



Diecasting Mold Bases

Блок-пакеты для литья металла



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Mold Bases

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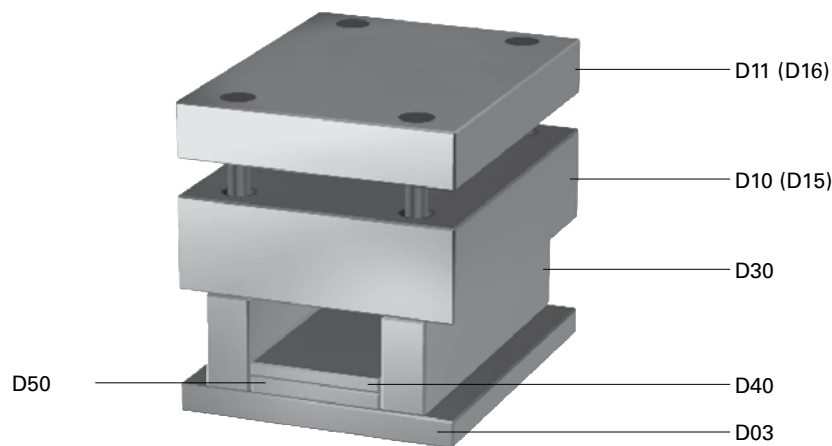
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Info

Steel specification	Analysis & tensile strength	Description
DME 1 C 45 W 1.1730	ca.640MPa(N/mm ²) C=0.45 Si=0.30 Mn=0.70	Non alloy tool steel. Not to be hardened and easy to machine. For molds and simple structural components.
DME 3 40 Cr Mn Mo S 8 6 1.2312	ca.1050 Mpa(N/mm ²) C=0.40 Mn=1.50 Mo=0.20 Si=0.40 Cr=1.90 S=0.07	Low alloy pre-heated tool steel. Excellent machinability. No further hardening required. Can be nitrided.
DME 5 X 40 Cr Mo V 5 1 1.2344	ca.750 Mpa(N/mm ²) C=0.40 Mn=0.40 Mo=1.30 Si=1,00 Cr=5.20 V=1.00	Medium alloy hot work tool steel. Resistant to thermal shock and thermal fatigue. Can be heat-treated. For molds for injection molding and diecasting.

Ordering example



D 3040 DB - 96 - 106/3 126

Mold bases diecasting

SERIE(S)

Typ(e)

D 11 (D 16)
Thickness

Height risers D 30

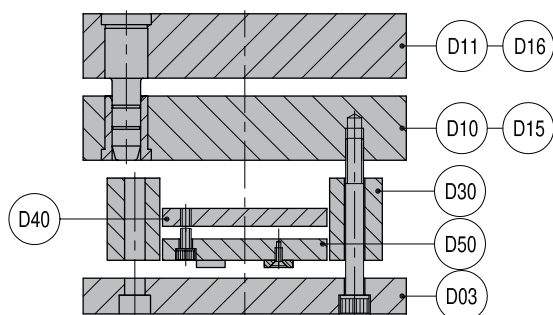
D 11 (D 16) & D 10 (D 15)
Steel

D 10 (D 15)
Thickness

Mold kit consisting of interchangeable plates, complete with components but not assembled.

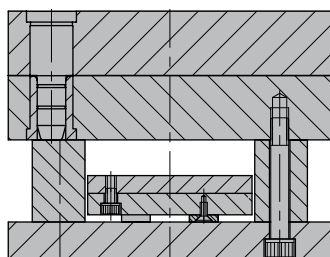
Assemblies

D



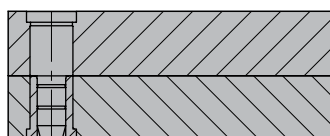
D-type mold base, assembled

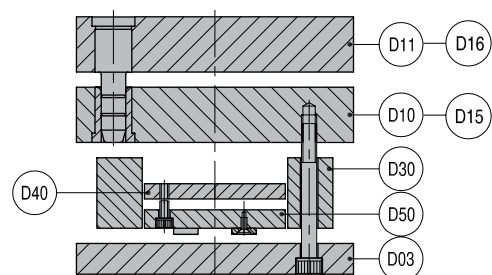
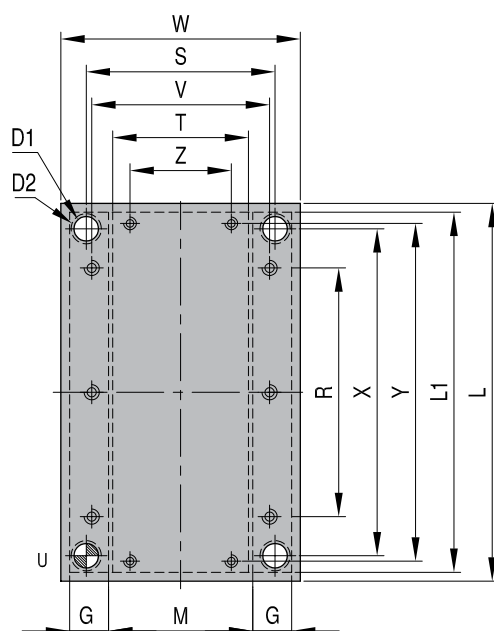
DB



Interchangeable plates (D 11 and D 10) with components installed.

DS





Series	W	L	X	S	R	Y	L1	M	V	Z	T	G	D03	D11/D10 (D16/D15)	D30	D40	D50	D 1	D 2	Screws	
																				Mold	D40 D50
2525	246	246	186	186	94	168	196	124	170	100	120	46	26	46-56-66-76 86-96-106	86-106- 126	16	26	24	32	M 12	M 8
2530	246	296	236	186	144	218	246	124	170	100	120	46	26			16	26	24	32	M 12	M 8
2535	246	346	286	186	194	268	296	124	170	100	120	46	26			16	26	24	32	M 12	M 8
2540	246	396	336	186	244	318	346	124	170	100	120	46	26			16	26	24	32	M 12	M 8
3030	296	296	216	216	114	218	246	154	210	130	150	56	36	56-76-96 106-126-146	86-106- 126	16	26	34	42	M 12	M 8
3040	296	396	316	216	214	318	346	154	210	130	150	56	36			16	26	34	42	M 12	M 8
3050	296	496	416	216	314	418	446	154	210	130	150	56	36			16	26	34	42	M 12	M 8
3535	346	346	266	266	160	260	296	184	250	156	180	66	36	56-76-96-106 126-146-166- 186	106-146- 166	16	26	34	42	M 16	M 10
3540	346	396	316	266	210	310	346	184	250	156	180	66	36			16	26	34	42	M 16	M 10
3550	346	496	416	266	310	410	446	184	250	156	180	66	36			16	26	34	42	M 16	M 10
4040	396	396	296	296	186	310	346	234	296	206	230	66	36	76-96-106 126-146-166- 186	106-146- 166	26	36	42	50	M 16	M 10
4050	396	496	396	296	286	410	446	234	296	206	230	66	36			26	36	42	50	M 16	M 10
4060	396	596	496	296	386	510	546	234	296	206	230	66	36			26	36	42	50	M 16	M 10
4545	446	446	346	346	236	360	396	264	346	236	260	76	36	76-96-106-126 146-166-186- 206	106-146- 186	26	36	42	50	M 16	M 10
4550	446	496	396	346	286	410	446	264	346	236	260	76	36			26	36	42	50	M 16	M 10
4560	446	596	496	346	386	510	546	264	346	236	260	76	36			26	36	42	50	M 16	M 10
5050	496	496	376	376	256	410	446	314	396	286	310	76	46	96-106-126 146-166-186- 206	106-146- 186	26	36	50	60	M 20	M 12
5060	496	596	476	376	356	510	546	314	396	286	310	76	46			26	36	50	60	M 20	M 12
5080	496	796	676	376	556	710	746	314	396	286	310	76	46			26	36	50	60	M 20	M 12
5555	546	546	426	426	306	460	496	344	446	316	340	86	46	96-106-126 146-166-186- 206	106-146- 186	26	36	50	60	M 20	M 12
5560	546	596	476	426	356	510	546	344	446	316	340	86	46			26	36	50	60	M 20	M 12
5580	546	796	676	426	556	710	746	344	446	316	340	86	46			26	36	50	60	M 20	M 12
6060	596	596	476	476	356	510	546	374	496	346	370	96	46	96-106-126 146-166-186- 206	126-146- 186	26	46	50	60	M 20	M 12
6080	596	796	676	476	556	710	746	374	496	346	370	96	46			26	46	50	60	M 20	M 12
6090	596	896	776	476	226/656	810	846	374	496	346	370	96	46			26	46	50	60	M 20	M 12

Interchangeable drilled D-plates
Info
D11 3030 - 96/3

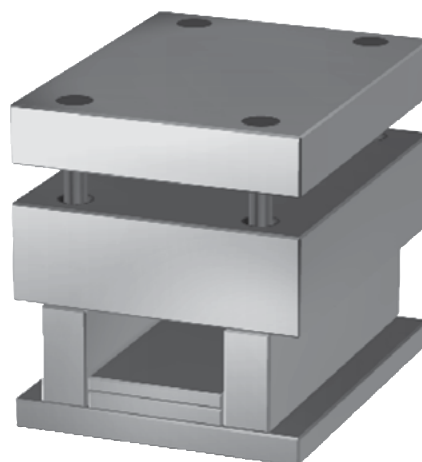
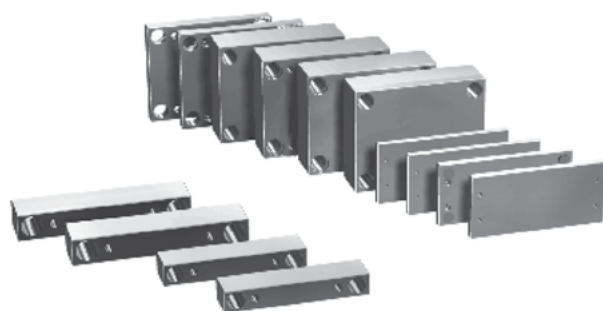
 Interchangeable drilled plates
for diecasting

Typ(e)

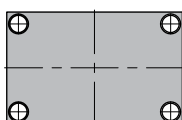
SERIE(S)

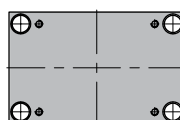
Steel

Thickness

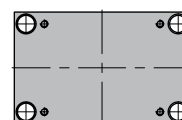

D11

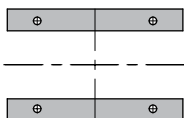
 Mold plate
without screw
holes

D16

 (DME 5)
D 11 plate with
undersize drilled holes
and oversize thickness

D10


Mold plate

D15

 (DME 5)
D 10 with undersize
drilled holes and
oversize thickness

D30


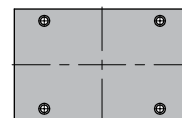
Risers

D40

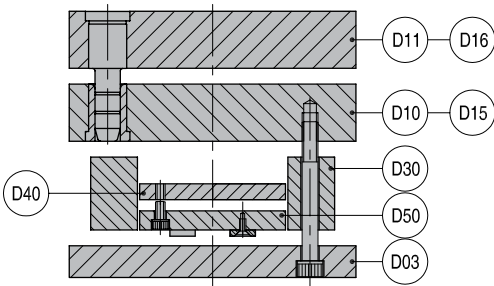

Ejector retainer plate

D50

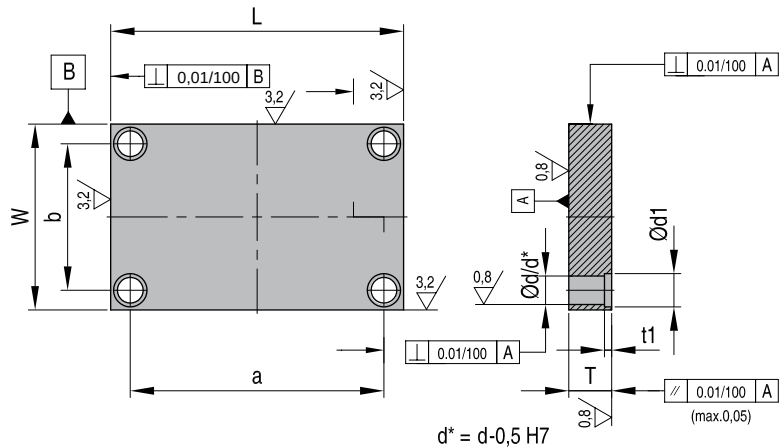

Ejector plate

D03


Clamping plate

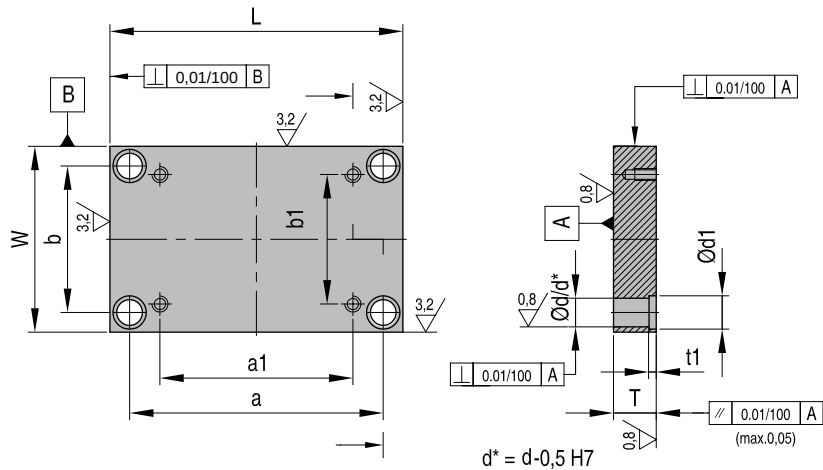


D11/D16*



	mm	D11	D16*
T		+0,05 0	+0,40 +0,2
L & W	≤ 396	± 0,05	
	446 >	± 0,10	
a & b	≤ 396	± 0,010	
	446 > ≤ 496	± 0,012	
	896 >	± 0,014	
d H7 & d* H7	≤ 446	+0,025 0	
	496 >	+0,030 0	
d1 H13		+0,4 0	
t1		+0,3 0	

