2024	HMP-26	HMP-30/32 XL-2430	
2"	0	1	1	0	14433
1-3/4"	0	1	1	0	14432
1-1/2"	0	1	1	0	14210
1-1/4"	1	2	2	1	11320
1"	0	2	2	0	11319
7/8"	0	2	2	0	11318

SQUEEZE BOARD ACCESSORIES:

Illustration	Description	Recommended Qty. For 1st Order			Part No.
		HMP-10	HMP-18/20	HMP-30/32	
	1-1/4" Dia. Basin Liner	1	4	1	11317
	1" Dia. Basin Liner	2	2	1	10825
	7/8" Dia. Basin Liner	2	2	0	10824
	3/4" Dia. Basin Liner	1	0	0	10823
	1/2" Dia. Basin Liner	2	0	0	11745
	Squeeze Board Stop-Off (To plug the sprue basin holes in the squeeze board.)	1	1	1	10680
	Stop-Off Adapter (Adapts stop-off to HMP-30.)	0	0	1	14577
	Blow-Off Nozzle	12	12	12	10209
	Male Half-Coupling 3/8" Hose	12	12	12	10233
	1/2" - 5/8" Hose	12	12	12	44744
	Female Half-Coupling 3/8" Hose	1	1	1	10251
	1/2" - 5/8" Hose	1	1	1	44743
	2"-8 Thread Tap (To tap pouring basin threads into the squeeze board.)	1	1	1	12293
	SAE Tool Kit (Drill bits & taps for setting up squeeze boards in countries without SAE tools.)				27853 (Conv. Dsgn.) 27854 (Sprue Slug Eject. Dsgn.)

SQUEEZE BOARDS AND BOTTOM BOARDS:

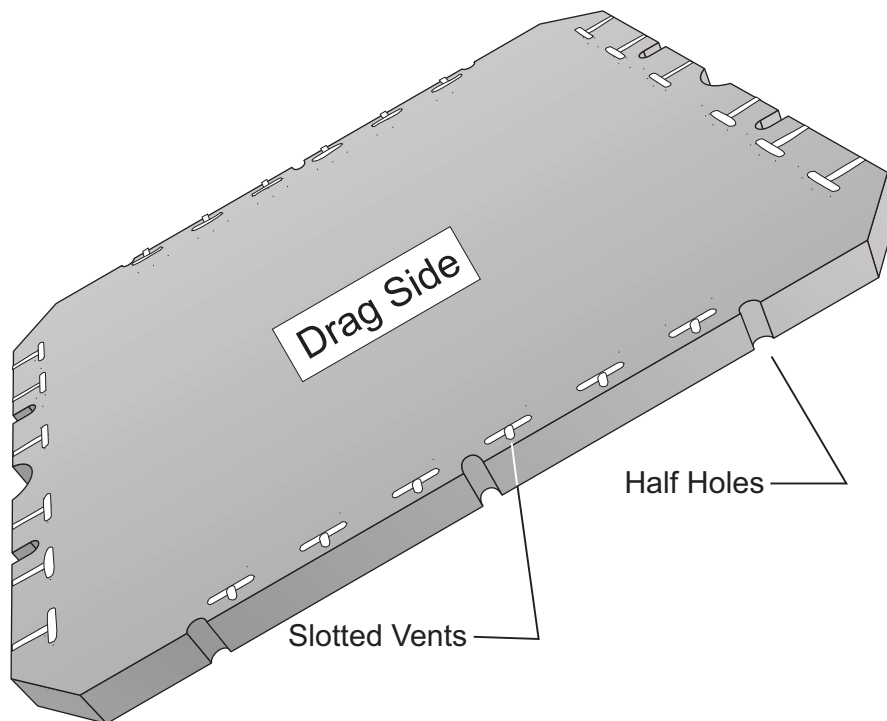
Illustration	Description	Boards for all model machines as noted:					
		10	18	20	26	30	32
	Squeeze Board (Quick Change) Approx. Weight Lbs. (Kg)	Part No. 11827 22 (10.0)	Part No. 28878 37 (16.8)	Part No. 11153 54 (38.1)	Part No. 76244 58.9 (26.7)	Part No. 14131 76560 (XL) 65 (29.6)	Part No. 18884 93 (42.3)
	Bottom Board (Alum. Casting) Approx. Weight Lbs. (Kg)	Part No. 45506 11.5 (5.2)		Part No. 11015 27 (12.3)			
	Bottom Board (Alum. Ribbed) For HMH Systems W/manual board return Approx. Weight Lbs. (Kg)	Part No. 46352 8 (3.6)					
	Bottom Board (Flat Alum. Precision Plate) For HMH Systems w/auto board returns And all HV Systems Approx. Weight Lbs. (Kg)	Part No. 12657 11 (5.0)	Part No. 28882 17 (7.7)	Part No. 12725 21 (9.6)	Part No. 69873 61842 (Mold Sensors Deep) 66819 (Mold Sensors Shallow)	Part No. 14245 (30) 28288 (30C) 73009 (XL2430 Shallow) 83075 (XL2430 Deep)	Part No. 49593 (32) 49593 (32C Deep) 33719 (32C Shallow)
	Matchplate Drill Fixture With bushings Approx. Weight Lbs. (Kg)	Part No. 10787 28 (12.7)	Part No. 28881 35 (15.9)	Part No. 11152 100 (45.5)		Part No. 14521	Part No. 19363
	Fixture, Pattern Plate (Guage) Approx. Weight Lbs. (Kg)	Part No. 80966 4.3 (1.89)		Part No. 76420 4.3 (1.89)			

