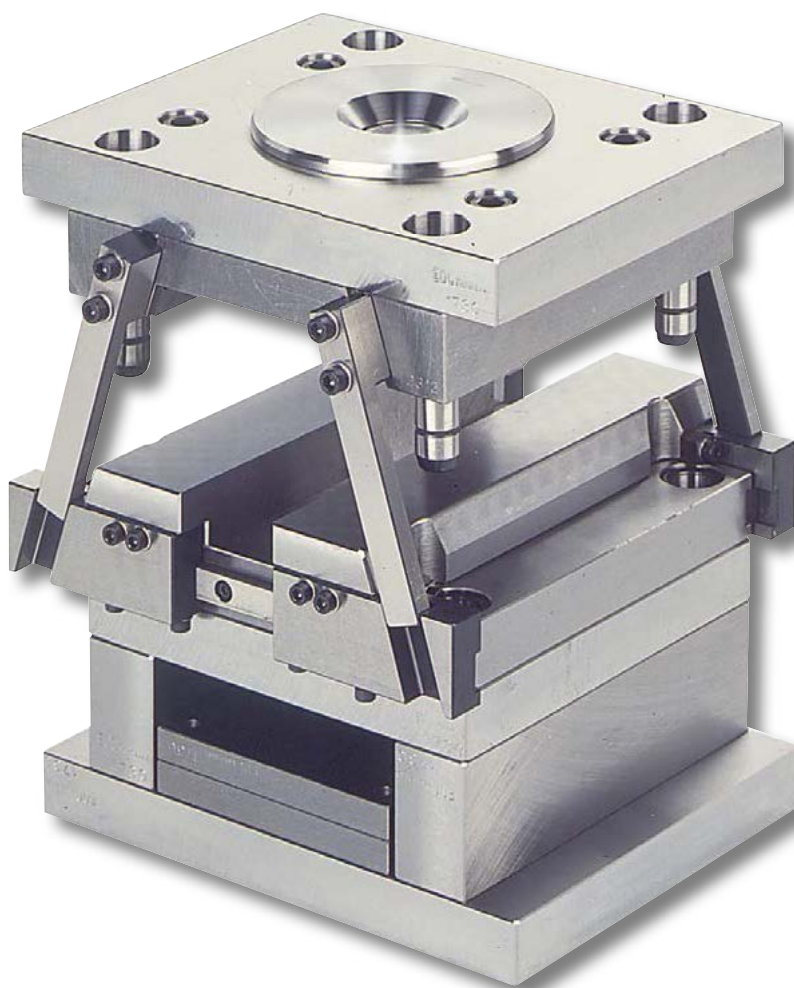


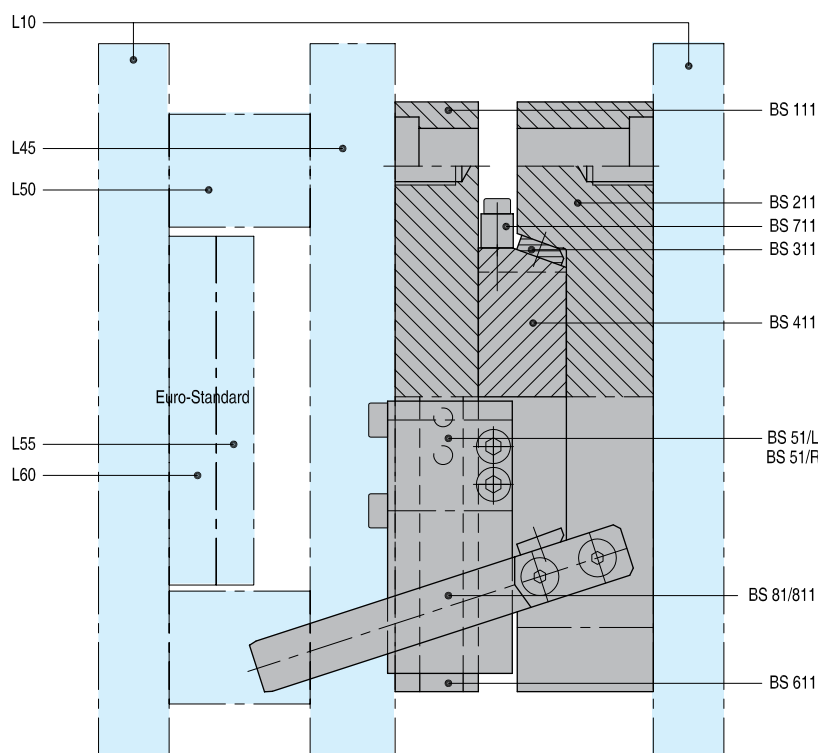


Sliding Core Molds Euro Standard Клиновые формы Евро стандарт



Info Type BS 011

Split Mold Set



156 156
BS 011
BS 111

BS 211

BS 311*
BS 411*

BS 51*

BS 611*

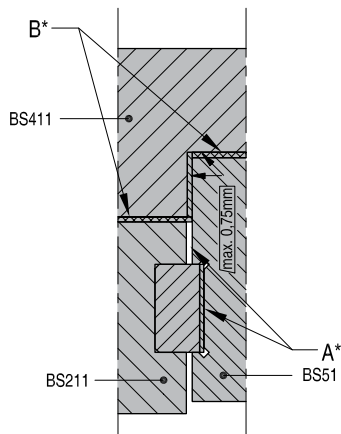
BS 711*

BS 811*

Sizes of split mould sets
Split mould set, complete
(Split mould) cavity plates
(Split mould) stripper plates
(Split mould) cavity plates, nozzle side
Compensating bars
Split cavity blocks
(L/R) Guide plates
Guide beads
Locating elements
Angle guide beads
(The shortening of the angle guide beads by 1mm yields a split cavity block way reduction w of 0,62 mm!)

* Please indicate number of parts when ordering

FIG. 1



* Grind equally

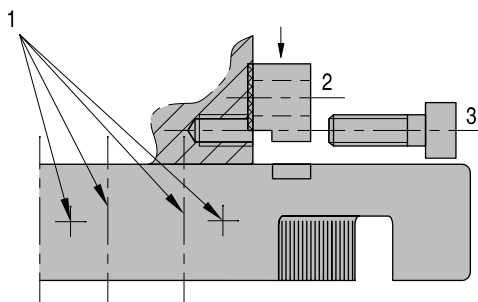
Installation instructions for split mould systems

Adjusting of the guides after finishing of the split cavity blocks (see Fig.1)

The rigid, demountable connection between split cavity blocks (BS 411) and guide plate (BS 51) is achieved by locating elements (BS 711). After finishing of the split cavity blocks the parts must be fitted:

- a) Bolt guide plate (BS 51) with split cavity blocks (BS 411) together and push them upright onto mold stripper plate (BS 111).
- b) Place cavity plate (BS 211, guide components assembled) on split cavity blocks after fitting of compensating bars (BS 311), then attach angle guide beads (B 811).
- c) Tighten fastening screws of guide plates (BS 51). Note! These screws have to be fitted with LOCTITE-threadlocking C 242.
- d) Dissamble cavity plate (BS 211) and split cavity blocks (BS 411) with guide plates (BS 51).
- e) Fit locating elements (BS 711) (see Fig.2).

