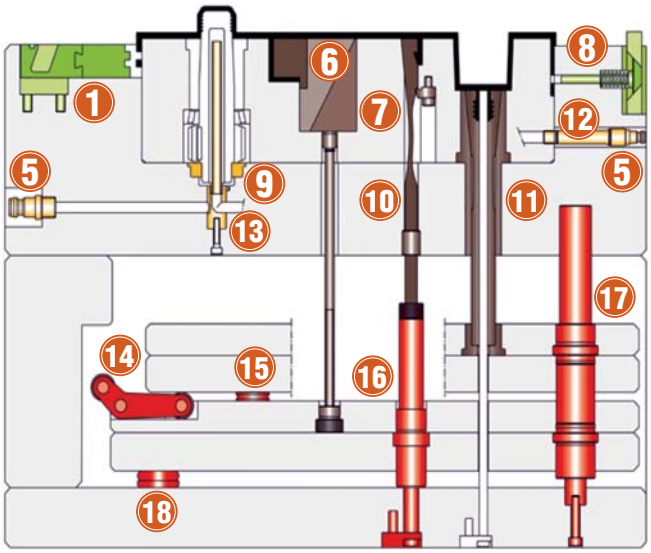
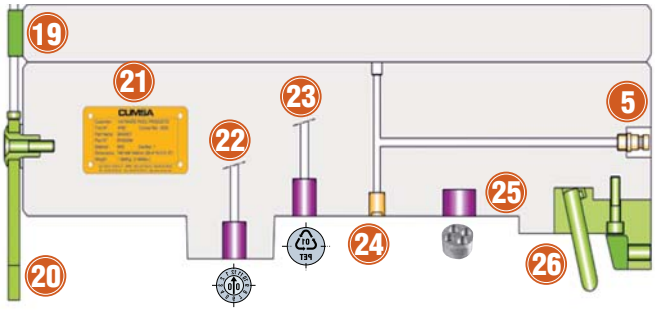
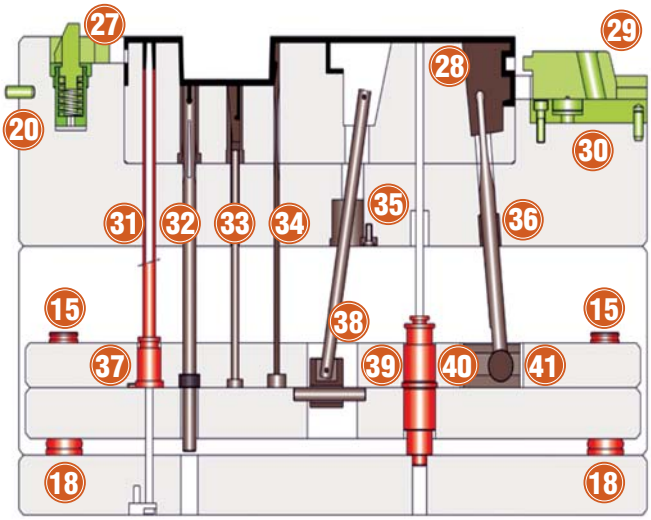
Standard Injection Mould Systems / Innovative Solutions for Your Moulds

CUMSA



For products not available in our catalogue, please request technical information or Cumsa catalogue from our company.





1	Code: SU	Slide Unit	
2	Code: FD	Double Date Stamp	
3	Code: CP	Color Plate	
4	Code: FP	Date Stamp Plus	
5	Code: BR	Hex Key Conector Plug	
6	Code: ID	Optional Insert for Undercuts	
7	Code: DHO	Outer Undercut Lifter	
8	Code: UA	Compact Coring Unit	
9	Code: SB	Seal Bearing	
10	Code: PX	Xtra Sprung Core	
11	Code: PE	Expandible Core	
12	Code: TH	Hex Key Extension Tube	
13	Code: TB	Seal Bearing Tube	
14	Code: EP	Ejector Plate Accelerator	
15	Code: TM	Magnetic Safety Stopper	
16	Code: LR	Threaded Limiter	
17	Code: DX	Superior Double Ejector	
18	Code: TA	Shock Absorber Disc	
19	Code: AB	Strap Extender	
20	Code: BS	Safety Strap	
21	Code: PI	Identification Plate	
22	Code: FP	Date Stamp Plus	
23	Code: IR	Recycle Insert	
24	Code: VA	Air Poppet Valve	
25	Code: BM	Block Base Insert	
26	Code: CG	Adjustable Wedge Assembly	
27	Code: UC	Core Cam	
28	Code: IF	Lifter Head	
29	Code: CA	Adjusted Slide	
30	Code: BC	Slide Base	
31	Code: TE	Headless Ejector Pin	
32	Code: EE	Tulip Ejetor	
33	Code: PS	Standard Lifter	
34	Code: PF	Flexible Sprung Core	
35	Code: CI	Angled Guide Bush	
36	Code: VI	Lifter Shaft	
37	Code: BA	Ejector Pin Base	
38	Code: SD	Undercut Base Unit	
39	Code: BD	Horizontal Base	
39	Code: AE	Accelerated Ejector	
40	Code: DF	Fixed Lifter Base	

CUMSA

Standard Injection Mould Systems / Innovative Solutions for Your Moulds

18 Code: TA Shock Absorber Disc

42 Code: MX Internal Latch Lock

43 Code: SL Stroke Limiter

44 Code: PR Plate Retainer

45 Code: UU Undercut Unit

46 Code: JV Vacuumjet Seal

47 Code: VH Air Valve for High Pressure

49 Code: DH Special Angular Undercut

50 Code: VS Spiral Sleeve

51 Code: VP Spiral Ejector

52 Code: VT Vacuumjet Valve Tube

54 Code: CV Vacuumjet Plug

55 Code: PT Pneumatic Piston

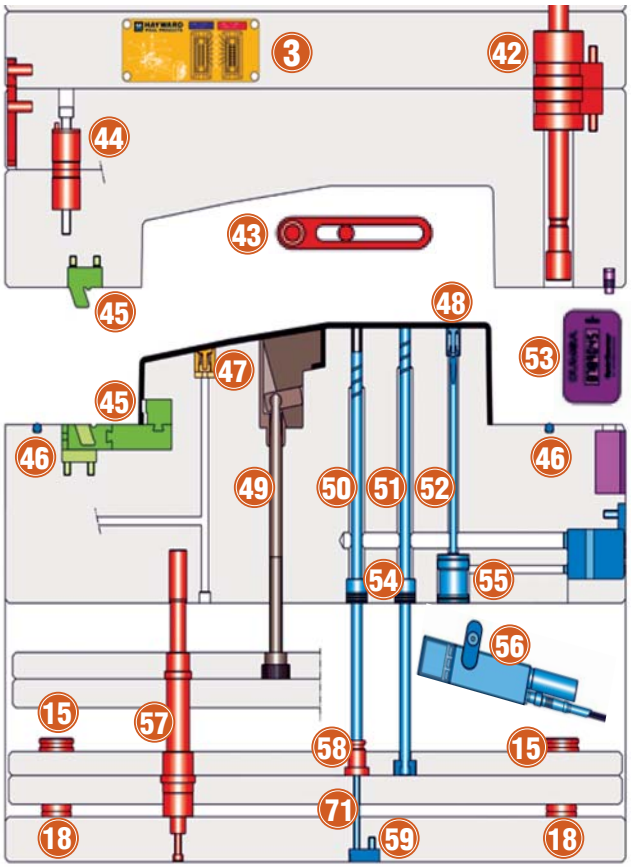
56 Code: VK Automatic Vacuumjet System

57 Code: DY Rear Double Ejector

58 Code: BT Ejector Pin Base

59 Code: NP No - rotating head for

71 Code: PH Ejector



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48 Code: VV Vacuumjet Valve

53 Code: CC High Speed Cycle Counter

60 Code: SC Cable Retainer

66 Code: DB Dog Lifter Limiter

61 Code: CR Adjustable Wedge

67 Code: RA Automatic Retainer

62 Code: GR Angle Pin Housing

68 Code: SY Compact Double Ejection

63 Code: BG Square Angle Pin Housing

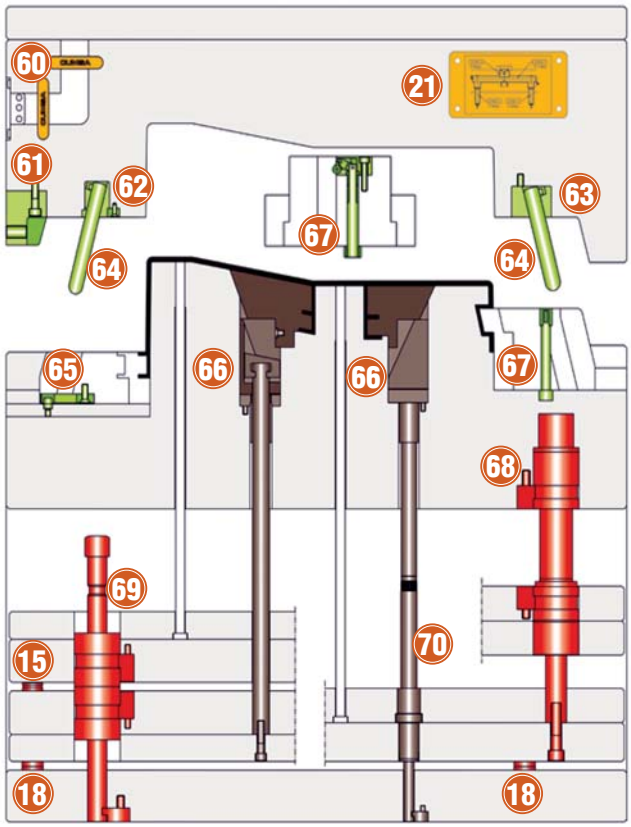
69 Code: DX Superior Double Ejector

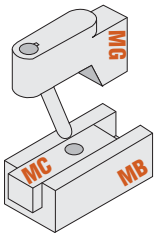
64 Code: GI Angle Pin

70 Code: LD Dog Lifter Limiter

65 Code: RCM Slide Retainer

15 Code: TM Magnetic Safety Stopper





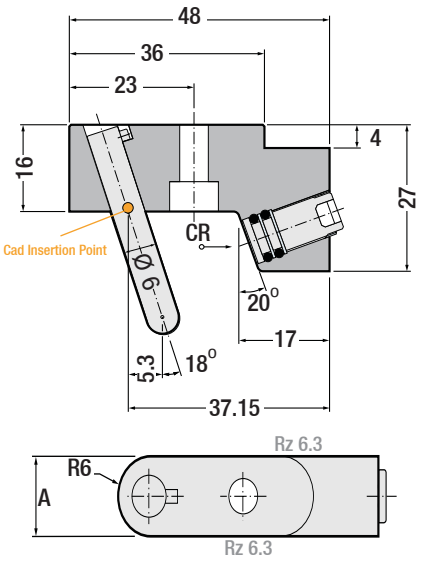
Mini Guide

Code: MG

It is consisted of angular pin and locking thrust wedge. While mould is closed, it can be easily adjusted with allen key. All machining is made 90° to the parting line. Parts can be replaced from the parting line.

Material: 1.2312
≈ 1.080 N/mm².
Patented System

Attention! Standard stroke of 4mm.



Order	A mm	CR (N)
MG.121648	12	50.000
MG.201648	20	90.000

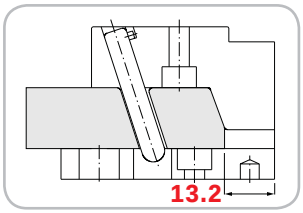
Mini Slide

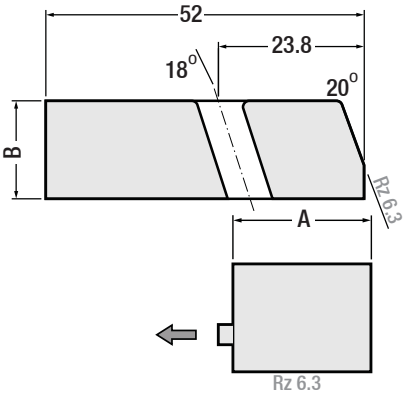
Code: MC

It is ready for machining, it comes with adjustment tolerances. It is only necessary to machine the cavity area.

Material: 1.2344
Hardness: 44 ± 2 HRC
Patented System

Attention! Machining reference is 13.2





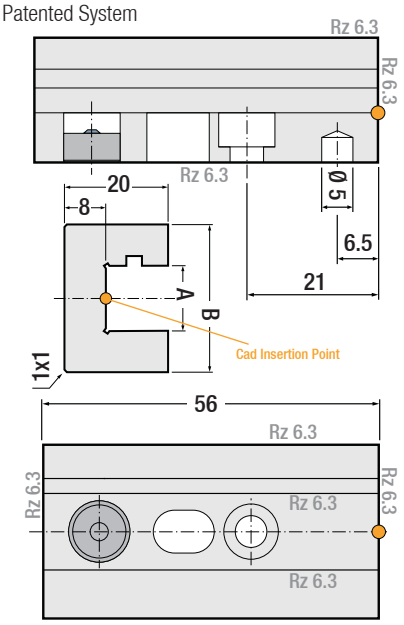
Order	A mm	B mm
MC.121252	12.5	12
MC.121652	12.5	16
MC.201252	20.5	12
MC.201652	20.5	16

Mini Base

Code: MB

An unique unit hardened and ground with the adjustment tolerances. Has various assembly posibilities and it is also easy to change, with magnetic retainer. Minimum space required for installation.

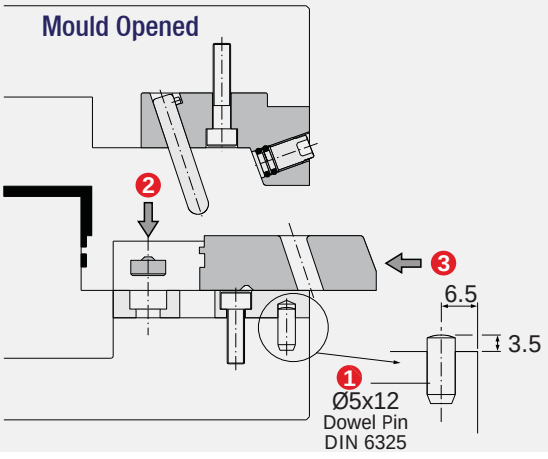
Material: 1.2510
Hardness: 54 ± 2 HRC
Patented System

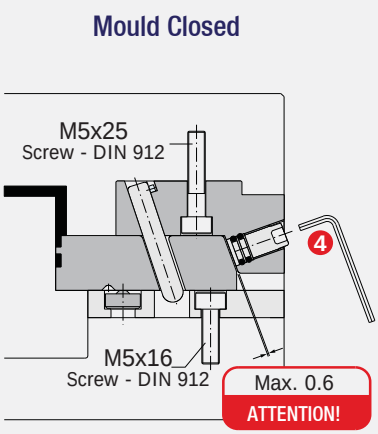


Order	A mm	B mm
MB.122056	12.5	28
MB.202056	20.5	36

Installation & Operation Examples

1- Determine the position of MB (mini base) and mount it.
2- Place the magnetic retainer into hole.
3- Insert MC (mini slide).
4- While mould is closed, please adjust MC (mini slide) up to 0.6mm maximum.



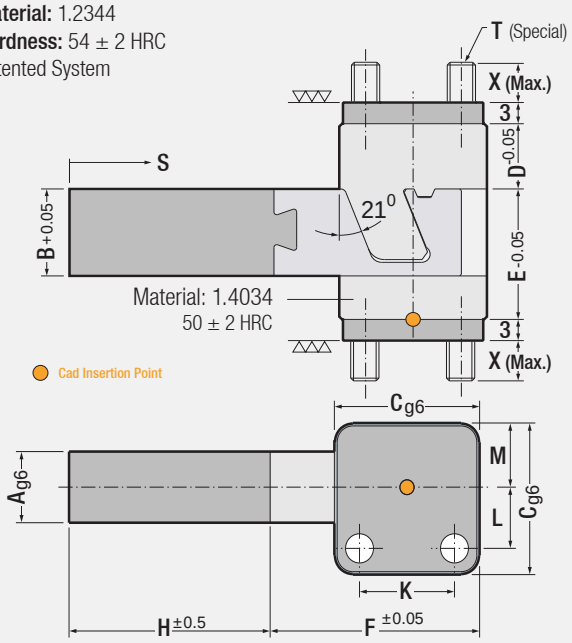


Slide Unit

Code: SU

Ideal to de-mold external details. Compact unit with strokes up to 5mm. Slider is made from two different inserts, allowing flexibility regarding the molding feature. All machining can be made 90° to parting line. Easy to change molding inserts due to fixing method. Incorporates a slide retainer and an angle pin.

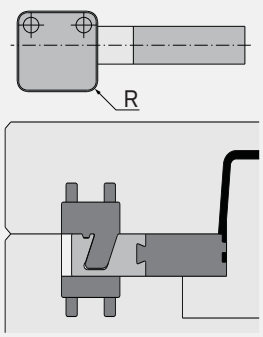
Material: 1.2344
Hardness: 54 ± 2 HRC
Patented System



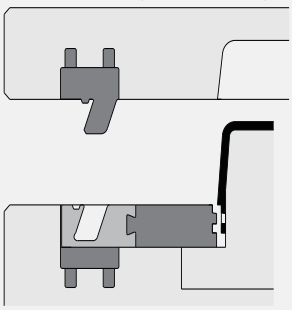
Code: SU

Order	A	B	C	D	E	F	H
SU.081220	8.2	12	20	10	18	28	32
SU.121626	12.2	16	26	12	24	37.5	36
SU.162032	16.2	20	32	16	30	46.5	40

K	L	M	R	S	T	X
12.5	8.25	8	3.75	3	M4	6.2
17	10.5	11	4.5	4	M5	7.2
22	13	14	5	5	M6	9.2



Installation & Operation Example

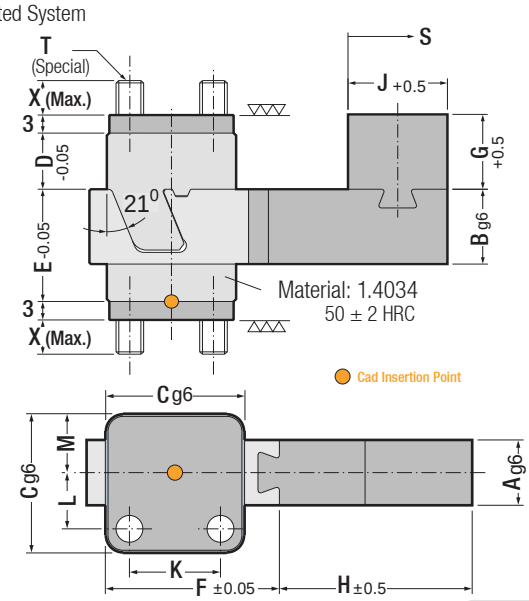


Undercut Unit

Code: UU

Inverse movement regarding normal units, ideal for de-moulding internal detail. Compact unit with strokes up to 5mm. Slider is made from two different inserts, allowing flexibility regarding the molding feature.
All machining can be made 90° to parting line.
Incorporates a slide retainer and an angle pin.