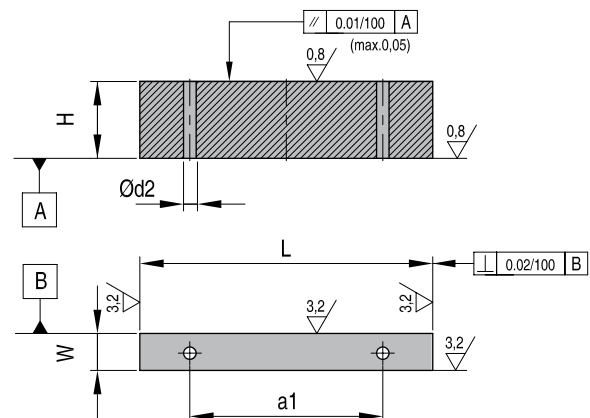
D10/D15*



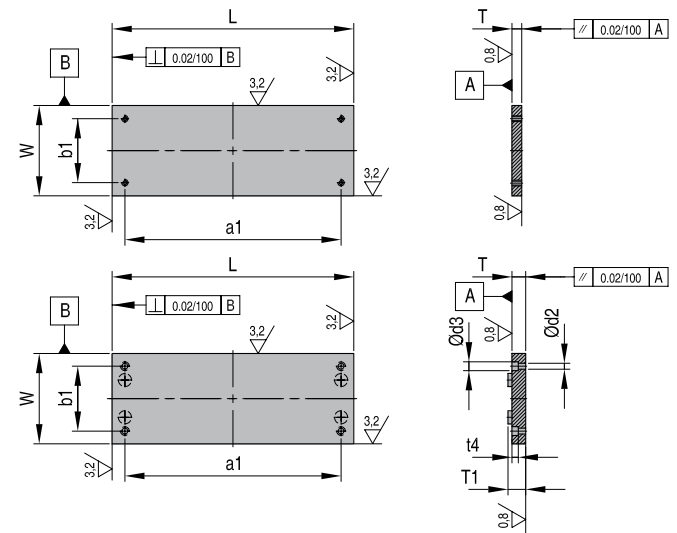
	mm	D10	D15*
T	≤ 896	+0,05 0	+0,40 +0,2
L & W	≤ 396	± 0,05	
	446 >	± 0,10	
a & b	≤ 396	± 0,010	
	446 > ≤ 496	± 0,012	
	896 >	± 0,014	
a1 & b1	≤ 396	± 0,2	
	446 >	± 0,3	
d H7 & d* H7	≤ 446	+0,025 0	
	496 >	+0,030 0	
d1 H13	≤ 896	+0,4 0	
t1	≤ 896	+0,3 0	

Tolerances
Info
D30

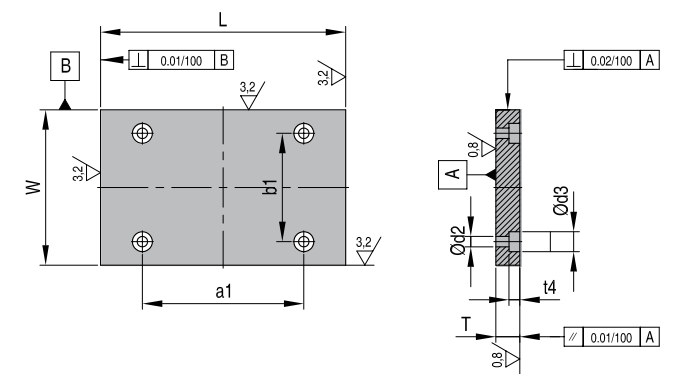
	mm	D30
H		+0,02 0
L		-0,4 -0,8
W		-0,2 -0,6
a1	≤ 396	± 0,2
	896 >	± 0,3
d2 H13	≤ 496	+0,22 0
	496 > ≤ 596	+0,27 0
	596 >	+0,33 0


D40/D50

	mm	D40 / D50
T		+0,4 0
T1		+0,05 0
L & W		0 -0,1
a1 & b1	≤ 396	± 0,2
	446 > ≤ 896	± 0,3
d2 H13 & d3 H13	≤ 446	+0,22 0
	496 >	+0,27 0
t4	≤ 596	+0,3 0
	596 > ≤ 896	+0,4 0


D03

	mm	D03
T		+0,05 0
L & W	≤ 396	± 0,05
	446 >	± 0,10
a1 & b1	≤ 396	± 0,2
	446 > ≤ 896	± 0,3
d2 H13 & d3 H13	≤ 446	+0,22 0
	496 >	+0,27 0
t4		+0,4 0



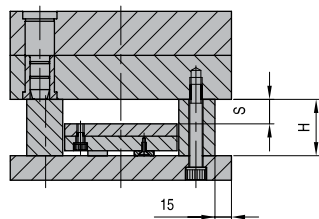
D 25

Basic assemblies

D 2525 (246 x 246 mm)
D 2530 (246 x 296 mm)
D 2535 (246 x 346 mm)
D 2540 (246 x 396 mm)

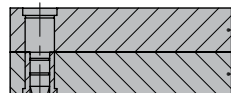
DB T T H

D 2525 DB - D11 - D10 / Mat. 106

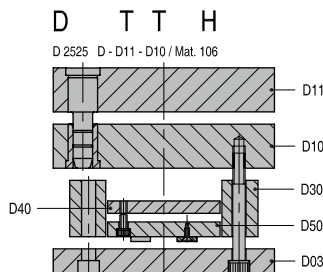
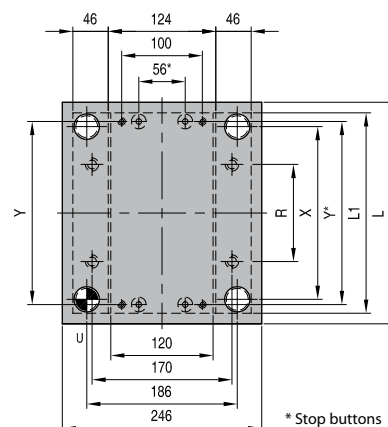


DS T T

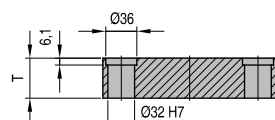
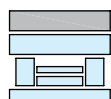
D 2525 DS - D11 - D10 / Mat.



D25	L	LI	Y/Y*	X	R	
2525	246	196	168	186	94	4 x M12
2530	296	246	218	236	144	4 x M12
2535	346	296	268	286	194	4 x M12
2540	396	346	318	336	244	4 x M12

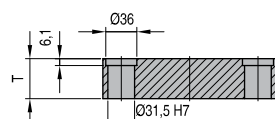


Interchangeable drilled D-plates



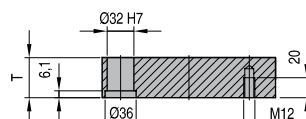
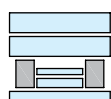
D11

REF	Mat.	T						
		46	56	66	76	86	96	106
D11 2525 T Mat.	01=1730 03=2312 05=2344							
D11 2530 T Mat.								
D11 2535 T Mat.								
D11 2540 T Mat.								



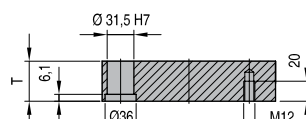
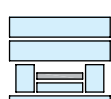
D16

REF	Mat.	T						
		46	56	66	76	86	96	106
D16 2525 T Mat.	05=2344							
D16 2530 T Mat.								
D16 2535 T Mat.								
D16 2540 T Mat.								



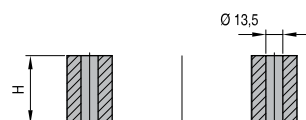
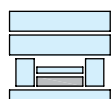
D10

REF	Mat.	T						
		46	56	66	76	86	96	106
D10 2525 T Mat.	01=1730 03=2312 05=2344							
D10 2530 T Mat.								
D10 2535 T Mat.								
D10 2540 T Mat.								



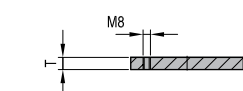
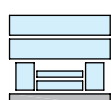
D15

REF	Mat.	T						
		46	56	66	76	86	96	106
D10 2525 T Mat.	05=2344							
D10 2530 T Mat.								
D10 2535 T Mat.								
D10 2540 T Mat.								



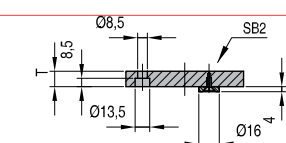
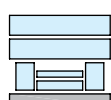
D30

REF	Mat.	H		
		86	106	126
D30 H 2525 01	1730			
D30 H 2530 01				
D30 H 2535 01				
D30 H 2540 01				
		S		
		40	60	80



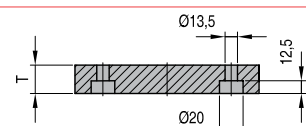
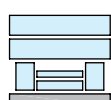
D40

REF	Mat.	T
D40 16 2525 01	1730	16
D40 16 2530 01		16
D40 16 2535 01		16
D40 16 2540 01		16



D50

REF	Mat.	T
D50 26 2525 01	1730	26
D50 26 2530 01		26
D50 26 2535 01		26
D50 26 2540 01		26



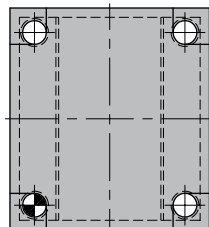
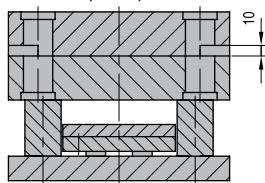
D03

REF	Mat.	T
D03 2525 26 01	1730	26
D03 2530 26 01		26
D03 2535 26 01		26
D03 2540 26 01		26

D 25

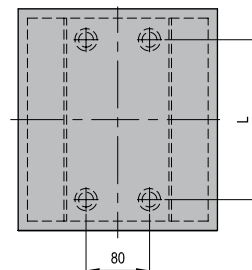
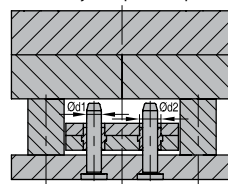
D 2525 (246 x 246 mm)
D 2530 (246 x 296 mm)
D 2535 (246 x 346 mm)
D 2540 (246 x 396 mm)

* Lever slots - upon request

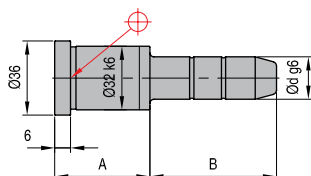


D25	L	d1	d2
2525	116	20	28
2530	166	20	28
2535	216	20	28
2540	266	20	28

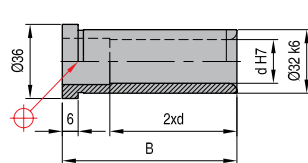
* Guided ejector plates - upon request



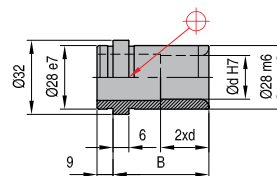
FSN



FBN



FBC



REF	d	A	B
FSN 24-	46-	046	
	- 066		
	- 086		
	- 106		
FSN 24-	56-	046	
	- 056		
	- 076		
	- 096		
FSN 24-	66-	066	
	- 086		
	- 106		
FSN 24-	76-	056	
	- 076		
	- 096		
FSN 24-	86-	066	
	- 086		
	- 106		
FSN 24-	96-	056	
	- 076		
	- 096		
FSN 24-	106-	056	
	- 076		
	- 086		

REF	d	A	B
FSN 23-	46-	046	
	- 066		
	- 086		
	- 106		
FSN 23-	56-	046	
	- 056		
	- 076		
	- 096		
FSN 23-	66-	066	
	- 086		
	- 106		
FSN 23-	76-	056	
	- 076		
	- 096		
FSN 23-	86-	066	
	- 086		
	- 106		
FSN 23-	96-	056	
	- 076		
	- 096		
FSN 23-	106-	056	
	- 076		
	- 086		

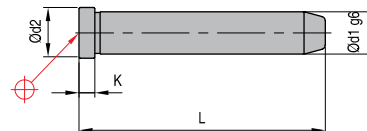
REF	d	B
FBN 24-	046	
	- 056	
	- 066	
	- 076	
	- 086	
	- 096	
	- 106	

REF	d	B
FBN 23-	046	
	- 056	
	- 066	
	- 076	
	- 086	
	- 096	
	- 106	

REF	d	B
FBC 20-	026	

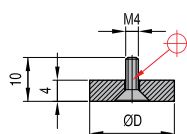
REF	d	B
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APD



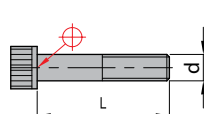
REF	d1	L	d2	K
APD 20-	100			
	- 120		24	8
	- 140			
	- 160			

SB



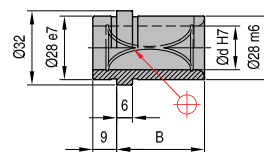
REF	D
SB2	16

M



REF	d	L
M	8 x	30
M	12 x	120
	x	140
	x	160

GEB



REF	d	B
GEB 20-	026	

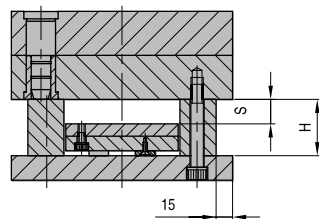
D 30

Basic assemblies

D 3030 (296 x 296 mm)
D 3040 (296 x 396 mm)
D 3050 (296 x 496 mm)

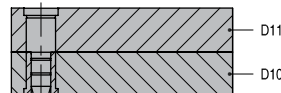
DB T T H

D 3030 DB - D11 - D10 / Mat. 106



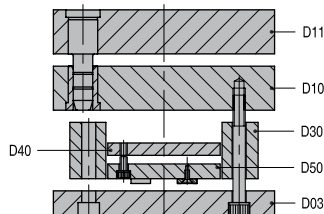
DS T T

D 3030 DS - D11 - D10 / Mat.