FIG. 2



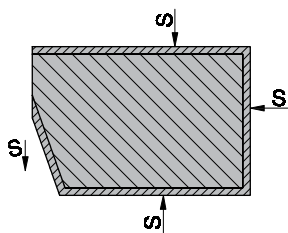
1 Transversal resistance due to screwed joint approx. 5KN (*)

2 Locating element - BS 711

3 Permissible tensile force approx. 15KN (*)

(*) Both values sum up

FIG. 3



Overmeasures for split cavity blocks

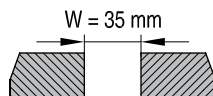
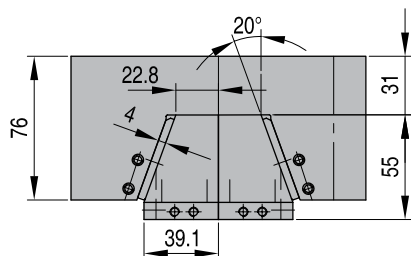
s = 0,15 from size 196 296

s = 0,20 from size 246 246

After rough milling the split cavity blocks are generally stress-free

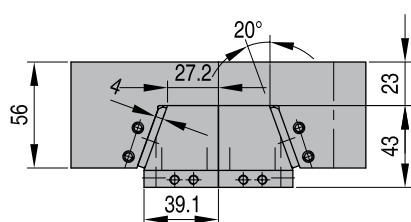
BS 011 156-156

Split Mold Set - Series 1616



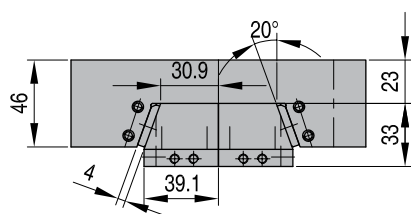
h = 55 mm

REF	b	l	h
BS 011	156-156-55		



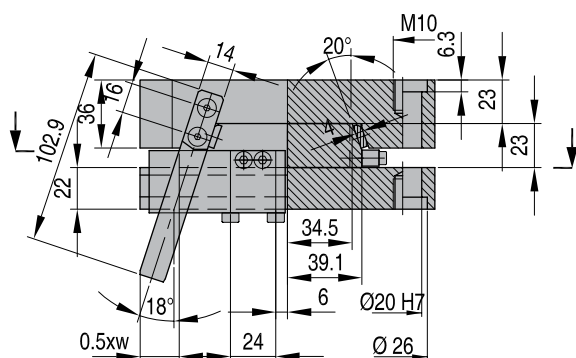
h = 43 mm

REF	b	l	h
BS 011	156-156-43		



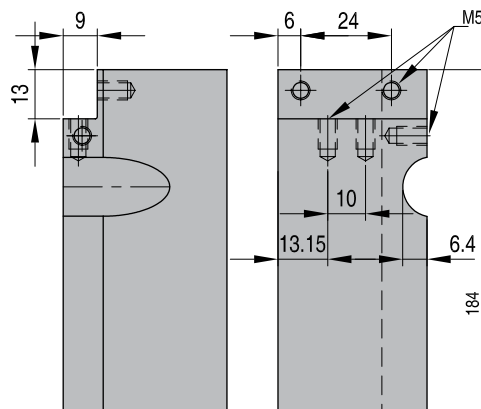
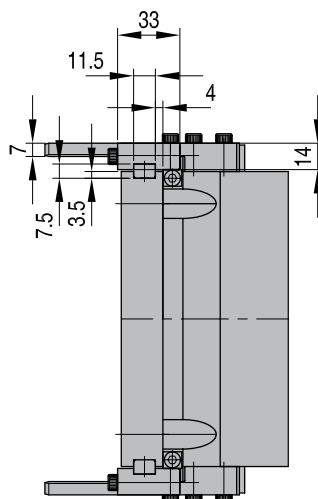
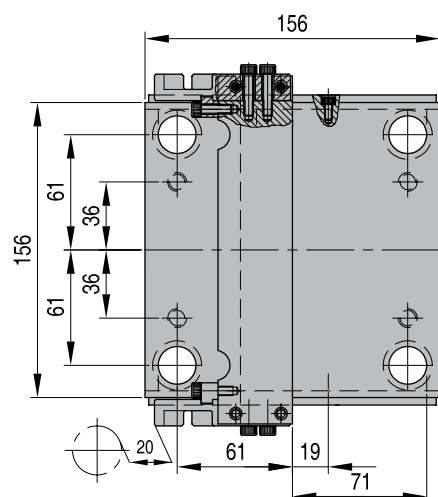
h = 33 mm

REF	b	l	h
BS 011	156-156-33		



h = 23 mm

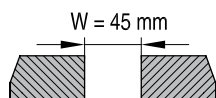
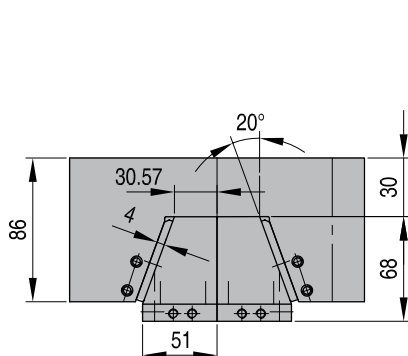
REF	b	l	h
BS 011	156-156-23		



- 1 x BS 111 DME 3 (1.2312)
Mold Stripper Plate
- 1 x BS 211 DME 3 (1.2312)
Top Bolster Plate
- 2 x BS 311 DME 23 (1.2842)
Compensating bars
- 2 x BS 411 DME 26 (1.2764) or
DME 6 (1.2767)
Split Cavity Blocks
- 2 x BS 51R DME 23 (1.2842)
Guide Plate, right hand
- 2 x BS 51L DME 23 (1.2842)
Guide Plate, left hand
- 2 x BS 611 DME 23 (1.2842)
Guide beads
- 4 x BS 711 DME 23 (1.2842)
Locating elements
- 4 x BS 811 DME 76 (1.7131)
Angle guide beads