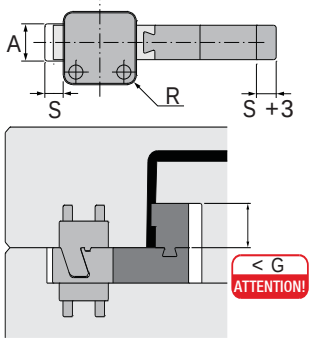
Material: 1.2344
Hardness: 54 ± 2 HRC
Patented System

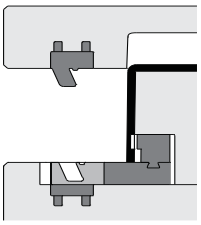


Code: UU

Order	A	B	C	D	E	F	G
UU.081220	8.2	12	20	10	18	24.5	12
UU.121626	12.2	16	26	12	24	32.5	16
UU.162032	16.2	20	32	16	30	41	20

H	J	K	L	M	S	R	T	X
32	16	12.5	8.25	8	3	3.75	M4	6.2
36	20	17	10.5	11	4	4.5	M5	7.2
50	25	22	13	14	5	5	M6	9.2





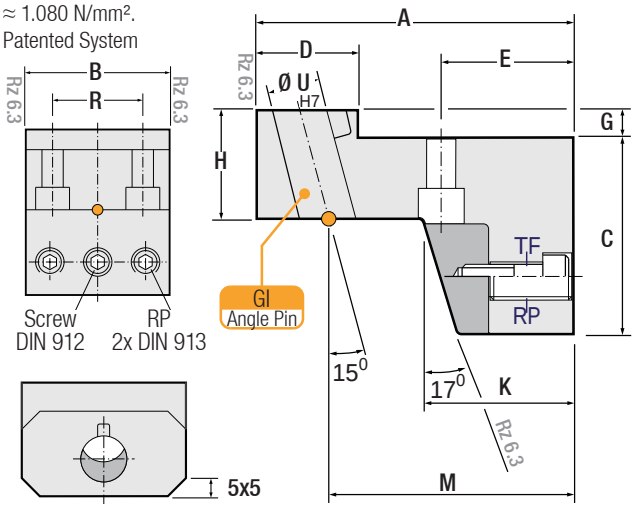
Adjustable Wedge Assembly

Code: CG

(Heel Unit)

It is unit of core / slide system starting motion. Adjustable with the mold closed. All machining is made 90° to the parting line. Parts can be replaced from the Parting Line. Hardened steel pre-adjusted for immediate use. Hardened wear plate. Two outer screws force the heel against the slide forming the shut off, while the central screw locks it into position. Minimum space required for installation

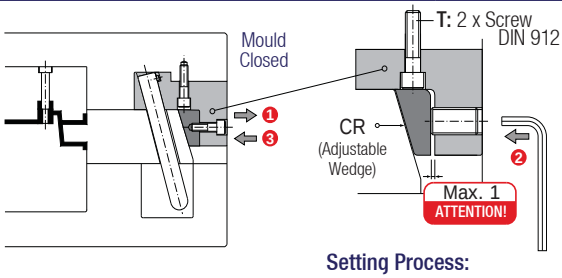
Material: 1.2312
≈ 1.080 N/mm².
Patented System



Code: CG

Order	A	B	C	D	E	G	H
CG.603035	60	30	35	25	23	6	23
CG.604035	60	40	35	25	23	6	23
CG.754049	75	40	49	30	32	7	27
CG.864857	86	48	57	35	36	8	32

K	M	R	TF	U	RP	CR (N)
29	43.7	17	M6x25	10	081015	180.000
29	43.7	22	M6x25	10	101015	320.000
39	58	22	M8x30	12	101020	320.000
44	65	28	M8x35	16	121025	480.000



Setting Process:
1- Unbolt "**TF**" (screw)
2- Tighten "**RP**" (screw)
3- Lock "**TF**"

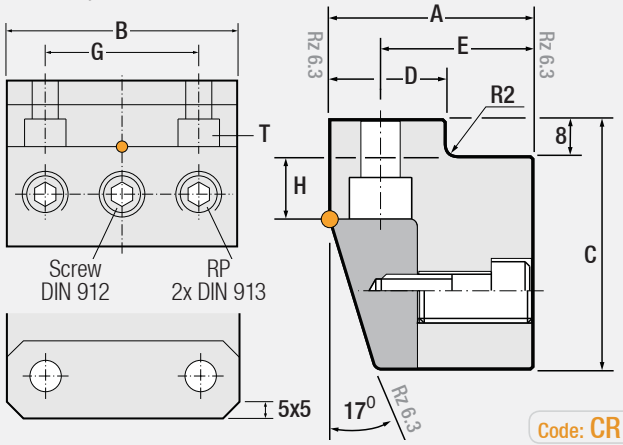
Adjustable Wedge

Code: CR

(Heel Unit)

Adjustable with the mold closed. All machining is made 90° to the parting line. Parts can be replaced from the Parting Line. Hardened steel pre-adjusted for immediate use. Hardened wear plate. Interchangeable parts. Allows the slide to be adjusted with the mold closed. Two outer screws force the heel against the slide forming the shut off, while the central screw locks it into position. Minimum space required for installation

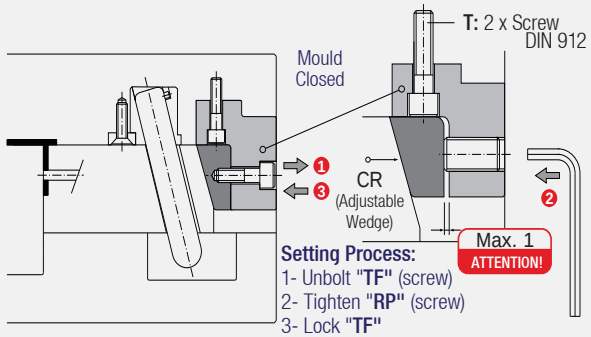
Material: 1.2312
≈ 1.080 N/mm².
Patented System



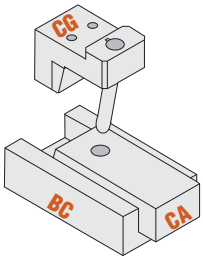
Code: CR

Order	A	B	C	D
CR.403840	40	38	40	25
CR.454849	45	48	49	28
CR.526052	52	60	52	32
CR. 526852	52	68	52	32
CR.527556	52	75	56	32

E	G	H	T	RP	CR (N)
30	22	12	M8x30	101020	320.000
35	28	16	M10x35	121025	480.000
40	35	16	M10x35	141030	750.000
40	45	16	M10x35	141030	750.000
40	50	16	M10x35	141030	750.000



Setting Process:
1- Unbolt "**TF**" (screw)
2- Tighten "**RP**" (screw)
3- Lock "**TF**"



Code: CG

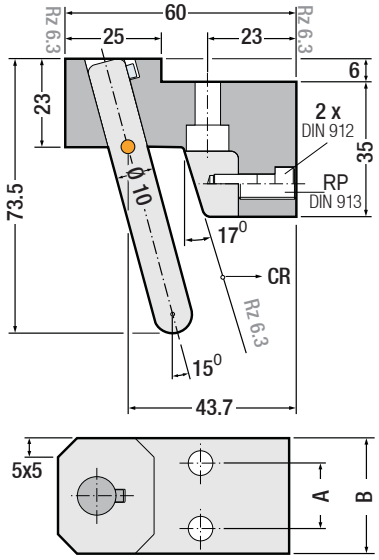
Adjustable Wedge Assembly

(Heel Unit & Including Pin)

It is consisted of angular pin and locking thrust wedge. While mould is closed, it can be easily adjusted with allen key. All machining is made 90° to the parting line. Parts can be replaced from the parting line. Angle pin included in CG - SET. Hardened steel pre-adjusted for immediate use. Hardened wear plate.

Material: 1.2312
≈ 1.080 N/mm².
Patented System

Attention!
Standard stroke
of 12mm.



Order	A	B
CG.603075	17	30
CG.604075	22	40

CR (N)	RP (Screw)	Angle Pin
180.000	081015	GI.010075
320.000	101015	GI.010075

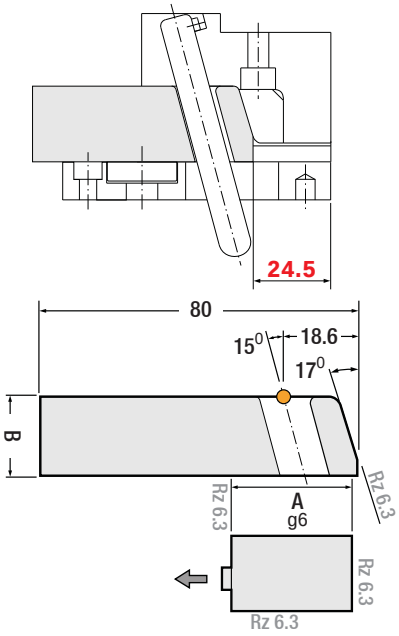
Adjusted Slide

Code: CA

Interchangeable and completly adjusted, only requires the part detail to be machined.
Its rectangular shape simplifies machining.
Angular hole is drilled on slide.

Material: 1.2344
Hardness: 42 ± 2 HRC
Patented System

Attention! Machining reference is 24.5



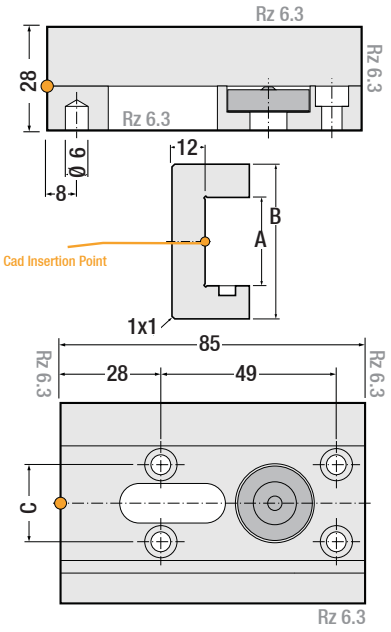
Order	A	B
CA.322080	32	20
CA.322480	32	24
CA.422080	42	20
CA.422480	42	24

Slide Base

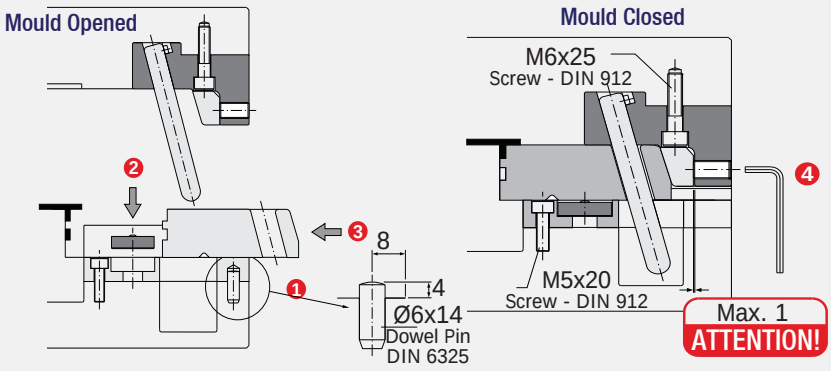
Code: BC

The slide retainer is built into the set.
Different hardness and materials between CA and BC to guarantees smooth movements.
Interchangeable parts. Parts can be replaced from the Parting Line. Hardened and ground, with the correct adjusting tolerances. Incorporates a magnetic Retainer (RM) which must be installed after the slide adjustment and allows fixing the slide movement where needed. Minimum space required for installation.

Material: 1.2510
Hardness: 54 ± 2 HRC
Patented System



Order	A	B	C
BC.322885	32	56	21.5
BC.422885	42	66	26.5



Installation

1- Determine the position of BC (slide base) and mount it.
2- Place the magnetic retainer into hole.
3- Determine the position of CA (adjusted slide).
4- While mould is closed, please adjust CA (adjused slide) up to 1 mm maximum.

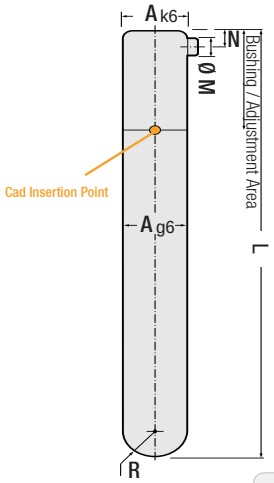
Angle Pin

Code: GI

This item can be fitted to any of the corresponding Cumsa sets (CG, GR & BG). Several diameters and lengths of angle pins.

Attention! When ordering, indicate the desired "L" dimension after the order reference code.

Material: 1.7242
Hardness: 60 ± 2 HRC



Code: GI

Order	A	Bushing / Adjustment Area
GI.010.. L	10	≃ 25
GI.012.. L	12	≃ 30
GI.016.. L	16	≃ 35
GI.020.. L	20	≃ 40
GI.024.. L	24	≃ 45
GI.028.. L	28	≃ 50

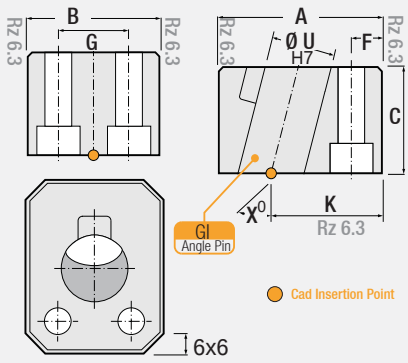
M	N	L (Length)			R
4	4	075	090	105	5
4	4	095	110	130	6
4	4	115	135	160	8
6	6	140	165	190	10
6	6	170	195	220	12
6	6	200	225	250	14

Code: BG

Square Angle Pin Housing

This is similar to the round Angle Pin Housing (GR) but allows the fitting of angle pins from 15°or 20°. This unit is bigger than the GR to allow for the greater angles and it requires a square pocket to be machined in the mould base. All machining is made 90° to the parting line. Parts can be replaced from the Parting Line. Minimum space required for installation.

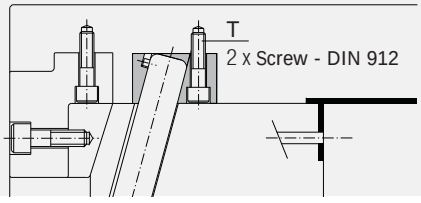
Material: 1.2312
≃ 1.080 N/mm².
Patented System



Code: BG

Order	A	B	C	F
BG.423016-15	42	30	30	7.5
BG.504020-15	50	40	36	9
BG.554024-15	55	40	40	9
BG.655028-15	65	50	45	12
BG.423016-20	42	30	30	7.5
BG.504020-20	50	40	36	9
BG.554024-20	55	40	40	9
BG.655028-20	65	50	45	12

G	K	T	U	X
15	28	M6x35	Ø 16	15⁰
22	34	M8x40	Ø 20	
22	38	M8x45	Ø 24	
26	45	M10x50	Ø 28	
15	28	M6x35	Ø 16	20⁰
22	34	M8x40	Ø 20	
22	38	M8x45	Ø 24	
26	45	M10x50	Ø 28	

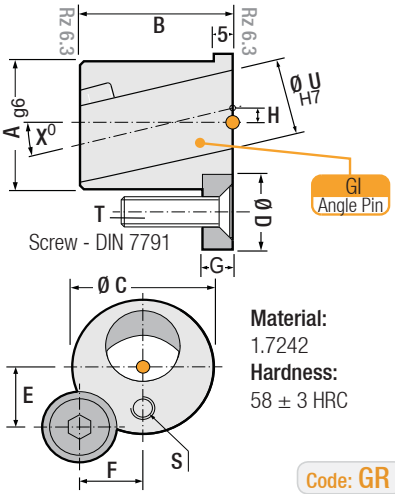


Angle Pin Housing

Code: GR

This unit incorporates a predrilled hole for the angle pin which eliminates the need to angularly drill the mould base.The mould base only needs to be drilled from the front to accept this unit. The unit comes in either 10°or 15°.

All drilling is made 90° to the parting line.
Parts can replaced from the Parting Line.
Minimum space required for installation.
Several diameters and lengths of angle pins.



Material:
1.7242
Hardness:
58 ± 3 HRC

Code: GR

Order	A	B	C	D	E
GR.182622-10	18	26	22	12	10.8
GR.222826-10	22	28	26	16	11
GR.283432-10	28	34	32	16	13
GR.344038-10	34	40	38	20	17
GR.424546-10	42	45	46	20	19.5
GR.465050-10	46	50	50	20	21
GR.182622-15	18	26	22	12	10.8
GR.222826-15	22	28	26	16	11
GR.283432-15	28	34	32	16	13
GR.344038-15	34	40	38	20	17
GR.424546-15	42	45	46	20	19.5
GR.465050-15	46	50	50	20	21

F	G	H	S	T	U	X⁰
7.5	6	3.8	M5x5	M5x16	10	10⁰
11		4	M6x6	M6x16	12	
13		5			16	
17	8	5.5	M8x6	M8x20	20	
19.5		6			24	
21		7			28	
7.5	6	3.8	M5x5	M5x16	10	15⁰
11		4	M6x6	M6x16	12	
13		5			16	
17	8	5.5	M8x6	M8x20	20	
19.5		6			24	
21		7			28	

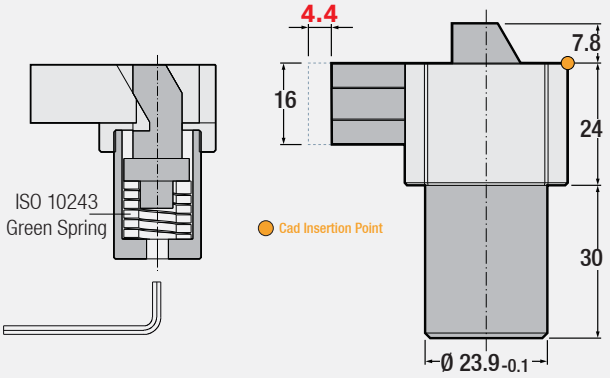
Core Cam (for lateral holes)

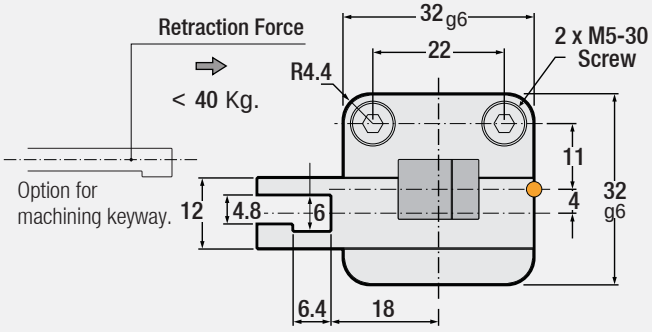
Code: UC

Mechanism to make lateral holes, automatic retention for the core insert. Requires very small area for installation. Reduces costs in machining and fitting. Reduces mould production time. Machining for installation is easier due to always being at 90° to parting line. Offers a standard solution to the mould makers.