PATTERN PLATES:

Hunter Precision Pattern Plates are a stable aluminum tooling plate, flat and parallel within .005 in. The plates can be ordered with slotted mounting holes, which allow fast pattern changes, or with full size mounting holes. An optional Quick Change feature can be added to reduce pattern change times even further. All Hunter Precision Pattern Plates are vented to improve pattern draw and are available in all flask sizes. Optional Joint Locks are also available to reduce mold shift. The plates can be ordered with slotted or full size mounting holes.

The inventory of pattern plate options are illustrated on the following pages:

Slotted Vents and Half Holes

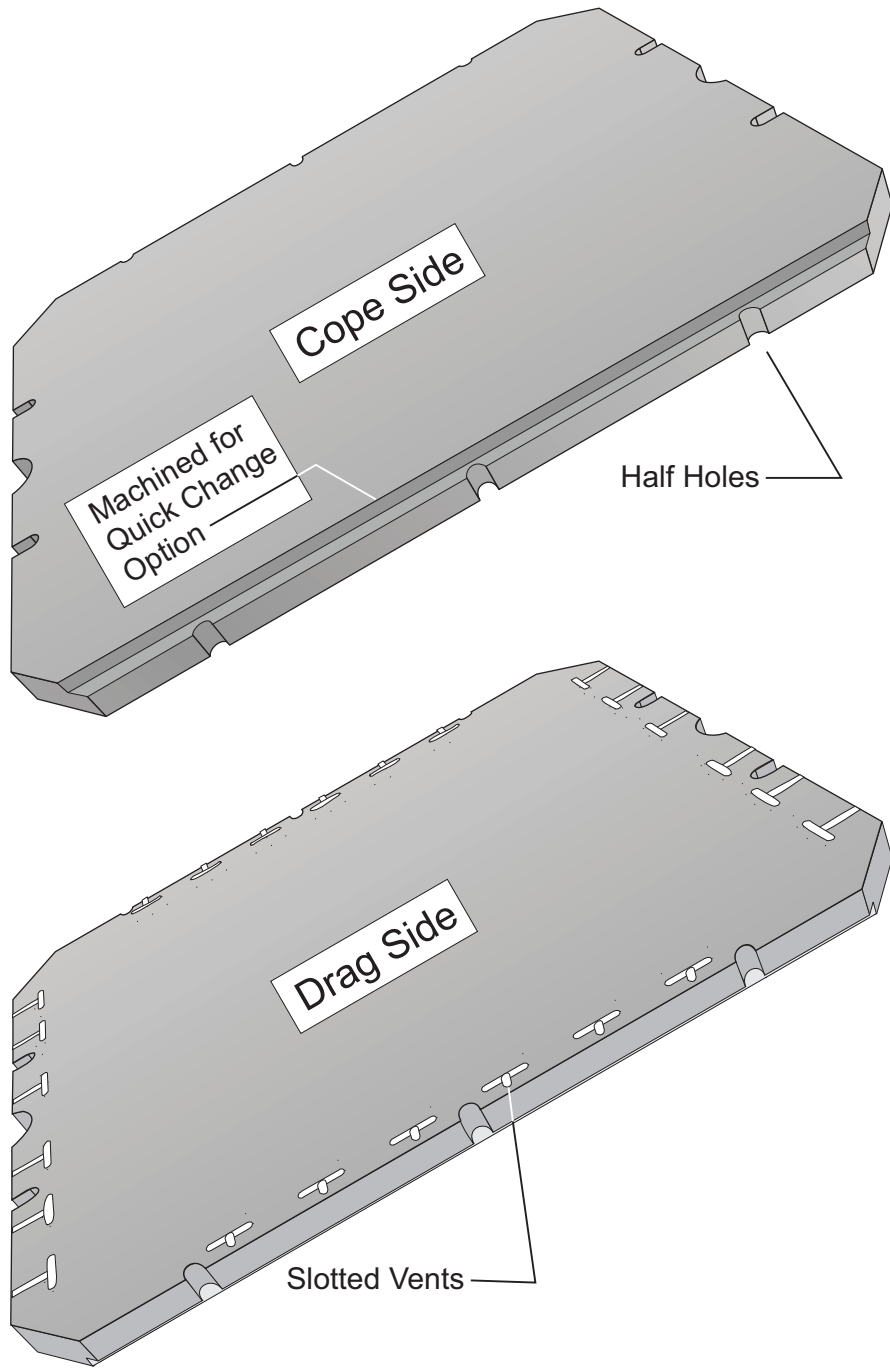


Hunter Model	Plate Thickness	Part Number	
		With Vents	*Without Vents
HMP-10 (14" X 19")	5/8"	41655	63540
HMP-18 (18" X 20")	5/8"	41656	N/A
HMP-20 (20" X 24")	5/8"	41657	63544
HMP-20 (20" X 24")	3/4"	41658	63545
HMP-30 (24" x 30")	7/8"	41659	N/A
HMP-32 (30" x 32")	1"	41660	N/A

*Without Vents Not Illustrated - For G & H Machines Only

PATTERN PLATES (CONT'D):