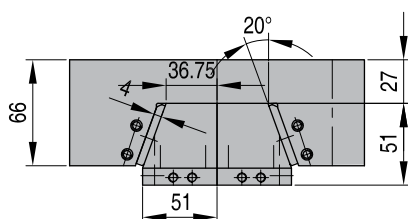
Split Mold Set - Series 2020

BS 011 196-196



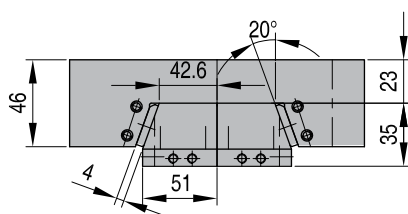
h = 68 mm

REF	b	l	h
BS 011	196	196	68



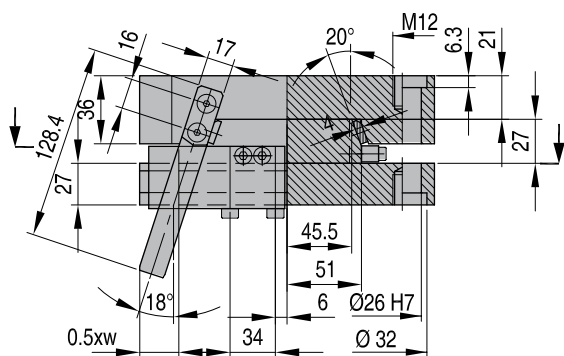
h = 51 mm

REF	b	l	h
BS 011	196	196	51



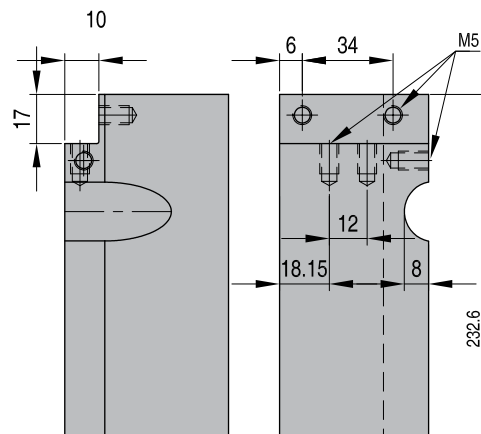
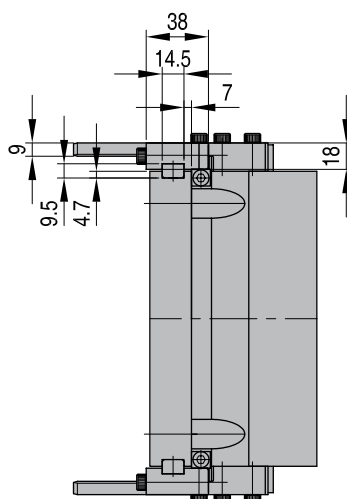
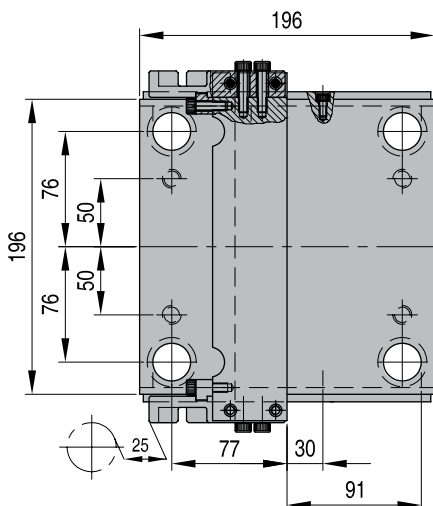
h = 35 mm

REF	b	l	h
BS 011	196	196	35



h = 27 mm

REF	b	l	h
BS 011	196	196	27



1 x BS 111 DME 3 (1.2312)
Mold Stripper Plate

1 x BS 211 DME 3 (1.2312)
Top Bolster Plate

2 x BS 311 DME 23 (1.2842)
Compensating bars

2 x BS 411 DME 26 (1.2764) or DME 6 (1.2767)
Split Cavity Blocks

2 x BS 51R DME 23 (1.2842)
Guide Plate, right hand

2 x BS 51L DME 23 (1.2842)
Guide Plate, left hand

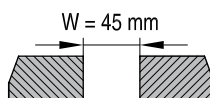
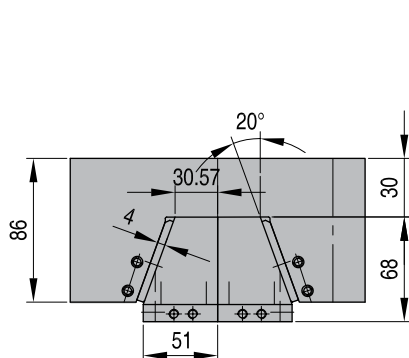
2 x BS 611 DME 23 (1.2842)
Guide beads

4 x BS 711 DME 23 (1.2842)
Locating elements

4 x BS 811 DME 76 (1.7131)
Angle guide beads

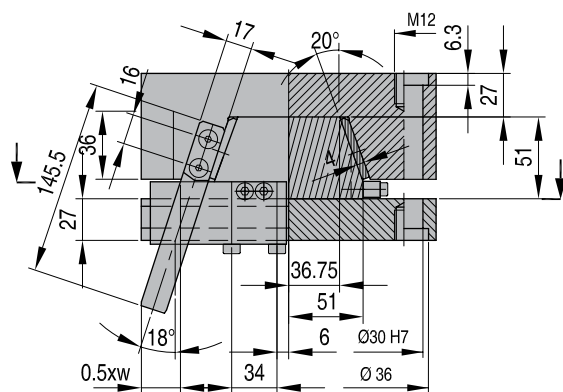
BS 011 196-296

Split Mold Set - Series 2030



h = 68 mm

REF	b	l	h
BS 011 196-296-68			



h = 51 mm

REF	b	l	h
BS 011 196-296-51			

1 x BS 111 DME 3 (1.2312)

Mold Stripper Plate

1 x BS 211 DME 3 (1.2312)

Top Bolster Plate

2 x BS 311 DME 23 (1.2842)

Compensating bars

2 x BS 411 DME 26 (1.2764) or DME 6 (1.2767)

Split Cavity Blocks

2 x BS 51R DME 23 (1.2842)

Guide Plate, right hand

2 x BS 51L DME 23 (1.2842)

Guide Plate, left hand

2 x BS 611 DME 23 (1.2842)

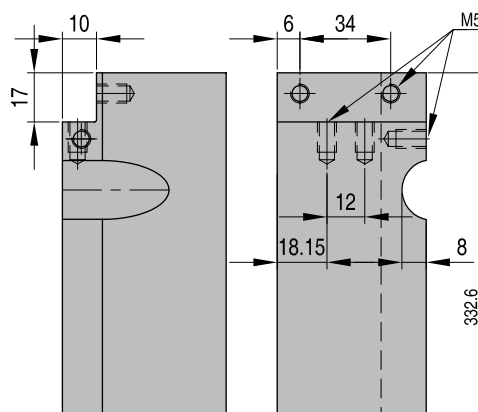
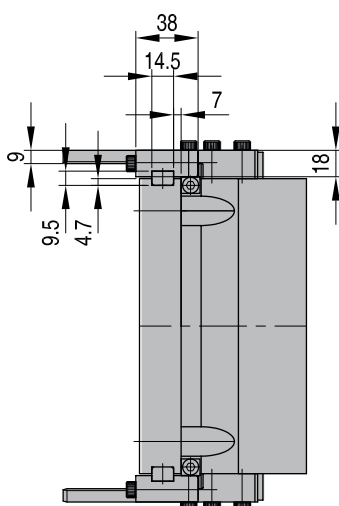
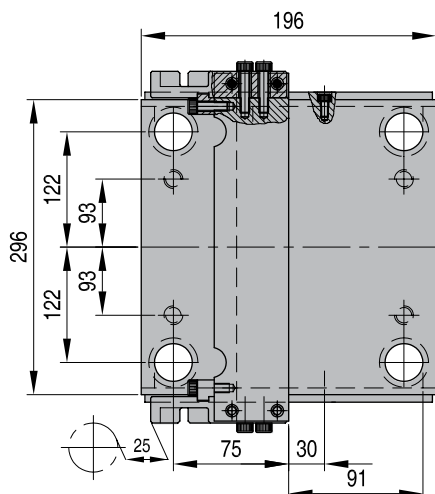
Guide beads

4 x BS 711 DME 23 (1.2842)

Locating elements

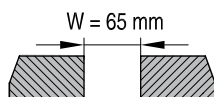
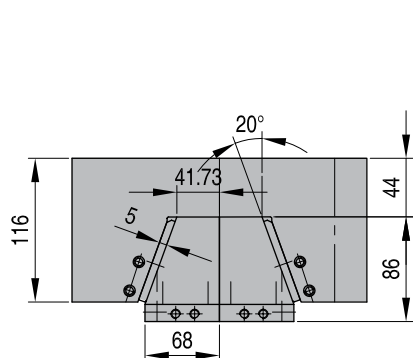
4 x BS 811 DME 76 (1.7131)