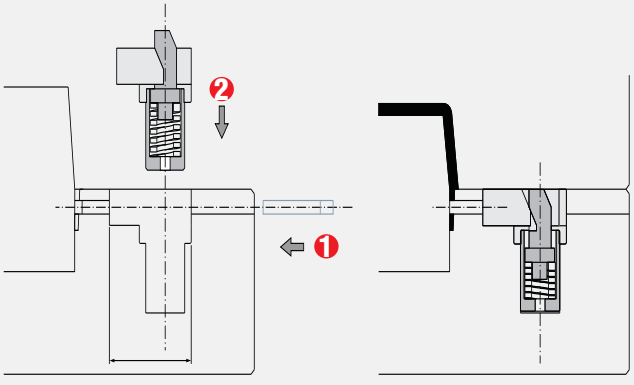
Material: 1.2344
Hardness: 52 - 54 HRC
Max. working temperature: 150°.

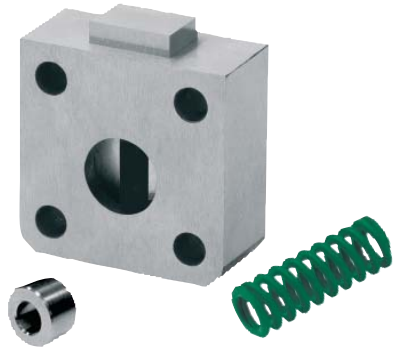
Attention! Standard stroke of 4.4mm.





Order: UC.325445





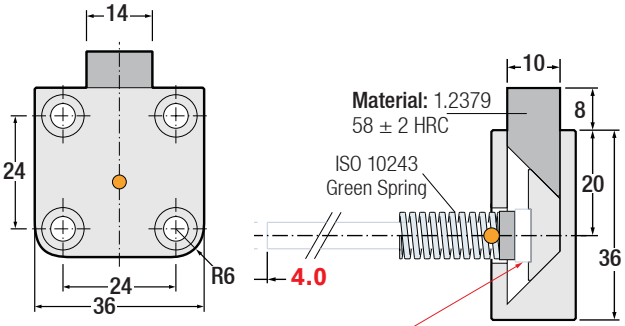
Compact Coring Unit (for lateral holes)

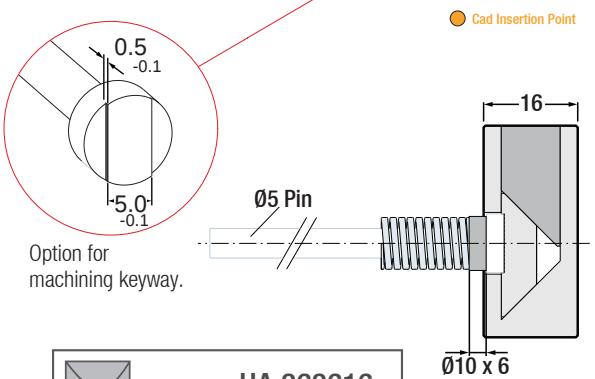
Code: UA

This unit uses the open and close movement of the mould to make lateral holes in wall sections of plastic parts. Easy to assemble and remove from the mould. Reduces costs in machining and fitting. Reduces mould production time. Machining for installation is easier due to always being at 90° to parting line. Offers a standard solution to the mould makers.
Requires very small area for installation.

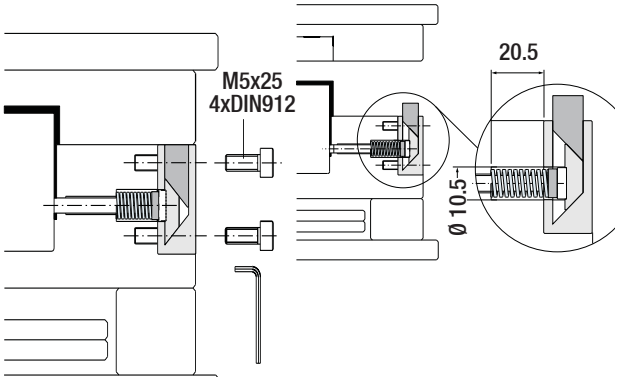
Material: 1.2344
Hardness: 52 - 54 HRC
Max. working temperature: 150°.

Attention! Standard stroke of 4.0mm.





Order: UA.363616



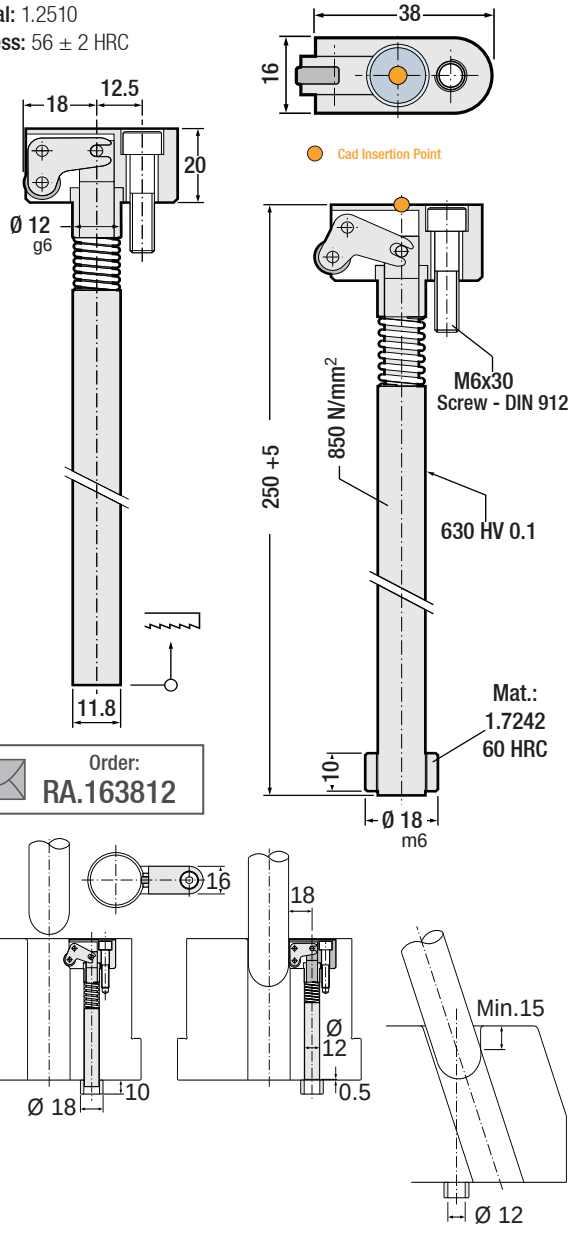
Automatic Retainer

Code: RA

This retainer for large slides is actuated by the angle pin, ensuring smooth and easy movement with no excess force required.
Reduces costs in machining and fitting. No need for complex retaining systems or expensive hydraulic systems. Retention of cam slides up to 2000 Kg. Offers a standard solution to the mould makers.

Attention! Cut the rod 0.5mm shorter than the slide height.

Material: 1.2510
Hardness: 56 ± 2 HRC



Order: RA.163812

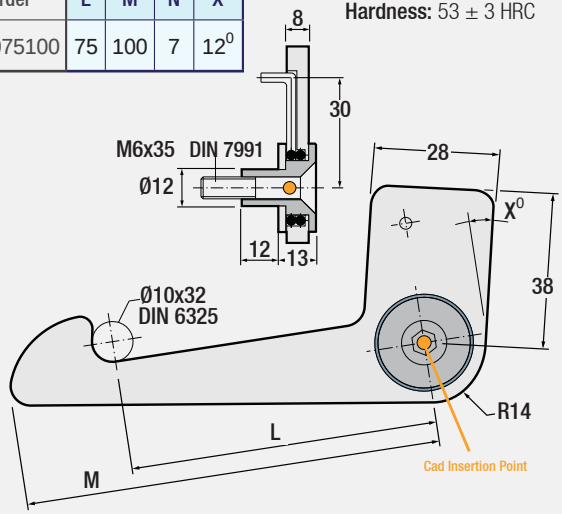
Safety Strap

Code: BS

Keeps the mould closed when it is not in the machine.
The mould is unlocked automatically, when mounted on the machine.
Minimum space required for installation. Guarantees automatic opening and closing of the mould when loaded or unloaded from the machine.

Order	L	M	N	X
BS.075100	75	100	7	12^0

Material: 1.0503
Hardness: 53 ± 3 HRC



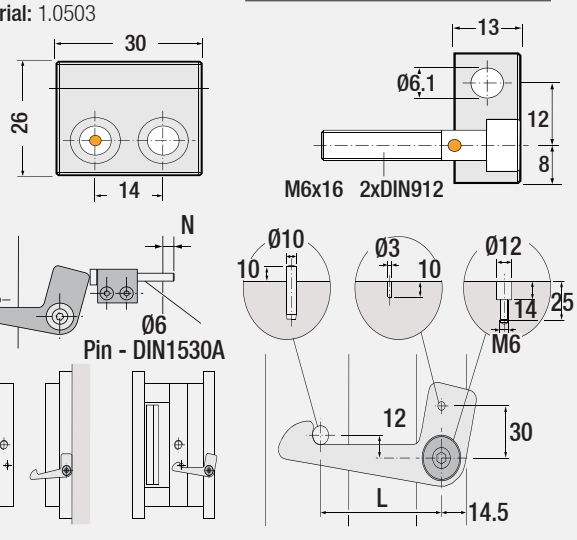
Strap Extender

Code: AB

Used where the cavity plate is thicker than 120 mm.

Order: AB.302613

Material: 1.0503

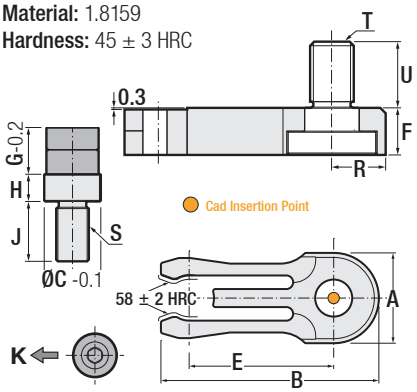


Slide Retainer

Code: RCM

Incorporates a mechanical stopper.
The fixing pin has rollers to avoid wear on friction surfaces. Less machining for installation compared to similar products on the market.
Minimum space required for installation.

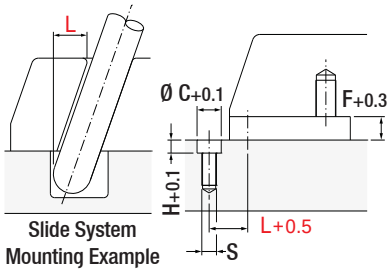
Material: 1.8159
Hardness: 45 ± 3 HRC

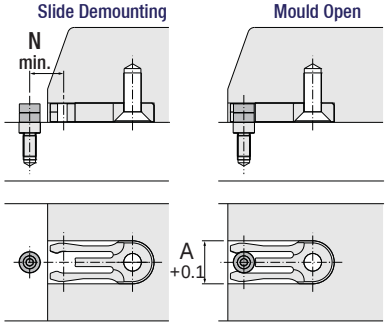


Order	A	B	C	E	F	G
RCM.163808	16	38	8	25	7.6	7.6
RCM.204810	20	48	10	32	8.7	8.6
RCM.245712	24	57	12	37.5	9.6	9.6

H	J	K	N	R	S	T	U
4	10	8 Kg.	7	8	M5	M6	9
5	11	14 Kg.	8	10	M6	M8	12
6	12	18 Kg.	9	12	M8	M10	15

K: Force to release the retainer.



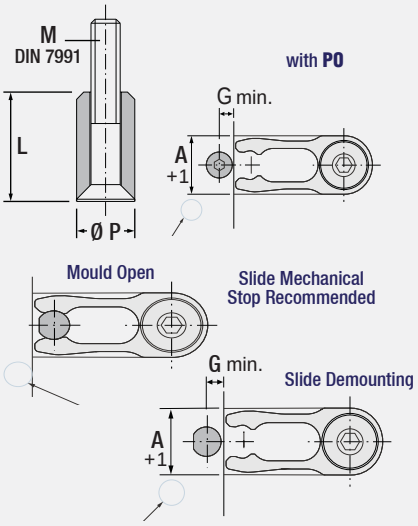


Optional Dowel Pin for Slide Retainer

Code: PO

Optional method for holding the Slide Retainer, that simplifies the disassembling.
This item must be ordered separately.

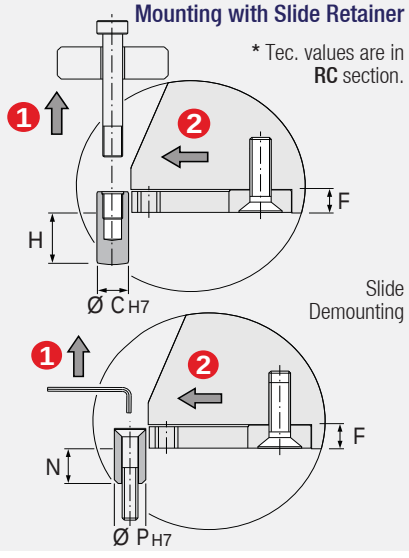
Material: 1.3505
Hardness: 60 ± 2 HRC



Order	L	M	N	P
PO.120320	12	M3x20	7.5	6
PO.150425	15	M4x25	10	8
PO.200530	20	M5x30	13	10
PO.250635	25	M6x35	16	12
PO.340850	34	M8x50	23	16

Mounting with Slide Retainer

* Tec. values are in **RC** section.

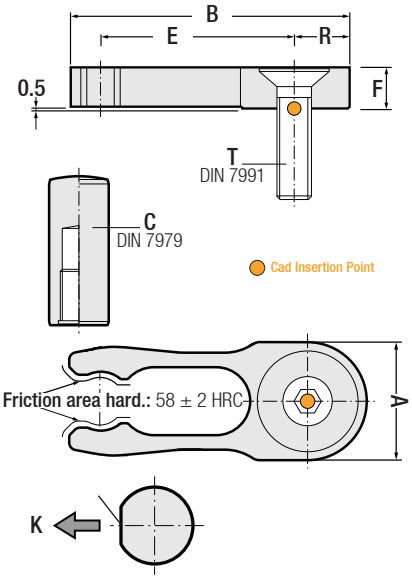


Slide Retainer

Code: RC

Less machining for installation compared to similar products on the market.
Minimum space required for installation.
Reduces costs in tool downtime.
Offers a standard solution to the mould makers.

Material: 1.8159
Hardness: 45 ± 3 HRC



K: Force to release the retainer.
Slot depths should be: F = +0.30mm.

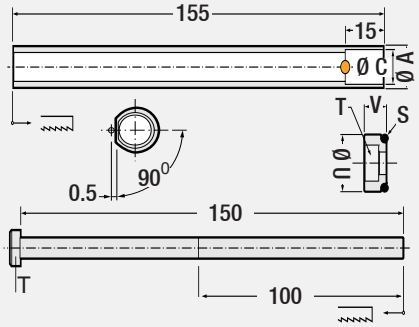
Order	A	B	C	E	F
RC.123006	12	30	6x20	21	4.7
RC.164008	16	40	8x20	28	5.7
RC.205010	20	50	10x24	34	7.7
RC.246012	24	60	12x32	42	9.7
RC.328012	32	80	16x40	56	11.7
RC.328016	32	80	16x40	56	15.7

G	H	K	R	T
4	16	5 Kg.	6	M5x16
5	15	7 Kg.	8	M6x20
6	17	14 Kg.	10	M8x25
7	23	21 Kg.	12	M10x30
9	27	28 Kg.	16	M12x35
9	25	38 Kg.	16	M12x50

Code: AP

Retractable Core Extension

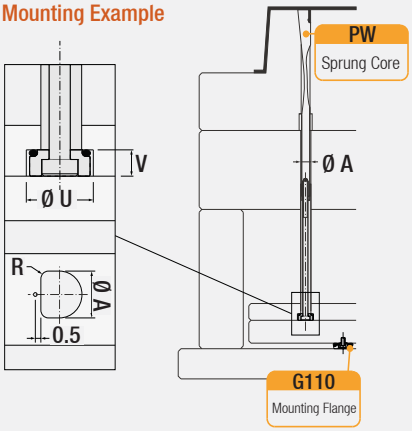
Standard extension. Flat for key position included. Hardened and ground to size. Enables a standard length of the PW up to 315mm. Keyed pocket included.



Order	A	C	R
AP.080615	8	6	1.25
AP.100815	10	8	2.0
AP.121015	12	10	2.5

S	T	U	V
9.5 x 2	M4	14	5
11.5 x 2	M5	16	6
14.5 x 2.5	M6	20	8

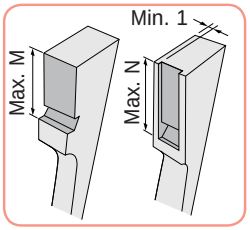
Mounting Example



Güvenal GTH Die & Mould Components
Standard Injection Mould Systems

CUMSA
Innovative Solutions for Your Moulds

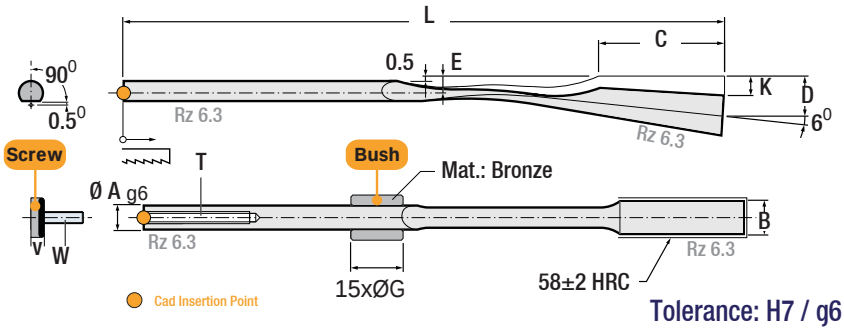
After setting core, please machining 0.1mm from end section to make ejector effortlessly.



