CLAIMS

1. A die casting system, comprising:

a shot rod;

a shot tube plunger connected to said shot rod; and

a tip portion separate from and connected to said shot tube plunger, wherein said tip portion includes an inner flange and a lip portion circumferentially disposed about said inner flange, and a recess is circumferentially disposed between said lip portion and said inner flange.

2. The system as recited in claim 1, wherein said lip portion includes a radially inner wall and said inner flange includes a radially outer wall and said recess extends between said radially inner wall and said radially outer wall.

3. The system as recited in claim 2, wherein said radially inner wall and said radially outer wall are angled relative to a floor of said recess.

4. The system as recited in claim 1, wherein said tip portion is connected to an end face of said shot tube plunger.

5. The system as recited in claim 4, wherein said tip portion includes a front face and a rear face, said rear face facing toward said end face of said shot tube plunger.

6. The system as recited in claim 1, wherein said tip portion is threadably received onto a protruding member of said shot tube plunger.

7. The system as recited in claim 2, wherein said radially inner wall and said radially outer wall are transverse to a longitudinal axis of said shot tube plunger.

8. The system as recited in claim 1, wherein said shot rod extends between said shot tube plunger and a mechanism for moving said shot tube plunger.

9. The system as recited in claim 1, wherein said tip portion includes a front face, a rear face and an outer peripheral surface that extends between said front face and said rear face.

10. The system as recited in claim 9, wherein said lip portion is circumferentially disposed about said front face.

CLAIMS

1. A die casting system (10), comprising:

a shot rod (31);

a shot tube plunger (128) connected to said shot rod (31); and

a tip portion (46) separate from and connected to said shot tube plunger (128), wherein said tip portion (46) includes an inner flange (62) and a lip portion (60) circumferentially disposed about said inner flange (62), and a recess (66) is circumferentially disposed between said lip portion (60) and said inner flange (62).

2. The system as recited in claim 1, wherein said lip portion (60) includes a radially inner wall (64) and said inner flange (62) includes a radially outer wall (68) and said recess (66) extends between said radially inner wall (64) and said radially outer wall (68).

3. The system as recited in claim 2, wherein said radially inner wall (64) and said radially outer wall (68) are angled relative to a floor (70) of said recess (66).

4. The system as recited in claim 1, wherein said tip portion (46) is connected to an end face (47) of said shot tube plunger (128).

5. The system as recited in claim 4, wherein said tip portion (46) includes a front face (40) and a rear face (42), said rear face (42) facing toward said end face (47) of said shot tube plunger (128).

6. The system as recited in claim 1, wherein said tip portion (46) is threadably received onto a protruding member (49) of said shot tube plunger (128).

7. The system as recited in claim 2, wherein said radially inner wall (64) and said radially outer wall (68) are transverse to a longitudinal axis (A) of said shot tube plunger (128).

8. The system as recited in claim 1, wherein said shot rod (31) extends between said shot tube plunger (128) and a mechanism (30) for moving said shot tube plunger (128).

9. The system as recited in claim 1, wherein said tip portion (46) includes a front face (40), a rear face (42) and an outer peripheral surface (44) that extends between said front face (40) and said rear face (42).

10. The system as recited in claim 9, wherein said lip portion (60) is circumferentially disposed about said front face (40).