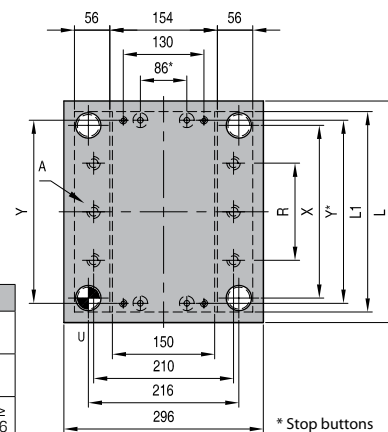


D T T H

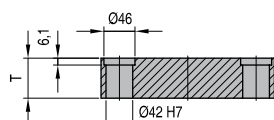
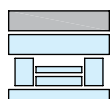
D 3030 D - D11 - D10 / Mat. 106



D30	L	L1	Y/Y*	X	R	A
3030	296	246	218	216	114	4 x M12
3040	396	346	318	316	214	4 x M12
3050	496	446	418	416	314	6 x M12

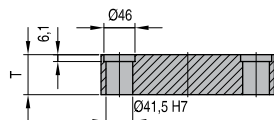


Interchangeable drilled D-plates



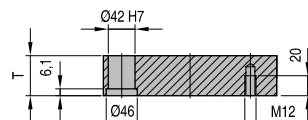
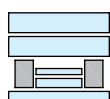
D11

REF	Mat.	T					
		56	76	96	106	126	146
D11 3030 T Mat.	01=1730						
D11 3040 T Mat.	03=2312						
D11 3050 T Mat.	05=2344						



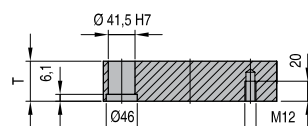
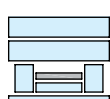
D16

REF	Mat.	T					
		56	76	96	106	126	146
D16 3030 T Mat.	05=2344						
D16 3040 T Mat.							
D16 3050 T Mat.							



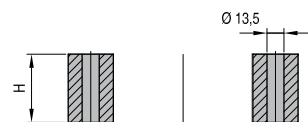
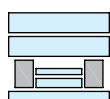
D10

REF	Mat.	T					
		56	76	96	106	126	146
D10 3030 T Mat.	01=1730						
D10 3040 T Mat.	03=2312						
D10 3050 T Mat.	05=2344						



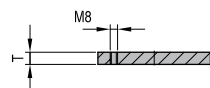
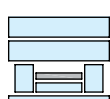
D15

REF	Mat.	T					
		56	76	96	106	126	146
D15 3030 T Mat.	05=2344						
D15 3040 T Mat.							
D15 3050 T Mat.							



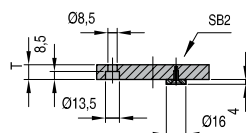
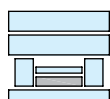
D30

REF	Mat.	H		
		86	106	126
D30 H 3030 01	1730			
D30 H 3040 01				
D30 H 3050 01				
		S		
		40	60	80



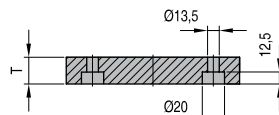
D40

REF	Mat.	T
D40 16 3030 01	1730	16
D40 16 3040 01		16
D40 16 3050 01		16



D50

REF	Mat.	T
D50 26 3030 01	1730	26
D50 26 3040 01		26
D50 26 3050 01		26



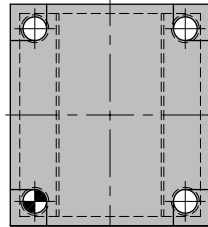
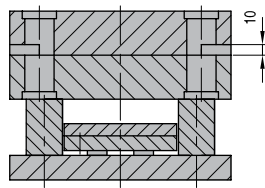
D03

REF	Mat.	T
D03 3030 36 01	1730	36
D03 3040 36 01		36
D03 3050 36 01		36

D 30

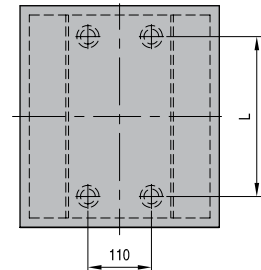
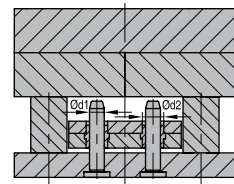
D 3030 (296 x 296 mm)
D 3040 (296 x 396 mm)
D 3050 (296 x 496 mm)

* Lever slots - upon request

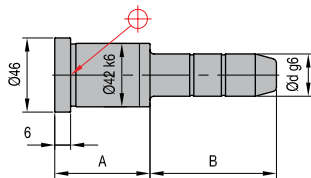


D25	L	d1	d2
3030	166	20	28
3040	266	20	28
3050	360	20	28

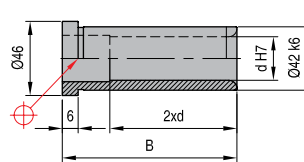
* Guided ejector plates



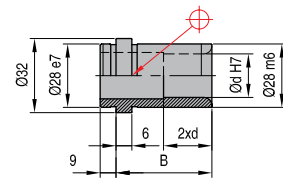
FSN



FBN



FBC



REF	d	A	B
FSN 34- 56-	056		
-	066		
-	096		
-	126		
FSN 34- 76-	066		
-	106		
-	146		
FSN 34- 96-	066		
-	096		
-	146		
FSN 34- 106-	056		
-	076		
-	106		
-	146		
FSN 34- 126-	056		
-	086		
-	126		
-	146		
FSN 34- 146-	056		
-	086		
-	106		

REF	d	A	B
FSN 33- 56-	056		
-	066		
-	096		
-	126		
FSN 33- 76-	066		
-	106		
-	146		
FSN 33- 96-	066		
-	096		
-	146		
FSN 33- 106-	056		
-	076		
-	106		
-	146		
FSN 33- 126-	056		
-	086		
-	126		
-	146		
FSN 33- 146-	056		
-	086		
-	106		

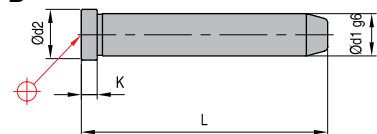
REF	d	B
FBN 34- 056		
- 076		
- 096		
- 106		
- 126		
- 146		

REF	d	B
FBN 33- 056		
- 076		
- 096		
- 106		
- 126		
- 146		

REF	d	B
FBC 20- 026		

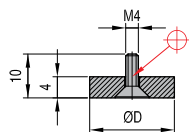
REF	d	B
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APD



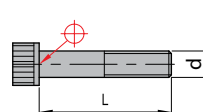
REF	d1	L	d2	K
APD 20- 110			24	8
- 120				
- 140				
- 160				
- 180				

SB



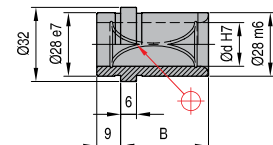
REF	D
SB2 16	

M



REF	d	L
M 8 x 30		
M 12 x 130		
x 150		
x 170		

GEB



REF	d	B
GEB 20- 026		

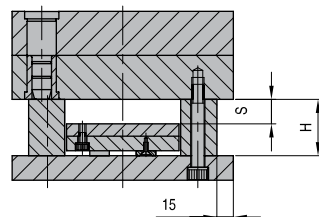
D 35

Basic assemblies

D 3535 (346 x 346 mm)
D 3540 (346 x 396 mm)
D 3550 (346 x 496 mm)

DB T T H

D 3535 DB - D11 - D10 / Mat. 146

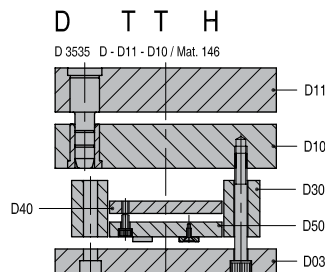
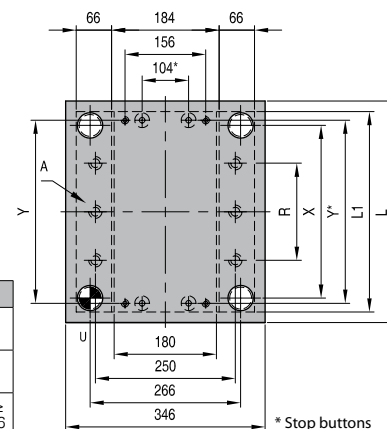


DS T T

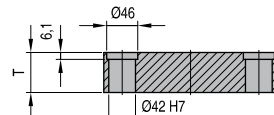
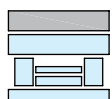
D 3535 DS - D11 - D10 / Mat.



D35	L	L1	Y/Y*	X	R	A
3535	346	296	260	266	160	4 x M16
3540	396	346	310	316	210	4 x M16
3550	496	446	410	416	310	6 x M16 L ≥ 496

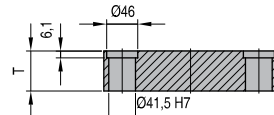
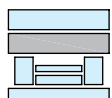


Interchangeable drilled D-plates



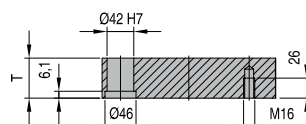
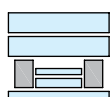
D11

REF	Mat.	T							
		56	76	96	106	126	146	166	186
D11 3535 T Mat.	01=1730								
D11 3540 T Mat.	03=2312								
D11 3550 T Mat.	05=2344								



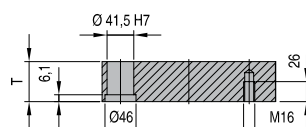
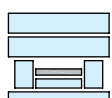
D16

REF	Mat.	T							
		56	76	96	106	126	146	166	186
D16 3535 T Mat.	05=2344								
D16 3540 T Mat.									
D16 3550 T Mat.									



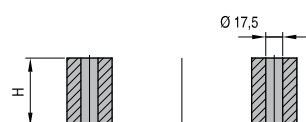
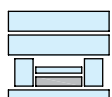
D10

REF	Mat.	T							
		56	76	96	106	126	146	166	186
D10 3535 T Mat.	01=1730								
D10 3540 T Mat.	03=2312								
D10 3550 T Mat.	05=2344								



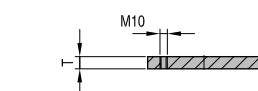
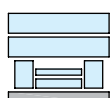
D15

REF	Mat.	T							
		56	76	96	106	126	146	166	186
D15 3535 T Mat.	05=2344								
D15 3540 T Mat.									
D15 3550 T Mat.									