Sprung Core

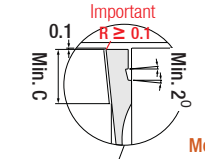
Code: PW

Minimum space required for installation, only needs the space of an ejector. No milling, grinding or hardening other than the machining of detail needed. Machining for installation is easier due to always being at 90° to parting line. No need for complex mechanical systems. The opening of the sprung cores is a radial movement. Due to this, at the edge of the stroke, the opening is 3.5mm (0.138"), 4.5mm (0.177") and 5.5mm (0.217"), depending on the model (K dimension in the catalogue).
Correctly installed sprung cores (following our catalogue installation instructions) can produce more than 1 million parts. (welding is not recommended on any of the sprung core products & we only recommend using Balinit C coating, other coatings are not recommended as they can reduce the sprung core life)
Material: 1.8159 **Hardness:** 45 ± 3 HRC **Max. working temperature:** 150°.

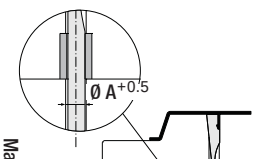


Tolerance: H7 / g6

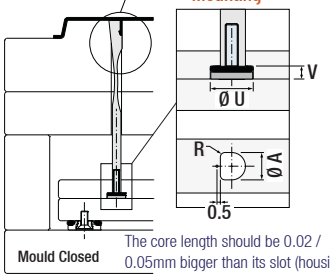
Order	A	B	C	D	E	G	K	L	M	N	R	T	U	V	W
PW.060622	6	6.2	22	9	3.5	-	3.5	125	16	18	1.25	M4 x 36	12	5	M4 x 16
PW.060630			30	10		12	4.5	175	20	26					
PW.060822		8.2	22	9		-	3.5	125	16	18					
PW.060830			30	10		12	4.5	175	20	26					
PW.080825	8	8.2	25	11.5	4.5	-	4.5	140	18	21	2.0	M5 x 36	14	6	M5 x 16
PW.081025		10.2				-									
PW.081030			30	11.2		12		175	20	26					
PW.081225		12.2	25	11.5		-		140	18	21					
PW.081230			30	11.2		12		175	20	26					
PW.101430	10	14.2	30	13.6	5.5	16	5.5	175	20	26	2.5	M6 x 36	18	8	M6 x 16
PW.101630		16.2													
PW.101830		18.2													



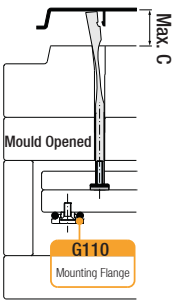
"D" gap (6mm): Up to < 3 mm.
"B" width: Min. 2° can be slepped
6° surface / bushing: Min. 5 mm
Core can be adjusted with mould cavity.
Slot: 6°

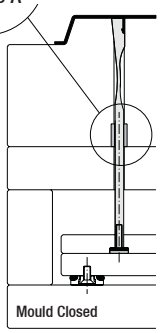


Mounting



The core length should be 0.02 / 0.05mm bigger than its slot (housing).





"PX" Cutting Jig

Code: CX

Enables accurate fine tuning in the height of the PX. Simplifies the measuring and cutting of the shaft of the PX. Easier to cut larger quantities of PX at a time.

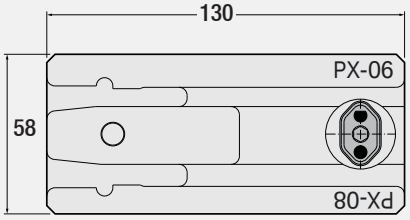
How to use the PX Cutting Jig ?

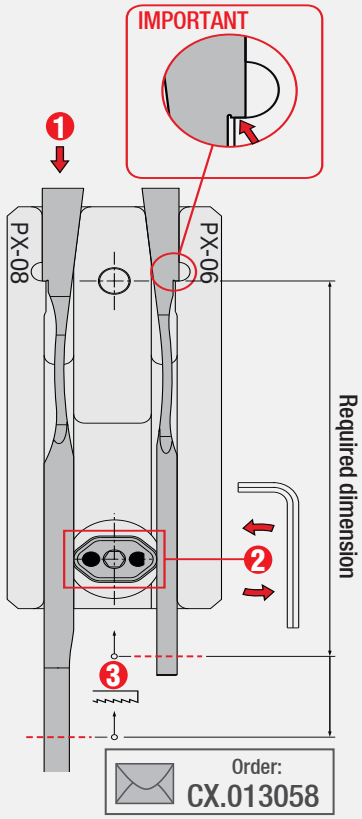
1- Insert the PX into the corresponding slot, for 6 or 8mm. shank. Ensure that the shape of the PX head is adjusted in the housing support.

2- Use an allen key to select the correct option: flat ● or ● round.

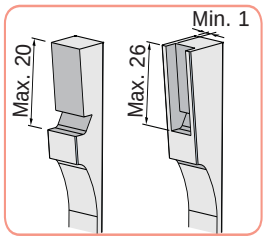
3- Cut the PX to the required dimension.

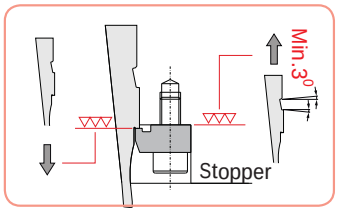
Material: INOX / 1.4034





After setting core, please machining 0.1mm from end section to make ejector effortlessly.





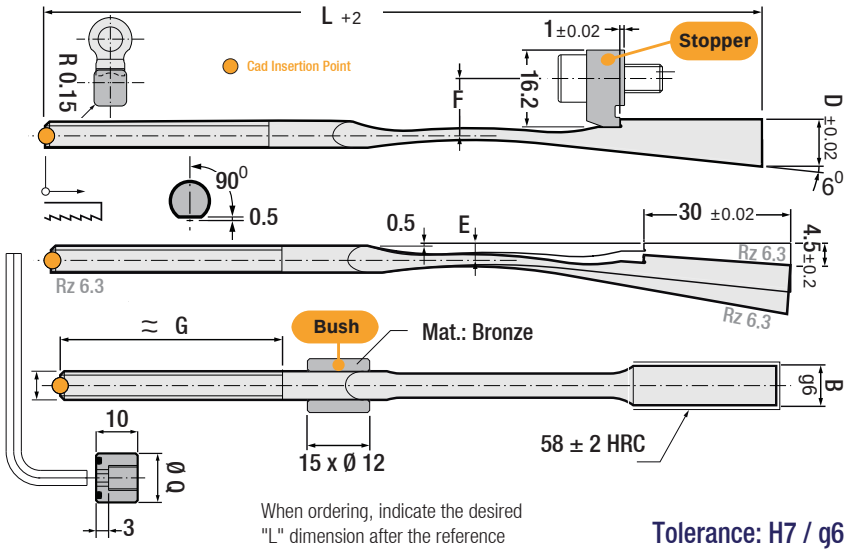
Xtra Sprung Core

Code: PX

The stopper simplifies the adjustment and allows a longer lifetime guarantee. Completely adjusted to fit an H7 housing, radiuses already made on the head of the sprung core. Simple fixing system due to its external thread.

Available in three lengths. Jig to guarantee the part is cut at the exact length (supplied separately).

Material: 1.8159 **Hardness:** 45 ± 3 HRC **Max. working temperature:** 150°.

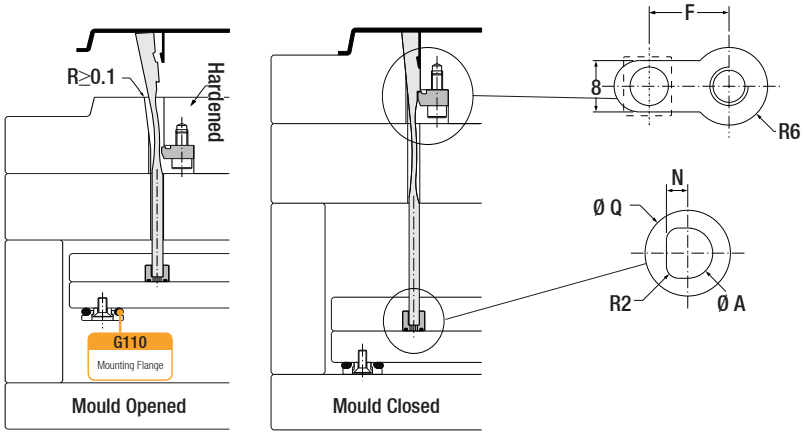


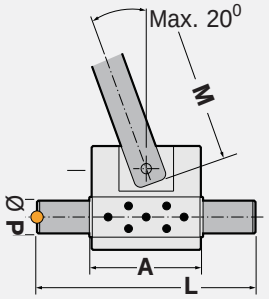
When ordering, indicate the desired "L" dimension after the reference

Tolerance: H7 / g6

Order	A	B	D	E	F	L=175		L=250		L=325		N	Q
						G	Bush	G	Bush	G	Bush		
PX.060630-...	6	6.2	10	3.5	12.5	60	-	80	-	80	-	2.5	12
PX.060830-...	6	8.2	10	3.5	12.5	60	-	80	-	80	-	2.5	12
PX.081030-...	8	10.2	11.2	4.5	13.5	60	-	80	-	80	-	3.5	14
PX.081230-...	8	12.2	11.2	4.5	13.5	60	-	80	-	80	-	3.5	14

As other ejector, it is operated with ejector plates. Especially, it is ideal to remove small lugs.





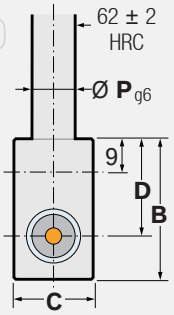
Undercut Base Unit

Code: SD

Used for internal undercut movements which require different angles of ejection. Its bronze guide bushing with graphite inserts, simplifies its movement. No milling, grinding or hardening need, only pocket machining.

Mat.: 1.2312 ≈1.080.N / mm²

Order	A	B	C	D	L	M	P
SD.3220GR	32	37	20	27	80	180	10
SD.3824GR	38	40	24	28	80	210	12
SD.4528GR	45	44	28	30	100	250	16

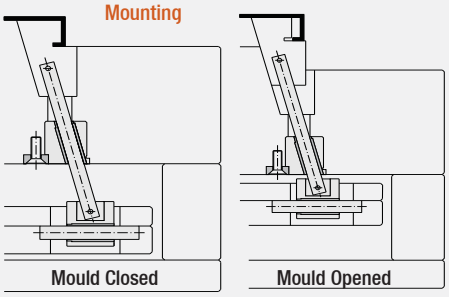


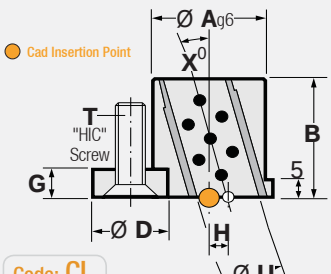
Attention: The unit and the rod are delivered separately.

The maximum weight that the Undercut Base Unit can support:

SD.322010 - 320 kg
SD.382412 - 420 kg
SD.452816 - 680 kg.

Mounting



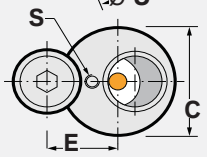


Angled Guide Bush

Code: CI

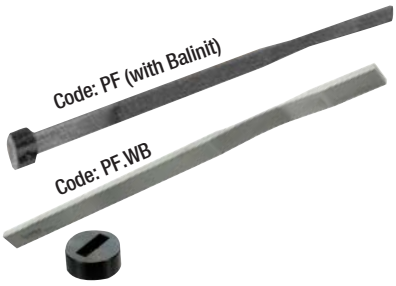
This unit is a guide bush for angled undercut blocks, which only requires a straight drilled hole for fitting. It does not require oil grooves due to the graphite-bronze insert.

Material: 1.7242 **Hardness:** 58 ± 3 HRC

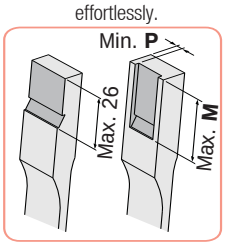


Order	A	B	C	D	E	G	H	T	U	X⁰
CI.3034-5	30	34	34	16	20	6	0	M6x16	10	5⁰
CI.3438-5	34	38	38	20	24	8	0	M8x20	12	
CI.4040-5	40	40	44	20	27	8	0		16	
CI.3034-10	30	34	34	16	20	6	7	M6x16	10	10⁰
CI.3438-10	34	38	38	20	24	8	8.5	M8x20	12	
CI.4040-10	40	40	44	20	27	8	8.5		16	
CI.3034-15	30	34	34	16	20	6	7	M6x16	10	15⁰
CI.3438-15	34	38	38	20	24	8	8.5	M8x20	12	
CI.4040-15	40	40	44	20	27	8	8.5		16	
CI.3034-20	30	34	34	16	20	6	7	M6x16	10	20⁰
CI.3438-20	34	38	38	20	24	8	8.5	M8x20	12	
CI.4040-20	40	40	44	20	27	8	8.5		16	

"S": Demounting screw hole. Please see 3D file for "S" hole position.



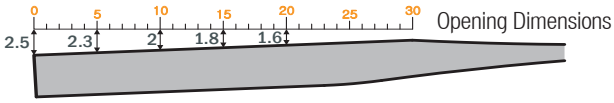
After setting core, please machining from end section to "P" due to make ejector effortlessly.



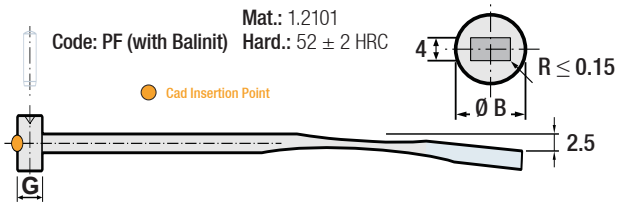
Flexible Sprung Core

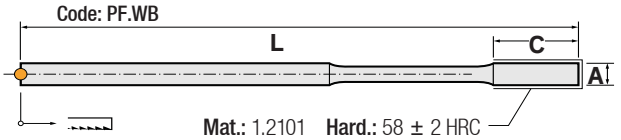
Code: PF

Thanks to its parallel walls, this core allows undercuts to be released in compact areas (only 4mm. thickness). Include a simple system for adjustment. A new feature to this product is that it ejects first then releases the undercut. Minimum space required for installation,only needs the space of an ejector. No milling, grinding or hardening other than the machining of detail needed. All drilling is 90° to the parting line. Available with and without Balinit C® coating.

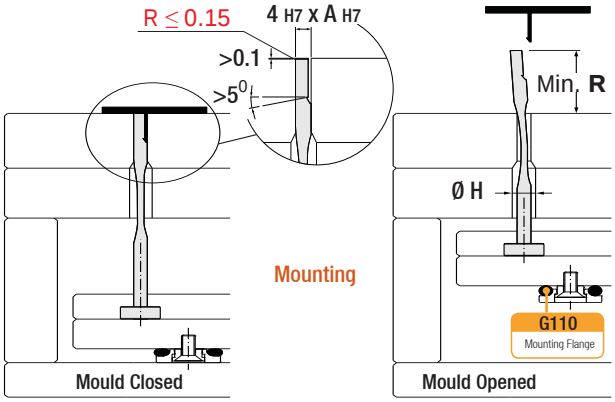


The opening of the sprung cores is a radial movement.
Due to this, at the edge of the stroke, the opening is 2.5mm (0.098").





Order	A	B	C	G	H	L	M	N	P	R	Balinit C
PF.044150	4	8	24	6	6	150	12	14	0.8	30	•
PF.054150	5				6						•
PF.064200	6	12	30	8	7	200	18	20	1.0	36	•
PF.084200	8	14			9						•
PF.104200	10	16			11						•
PF.124200	12	18			13						•
PF.0642-WB	6	12	30	8	7	200	18	20	1.0	36	-
PF.0842-WB	8	14			9						-
PF.01042-WB	10	16			11						-
PF.01242-WB	12	18			13						-



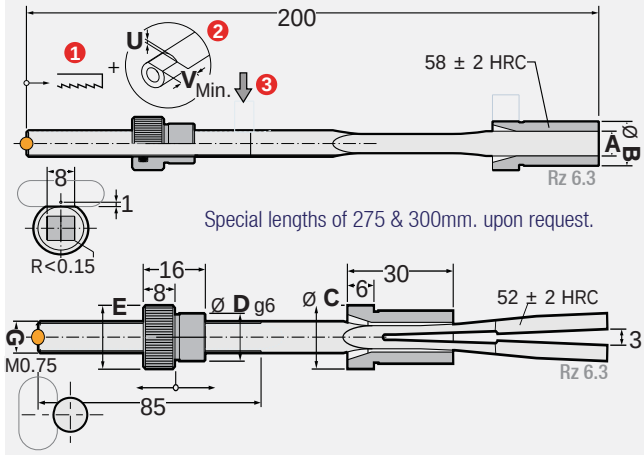
Double Ejector

Code: ED

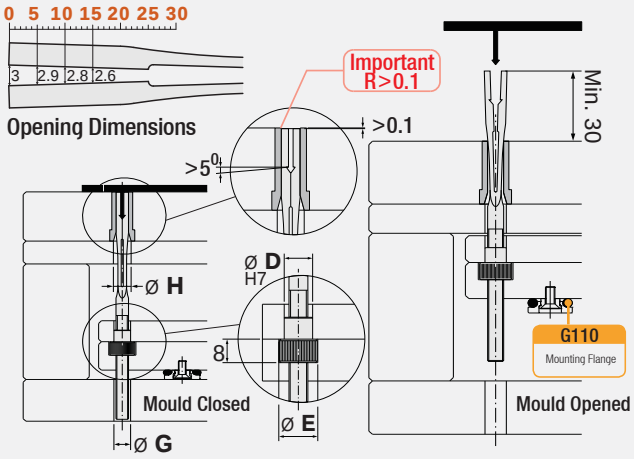
Two separte movements in one component. Minimum space required for installation, only needs the space of an ejector.
No milling, grinding or hardening other than the machining of detail needed. No need for complex mechanical systems. Useful to release small undercuts, this ejector is pre-adjusted and height adjustable. Easy to install, machining is 90° to parting line. The Balinit C® coating offers smooth action.

Material: 1.2101 **Hardness:** 45 ± 3 HRC
Max. working temperature: 150°.