Slotted Vents, Half Holes and Machined for Quick Change Option

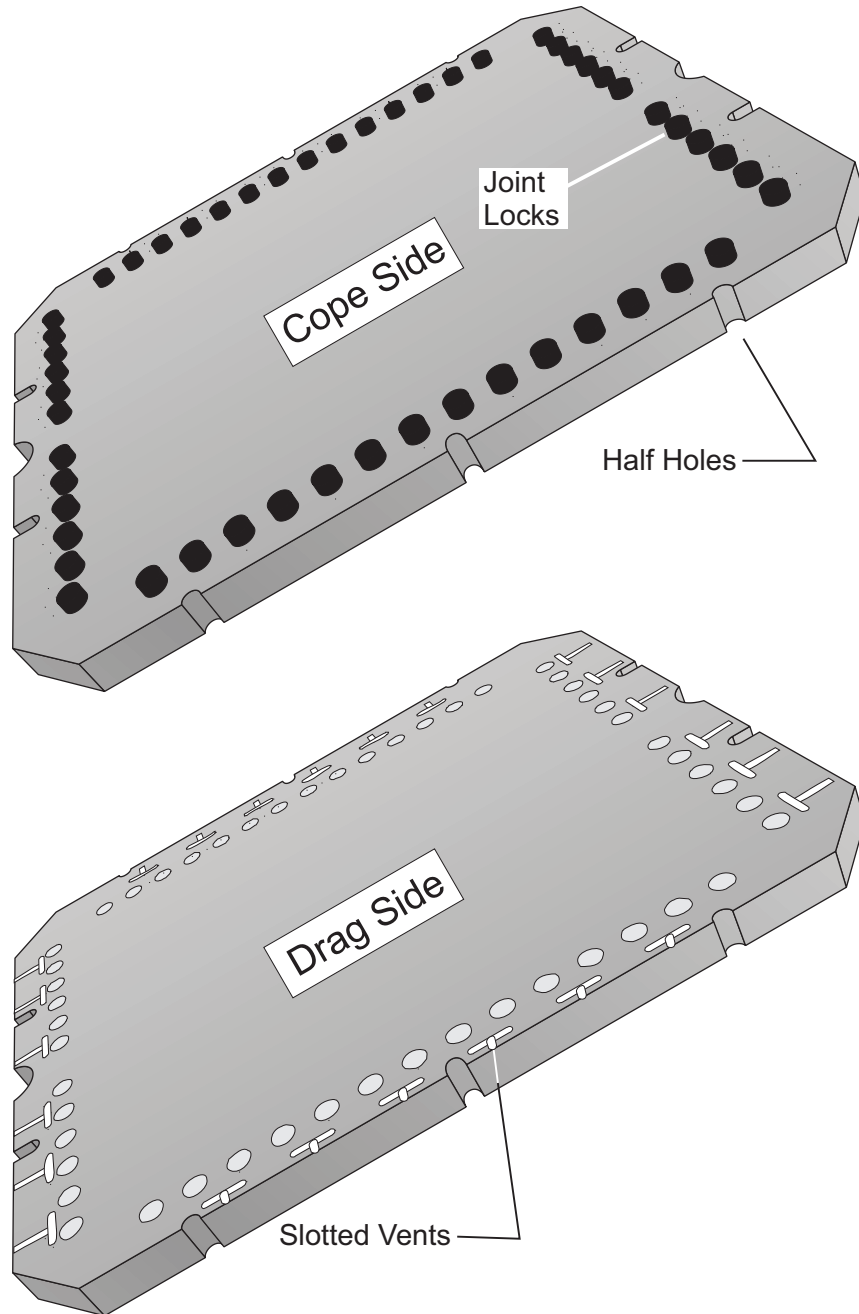


Hunter Model	Plate Thickness	Part Number	
		With Vents	*Without Vents
HMP-10 (14" X 19")	5/8"	43080	63541
HMP-20 (20" X 24")	5/8"	43083	63546
HMP-20 (20" X 24")	3/4"	43087	63547
HMP-20 (20" X 24")	1" (Special Order)	*****	N/A

*Without Vents Not Illustrated - For G & H Machines Only

PATTERN PLATES (CONT'D):