Angle guide beads



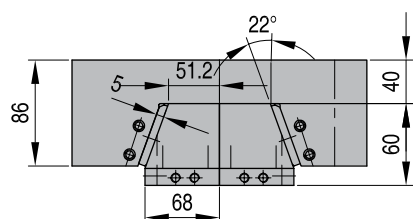
Split Mold Set - Series 2525

BS 011 246-246



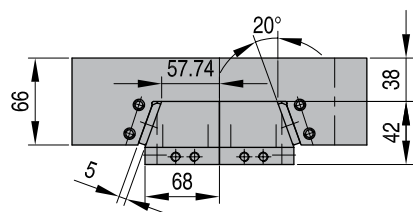
h = 86 mm

REF	b	l	h
BS 011	246	246	86



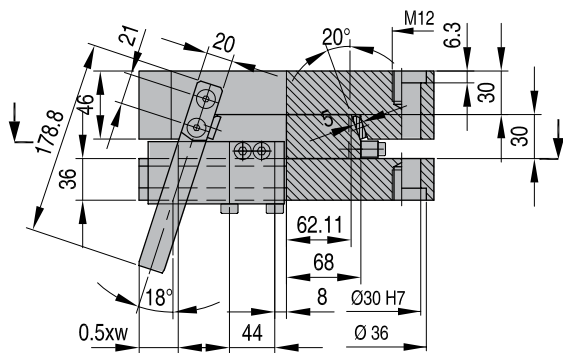
h = 60 mm

REF	b	l	h
BS 011	246	246	60



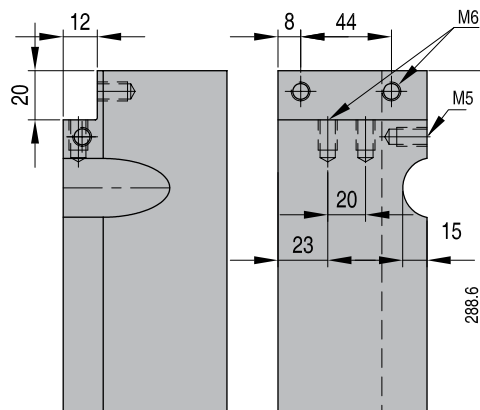
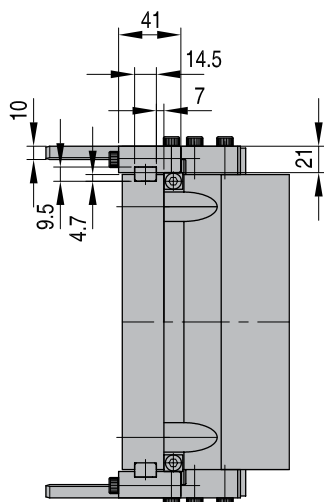
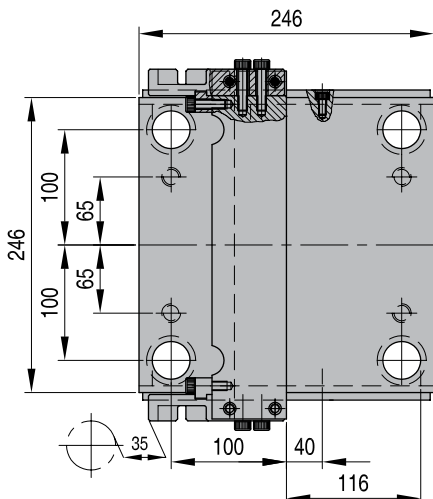
h = 42 mm

REF	b	l	h
BS 011	246	246	42



h = 30 mm

REF	b	l	h
BS 011	246	246	30



1 x BS 111 DME 3 (1.2312)
Mold Stripper Plate

1 x BS 211 DME 3 (1.2312)
Top Bolster Plate

2 x BS 311 DME 23 (1.2842)
Compensating bars

2 x BS 411 DME 26 (1.2764) or DME 6 (1.2767)
Split Cavity Blocks

2 x BS 51R DME 23 (1.2842)
Guide Plate, right hand

2 x BS 51L DME 23 (1.2842)
Guide Plate, left hand

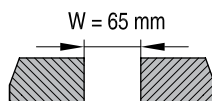
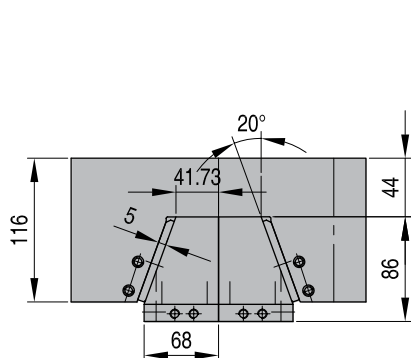
2 x BS 611 DME 23 (1.2842)
Guide beads

4 x BS 711 DME 23 (1.2842)
Locating elements

4 x BS 811 DME 76 (1.7131)
Angle guide beads

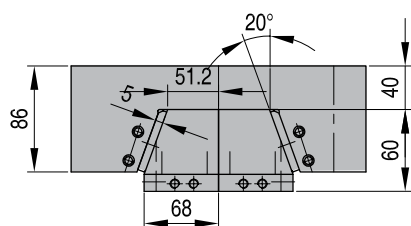
BS 011 246-346

Split Mold Set - Series 2535



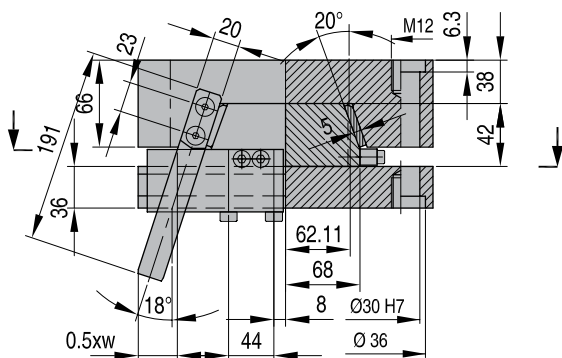
h = 86 mm

REF	b	l	h
BS 011	246	346	86



h = 60 mm

REF	b	l	h
BS 011	246	346	60



h = 42 mm

REF	b	l	h
BS 011	246	346	42

1 x BS 111 DME 3 (1.2312)

Mold Stripper Plate

1 x BS 211 DME 3 (1.2312)

Top Bolster Plate

2 x BS 311 DME 23 (1.2842)

Compensating bars

2 x BS 411 DME 26 (1.2764) or DME 6 (1.2767)

Split Cavity Blocks

2 x BS 51R DME 23 (1.2842)

Guide Plate, right hand

2 x BS 51L DME 23 (1.2842)

Guide Plate, left hand

2 x BS 611 DME 23 (1.2842)

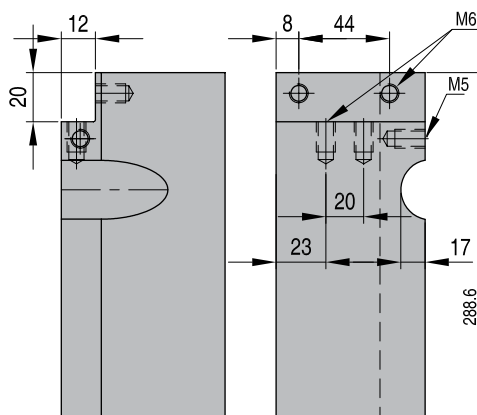
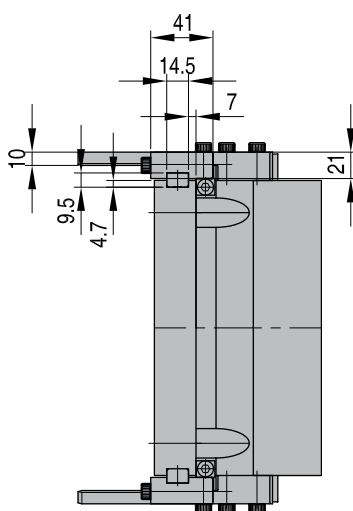
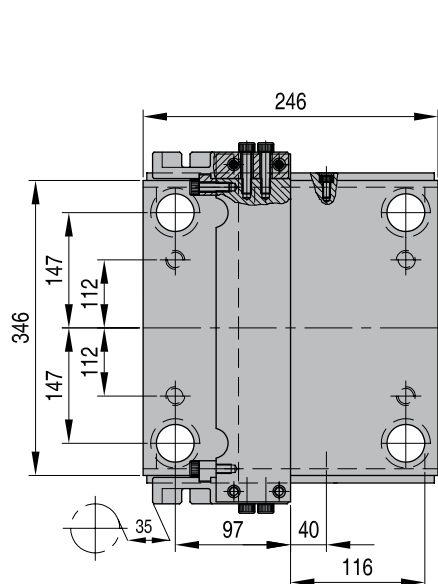
Guide beads