Every Ejector is adjusted individually with its bushing, with a tolerance g6/H7 between them. For this reason, it is important to keep track of both pieces in pairs while handling and installing. The opening of the sprung cores is a radial movement. Due to this, at the edge of the stroke, the opening is 3.0 mm.



Order	A	B	C	D	E	G	H	U	V
ED.068200	6	12	14	10	14	6	10	0.5	10
ED.088200	8	14	16	12	16	8	12		
ED.108200	10	16	18	14	18	8	14		15
ED.128200	12	16	18	16	20	8	15		



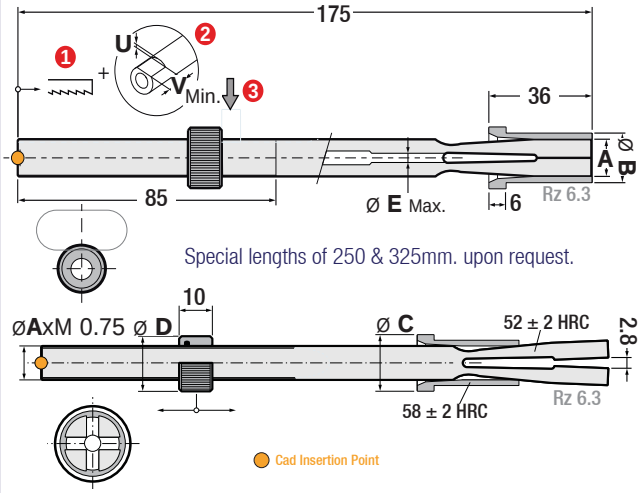
Tulip Ejector

Code: EE

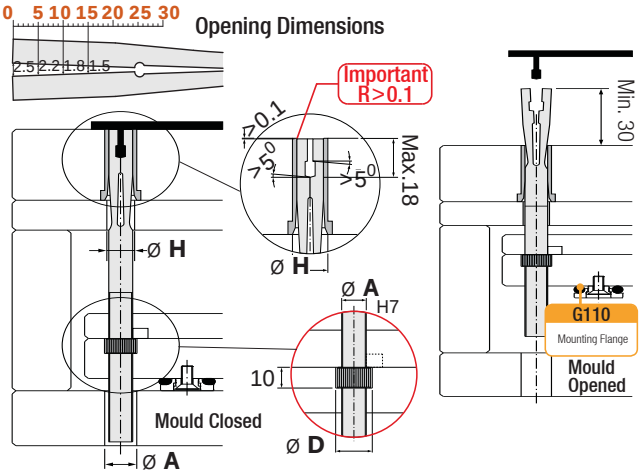
Four separte movements in one component. Useful to release small undercuts, this ejector is pre-adjusted and height adjustable. Cilindrical machining and made 90° regarding the parting line. No milling, grinding or hardening other than the machining of detail needed. The Balinit C® coating offers smooth action. Minimum space required for installation, only needs the space of an ejector.

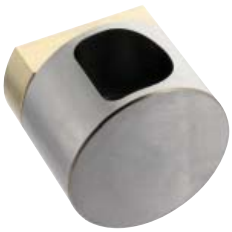
Material: 1.2101 **Hardness:** 45 ± 3 HRC
Max. working temperature: 150°.

Every Ejector is adjusted individually with its bushing, with a tolerance g6/H7 between them. For this reason, it is important to keep track of both pieces in pairs while handling and installing. The opening of the sprung cores is a radial movement. Due to this, at the edge of the stroke, the opening is 2.8mm (0.110").



Order	A	B	C	D	E	H	U	V
EE.060175	6	10	12	12	-	9	0.5	10
EE.082175	8	12	14	14	2	11		
EE.103175	10	14	16	16	3	13		15
EE.124175	12	16	18	18	4	15		
EE.168175	16	20	22	22	8	19	1.0	20



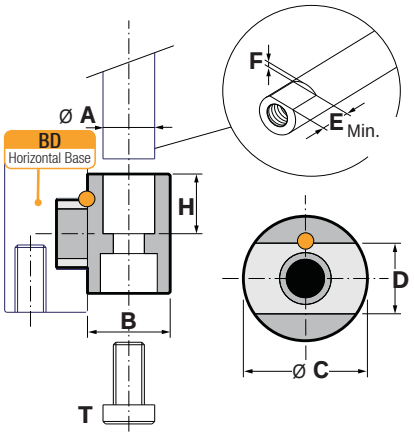


Fixed Lifter Base

Code: DF

Keyed pocket for the lifter shaft. Minimum space required in the ejector plates.
"VI" (Lifter Shaft) may be used as ejector.

Material: INOX 1.4034
Hardness: 48 ± 2 HRC

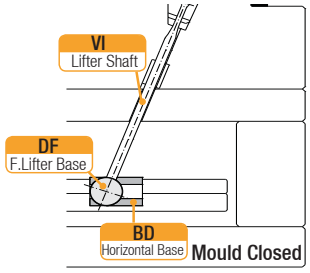


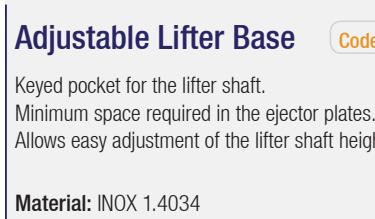
Cad Insertion Point

Code: DF

Order	A	B	C	D
DF.061220	6	12	20	11.5
DF.081220	8	12	20	11.5
DF.101624	10	16	24	13.5
DF.121624	12	16	24	13.5
DF.162032	16	20	32	19
DF.202538	20	25	38	21
DF.253148	25	31	48	28

E	F	H	T
12	0.5	10	M4 x 12
12	0.5	10	M5 x 12
14	0.5	12	M6 x 16
14	1.0	12	M8 x 16
18	1.5	16	M8 x 22
21	1.5	19	M10 x 25
26	2.0	24	M12 x 35



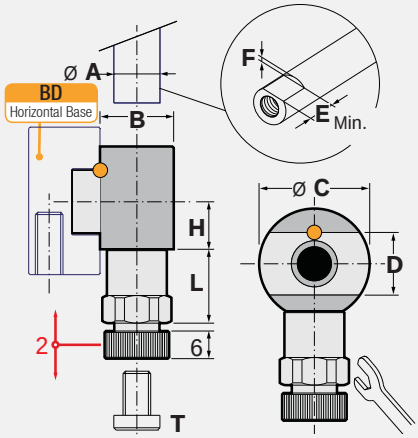


Adjustable Lifter Base

Code: DA

Keyed pocket for the lifter shaft.
Minimum space required in the ejector plates.**"DA"**
Allows easy adjustment of the lifter shaft height.

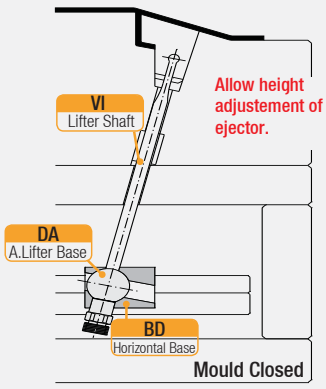
Material: INOX 1.4034
Hardness: 48 ± 2 HRC



Code: DA

Order	A	B	C	D
DA.061020	6	10	20	11.5
DA.081220	8	12	20	11.5
DA.101624	10	16	24	13.5
DA.121824	12	18	24	13.5

E	F	H	L	T
15	0.5	9.0	14	M4 x 40
15	0.5	8.5	14	M5 x 40
17	0.5	10.2	16	M6 x 40
17	1.0	9.6	16	M8 x 40



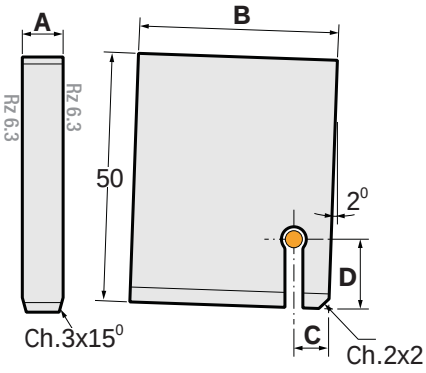
Lifter Head

Code: IF

Lifter Head hardened and ground to size.
No need for threads or dowel pins to attach the Lifter Head to the Lifter Shaft.
Offers a standard solution to the mould makers.

Material: 1.2344
Hardness: 45 ± 2 HRC

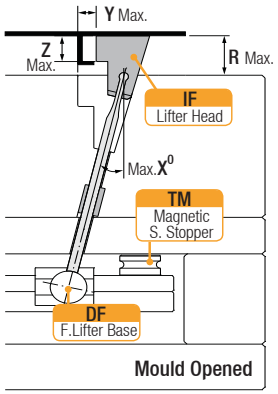
Patented System



Code: IF

Order	A	B	C	D
IF.064050	6.2	40	6	12
IF.084050	8.2	40	7	14
IF.104450	10.2	44	8	16
IF.124450	12.2	44	9	18

R	X	Y	Z
40	5	3.5	36
38	10	6.7	35
38	15	10.2	34
37	20	13.5	32

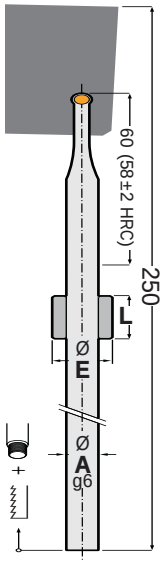


Lifter Shaft

Code: VI

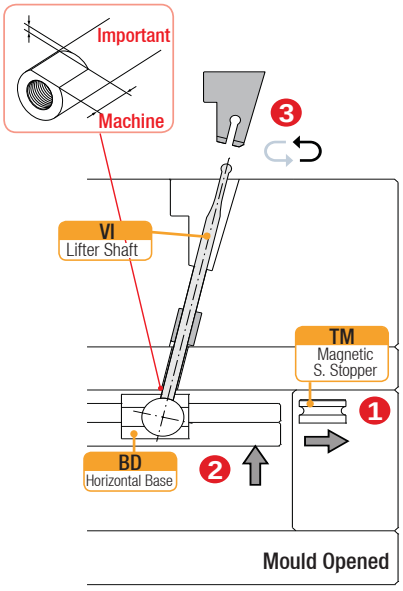
Lifter shaft includes oilless bushing.
No need for threads or dowel pins to attach the Lifter Head to the Lifter Shaft.
Offers a standard solution to the mould makers.

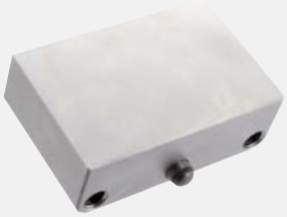
Material: 1.3505
Patented System



Code: VI

Order	A	E	L	U	V
VI.064200	6	10	15	0.5	12
VI.085200	8	12	20	0.5	12
VI.106200	10	14	20	0.5	14
VI.127200	12	16	20	1.0	14

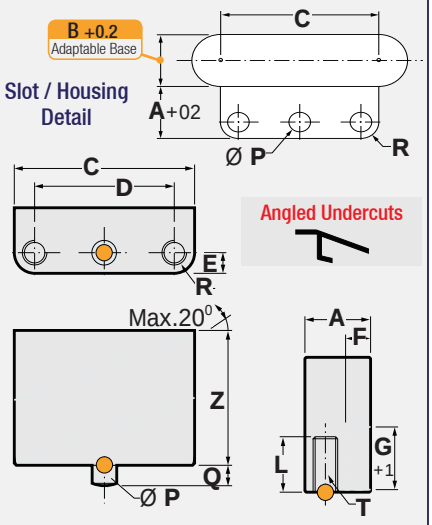




Adaptable Base

Code: BD

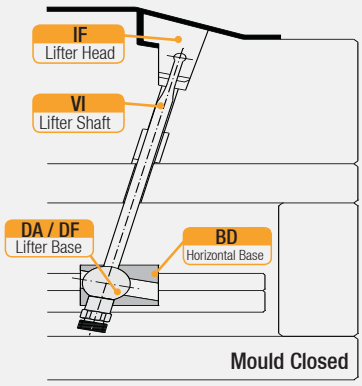
Cam slide for internal lifters.
Different hardness and materials between base and limiter guarantees smooth movements.
Minimum space required for installation.
Material: 1.2311 **Hardness:** 45 ± 2 HRC



Code: BD

Order	A	C	D	E	F
BD.122836	12	36	28	4	4.8
BD.143866	14	66	42	4	6.3
BD.163240	16	40	30	5	6.3
BD.204060	20	60	44	5	8.3
BD.254672	25	72	56	7	10.3
BD.315890	31	90	74	8	13.3

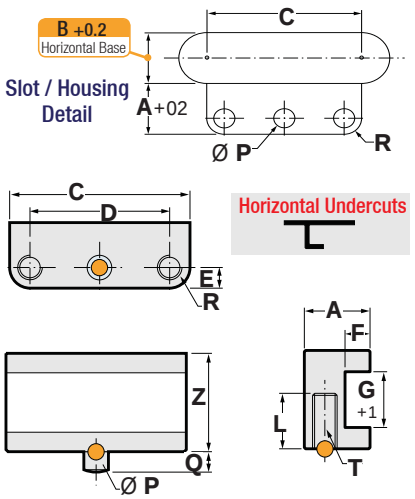
G	L	P	Q	R	T	Z
11.5	10	5	5	4	M5	28
11.5	10	5	5	4	M5	38
13.5	12	6	5	5	M6	32
19	15	6	5	5	M6	40
21	18	8	5	6	M8	46
28	18	10	8	8	M10	58



Horizontal Base

Code: BD

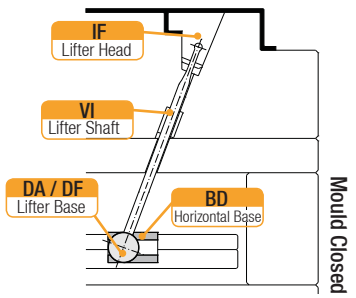
Cam slide for internal lifters.
Different hardness and materials between base and limiter guarantees smooth movements.
Minimum space required for installation.
Material: 1.2311 **Hardness:** 45 ± 2 HRC

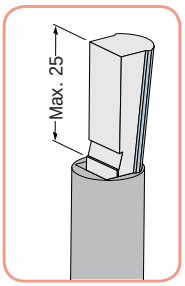


Code: BD

Order	A	C	D	E	F
BD.122036	12	36	28	4	4.8
BD.142266	14	66	42	4	6.3
BD.162440	16	40	30	5	6.3
BD.203260	20	60	44	5	8.3
BD.253872	25	72	56	7	10.3
BD.314890	31	90	74	8	13.3

G	L	P	Q	R	T	Z
11.5	10	5	5	4	M5	20
11.5	10	5	5	4	M5	22
13.5	12	6	5	5	M6	24
19	15	6	5	5	M6	32
21	18	8	5	6	M8	38
28	18	10	8	8	M10	48





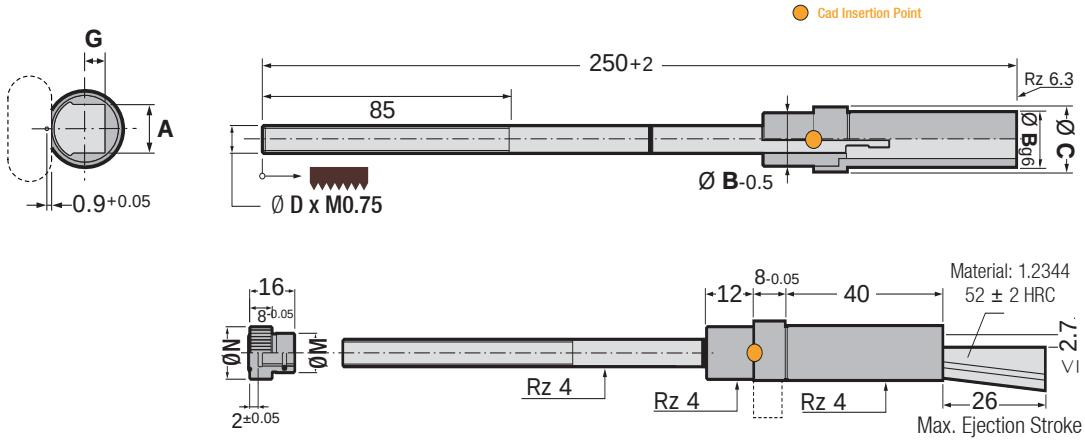
Important
Max. Operation Length

Standard Lifter

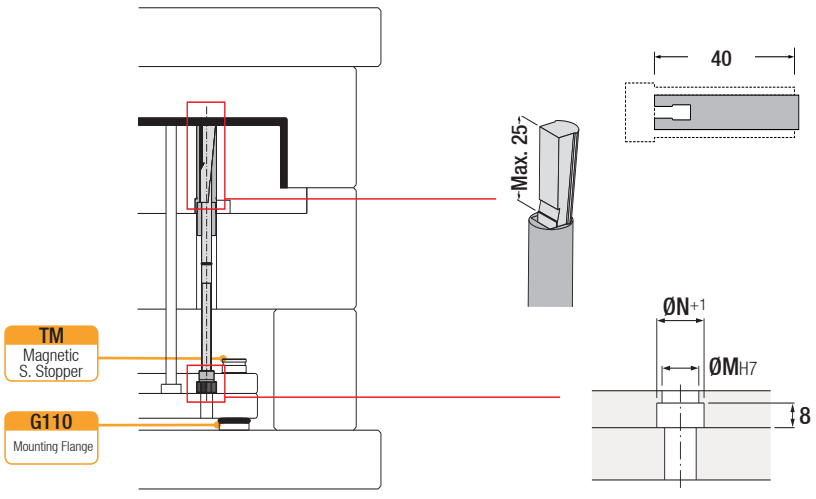
Code: PS

Compact unit for the release of small undercuts. The unit is completely pre adjusted and easy to install.
The space required for installation is reduced due to the vertical movement perpendicular to the ejector plates.
Minimum space required for installation, only needs the space of an ejector.
Mechanical solution. No milling, grinding or hardening
other than the machining of detail needed.

Material: INOX 1.4034 **Hardness:** 48 ± 2 HRC **Patented System**



Order Code	A	B	C	D	G	M	N	R
PS.062250	6.2	10	12	6	3.4	12	16	1.25
PS.082250	8.2	12	14	6	4	12	16	1.25
PS.102250	10.2	14	16	8	4.2	14	18	2
PS.122250	12.2	16	18	8	4.2	14	18	2



* The bushing can be machined to make the molding surface up to 25mm (0.98").

How much can be cut from the top on the bushing and RP in Z axis?