Slotted Vents, Half Holes and Joint Locks

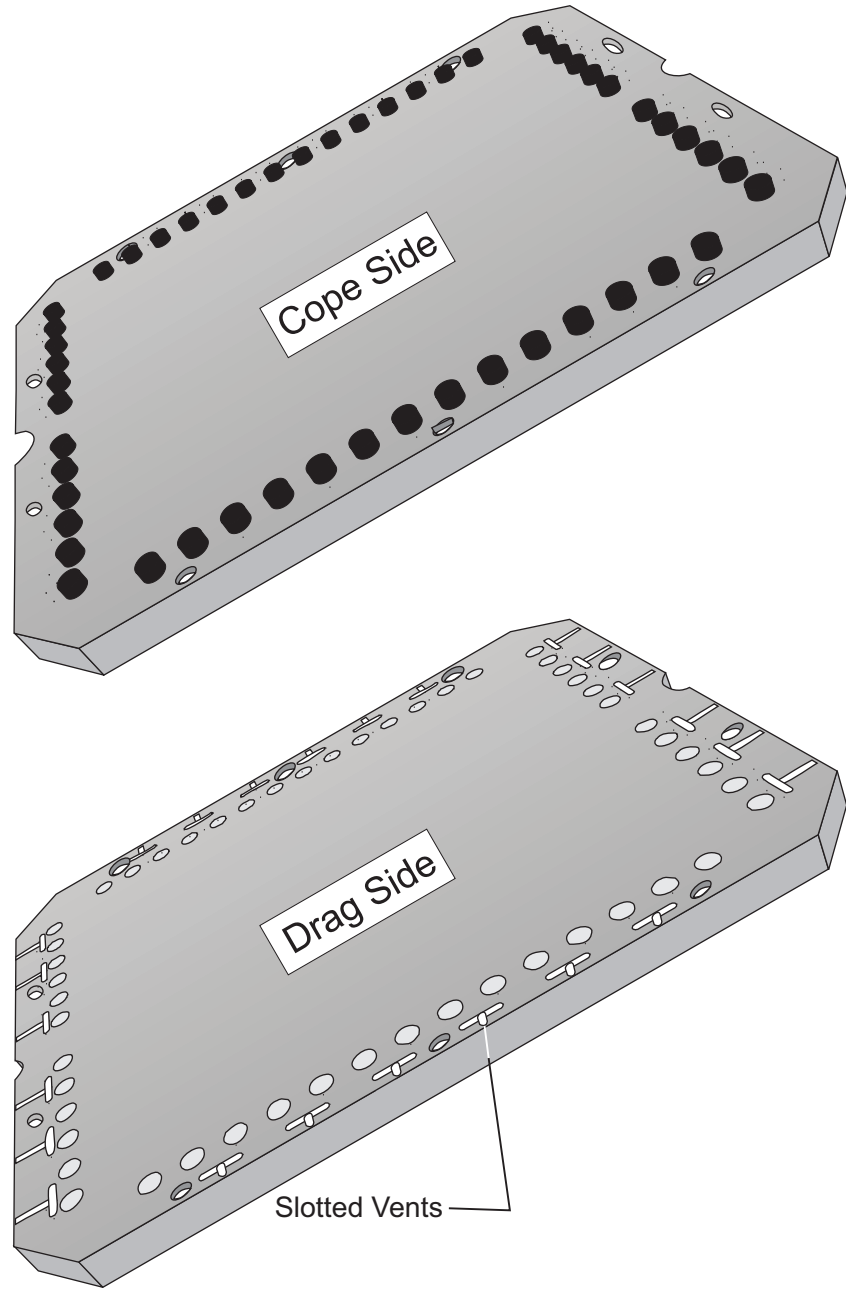


Hunter Model	Plate Thickness	Part Number	
		With Vents	*Without Vents
HMP-10 (14" X 19")	5/8"	41649	63543
HMP-18 (18" X 20")	5/8"	41650	N/A
HMP-20 (20" X 24")	5/8"	41651	63550
HMP-20 (20" X 24")	3/4"	41652	63551
HMP-20 (20" X 24")	1" (Special Order)	46980	N/A
HMP-30 (24" X 30")	7/8"	41653	N/A
HMP-32 (30" X 32")	1"	41654	N/A