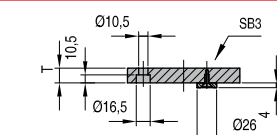
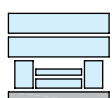
D30

REF	Mat.	H		
		106	146	166
D30 H 3535 01	1730			
D30 H 3540 01				
D30 H 3550 01				
		S		
		60	100	120



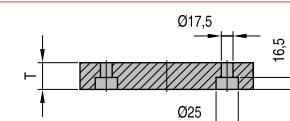
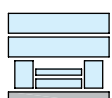
D40

REF	Mat.	T
D40 16 3535 01	1730	16
D40 16 3540 01		16
D40 16 3550 01		16



D50

REF	Mat.	T
D50 26 3535 01	1730	26
D50 26 3540 01		26
D50 26 3550 01		26



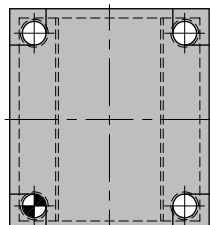
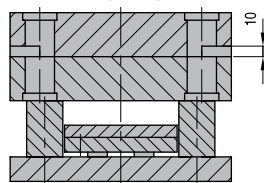
D03

REF	Mat.	T
D03 3535 36 01	1730	36
D03 3540 36 01		36
D03 3550 36 01		36

D 35

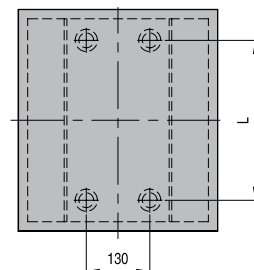
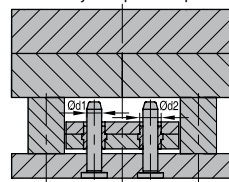
D 3535 (346 x 346 mm)
D 3540 (346 x 396 mm)
D 3550 (346 x 496 mm)

* Lever slots - upon request

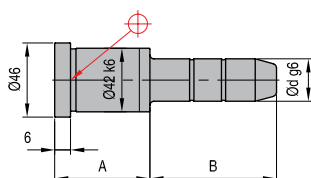


D35	L	d1	d2
3535	206	24	32
3540	256	24	32
3550	356	24	32

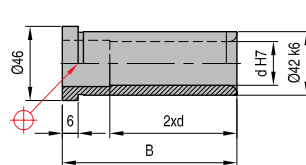
* Guided ejector plates - upon request



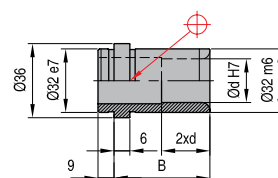
FSN



FBN



FBC



REF	d	A-	B
FSN 34-	56-	056	
	- 066		
	- 096		
	- 126		
FSN 34-	76-	066	
	- 106		
	- 146		
FSN 34-	96-	066	
	- 096		
	- 146		
FSN 34-	106-	056	
	- 076		
	- 106		
	- 146		
FSN 34-	126-	056	
	- 086		
	- 126		
	- 146		
FSN 34-	146-	056	
	- 086		
	- 106		
FSN 34-	166-	166	
FSN 34-	186-	186	

REF	d	A-	B
FSN 33-	56-	056	
	- 066		
	- 096		
	- 126		
FSN 33-	76-	066	
	- 106		
	- 146		
FSN 33-	96-	066	
	- 096		
	- 146		
FSN 33-	106-	056	
	- 076		
	- 106		
	- 146		
FSN 33-	126-	056	
	- 086		
	- 126		
	- 146		
FSN 33-	146-	056	
	- 086		
	- 106		
FSN 33-	166-	166	
FSN 33-	186-	186	

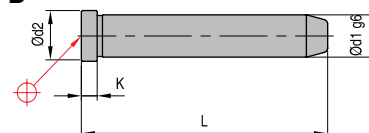
REF	d	B
FBN 34-	056	
	- 076	
	- 096	
	- 106	
	- 126	
	- 146	
	- 166	
	- 186	

REF	d	B
FBN 33-	056	
	- 076	
	- 096	
	- 106	
	- 126	
	- 146	
	- 166	
	- 186	

REF	d	B
FBC 24-	026	

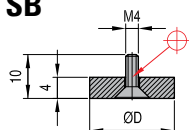
REF	d	B
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APD



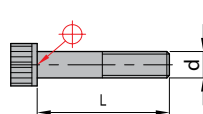
REF	d1	L	d2	K
APD 24-	110			
	- 120			
	- 140			
	- 160			
	- 200			
	- 220			

SB



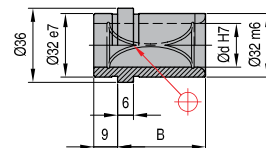
REF	D
SB3	26

M



REF	d	L
M	10 x 30	
M	16 x 150	
	x 190	
	x 210	

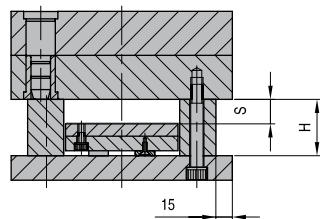
GEB



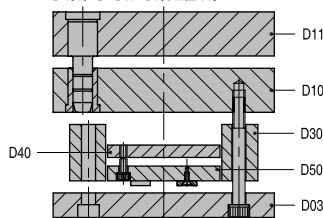
REF	d	B
GEB 24-	026	

Basic assemblies

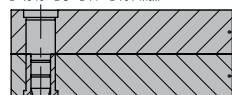
D 4040 DB - D11 - D10 / Mat. 146



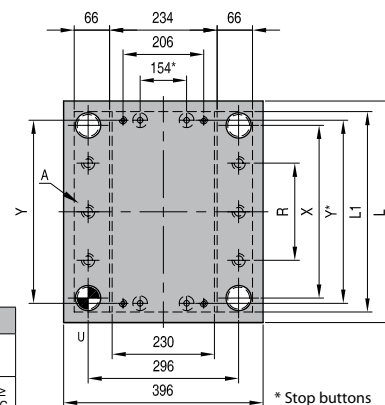
D 4040 D - D11 - D10 / Mat. 146



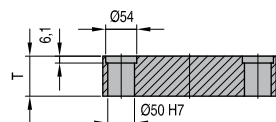
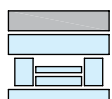
D 4040 DS - D11 - D10 / Mat



D40	L	L1	V/Y*	X	R		A
4040	396	346	310	296	186	4 x M16	
4050	496	446	410	396	286	6 x M16	L ≥ 496
4060	596	546	510	496	386	6 x M16	L ≥ 496

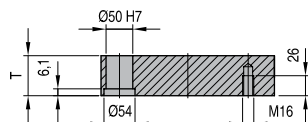


Interchangeable drilled D-plates



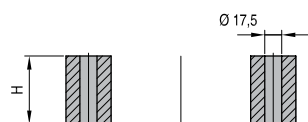
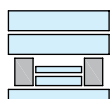
D11

REF	Mat.	T						
		76	96	106	126	146	166	186
D11 4040 T Mat.	01=1730							
D11 4050 T Mat.	03=2312							
D11 4060 T Mat.	05=2344							



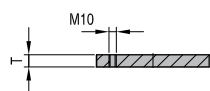
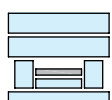
D10

REF	Mat.	T						
		76	96	106	126	146	166	186
D10 4040 T Mat.	01=1730							
D10 4050 T Mat.	03=2312							
D10 4060 T Mat.	05=2344							



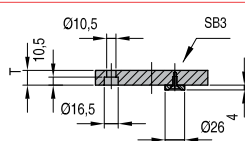
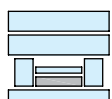
D30

REF	Mat.	H		
		106	146	166
D30 H 4040 01	1730			
D30 H 4050 01				
D30 H 4060 01				
		S		
		40	80	100



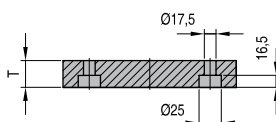
D40

REF	Mat.	T
D40 26 4040 01	1730	26
D40 26 4050 01		26
D40 26 4060 01		26



D50

REF	Mat.	T
D50 36 4040 01	1730	36
D50 36 4050 01		36
D50 36 4060 01		36



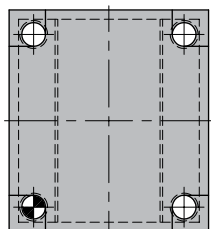
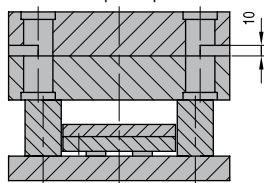
D03

REF	Mat.	T
D03 4040 36 01	1730	36
D03 4050 36 01		36
D03 4060 36 01		36

D 40

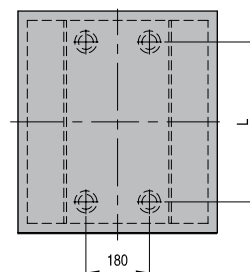
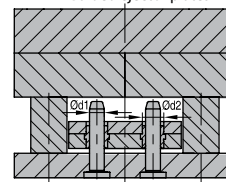
D 4040 (396 x 396 mm)
D 4050 (396 x 496 mm)
D 4060 (396 x 596 mm)

* Lever slots - upon req-uest

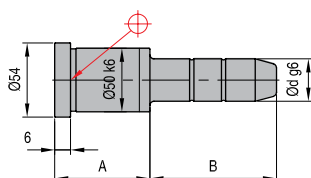


D40	L	d1	d2
4040	251	24	32
4050	351	24	32
4060	451	24	32

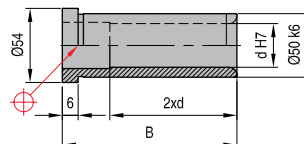
* Guided ejector plates



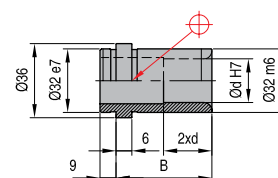
FSN



FBN



FBC



REF	d	A-	B
FSN 42-	76-	076	
-	096		
-	146		
FSN 42-	96-	076	
-	096		
-	146		
FSN 42-	106-	076	
-	096		
-	146		
FSN 42-	126-	086	
-	146		
FSN 42-	146-	076	
-	096		
-	146		
FSN 42-	166-	166	
FSN 42-	186-	186	

REF	d	A-	B
FSN 41-	76-	076	
-	096		
-	146		
FSN 41-	96-	076	
-	096		
-	146		
FSN 41-	106-	076	
-	096		
-	146		
FSN 41-	126-	086	
-	146		
FSN 41-	146-	076	
-	096		
-	146		
FSN 41-	166-	166	
FSN 41-	186-	186	

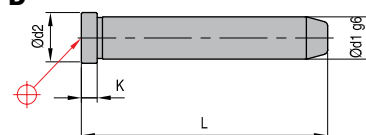
REF	d	B
FBN 42-	076	
-	096	
-	106	
-	126	
-	146	
-	166	
-	186	

REF	d	B
FBN 41-	076	
-	096	
-	106	
-	126	
-	146	
-	166	
-	186	

REF	d	B
FBC 24-	036	

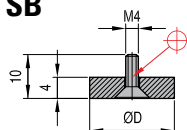
REF	d	B
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APD



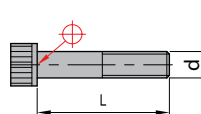
REF	d1	L	d2	K
APD 24 -	140			
-	160			
-	180			
-	200			
-	220			

SB



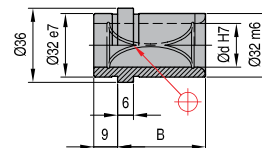
REF	D
SB3	26

M



REF	d	L
M	10	x 50
M	16	x 150
		x 190
		x 210

GEB

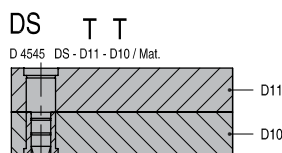
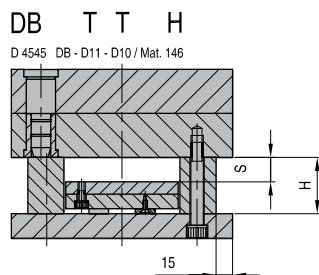
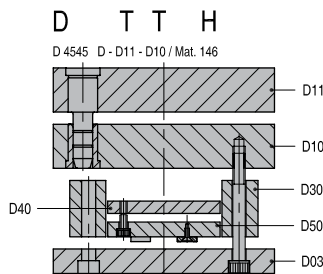


REF	d	B
GEB 24-	036	

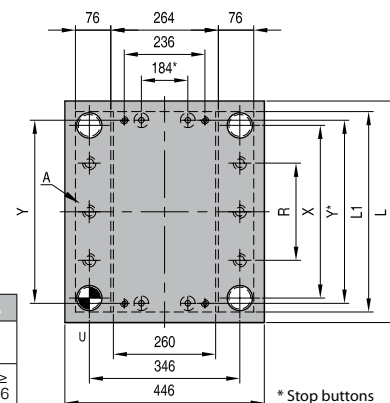
D 45

Basic assemblies

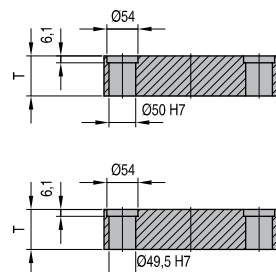
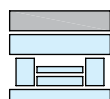
D 4545 (446 x 446 mm)
D 4550 (446 x 496 mm)
D 4560 (446 x 596 mm)



D45	L	L1	Y/Y*	X	R	A
4545	446	396	360	346	236	4 x M16
4550	496	446	410	396	286	6 x M16 L ≥ 496
4560	596	546	510	496	386	6 x M16 L ≥ 496

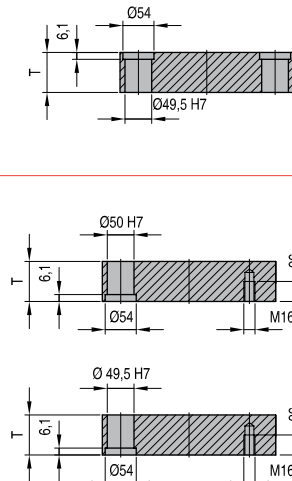


Interchangeable drilled D-plates



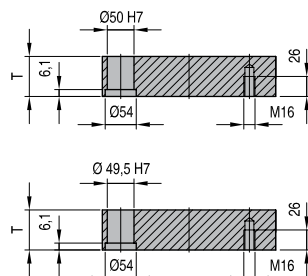
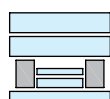
D11

REF	Mat.	T							
		76	96	106	126	146	166	186	206
D11 4545 T Mat.	01=1730								
D11 4550 T Mat.	03=2312								
D11 4560 T Mat.	05=2344								



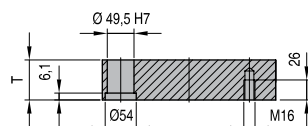
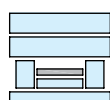
D16

REF	Mat.	T							
		76	96	106	126	146	166	186	206
D16 4545 T Mat.	05=2344								
D16 4550 T Mat.									
D16 4560 T Mat.									