PS.062250: 8 mm (0.315")
PS.082250: 15 mm (0.591")
PS.102250: 15 mm (0.591")
PS.122250: 20 mm (0.787")

Vertical Lifter Block

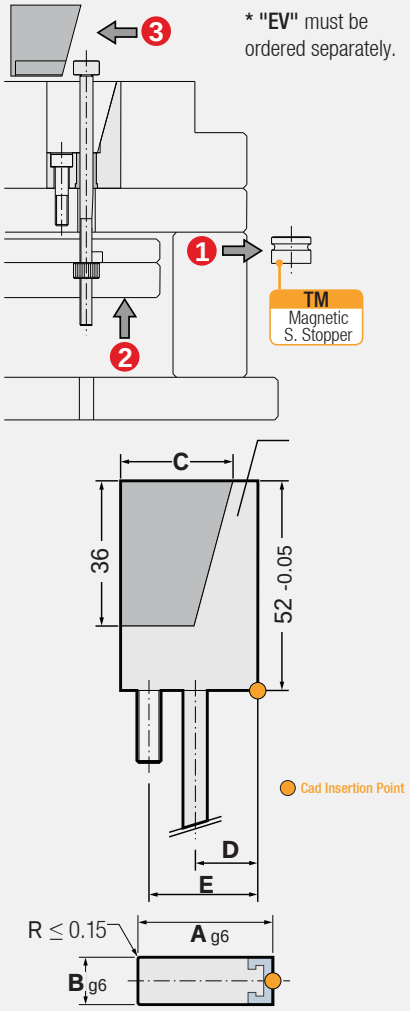
Code: PV

They are used along with mechanic Vertical Lifters, in profile block vertical lifting.

Material: 1.2842 **Hardness:** 56 ± 2 HRC

Usage: Removal process of profile block (according to technical drawing detail).

1- Pull **"TM"** (Magnetic Stopping) safety disc.
2- Push ejector plate forward.
3- Remove lifter housing.



* **"EV"** must be ordered separately.

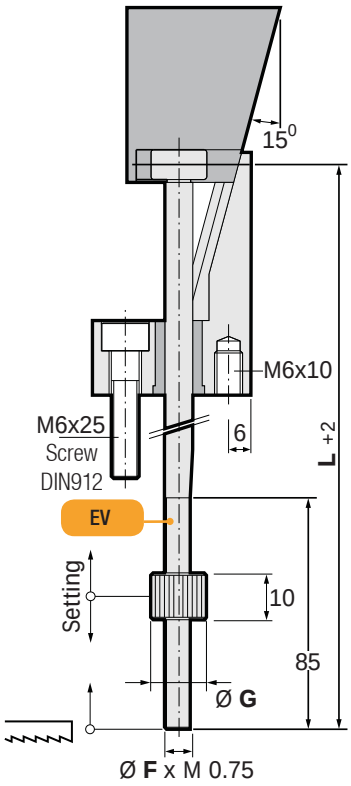
Order	A	B	C	D	E
PV.341252	34	12	28	15.5	27
PV.402452	40	24	34	18.5	33

Vertical Lifter

Code: EV

Reduces costs in machining and fitting. Reduces costs in tool downtime.
All machining are made in a 90° position. Less space required compared to conventional solutions.
Offers a standard solution to the mould makers.

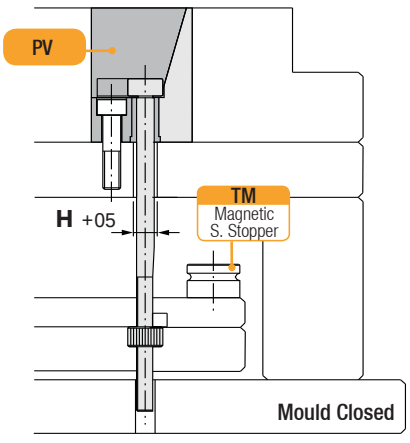
Material: 1.2344 **Hardness:** 50 ± 2 HRC **Patented System**

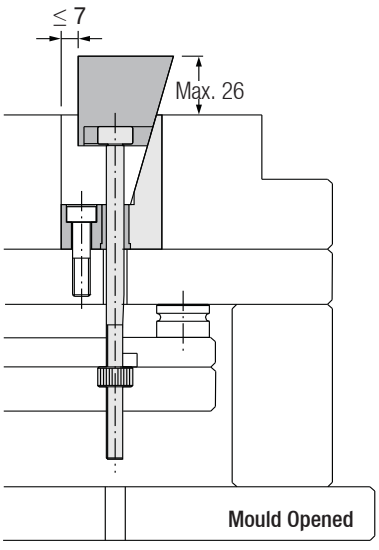


* **"PV"** must be ordered separately.
* When ordering, indicate the desired "L" dimension after the reference.

Code: EV

Order	F	G	H	L	
EV.006. (L)	6	12	6.5	150	225
EV.012. (L)	12	18	12.5	150	225

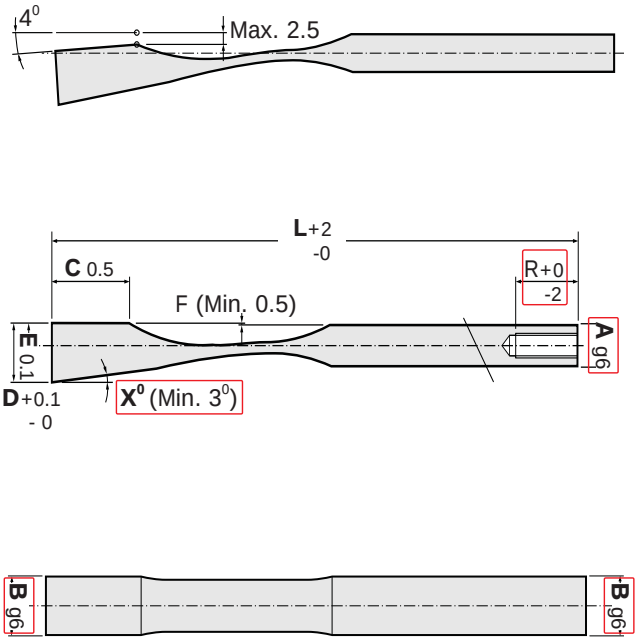




Custom-Made Sprung Cores

Special sprung cores to suit your dividual requirements.
If no other Cumsa undercuts product is compatible, this is your solution.
Delivery time from 6 to 8 weeks.
Different strokes and undercut dimensions are available.

Material: 1.8159 **Hardness:** 45 ± 3 HRC



The dimensions **A, R** and **X°** will be determined by Cumsa depending on the head dimensions required by the customer.

Custom-Made Sprung Cores

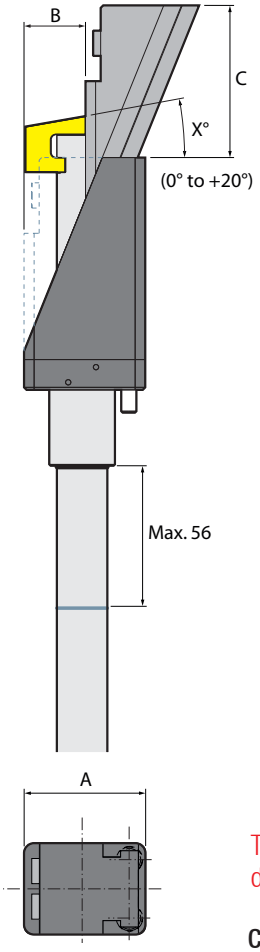
Order	B	C	D	E	F	L	Pcs.
Custom-made production							

Custom-Made Angular Dog Lifters

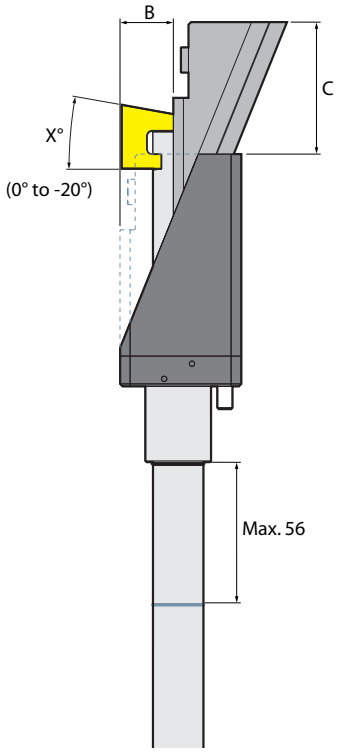
This unit allows to use the advantages of the DB reference in angled parts.
To order this part just fill the Ordering Table provided. Once we receive the required dimensions we will send to you a 3D file for your approval.

Material: 1.2311 Gas Nitrided ≈ 840Hv.

Positive Angle Version



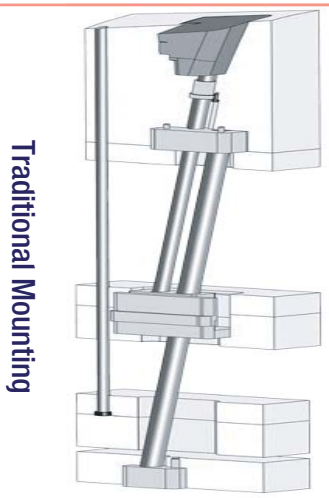
Negative Angle Version



The other dimensions will be determined by Cumsa.

Custom-Made Angular Dog Lifters

Order	A	B	+X°	-X°	Pcs.
Custom-made production	44				
	48				
	54				



Traditional Mounting

Single Ejector System

Automatic Dog Lifter

Code: DB

Designed to function with just one set of ejector plates, saving machining costs and reducing the size of the mould. Undercuts of up to 26mm with just 56mm stroke. This innovative system gives the capability of designing their own insert.

Material: PKT-117 **Hardness:** 42 ± 2 HRC.
Gas Nitrided ≈ 840Hv.

Dog Lifter Limiter

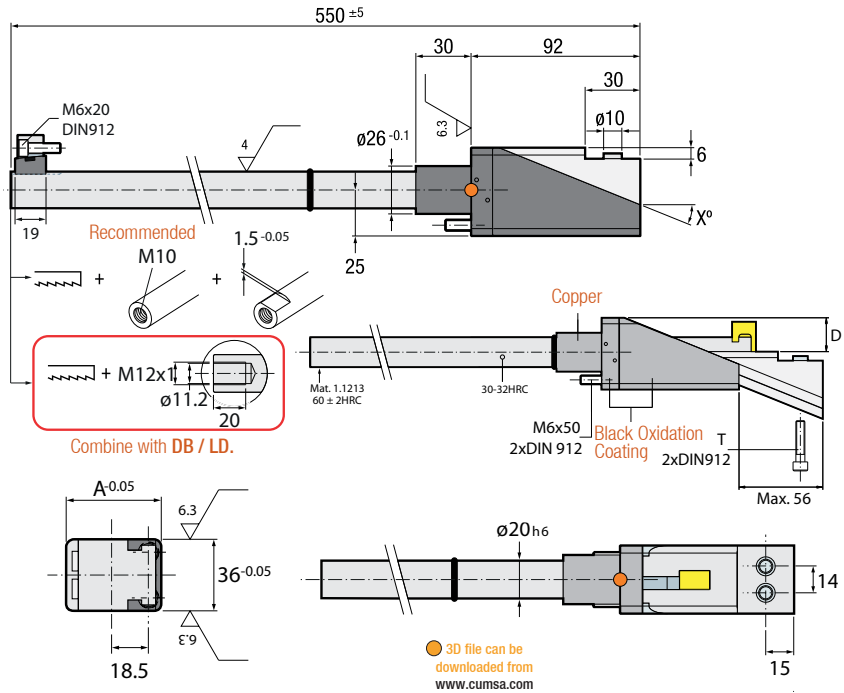
Code: LD

In single ejector plate systems.
Limits the stroke of a lifter with respect to the ejector stroke. Enables two stage ejection with only one ejector plate. All movements are 90° to the parting line.
Minimum space required for installation.

Material: 1.2311 Gas Nitrided ≈ 840Hv.

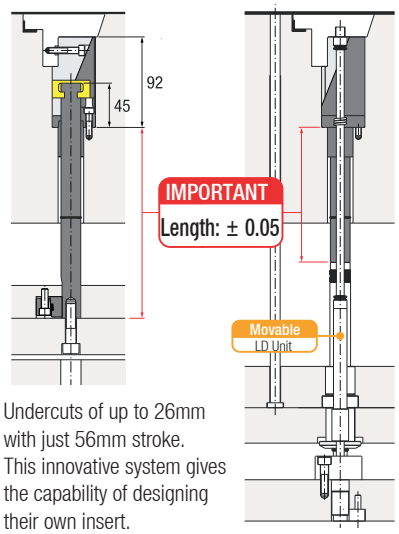
90° Machining and mould area

Dual Ejector System



Completed Mounting

Order	A	D	E	T	X
DB.482292	48	22	35	6x40	22
DB.542792	54	26	41	6x45	26



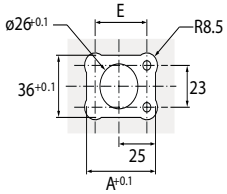
Undercuts of up to 26mm with just 56mm stroke. This innovative system gives the capability of designing their own insert.

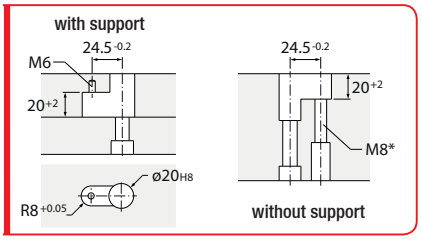
Order
LD.142130

"DB / LD" order should be given separately

Pocket Detail

Pls. machining as indicated.



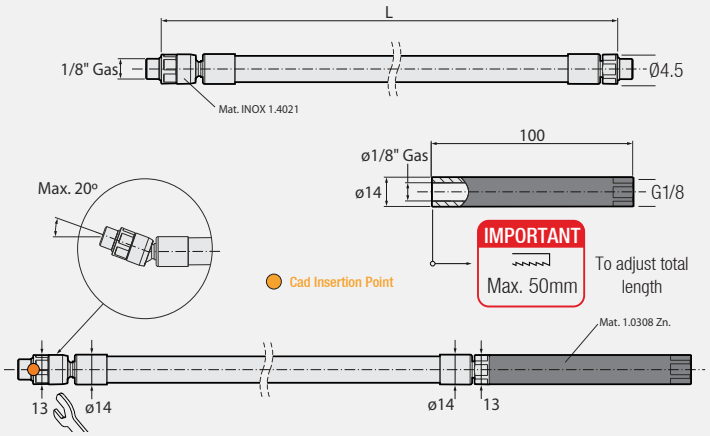


"DR" Cooling Hose

Code: DK

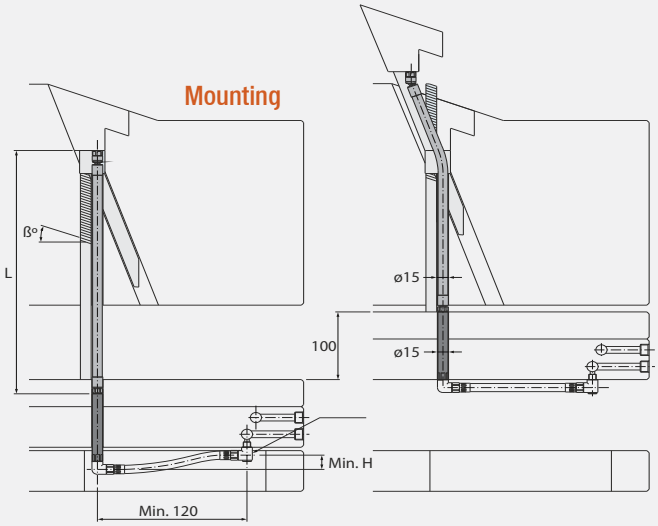
Cooling Hose for 90° "DR" Lifters.
The swivel coupling prevents the hose from bending excessively when demolding the undercut.

Maximum cooling fluid temperature 50°C.



Order	ß⁰	H			
		DR.xx-8	DR.xx12	DR.xx16	DR1.xx20
DK.141818	0⁰	10	10	10	10
	+1⁰ ~ +9⁰	10	10	10	15
	+10⁰ ~ +20⁰	10	15	20	25
	>+20⁰	15	20	25	30

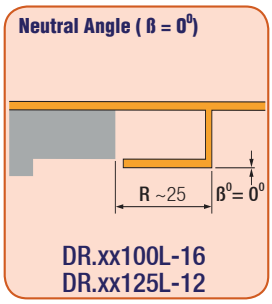
Mounting

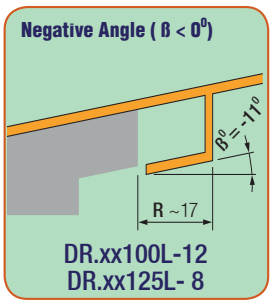


Important

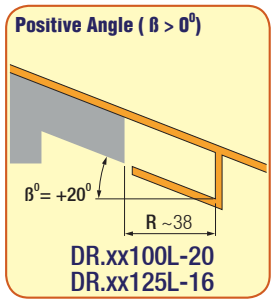
Please indicate the required L dimension when ordering; the length will be rounded up to the next multiple of 25mm.

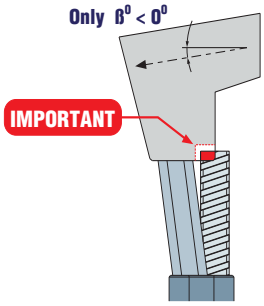
Double Rack Lifter (DR) Selection Table





Designed according to the colour system in the table!