*Without Vents Not Illustrated - For G & H Machines Only

PATTERN PLATES (CONT'D):

Slotted Vents, Joint Locks and Full Size Mounting Holes



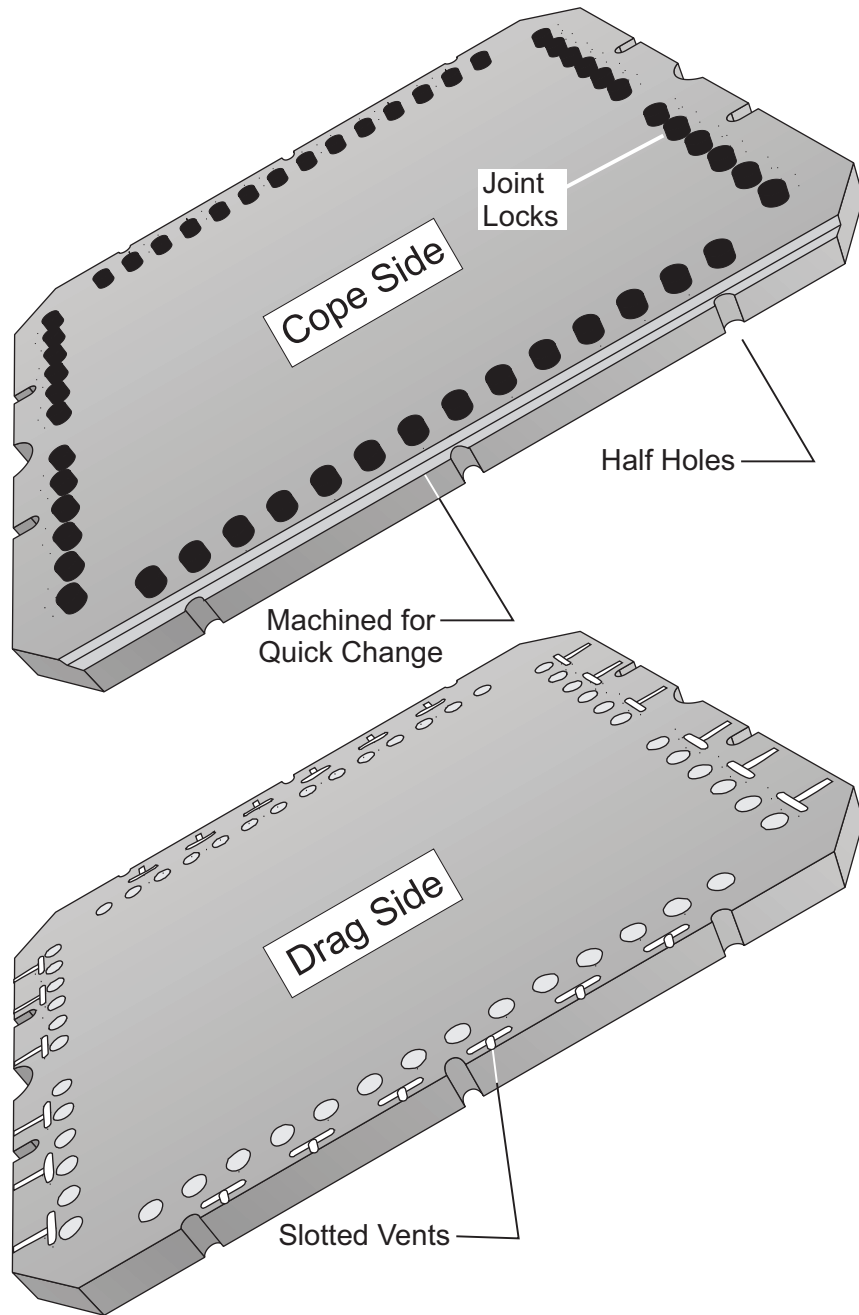
Hunter Model	Plate Thickness	Part No.	
		With Vents	W/o Vents
HMP-10 (14" X 19")	5/8"	46490	69199
HMP-20 & XL2024 (20" X 24")	5/8"	46492*	68799
HMP-20 & XL2024 (20" X 24")	3/4"	46511*	68800
HMP-26 (20" X 26")	5/8"		80619
HMP-26 (20" X 26")	5/8"		80620**
XL2430 (24" X 30")	1"		84147