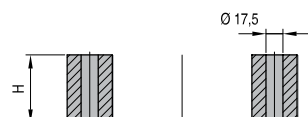
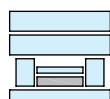
D10

REF	Mat.	T							
		76	96	106	126	146	166	186	206
D10 4545 T Mat.	01=1730								
D10 4550 T Mat.	03=2312								
D10 4560 T Mat.	05=2344								



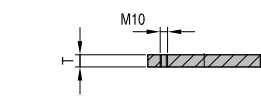
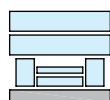
D15

REF	Mat.	T							
		76	96	106	126	146	166	186	206
D15 4545 T Mat.	05=2344								
D15 4550 T Mat.									
D15 4560 T Mat.									



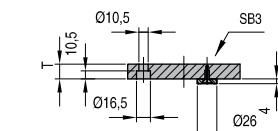
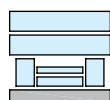
D30

REF	Mat.	H		
		106	146	186
D30 H 4545 01	1730			
D30 H 4550 01				
D30 H 4560 01				
		S		
		40	80	120



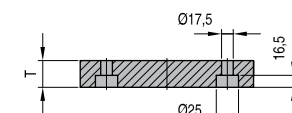
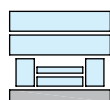
D40

REF	Mat.	T
D40 26 4545 01	1730	26
D40 26 4550 01		26
D40 26 4560 01		26



D50

REF	Mat.	T
D50 36 4545 01	1730	36
D50 36 4550 01		36
D50 36 4560 01		36



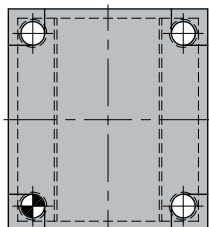
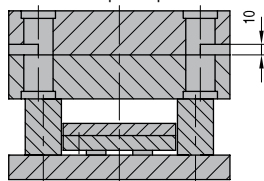
D03

REF	Mat.	T
D03 4545 36 01	1730	36
D03 4550 36 01		36
D03 4560 36 01		36

D 45

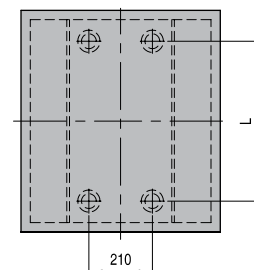
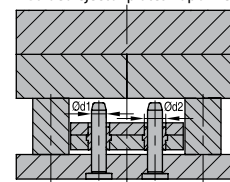
D 4545 (446 x 446 mm)
D 4550 (446 x 496 mm)
D 4560 (446 x 596 mm)

* Lever slots - upon request

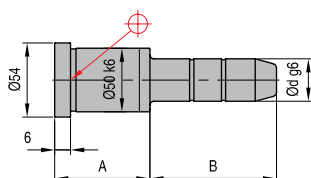


D45	L	d1	d2
4545	296	24	32
4550	346	24	32
4560	446	24	32

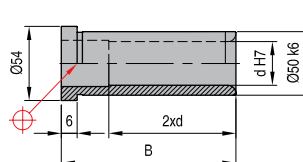
* Guided ejector plates - upon request



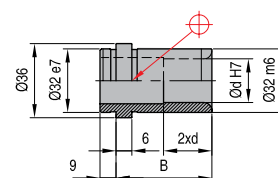
FSN



FBN



FBC



REF	d	A	B
FSN 42-	76	-	076
-	096		
-	146		
FSN 42-	96	-	076
-	096		
-	146		
FSN 42-	106	-	076
-	096		
-	146		
FSN 42-	126	-	086
-	146		
FSN 42-	146	-	076
-	096		
-	146		
FSN 42-	166	-	166
FSN 42-	186	-	186

REF	d	A	B
FSN 41-	76	-	076
-	096		
-	146		
FSN 41-	96	-	076
-	096		
-	146		
FSN 41-	106	-	076
-	096		
-	146		
FSN 41-	126	-	086
-	146		
FSN 41-	146	-	076
-	096		
-	146		
FSN 41-	166	-	166
FSN 41-	186	-	186

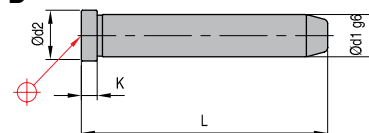
REF	d	B
FBN 42-	076	
-	096	
-	106	
-	126	
-	146	
-	166	
-	186	

REF	d	B
FBN 41-	076	
-	096	
-	106	
-	126	
-	146	
-	166	
-	186	

REF	d	B
FBC 24-	036	

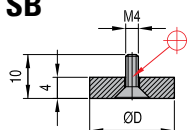
REF	d	B
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APD



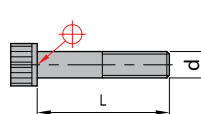
REF	d1	L	d2	K
APD 24	-140		28	15
-160				
-200				
-210				
-220				

SB



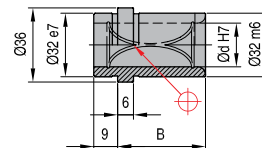
REF	D
SB3	26

M



REF	d	L
M 10	x	50
M 16	x	160
	x	200
	x	240

GEB

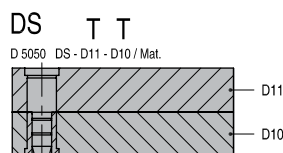
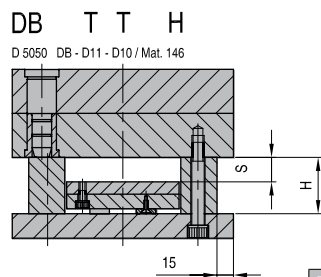
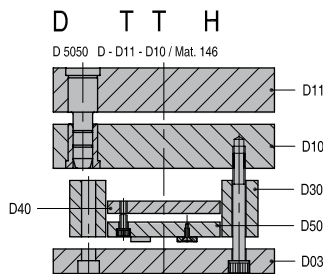


REF	d	B
GEB	24-036	

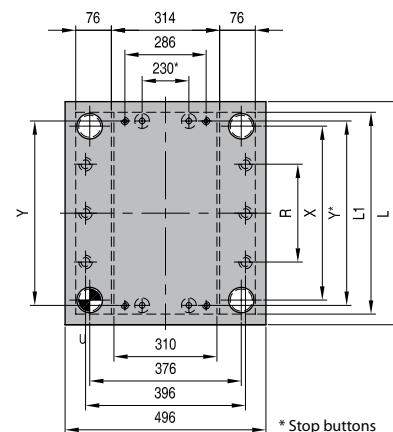
D 50

Basic assemblies

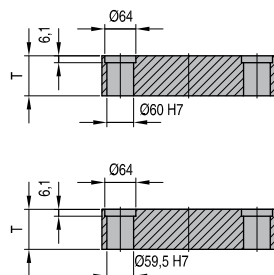
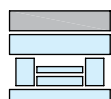
D 5050 (496 x 496 mm)
D 5060 (496 x 596 mm)
D 5080 (496 x 796 mm)



D50	L	L1	Y/Y*	X	R	
5050	496	446	410	376	256	6 x M20
5060	596	546	510	476	356	6 x M20
5080	796	746	710	676	556	6 x M20

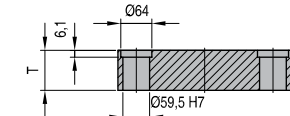


Interchangeable drilled D-plates



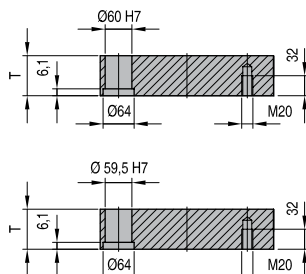
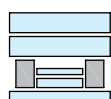
D11

REF	Mat.	T						
		96	106	126	146	166	186	206
D11 5050 T Mat.	01=1730							
D11 5060 T Mat.	03=2312							
D11 5080 T Mat.	05=2344							



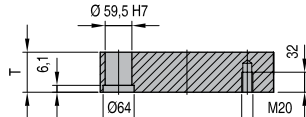
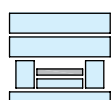
D16

REF	Mat.	T						
		96	106	126	146	166	186	206
D16 5050 T Mat.	05=2344							
D16 5060 T Mat.								
D16 5080 T Mat.								



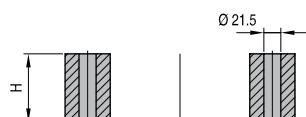
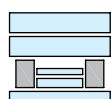
D10

REF	Mat.	T						
		96	106	126	146	166	186	206
D10 5050 T Mat.	01=1730							
D10 5060 T Mat.	03=2312							
D10 5080 T Mat.	05=2344							



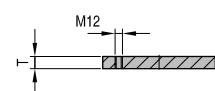
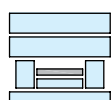
D15

REF	Mat.	T						
		96	106	126	146	166	186	206
D15 5050 T Mat.	05=2344							
D15 5060 T Mat.								
D15 5080 T Mat.								



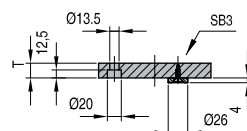
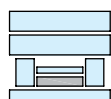
D30

REF	Mat.	H		
		106	146	186
D30 H 5050 01	1730			
D30 H 5060 01				
D30 H 5080 01				
		S		
		40	80	120



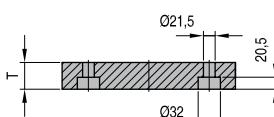
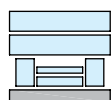
D40

REF	Mat.	T
D40 26 5050 01	1730	26
D40 26 5060 01		26
D40 26 5080 01		26



D50

REF	Mat.	T
D50 36 5050 01	1730	36
D50 36 5060 01		36
D50 36 5080 01		36

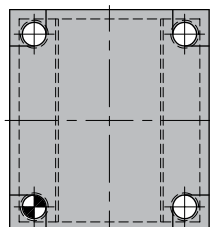
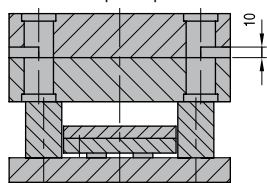


D03

REF	Mat.	T
D03 5050 46 01	1730	46
D03 5060 46 01		46
D03 5080 46 01		46

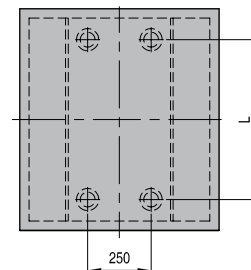
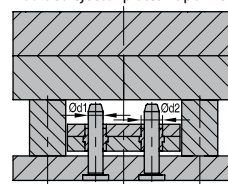
D 5050 (496 x 496 mm)
D 5060 (496 x 596 mm)
D 5080 (496 x 796 mm)

* Lever slots - upon request

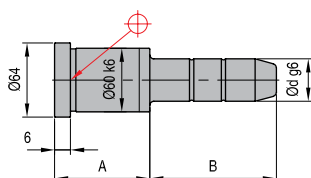
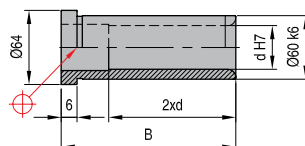
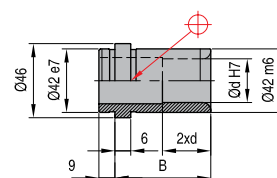


D50	L	d1	d2
5050	336	34	42
5060	436	34	42
5080	636	34	42

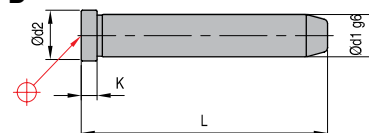
* Guided ejector plates - upon request



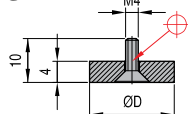
FSN

**FBN****FBC**[illegible][illegible][illegible][illegible][illegible][illegible]

APD

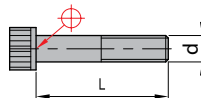


REF	d1	L	d2	K
APD	34-	120	38	15
	-	170		
	-	210		
	-	250		

SB

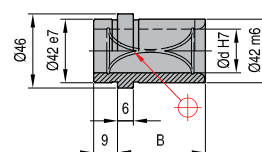
REF	D
SB3	26

M



REF	d	L
M 12	x	50
M 20	x	160
	x	200
	x	240

GEB

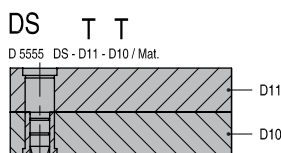
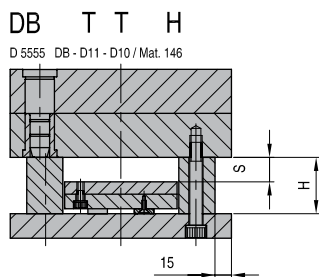
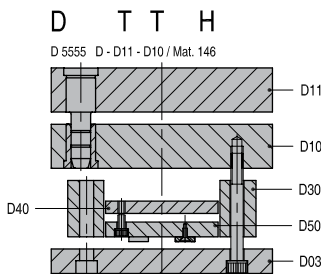