4 x BS 711 DME 23 (1.2842)

Locating elements

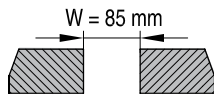
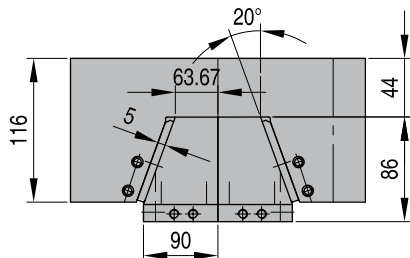
4 x BS 811 DME 76 (1.7131)

Angle guide beads



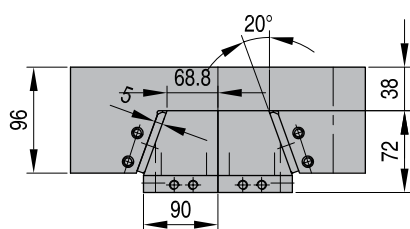
Split Mold Set - Series 3030

BS 011 296-296



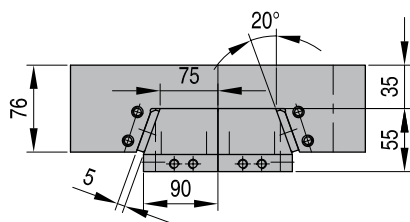
h = 86 mm

REF	b	l	h
BS 011	296	296	86



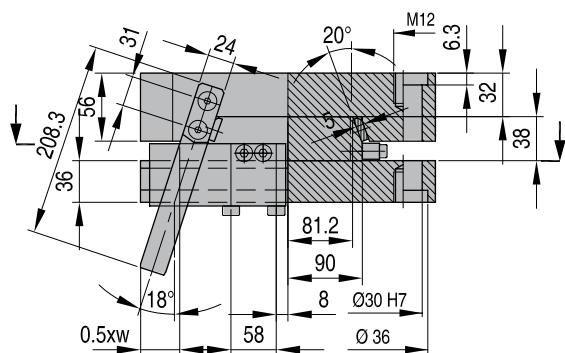
h = 72 mm

REF	b	l	h
BS 011	296	296	72



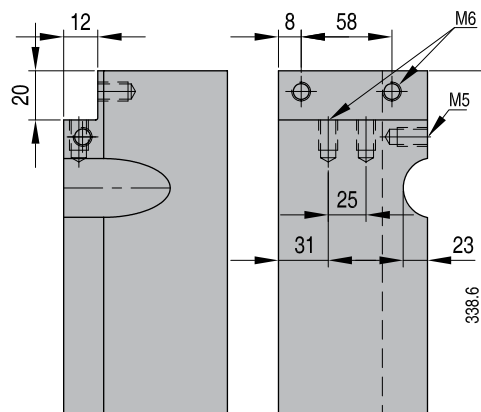
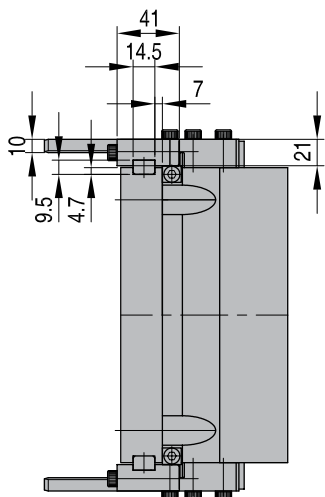
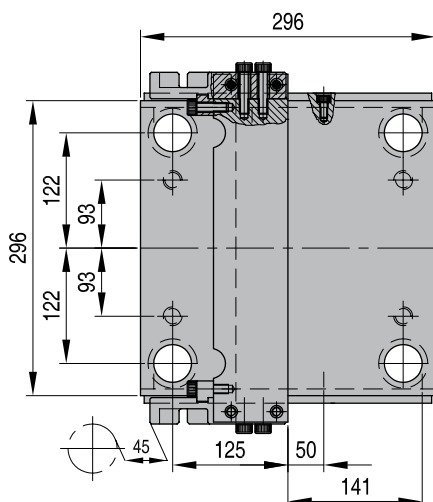
h = 55 mm

REF	b	l	h
BS 011	296	296	55



h = 38 mm

REF	b	l	h
BS 011	296	296	38



1 x BS 111 DME 3 (1.2312)

Mold Stripper Plate

1 x BS 211 DME 3 (1.2312)

Top Bolster Plate

2 x BS 311 DME 23 (1.2842)

Compensating bars

2 x BS 411 DME 26 (1.2764) or DME 6 (1.2767)

Split Cavity Blocks

2 x BS 51R DME 23 (1.2842)

Guide Plate, right hand

2 x BS 51L DME 23 (1.2842)

Guide Plate, left hand

2 x BS 611 DME 23 (1.2842)

Guide beads

4 x BS 711 DME 23 (1.2842)

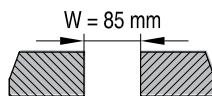
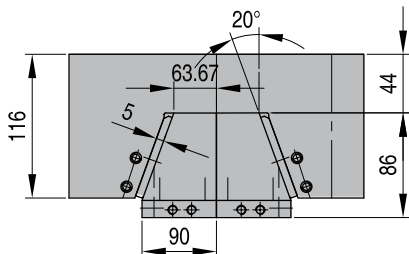
Locating elements

4 x BS 811 DME 76 (1.7131)