ß⁰	DR.xx-100L - 8		DR.xx-100L-12		DR.xx-100L-16		DR.xx-100L-20	
	S (-ß⁰)	S (+ß⁰)	S (-ß⁰)	S (+ß⁰)	S (-ß⁰)	S (+ß⁰)	S (-ß⁰)	S (+ß⁰)
0	14.0		21.2		28.6		36.4	
1	14	14	21.1	21.3	28.5	28.8	36.1	36.6
2	13.9	14.1	21.1	21.4	28.3	28.9	25.9	36.8
3	13.9	14.1	21	21.5	28.2	29.1	35.7	37.1
4	13.9	14.1	20.9	21.5	28.1	29.2	35.4	37.3
5	13.8	14.2	20.8	21.6	27.9	29.4	35.2	37.5
6	13.8	14.2	20.7	21.7	27.8	29.5	35	37.8
7	13.8	14.3	20.7	21.8	27.7	29.7	34.8	38.1
8	13.7	14.3	20.6	21.9	27.5	29.8	34.6	38.3
9	13.7	14.3	20.5	22	27.4	30	34.4	38.6
10	13.7	14.4	20.4	22	27.2	30.2	34.2	38.8
11	13.6	14.4	20.4	22.1	27.1	30.3	33.9	39.1
12	13.6	14.4	20.3	22.2	27	30.5	33.7	39.4
13	13.6	14.5	20.2	22.3	26.8	30.7	33.5	39.7
14	13.5	14.5	20.1	22.4	26.7	30.8	33.3	40
15	13.5	14.6	20.1	22.5	26.6	31	33.1	40.3
16	13.5	14.6	20	22.6	26.5	31.2	32.9	40.6
17	13.4	14.6	19.9	22.7	26.3	31.4	32.7	40.9
18	13.4	14.7	19.8	22.8	26.2	31.6	32.5	41.2
19	13.4	14.7	19.8	22.9	26.1	31.8	32.3	41.6
20	13.3	14.8	19.7	23	25.9	32	32.1	41.9

Object Position / Mounting & Demounting Measurement Table:

Stroke	F	G	H	J	K	M	N	S	T	W	Y	Z
DR16	10	4.6	4.5	3	2.35	3	2.8	2.5	M5	6	9	M4
DR22	13	5.6	5.6	4.2	3.7	4.2	3.5	2.5	M6	8	12	M4
DR28	16	7.5	7.5	5	5.4	4.8	4.8	2.5	M8	8	13.5	M4
DR34	16	10.5	8	7	7	5	6	4	M8	8	16	M4
DR40	20	11	11	7	8	7	7	4	M10	10	20	M6
DR46	25	13	13	8	8	9	9	5	M12	10	24	M6

Locating and Rack Combination

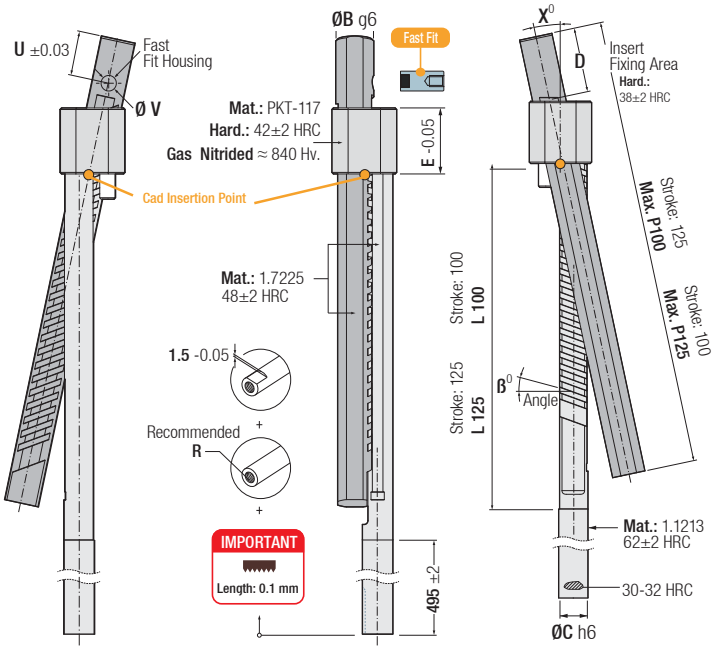
DR16 Stroke: 100
DR22 Stroke: 100 - 125
DR28 Stroke: 100 - 125
DR34 Stroke: 100 - 125
DR40 Stroke: 100 - 125
DR46 Stroke: 100 - 125

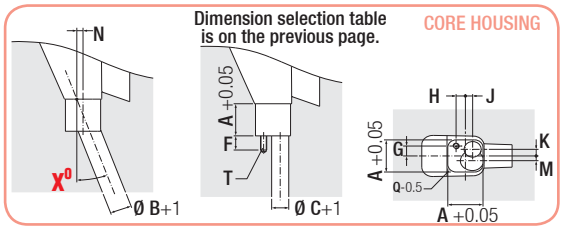
Double Rack Lifter System

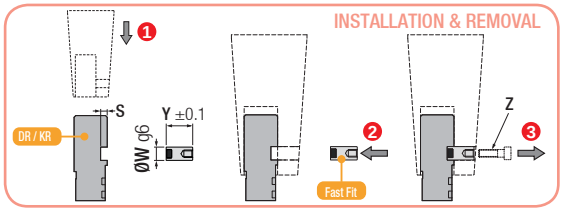
Code: DR

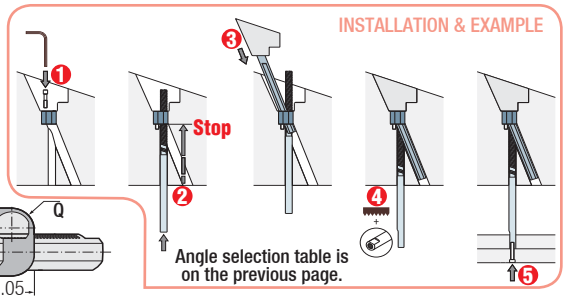
De-moulding strokes from 14mm to 60mm. Significant reduction to the ejection stroke.
"Mirror" parts available for 1+1 cavities moulds.
In Mounting: Fast delivery of the required draft. Vertical function maximizing strength. Complete flexibility for the moulding insert dimension. Eliminates the need for high-precision angled housings in the core plates. Smaller and less expensive injection machine required. Possibility to produce angles bigger than ±20º upon request.
Big savings in time & cost for machining and adjustments.

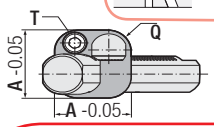
Stroke (Value): 14mm.
Undercut Width (Value): 70mm.
Ejection Stroke: 100mm.
Mechanism Type: Mechanical
Cooling Available: Yes
Max. Undercut Degrees: +35º
Min. Undercut Degrees: -55º



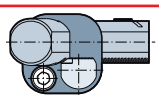








IMPORTANT
Mirror Part



"S" letter is added to the end of order code for Mirror Part.

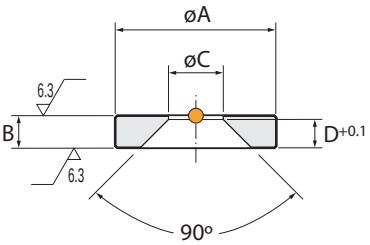
Order "Stroke 100"	Order "Stroke 125"	X⁰	A	B
DR16100L-X	-	8	16	9
DR22100L-X	DR22125L-X	12	22	12
DR28100L-X	DR28125L-X	16	28	16
DR34100L-X	DR34125L-X	20	34	20
DR40100L-X	DR40125L-X		40	22
DR46100L-X	DR46125L-X		46	24

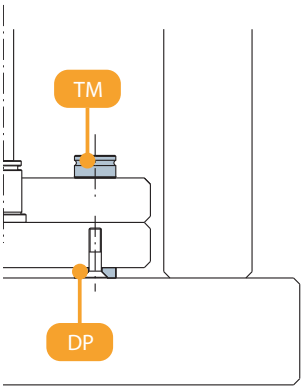
C	D	E	L100	P100	L125	P125	Q	R	T	U	V	Order: Stroke 100 - S	Order: Stroke 125 - S
8	20	20	142	178	-	-	4	M4	M5	10	6	DR16100L-X-S	-
12	30	22	148	202	202	261	6.5	M6	M6	17	8	DR22100L-X-S	DR22125L-X-S
14	36	28	152.5	214	194.5	266	8.5	M8	M8	23	8	DR28100L-X-S	DR28125L-X-S
16	36	34	160.5	227	188.5	264	10.5	M10	M8	23	8	DR34100L-X-S	DR34125L-X-S
20	36	40	170	244	204	284	10.5	M12	M10	20	10	DR40100L-X-S	DR40125L-X-S
24	42	46	175	258	201	289	10.5	M16	M12	26	10	DR46100L-X-S	DR46125L-X-S

IMPORTANT!
When ordering, replace the x in the reference with the required X° dimension (8°, 12°, 16° or 20°) and indicate the required ß°.

Ejector Foot

Code: DP



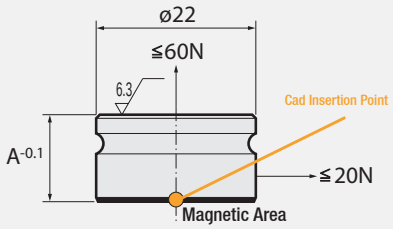


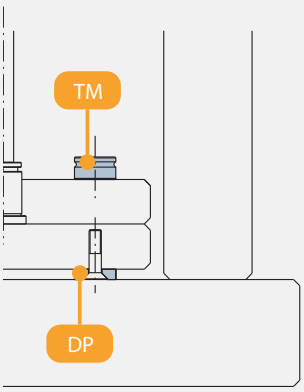
This unit is fixed through both ejector plates in conjunction with the spacer discs to provide support to the plates. These are fixed to the ejector plates so eliminating machining in the back plates.
Easy installation by using just one screw.

Order	A	B	C	D
DP.200506	20	5	6.5	3.5
DP.250508	25	5	8.5	4.4
DP.280610	28	6	12	5.5

Magnetic Safety Stopper

Code: TM



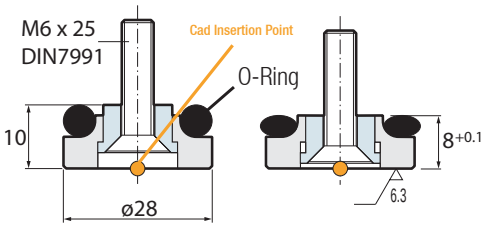


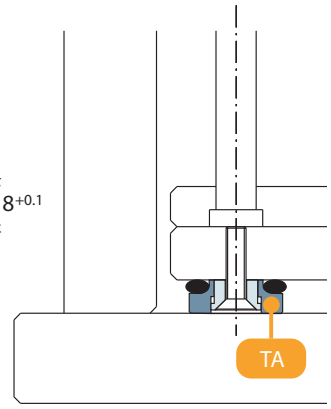
This is a safety stop to prevent the actuation of the ejector bases.
It can be easily removed to release the grip on the pins when required.

Order	A
TM.102214	10
TM.122214	12.5
TM.152214	15
TM.202214	20

Shock Absorber Disc

Code: TA





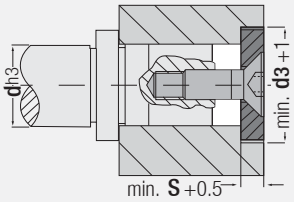
Used to minimize the vibrations caused by the ejector plates returning to position. The main advantage is the increase in the life of parts within the ejector frame through the reduction of damage and wear.

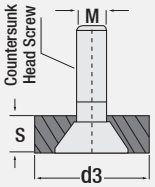
Order: TA.280806

Mounting Flange

Code: G110

Support washer & Guide pillar fixation





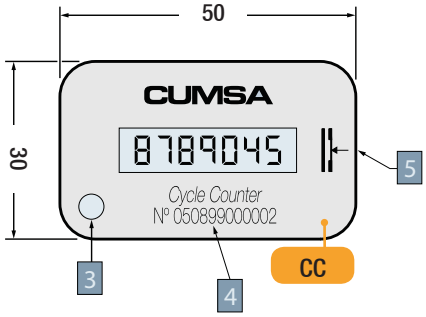
Order: G110 x d3

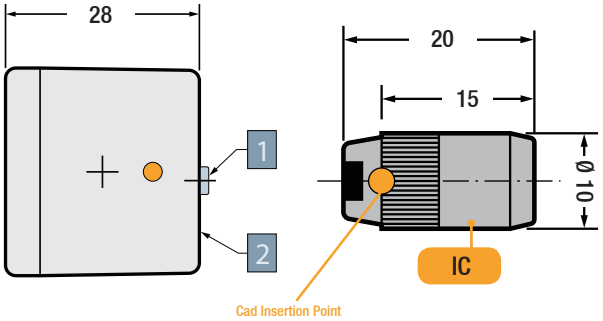
Usage: Support washer (Mould)
Guide pillar fixation (Die)

★ It can also be used to support for ejector plates in injection moulds / etc.

★ Reliable product used for guide pillar with centre collar mountings min. d3 + 1

Ø d3	Pillar Diameter d	Flange S	Screw M
22	Ø 15 / 16	5.5 mm	M8 x 20
25	Ø 19 / 20		
32	Ø 24 / 25		
40	Ø 32 / 30	7.5	
50	Ø 38 / 40	9.5 mm	
60	Ø 48 / 50		
73	Ø 60 / 63		
93	Ø 80	12	M12 x 20





High Speed Cycle Counter

Code: CC

The Counter is expected to last 3 to 5 years, if it worked 24hour 7day / 12 month. The Counter battery starts working when it is installed in the mould. When the Counter is removed from its placement, a capital "E" (error) is shown on the screen, which you cannot delete.
This mechanism only activates after the first 25 consecutive shots.
In case you want to know the injected pieces during mould testing, you can install the Counter and remove it with tape before the 25th shot, then the Counter will go back to 0. As it has 7 numbers, it can count up to 9.999.999 parts.

To check exact total life time of the mould. To ensure that how many shots a determined mould made when our sourced. To predict preventive maintenance. Available with partial reset. The unique part nº for each counter gives a guarantee to the mould makers and a planning aid for maintenance to the mould makers. Any tampering with the unit is shown in the screen.

This unit contains an electronic circuit which counts the number of cycles made by the mould.

Mounting Instructions:

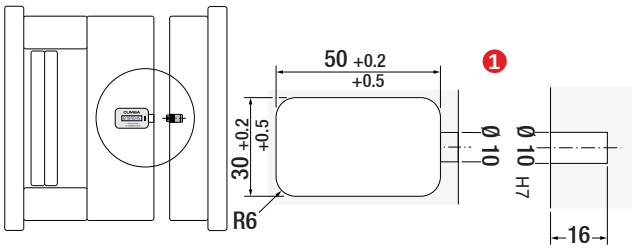
1 - Please machine housing in a way that as determined in technical drawing.
2 - Please hammer Counter Pin **(IC)** of Counter to housing with bronze hammer.
3 - Please insert Counter unit **(CC)** its housing.

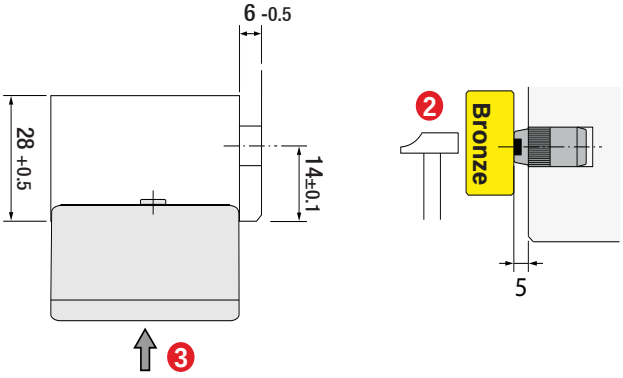
Working Temperature:

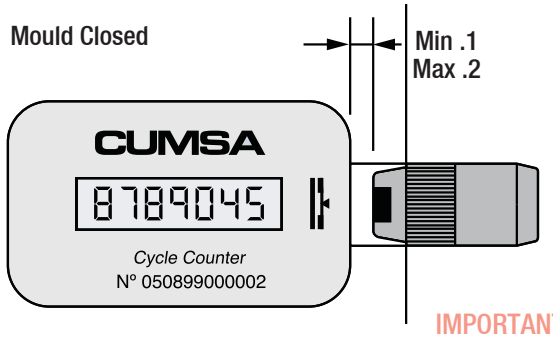
We recommend the Cycle Counter be placed at zones under 60 °C (140°F).

1 Security Switch
2 Magnetic Fixing
3 Total + Partial (Reset & Setting Up)
4 Unique Part Number
5 IC Position Indicator

Order	Reset & Setting Up	Cycles / Min.
CC.HS5328	Suitable	Up to 500



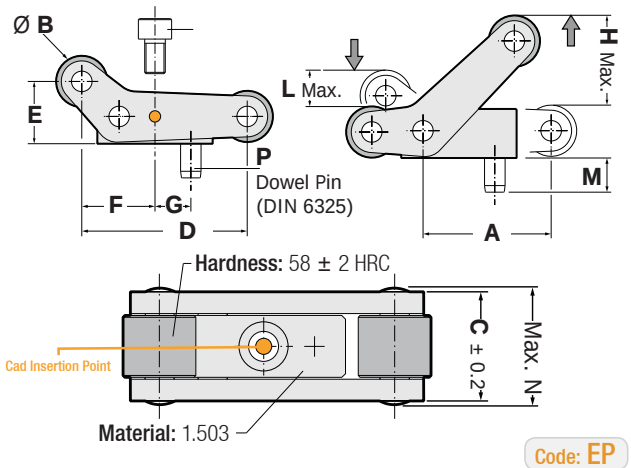




Ejector Plate Accelerator

Code: EP

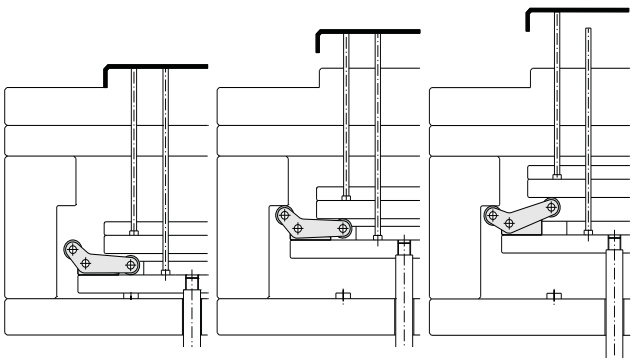
This item allows increased movement of a second ejector plate within a normal ejector stroke. Simple mechanical double ejection system.
Minimum space required for installation.
Avoids complex systems like others currently available in the market.
In small and medium moulds with standard ejectors, 1 piece is sufficient.
In more larger moulds and systematic moulds according to their configurations, dual Ejector Plate Accelerator can be used.
In a symmetric manner, generally 4 pieces.



Code: EP

Order	A	B	C	D	E	F	G
EP.200813	20	8	13.2	25.8	9.4	11.4	6
EP.251016	25	10	16	32.3	11.8	14.3	7
EP.371522	37.5	15	22	48.5	17.7	21.5	10.5
EP.502030	50	20	30	64.6	23.6	28.6	14

H Max.	L Max.	M	N	Ø P	T	Max. Force
11.6	4.4	5	15	2.5 x10	M3 x12	125 Kg.
15	5.7	6	18.5	3 x12	M4 x16	250 Kg.
23.5	9.1	8	25	4 x16	M6 x25	350 Kg.
32	12.5	10	34	5 x20	M8 x30	800 Kg.