REF	d	B
GEB	34	-036

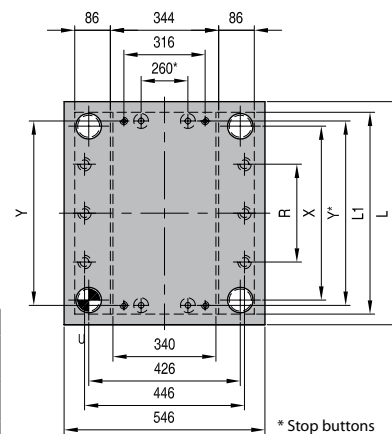
D 55

Basic assemblies

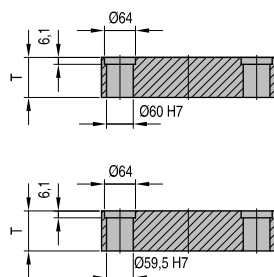
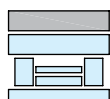
D 5555 (546 x 546 mm)
D 5560 (546 x 596 mm)
D 5580 (546 x 796 mm)



D55	L	L1	Y/Y*	X	R/R1	
5555	546	496	460	426	306	6 x M20
5560	596	546	510	476	356	6 x M20
5580	796	746	710	676	556	6 x M20

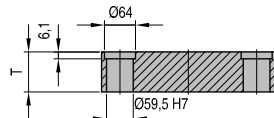


Interchangeable drilled D-plates



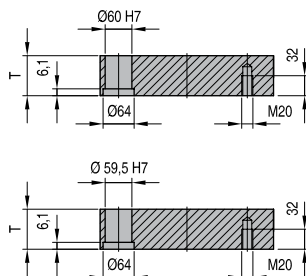
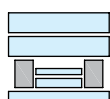
D11

REF	Mat.	T						
		96	106	126	146	166	186	206
D11 5555 T Mat.	01=1730							
D11 5560 T Mat.	03=2312							
D11 5580 T Mat.	05=2344							



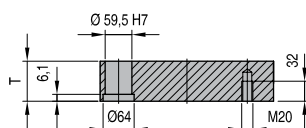
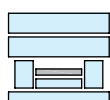
D16

REF	Mat.	T						
		96	106	126	146	166	186	206
D16 5555 T Mat.	05=2344							
D16 5560 T Mat.								
D16 5580 T Mat.								



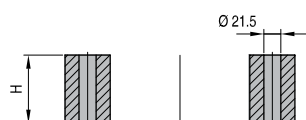
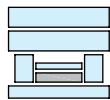
D10

REF	Mat.	T						
		96	106	126	146	166	186	206
D10 5555 T Mat.	01=1730							
D10 5560 T Mat.	03=2312							
D10 5580 T Mat.	05=2344							



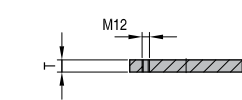
D15

REF	Mat.	T						
		96	106	126	146	166	186	206
D15 5555 T Mat.	05=2344							
D15 5560 T Mat.								
D15 5580 T Mat.								



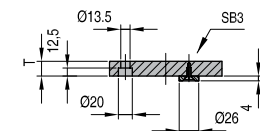
D30

REF	Mat.	H		
		126	146	186
D30 H 5555 01	1730			
D30 H 5560 01				
D30 H 5580 01				
		S		
		40	80	120



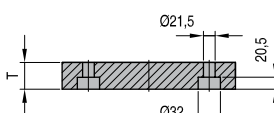
D40

REF	Mat.	T
D40 26 5555 01	1730	26
D40 26 5560 01		26
D40 26 5580 01		26



D50

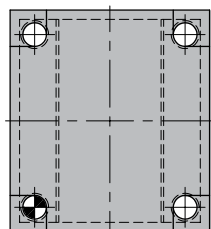
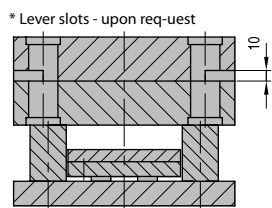
REF	Mat.	T
D50 36 5555 01	1730	36
D50 36 5560 01		36
D50 36 5580 01		36



D03

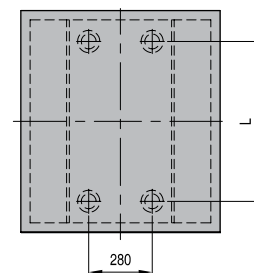
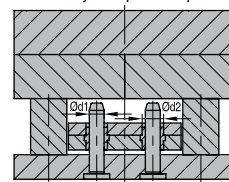
REF	Mat.	T
D03 5555 46 01	1730	46
D03 5560 46 01		46
D03 5580 46 01		46

D 5555 (546 x 546 mm)
D 5560 (546 x 596 mm)
D 5580 (546 x 796 mm)

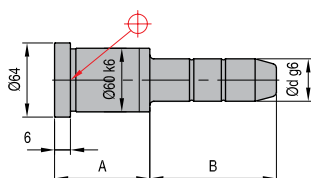


D55	L	d1	d2
5555	386	34	42
5560	400	34	42
5580	600	34	42

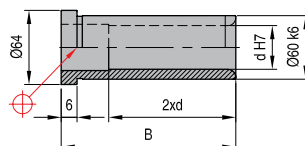
* Guided ejector plates - upon request



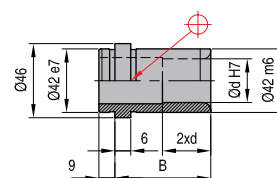
FSN



FBN



FBC



REF	d	A-	B
FSN 50-	96-	096	
-	126		
-	186		
FSN 50-	106-	096	
-	126		
-	186		
FSN 50-	126-	096	
-	146		
FSN 50-	146-	106	
-	146		
FSN 50-	166-	166	
FSN 50-	186-	186	
FSN 50-	206-	206	

REF	d	A-	B
FSN 49-	96-	096	
-	126		
-	186		
FSN 49-	106-	096	
-	126		
-	186		
FSN 49-	126-	096	
-	146		
FSN 49-	146-	106	
-	146		
FSN 49-	166-	166	
FSN 49-	186-	186	
FSN 49-	206-	206	

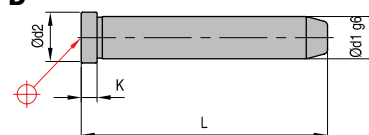
REF	d	B
FBN 50-	096	
-	106	
-	126	
-	146	
-	166	
-	186	
-	206	

REF	d	B
FBN 49-	096	
-	106	
-	126	
-	146	
-	166	
-	186	
-	206	

REF	d	B
FBC 34-	036	

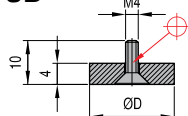
REF	d	B
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APD



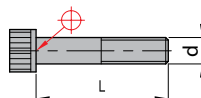
REF	d1	L	d2	K
APD 34-	120			
-	170		38	15
-	210			
-	250			

SB



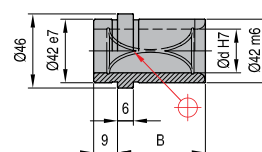
REF	D
SB3	26

M



REF	d	L
M 12	x	50
M 20	x	160
	x	200
	x	240

GEB

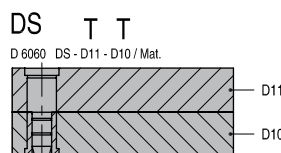
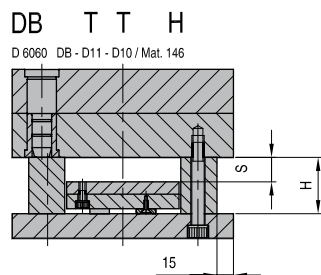
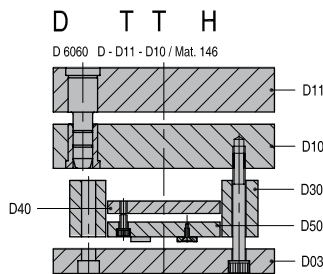


REF	d	B
GEB 34-	046	

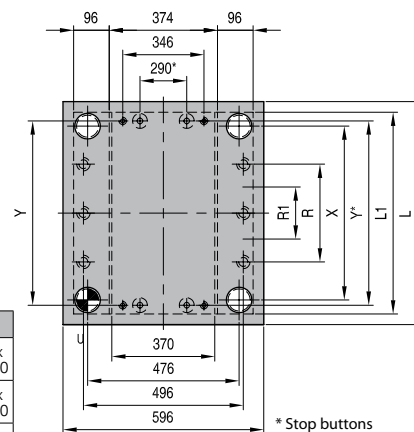
D 60

Basic assemblies

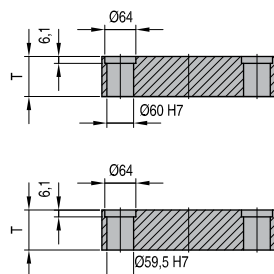
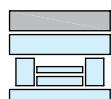
D 6060 (596 x 596 mm)
D 6080 (596 x 796 mm)
D 6090 (596 x 896 mm)



D60	L	L1	Y/Y*	X	R/R1	
6060	596	546	510	476	356	6 x M20
6080	796	746	710	676	556	6 x M20
6090	896	846	810	776	656/226	8 x M20



Interchangeable drilled D-plates

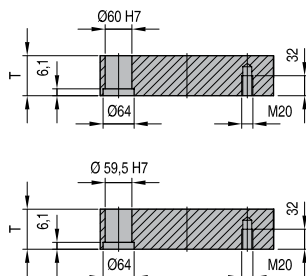


D11

REF	Mat.	T						
		96	106	126	146	166	186	206
D11 6060 T Mat.	01=1730							
D11 6080 T Mat.	03=2312							
D11 6090 T Mat.	05=2344							

D16

REF	Mat.	T						
		96	106	126	146	166	186	206
D16 6060 T Mat.	05=2344							
D16 6080 T Mat.								
D16 6090 T Mat.								

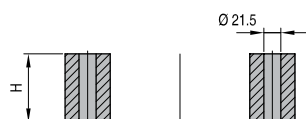
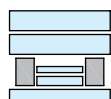


D10

REF	Mat.	T						
		96	106	126	146	166	186	206
D10 6060 T Mat.	01=1730							
D10 6080 T Mat.	03=2312							
D10 6090 T Mat.	05=2344							

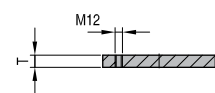
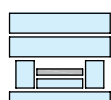
D15

REF	Mat.	T						
		96	106	126	146	166	186	206
D15 6060 T Mat.	05=2344							
D15 6080 T Mat.								
D15 6090 T Mat.								



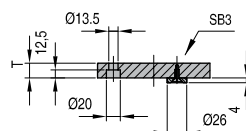
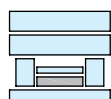
D30

REF	Mat.	H		
		126	146	186
D30 H 6060 01	1730			
D30 H 6080 01				
D30 H 6090 01				
		S		
		50	70	110



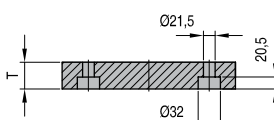
D40

REF	Mat.	T
D40 26 6060 01	1730	26
D40 26 6080 01		26
D40 26 6090 01		26



D50

REF	Mat.	T
D50 46 6060 01	1730	46
D50 46 6080 01		46
D50 46 6090 01		46



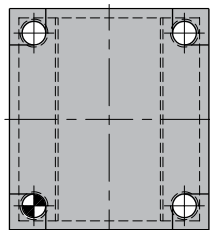
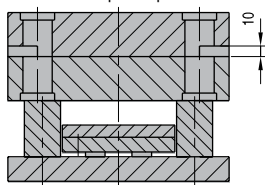
D03

REF	Mat.	T
D03 6060 46 01	1730	46
D03 6080 46 01		46
D03 6090 46 01		46

D 60

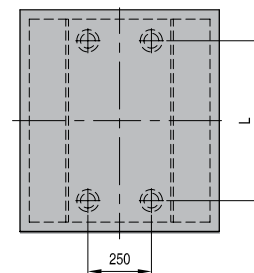
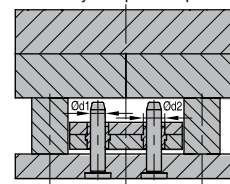
D 6060 (596 x 596 mm)
D 6080 (596 x 796 mm)
D 6090 (596 x 896 mm)

* Lever slots - upon request

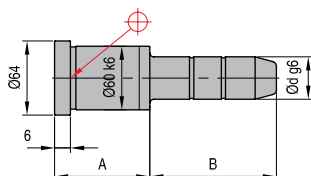


D60	L	d1	d2
6060	436	34	42
6080	636	34	42
6090	736	34	42

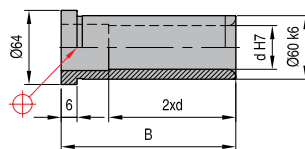
* Guided ejector plates - upon request



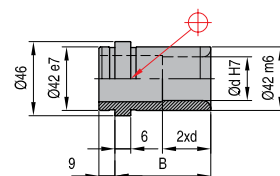
FSN



FBN



FBC



REF	d-	A-	B
FSN 50-	96-	096	
	- 126		
	- 186		
FSN 50-	106-	096	
	- 126		
	- 186		
FSN 50-	126-	096	
	- 146		
FSN 50-	146-	106	
	- 146		
FSN 50-	166-	166	
FSN 50-	186-	186	
FSN 50-	206-	206	