Angle guide beads

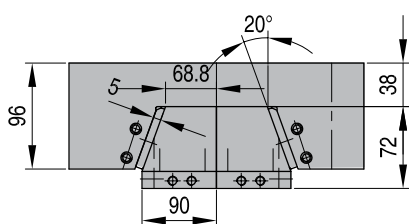
BS 011 296-396

Split Mold Set - Serie 3040



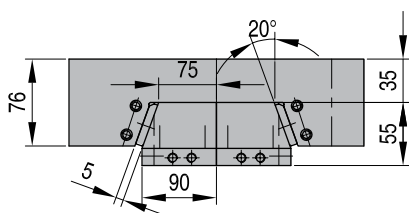
h = 86 mm

REF	b	l	h
BS 011	296-396	86	



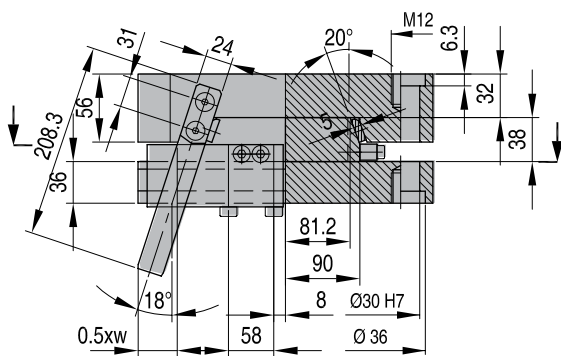
h = 72 mm

REF	b	l	h
BS 011	296-396	72	



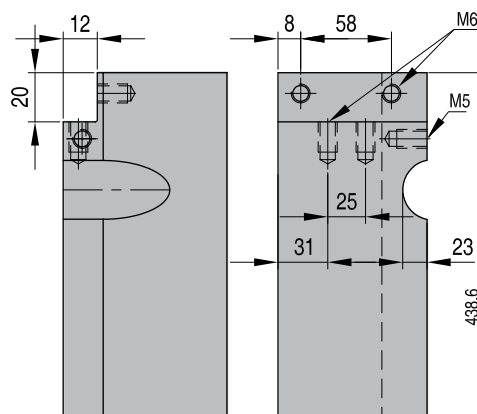
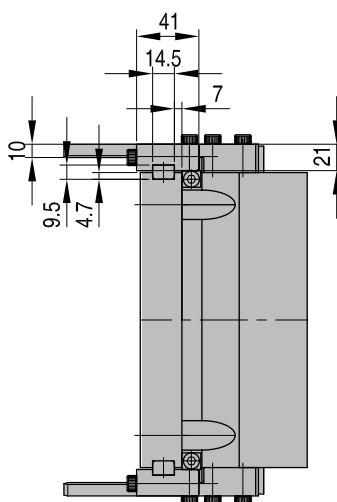
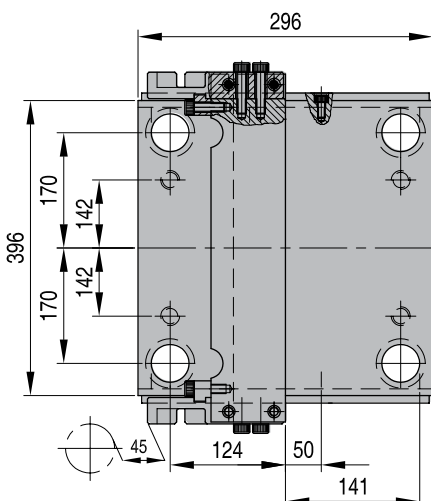
h = 55 mm

REF	b	l	h
BS 011	296-396	55	



h = 38 mm

REF	b	l	h
BS 011	296-396	38	

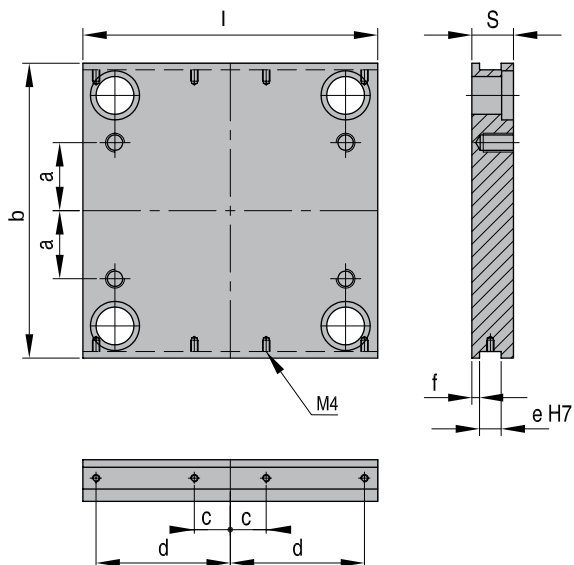


- 1 x BS 111 DME 3 (1.2312)
Mold Stripper Plate
- 1 x BS 211 DME 3 (1.2312)
Top Bolster Plate
- 2 x BS 311 DME 23 (1.2842)
Compensating bars
- 2 x BS 411 DME 26 (1.2764) or
DME 6 (1.2767)
Split Cavity Blocks
- 2 x BS 51R DME 23 (1.2842)
Guide Plate, right hand
- 2 x BS 51L DME 23 (1.2842)
Guide Plate, left hand
- 2 x BS 611 DME 23 (1.2842)
Guide beads
- 4 x BS 711 DME 23 (1.2842)
Locating elements
- 4 x BS 811 DME 76 (1.7131)
Angle guide beads

Mold Stripper Plate

Mat.: DME 3 (1.2312)~1080 N/mm²

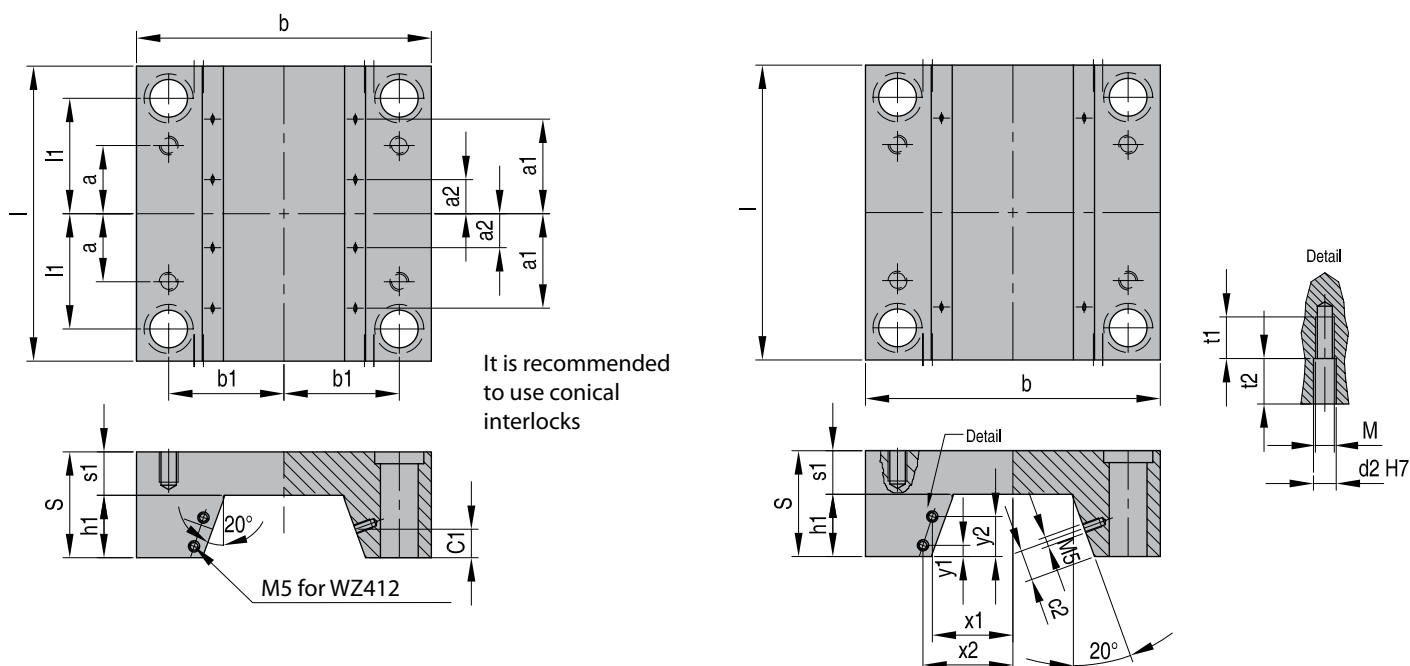
BS 111



REF	b	l	a	c	d	S	e	f
BS 111 156-156-22	156	156	36	19	71	22	11,5	4
BS 111 196-196-27	196	196	50	30	91	27	14,5	7
BS 111 196-296-27	196	296	93	30	91	27	14,5	7
BS 111 246-246-36	246	246	65	40	116	36	14,5	7
BS 111 246-346-36	246	346	112	40	116	36	14,5	7
BS 111 296-296-36	296	296	93	50	141	36	14,5	7
BS 111 296-396-36	296	396	142	50	141	36	14,5	7

BS 211

Top Bolster Plate

Mat.: DME 3 (1.2312)~1080 N/mm²

h = height Split Cavity Blocks

REF	b	l	b1	l1	a	a1	a2	S	s1	C1	h1	c2	x1	x2	y1	y2	d2	t2	M	t1	h
BS 211 156-156-36	156	156	61	61	36	50	-	36	23	6,6	13	7	42,61	47,55	5,99	21,21	6	12	M5	11	23
BS 211 156-156-46	156	156	61	61	36	50	-	46	23	11,3	23	12	42,61	47,55	5,99	21,21	6	12	M5	11	33
BS 211 156-156-56	156	156	61	61	36	50	-	56	23	15,0	33	16	42,61	47,55	5,99	21,21	6	12	M5	11	43
BS 211 156-156-76	156	156	61	61	36	50	-	76	31	20,7	45	22	42,61	47,55	5,99	21,21	6	12	M5	11	55