*Not used on XL2024.

** Special w/o mold locks w/o slotted vents.

PATTERN PLATES (CONT'D):

Slotted Vents, Joint Locks and Machined for Quick Pattern Change Option

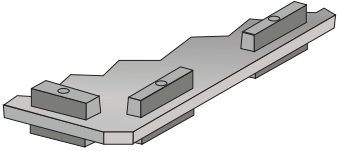
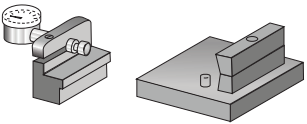
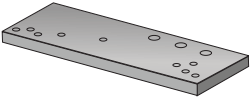


Hunter Model	Plate Thickness	Part Number	
		With Vents	*Without Vents
HMP-10 (14" X 19")	5/8"	43081	63542
HMP-20 (20" X 24")	5/8"	43085	63548
HMP-20 (20" X 24")	3/4"	43089	63549
HMP-20 (20" X 24")	1" (Special Order)	45888	N/A

*Without Vents Not Illustrated - For G & H Machines Only

MATCH™ SYSTEM KITS AND ACCESSORIES

The Hunter MATCH™ System consists of three matched pairs of precision gage blocks installed on a toolplate pattern. Any pattern equipped with the MATCH™ System becomes a test pattern. This system is capable of measuring precisely the alignment of the cope and drag after the mold is closed and pushed out of the machine.

Illustration	Description	HMP-10/18 Part No.	HMP-20 Part No.	HMP-30/32 Part No.
	<p>Gage Block Set (3 sets required per pattern plate)</p> <p>For Hunter pattern plates with Joint Locks</p> <p>For Hunter pattern plates without Joint Locks or other mfg's pattern plates</p>	<p>37122</p> <p>37123</p>	<p>37123</p> <p>37123</p>	<p>37124</p> <p>37131</p>
	<p>Match Assurance Indicator and Calibration Block</p>	<p>37125</p>		
	<p>Drill Fixture</p> <p>For Hunter pattern plates without Joint Locks or other mfg's pattern plates</p>	<p>64842</p>		
	<p>Start-Up Kit (Includes 3 each cope and drag Gage Block Sets, 1 each Match Assurance Indicator and Calibration Block)</p> <p>For Hunter pattern plates with Joint Locks</p> <p>For Hunter pattern plates without Joint Locks or other mfg's pattern plates (Includes Drill Fixture)</p>	<p>37126</p> <p>37130</p>		