REF	d-	A-	B
FSN 49-	96-	096	
	- 126		
	- 186		
FSN 49-	106-	096	
	- 126		
	- 186		
FSN 49-	126-	096	
	- 146		
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	- 146		
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FSN 49-	186-	186	
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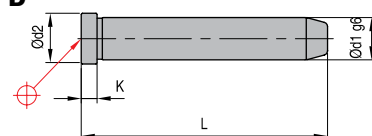
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	- 126	
	- 146	
	- 166	
	- 186	
	- 206	

REF	d	B
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	- 106	
	- 126	
	- 146	
	- 166	
	- 186	
	- 206	

REF	d	B
FBC 34-	046	

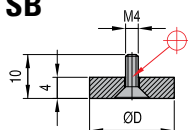
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APD



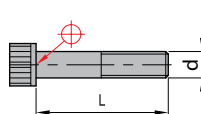
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APD 34-	170			
	- 190		38	15
	- 210			
	- 250			

SB



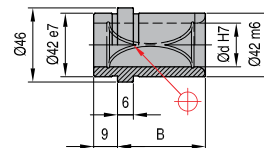
REF	D
SB3	26

M



REF	d	L
M 12	x	60
M 20	x	180
	x	200
	x	240

GEB



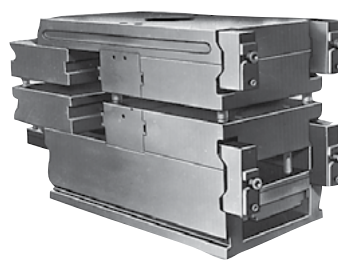
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GEB 34-	046	

Unit Die Holders

Info

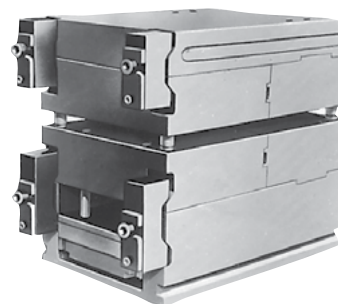
DR

Double unit die holder with replacement units for zinc and aluminium diecasting.



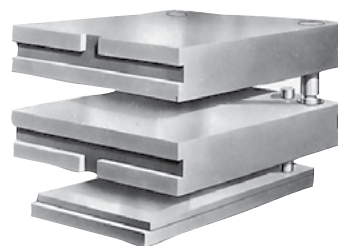
ER

Single unit die holder with replacement units for zinc and aluminium diecasting.



WF

Replacement units for zinc and aluminium diecasting.

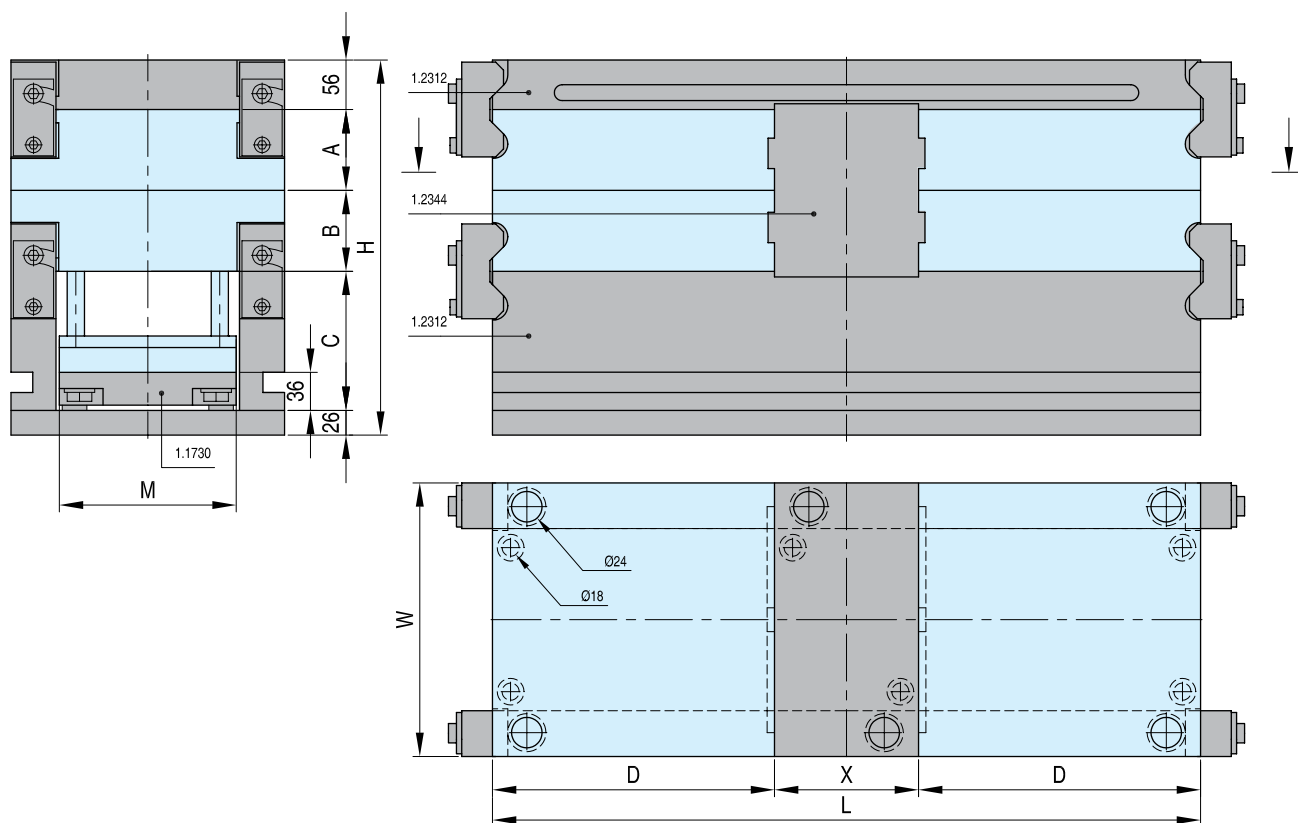


Pre-engineered design features

- **Maximum cavity area for greater range of jobs.**
Three sides of replacement units are open for installation of core slides or water lines.
- **Rigid center section for longer die life.**
Center section is made of steel DME 5 1.2344 heat treated to 42-46 RC.
- **Accurate alignment for minimum wear.**
Six leader pins diameter 24 mm and six return pins diameter 18 mm (four of each in single unit holders) provide better alignment and permit uniform control of ejector plates.
- **Steel qualities.**
The steel quality of the top and bottom clamping plates is DME 3 1.2312 with a hardness of ca. 280-325 HB. The risers are also in steel DME 3 1.2312 and the main ejector plate is in DME 1 1.1730 with a hardness of ca. 640 MPa.
- **Positive locking of interchangeable units.**
Precision made center section has solid horizontal and vertical keys for positive locking of replacement units. Lever slots facilitate removal of units.
- **Wedge clamps and solid steel wedge locks for safety and quick die changeover.**
Single and double unit die holders are equipped with wedge clamps with heavy-duty socket screws.
- **Designed for zinc or aluminium applications.**

DR

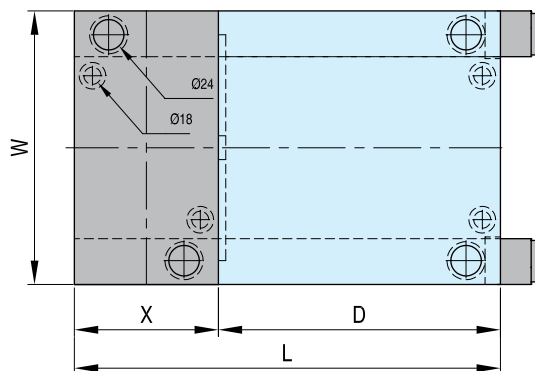
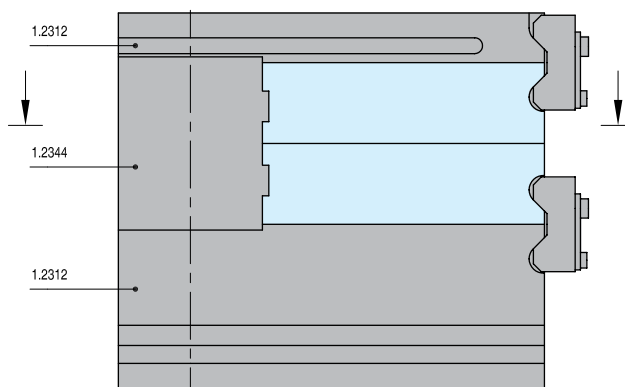
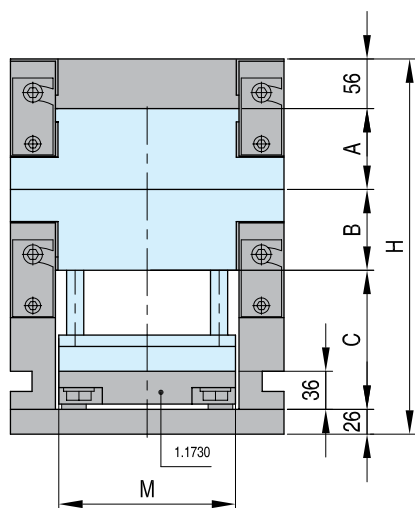
Double unit die holders



REF	W	D	X	L	C	M	H	A	B
DR-3025	296	246	136	628	146	200	420	96	96
DR-3830	376	296	152	744	146	280	440	106	106

When ordering specify:

- Ref. number
- Steel quality of replacement unit
- Drawing with all dimensions for special machining to be made by **DME**
- Nominal dimensions
- Position
- Tolerances



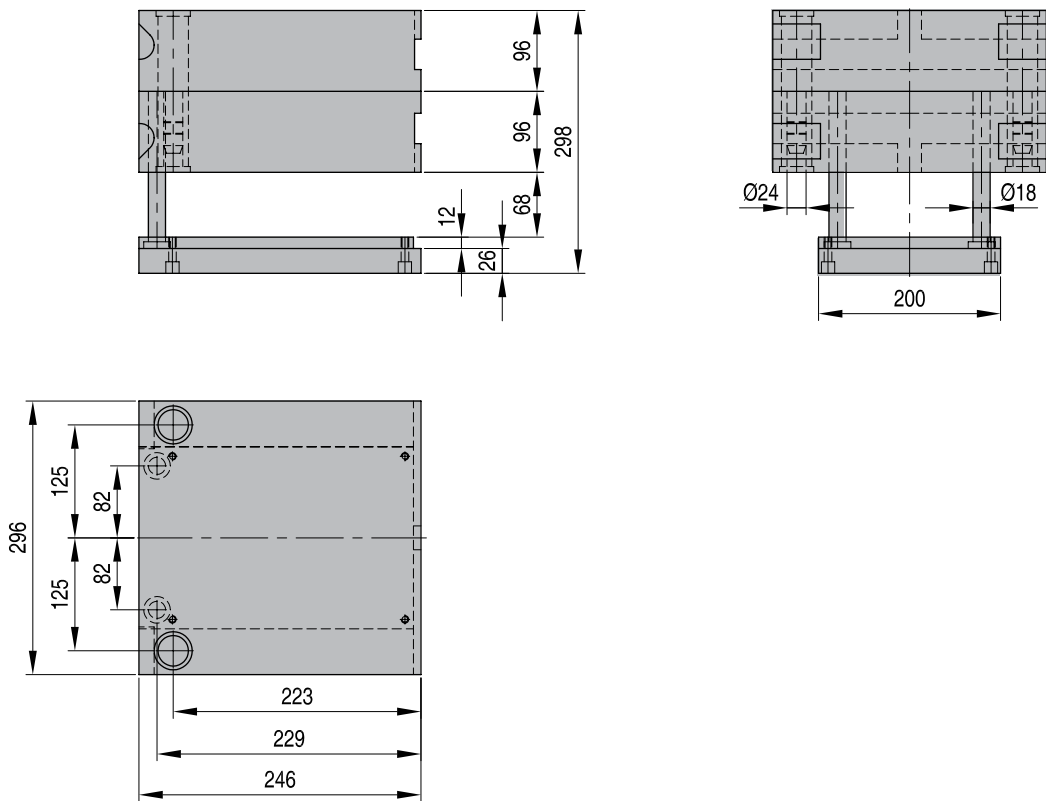
REF	W	D	X	L	C	M	H	A	B
ER-3025	296	246	200	446	146	200	420	96	96
ER-3830	376	296	232	528	146	280	440	106	106

When ordering specify:

- Ref. number
- Steel quality of replacement unit
- Drawing with all dimensions for special machining to be made by **DME**
- Nominal dimensions
- Position
- Tolerances