BS 211 196-196-36	196	196	77	76	50	60	-	36	21	7,5	15	8	54,91	59,86	14,28	29,5	8	13	M6	13	27
BS 211 196-196-46	196	196	77	76	50	60	-	46	23	11,3	23	12	54,91	59,86	14,28	29,5	8	13	M6	13	35
BS 211 196-196-66	196	196	77	76	50	60	-	66	27	15,0	39	16	54,91	59,86	14,28	29,5	8	13	M6	13	51
BS 211 196-196-86	196	196	77	76	50	60	-	86	30	20,7	56	22	54,91	59,86	14,28	29,5	8	13	M6	13	68

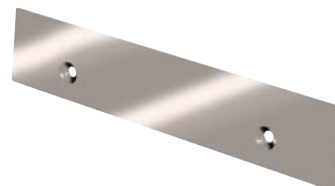
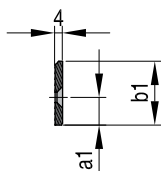
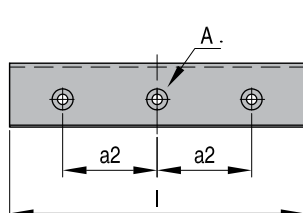
BS 211 196-296-66	196	296	75	122	93	106	42	66	27	15,0	39	16	49,67	54,81	30,48	45,7	8	13	M6	13	51
BS 211 196-296-86	196	296	75	122	93	106	42	86	30	20,7	56	22	49,67	54,81	30,48	45,7	8	13	M6	13	68

BS 211 246-246-46	246	246	100	100	65	90	0	46	30	9,4	16	10	72,01	78,5	18,5	38,47	10	10	M8	15	30
BS 211 246-246-66	246	246	100	100	65	90	0	66	38	14,1	28	15	72,01	78,5	18,5	38,47	10	10	M8	15	42
BS 211 246-246-86	246	246	100	100	65	90	0	86	40	22,6	46	24	72,01	78,5	18,5	38,47	10	10	M8	15	60
BS 211 246-246-116	246	246	100	100	65	90	0	116	44	22,6	72	24	72,01	78,5	18,5	38,47	10	10	M8	15	86

BS 211 246-346-66	246	346	97	147	112	124,75	48,25	66	38	14,1	28	15	68,26	75,37	28,13	50	10	10	M8	15	42
BS 211 246-346-86	246	346	97	147	112	124,75	48,25	86	40	22,6	46	24	68,26	75,37	28,13	50	10	10	M8	15	60
BS 211 246-346-116	246	346	97	147	112	124,75	48,25	116	44	22,6	72	24	68,26	75,37	28,13	50	10	10	M8	15	86

BS 211 296-296-56	296	296	125	122	93	106	42	56	32	13,0	24	14	95,66	105,24	10,37	39,85	10	10	M8	15	38
BS 211 296-296-76	296	296	125	122	93	106	42	76	35	21,6	41	23	95,66	105,24	10,37	39,85	10	10	M8	15	55
BS 211 296-296-96	296	296	125	122	93	106	42	96	38	26,3	58	28	95,66	105,24	10,37	39,85	10	10	M8	15	72
BS 211 296-296-116	296	296	125	122	93	106	42	116	44	31,0	72	33	95,66	105,24	10,37	39,85	10	10	M8	15	86

BS 211 296-396-56	296	396	124	170	142	143,5	54,5	56	32	13,0	24	14	95,66	105,24	10,37	39,85	10	10	M8	15	38
BS 211 296-396-76	296	396	124	170	142	143,5	54,5	76	35	21,6	41	23	95,66	105,24	10,37	39,85	10	10	M8	15	55
BS 211 296-396-96	296	396	124	170	142	143,5	54,5	96	38	26,3	58	28	95,66	105,24	10,37	39,85	10	10	M8	15	72
BS 211 296-396-116	296	396	124	170	142	143,5	54,5	116	44	31,0	72	33	95,66	105,24	10,37	39,85	10	10	M8	15	86



h = height Split Cavity Blocks

REF	l	a1	b1	A	a2	SET	h
BS 311 156-156-23	156	5,1	12,5	NO	50	2 PCS	23
BS 311 156-156-33	156	10,7	23,1	NO	50	2 PCS	33
BS 311 156-156-43	156	14,7	33,8	NO	50	2 PCS	43
BS 311 156-156-55	156	20,7	46,5	NO	50	2 PCS	55

BS 311 196-196-27	196	6,7	14,6	NO	60	2 PCS	27
BS 311 196-196-35	196	10,7	23,2	NO	60	2 PCS	35
BS 311 196-196-51	196	14,7	40,2	NO	60	2 PCS	51
BS 311 196-196-68	196	20,7	58,3	NO	60	2 PCS	68

BS 311 196-296-51	148	14,7	40,2	NO	32	4 PCS	51
BS 311 196-296-68	148	20,7	58,3	NO	32	4 PCS	68

BS 311 246-246-30	246	8,3	15,3	YES	90	2 PCS	30
BS 311 246-246-42	246	13,3	28,1	YES	90	2 PCS	42
BS 311 246-246-60	246	22,3	47,1	YES	90	2 PCS	60
BS 311 246-246-86	246	22,3	74,9	YES	90	2 PCS	86

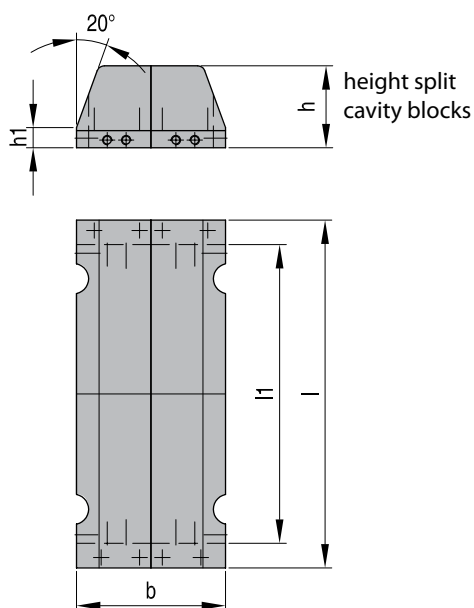
BS 311 246-346-42	173	13,3	28,1	NO	38,35	4 PCS	42
BS 311 246-346-60	173	22,3	47,1	NO	38,35	4 PCS	60
BS 311 246-346-86	173	22,3	74,9	NO	38,35	4 PCS	86

BS 311 296-296-38	148	12,3	23,8	NO	32	4 PCS	38
BS 311 296-296-55	148	21,3	41,9	NO	32	4 PCS	55
BS 311 296-296-72	148	26,3	60,0	NO	32	4 PCS	72
BS 311 296-296-86	148	31,3	74,9	NO	32	4 PCS	86

BS 311 296-396-38	198	12,3	23,8	NO	44,5	4 PCS	38
BS 311 296-396-55	198	21,3	41,9	NO	44,5	4 PCS	55
BS 311 296-396-72	198	26,3	60,0	NO	44,5	4 PCS	72
BS 311 296-396-86	198	31,3	74,9	NO	44,5	4 PCS	86

BS 411

Split Cavity Blocks

 Mat.: DME 26 (1.2764)~850N/mm²
 - DME 6 (1.2767)~830N/mm²


h = height split cavity blocks

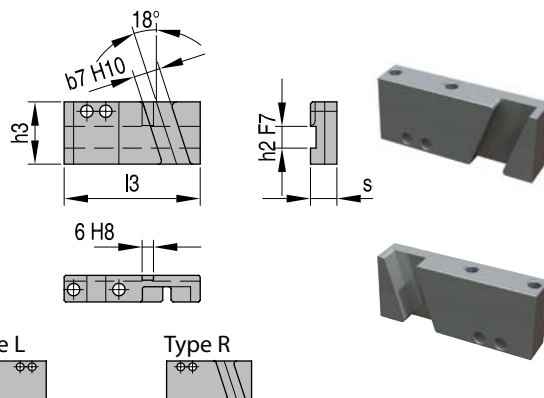
REF	b	l	h	REF	l	l1	b	h1	SET	h
BS 411 156-156-23				BS 411 156-156-23	184,0	158	78,5	10	2 PCS	23
BS 411 156-156-33				BS 411 156-156-33	184,0	158	78,5	10	2 PCS	33
BS 411 156-156-43				BS 411 156-156-43	184,0	158	78,5	10	2 PCS	43
BS 411 156-156-55				BS 411 156-156-55	184,0	158	78,5	10	2 PCS	55
BS 411 196-196-27				BS 411 196-196-27	232,6	198	102	12	2 PCS	27
BS 411 196-196-35				BS 411 196-196-35	232,6	198	102	12	2 PCS	35
BS 411 196-196-51				BS 411 196-196-51	232,6	198	102	12	2 PCS	51
BS 411 196-196-68				BS 411 196-196-68	232,6	198	102	12	2 PCS	68
BS 411 196-296-51				BS 411 196-296-51	332,6	298	102	12	2 PCS	51
BS 411 196-296-68				BS 411 196-296-68	332,6	298	102	12	2 PCS	68
BS 411 246-246-30				BS 411 246-246-30	288,6	248	136	14	2 PCS	30
BS 411 246-246-42				BS 411 246-246-42	288,6	248	136	14	2 PCS	42
BS 411 246-246-60				BS 411 246-246-60	288,6	248	136	14	2 PCS	60
BS 411 246-246-86				BS 411 246-246-86	288,6	248	136	14	2 PCS	86
BS 411 246-346-42				BS 411 246-346-42	388,6	348	136	14	2 PCS	42
BS 411 246-346-60				BS 411 246-346-60	388,6	348	136	14	2 PCS	60
BS 411 246-346-86				BS 411 246-346-86	388,6	348	136	14	2 PCS	86
BS 411 296-296-38				BS 411 296-296-38	338,6	298	180	14	2 PCS	38
BS 411 296-296-55				BS 411 296-296-55	338,6	298	180	14	2 PCS	55
BS 411 296-296-72				BS 411 296-296-72	338,6	298	180	14	2 PCS	72
BS 411 296-296-86				BS 411 296-296-86	338,6	298	180	14	2 PCS	86
BS 411 296-396-38				BS 411 296-396-38	438,6	398	180	14	2 PCS	38
BS 411 296-396-55				BS 411 296-396-55	438,6	398	180	14	2 PCS	55
BS 411 296-396-72				BS 411 296-396-72	438,6	398	180	14	2 PCS	72
BS 411 296-396-86				BS 411 296-396-86	438,6	398	180	14	2 PCS	86

Guide Plates

Mat.: DME 23 (1.2842)~60
HRC

BS 51/L - BS51/R

REF	REF	mold		l 3	h3	s4	b2	h2
		b	l					
BS BS51/L 156	BS BS51/R 156	156	156	72	33	14	14,1	11,5
BS BS51/L 196	BS BS51/R 196	196	196	90	38	18	17,1	14,5
BS BS51/L 196	BS BS51/R 196	196	296	90	38	18	17,1	14,5
BS BS51/L 246	BS BS51/R 246	246	246	112	41	21	20,1	14,5
BS BS51/L 246	BS BS51/R 246	246	346	112	41	21	20,1	14,5
BS BS51/L 296	BS BS51/R 296	296	296	138	41	21	20,1	14,5
BS BS51/L 296	BS BS51/R 296	296	396	138	41	21	20,1	14,5

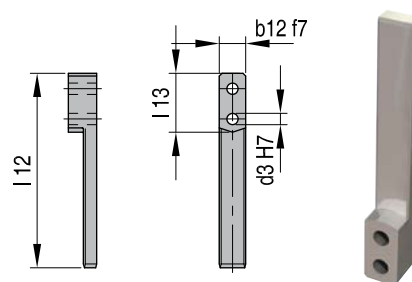


Angle Guide Beads

Mat.: DME 23 (1.2842)~60
HRC

BS 81 / 811

REF	mold		b12	f 12	l 13	d3
	b	l				
BS 811 156-156	156	156	14	102,9	31,2	6
BS 811 196-196	196	196	17	128,4	34	8
BS 811 196-296	196	296	17	145,5	34	8
BS 811 246-246	246	246	20	178,8	41	10
BS 811 246-346	246	346	20	191	43	10
BS 811 296-296	296	296	24	208,3	52	10
BS 811 296-396	296	396	24	208,3	52	10

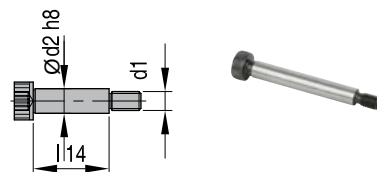


Shoulder Screw

Mat.: Case hardening steel

WZ 412

REF	mold		d2	d1	l 14
	b	l			
wz 412-5 x 25	156	156	6	M5	25
wz 412-6 x 30	196	196	8	M6	30
wz 412-6 x 30	196	296	8	M6	30
wz 412-8 x 30	246	246	10	M8	30
wz 412-8 x 30	246	346	10	M8	30
wz 412-8 x 30	296	296	10	M8	30
wz 412-8 x 30	296	396	10	M8	30

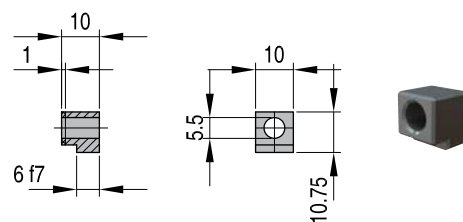


Locating Elements

Mat.: DME 23 (1.2842)~56
HRC

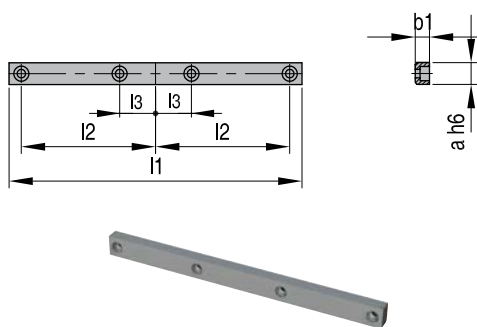
BS 711

REF	mold	
	b	l
BS 711 156-156	156	156
BS 711 196-196	196	196
BS 711 196-296	196	296
BS 711 246-246	246	246
BS 711 246-346	246	346
BS 711 296-296	296	296
BS 711 296-396	296	396



BS 611

Guided Beads

Mat.: DME 23 (1.2842)~56
HRC

REF	mold		l1	l2	l3	a	b1
	b	l					
BS 611 156-156	156	156	155	71	19	11,5	7,5
BS 611 196-196	196	196	195	91	30	14,5	9,5
BS 611 196-296	196	296	195	91	30	14,5	9,5
BS 611 246-246	246	246	245	116	40	14,5	9,5
BS 611 246-346	246	346	245	116	40	14,5	9,5
BS 611 296-296	296	296	295	141	50	14,5	9,5
BS 611 296-396	296	396	295	141	50	14,5	9,5