WF

Replacement units



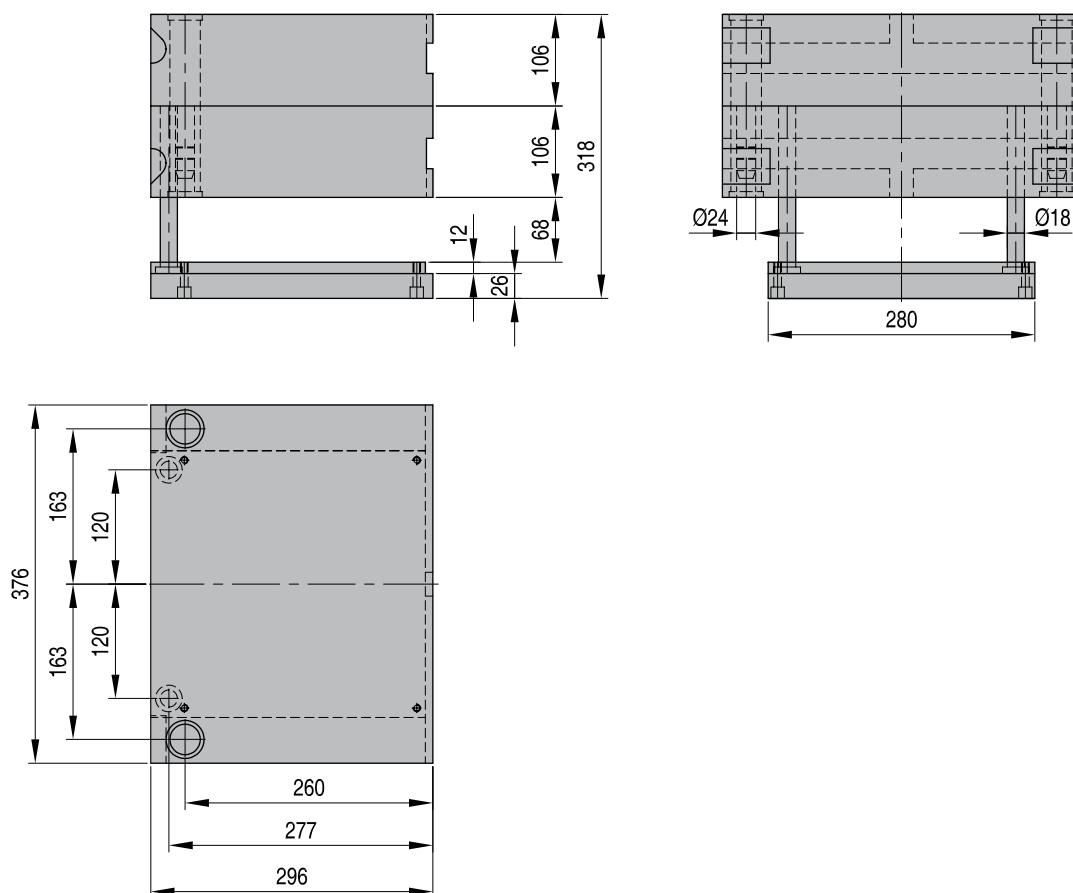
REF	Mat. 1.2312	Mat. 1.2344
WF-3025	DME 3	DME 5

When ordering specify:

- Ref. number
- Steel quality of replacement unit
- Drawing with all dimensions for special machining to be made by **DME**
- Nominal dimensions
- Position
- Tolerances

Replacement units

WF



REF	Mat. 1.2312	Mat. 1.2344
WF-3830	DME 3	DME 5

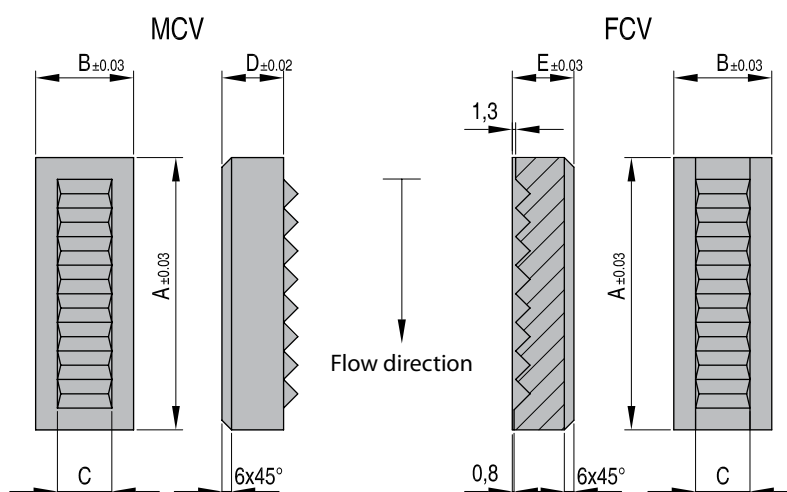
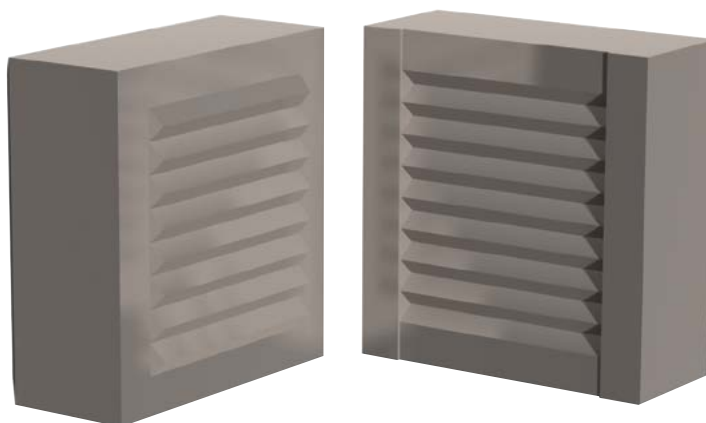
When ordering specify:

- Ref. number
- Steel quality of replacement unit
- Drawing with all dimensions for special machining to be made by **DME**
- Nominal dimensions
- Position
- Tolerances

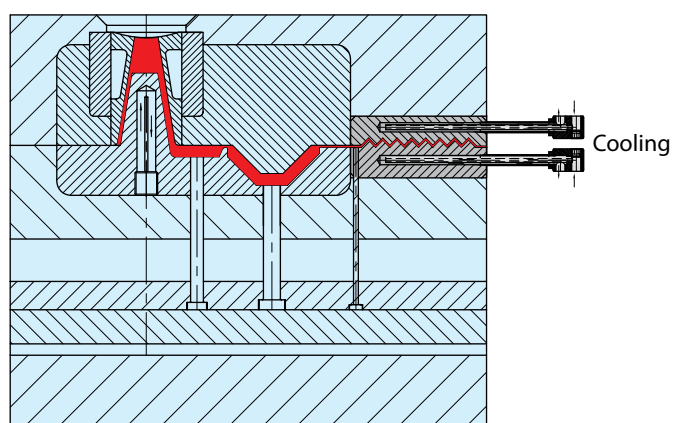
MCV - FCV

Chill vents (pair)

Mat.: 1.2344



Installation

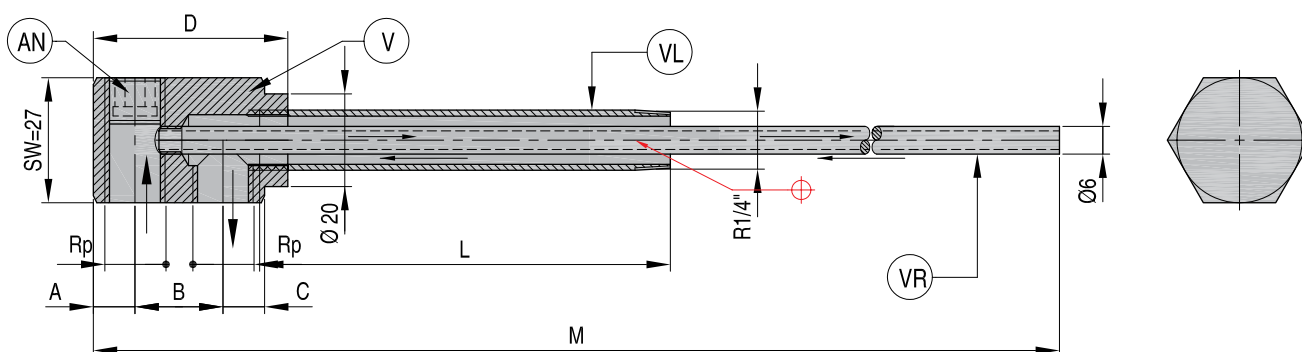


REF	A±0,03	B±0,03	C	D±0,02	E±0,03
MCV/FCV-136	100	36	20	35	40,3
MCV/FCV-156	100	56	36	35	40,3
MCV/FCV-196	100	96	70	45	45,3

Cascade water junctions

Mat.: Brass

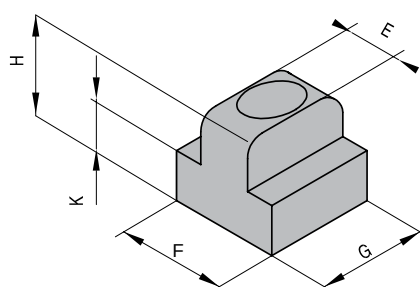
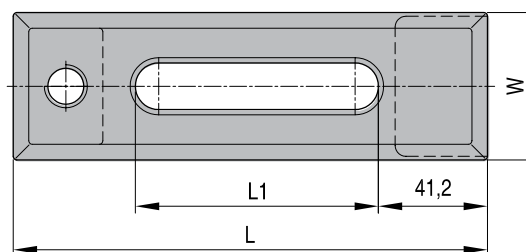
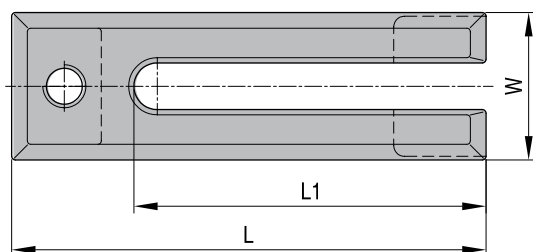
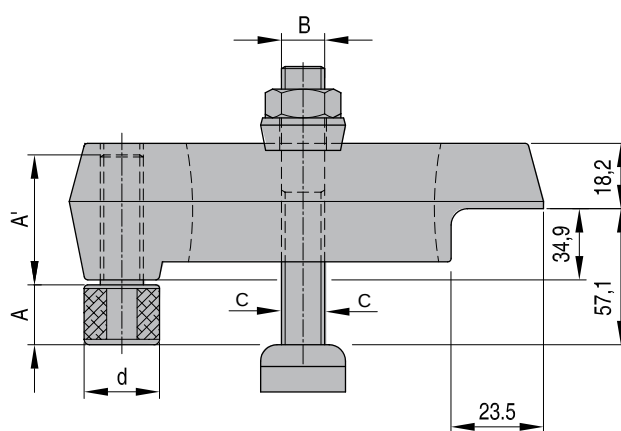
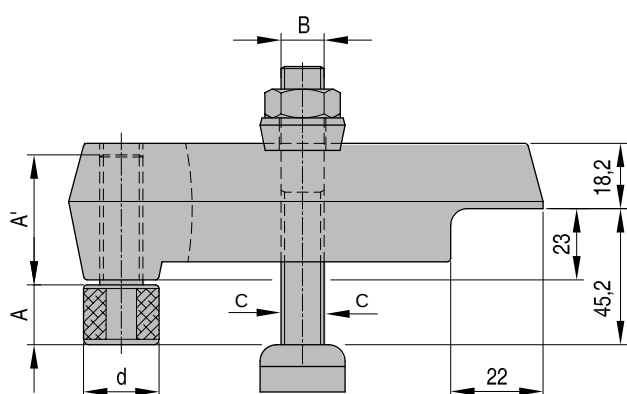
V



REF	Rp	M	A	B	D	C	L
V 485	1/8"	356	9	19	42	9	50
V 4810	1/8"	356	9	19	42	9	100
V 4815	1/8"	356	9	19	42	9	150
V 4820	1/8"	356	9	19	42	9	200
V 445	1/4"	356	9	19	42	9	50
V 4410	1/4"	356	9	19	42	9	100
V 4415	1/4"	356	9	19	42	9	150
V 4420	1/4"	356	9	19	42	9	200
V 585	1/8"	362	9	26	56	12	50
V 5810	1/8"	362	9	26	56	12	100
V 5815	1/8"	362	9	26	56	12	150
V 5820	1/8"	362	9	26	56	12	200
V 545	1/4"	362	9	26	56	12	50
V 5410	1/4"	362	9	26	56	12	100
V 5415	1/4"	362	9	26	56	12	150
V 5420	1/4"	362	9	26	56	12	200

Cascade Water Junctions are ideal for cooling plastics molds and die cast dies where drilled waterlines through the block are not possible due to interference with ejector pins, sprue puller pins, etc.

The brass tube has the rigidity to maintain uniform spacing inside the water channel and is threaded into the body for firm support. Waterlines may be connected to the same side or opposing sides of the brass hexagonal body.



REF	A	A'	B	C	d	L	L1	W	E	F	G	H	K
DMCA-5-5	15,8	39	5/8"-11 x 4" 1/2	15,9	35	132	86	48	15,9	28,6	33	16,2	6,4
DMCA-5-7						178	127		15,9	28,6	33	16,2	6,4
DMCA-6-5	19,0		3/4"-10 x 4" 1/2	19,1	38	132	86	51	19,0	33,3	37,6	20,6	13,5
DMCA-6-7						178	127		19,0	33,3	37,6	20,6	13,5
DMCA-8-95	22,2	50	1" x 6"	25,5	51	241	135	67	25,4	42,9	49,8	26,9	17,5