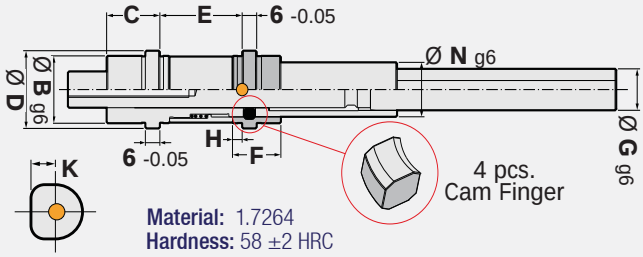


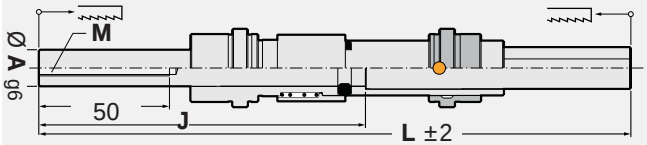
NOTE: It is recommended two piece to be used reciprocatively in ejector system in mould applications.

Superior Double Ejector

Code: DX

The rear plates stop and the upper plates continue for the full ejection stroke. Thanks to the assembly of the units away from the center of mold but within the ejector frame the space required for installation is drastically reduced leaving more space for other mechanisms. Also works as the ejector guide pins and bushes, having the possibility of eliminating the need to install extra items.
Maximum working temperature 150°C.

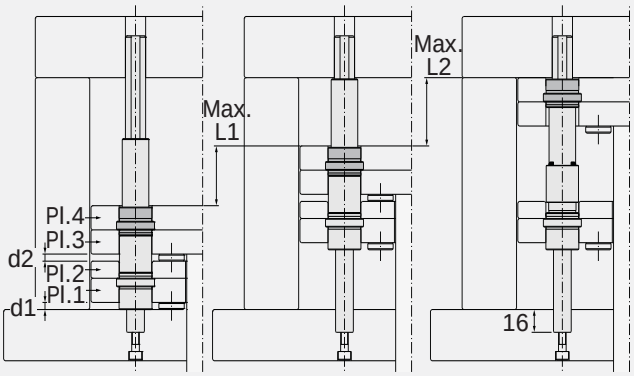




Code: DX

Order	A	B	C	D	E	F	G	H
DX.142622	14	26	22	30	34	20	16	4
DX.163027	16	30	27	34	44	23	18	6

J	K	L	M	N	L1	L2
125	7.2	243	M6	21	42	48
152	8	314	M8	24	54	80



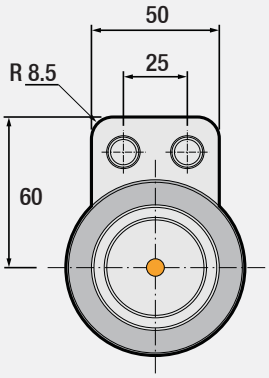
Standard Ejector Plate Combination

Size mm	DX.142622			
	1	2	3	4
d1	5	5	5	5
Pl.1	17	17	17	17
Pl.2	9	12	12	12
d2	13	10	5	5
Pl.3	12	12	17	17
Pl.4	9	9	9	12

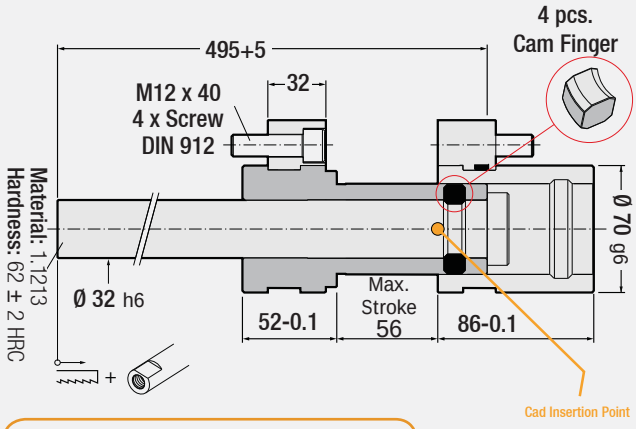
Size mm	DX.163027								
	1	2	3	4	5	6	7	8	9
d1	5	5	5	5	0	0	0	0	0
Pl.1	22	22	22	22	27	27	27	27	27
Pl.2	12	12	17	17	17	17	17	22	22
d2	5	5	5	5	5	5	10	0	0
Pl.3	27	27	22	22	22	22	17	22	22
Pl.4	17	22	12	17	12	17	12	12	17

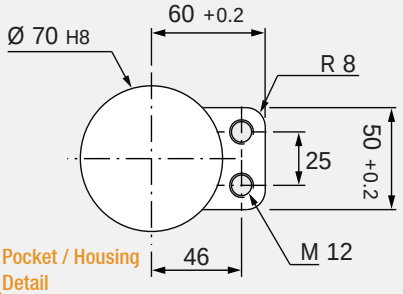
Compact Double Ejection

Code: SY



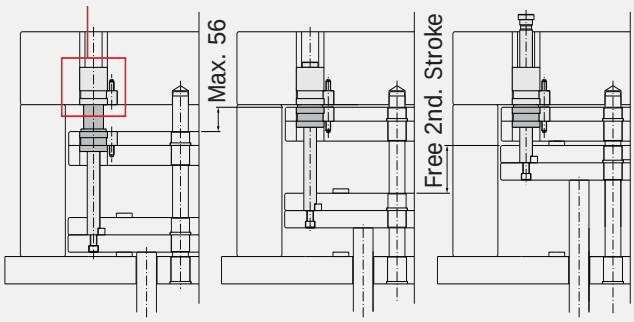
Developed for medium / large moulds.
The upper ejector plate stops when reaching the core plate, and the rear plate continues until it reaches the upper plate. As the assembly of the units is not in the center of the mold, but within the ejector frame, the space required for installation is drastically reduced.
Double ejection up to 56mm.

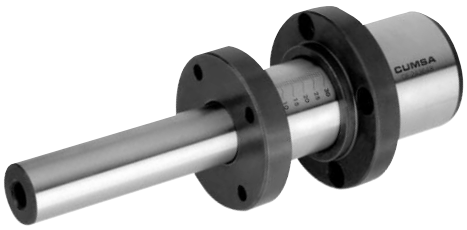




Material: 1.7242
Hardness: 56 ± 2 HRC
Patented System

Order: SY.327054



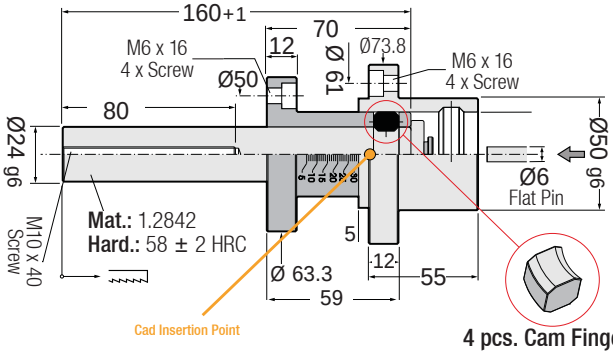


Two-Stage Ejector System

Code: DE

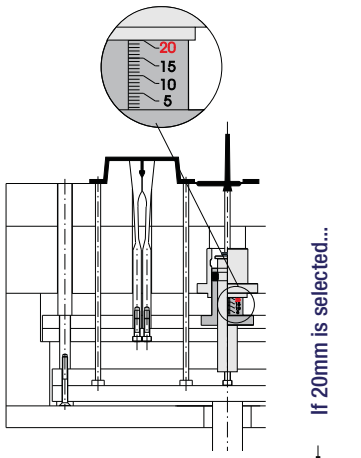
This unit divides the ejection travel in two predefined steps.
Useful to obtain automatic ejector strokes in moulds with sprung cores and collapsible cores units. Only round pockets needed to install the part.
Double ejector stroke up to 30mm.

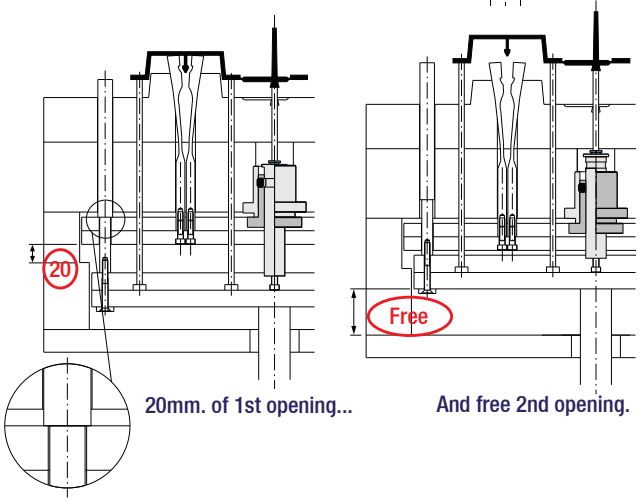
Material: 1.7243 **Hardness:** 58 ± 2 HRC



IMPORTANT!
To determine assembly dimensions, use the scale from 0 to 30mm, to select the first stroke.

Order: DE.243648



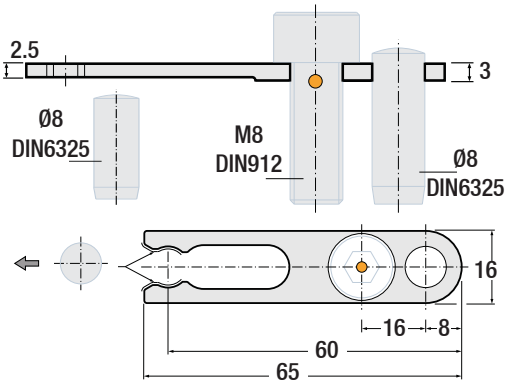


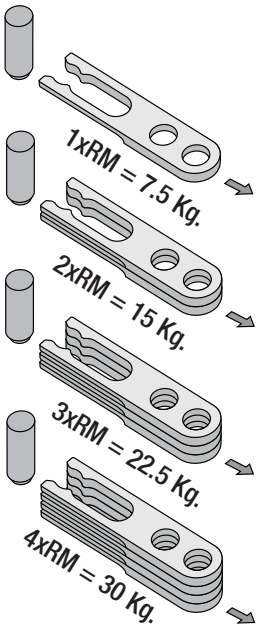
Modular Retainer

Code: RM

Useful for moulds that require delayed opening of parting line. Resistance can be increased by adding clips. No pocket machining required as needed with other similar products on the market. Minimum space required for installation. Reduces costs compared to conventional mechanisms. 4 pieces can be used on same surface max. The system should be distributed to different areas if the more use is needed.

Material: 1.8159 **Hardness:** 45±3 HRC
Max. working temperature: 150°.

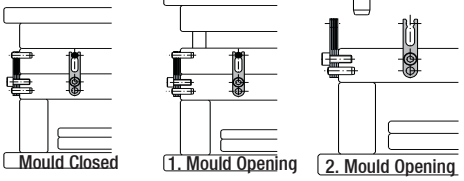




IMPORTANT!
The values displayed on the image are approximate values and they are used with 1-2-3-4 groups. Modular Retainer groups should be created in different regions / directions of the mould for more loadings.

Fasteners:
Screw and pin should be procured separately.

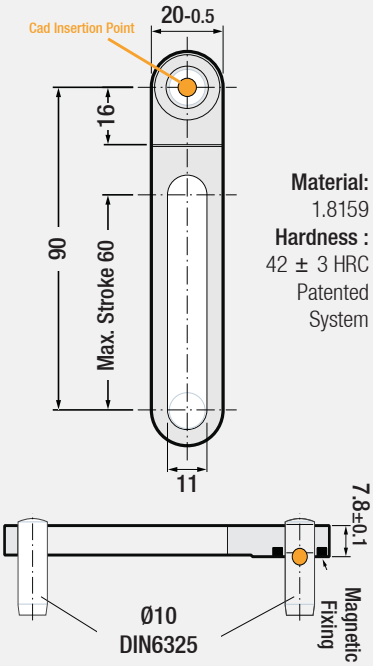
Order:
RM.651608
(1 pcs.)



Stroke Limiter

Code: SL

Stroke mechanical limiter for PR - Plate Retainer. When PR coded product is used dual opening systems with stripper limit stroke of bearing plate which is opened first in 1st group. Possibility to reduce the max. opening - 60mm. Then 2nd group's opening is engaged.



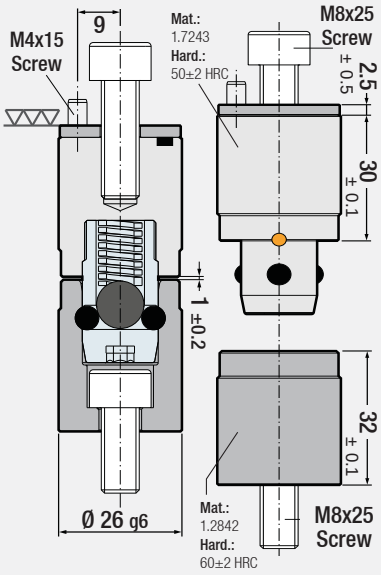
Material:
1.8159
Hardness :
42 ± 3 HRC
Patented
System

Order:
SL.602008

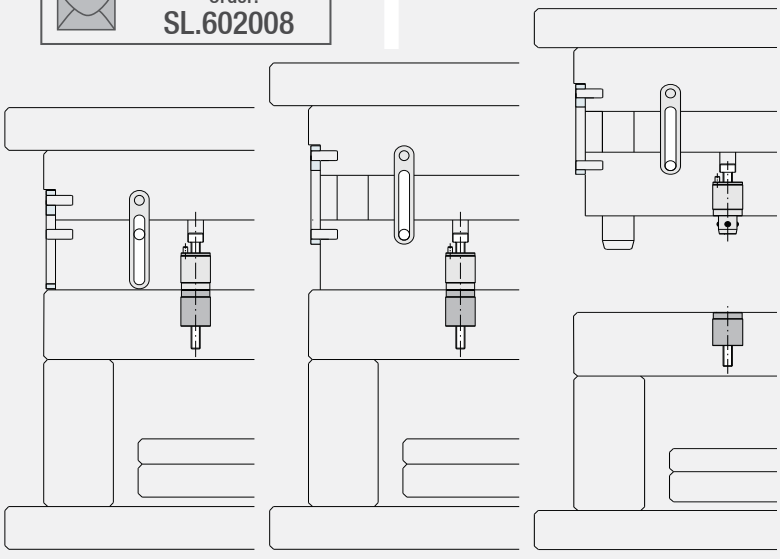
Plate Retainer

Code: PR

PR - Guarantees that the second opening stays closed until the first is completely open. 50 Kg. opening load required per unit (Minimum of 2 parts required).
Possibility to change inner spring from the parting line. Also protects mould affecting from vibrations and impacts by reducing speed tension and absorbing pinking during opening. The most important advantage of it is to extent life time of mould parts.



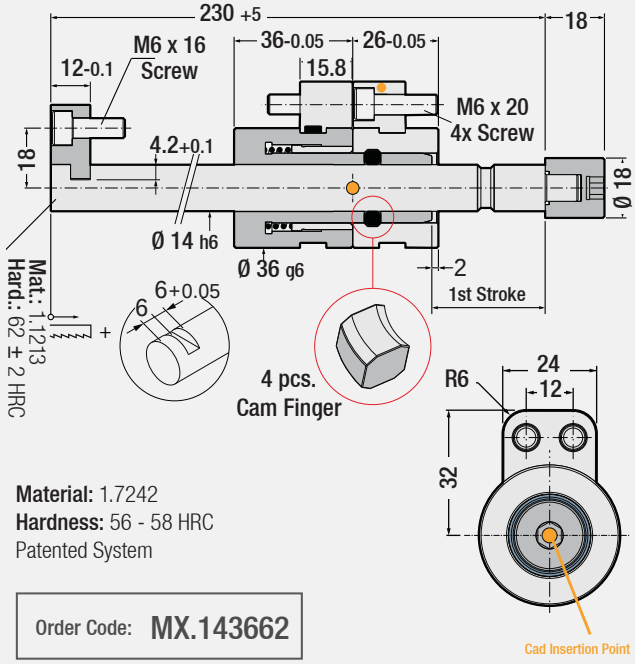
Order:
PR.263230



Internal Latch Lock

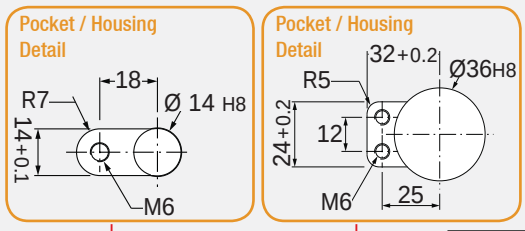
Code: MX

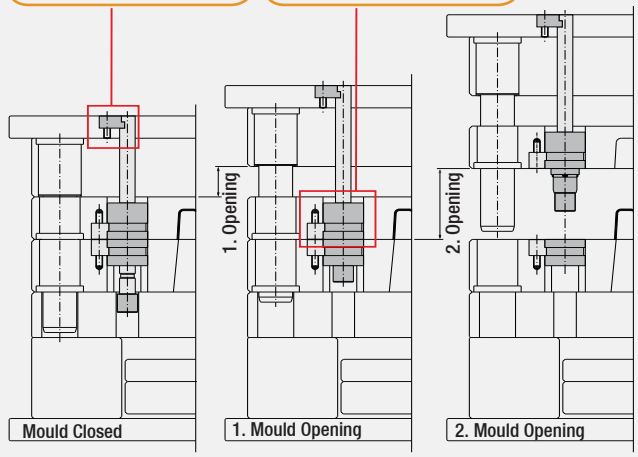
Controls two stage opening of the tool. Internal mechanism. Reduced space required for installation. Developed for small / medium tools.
Can also be used to control two sets of ejection plates for two stage ejection.

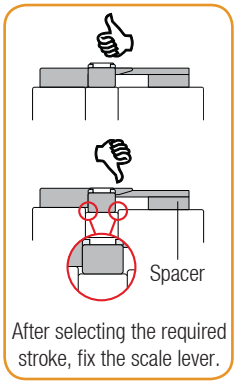


Material: 1.7242
Hardness: 56 - 58 HRC
Patented System

Order Code: **MX.143662**







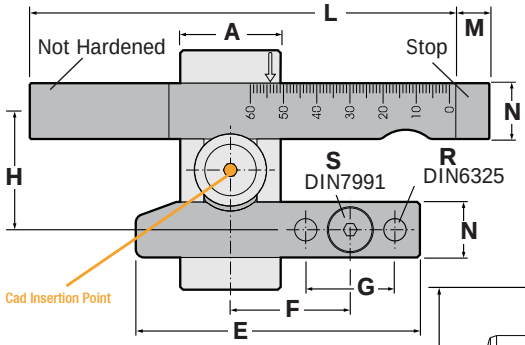
After selecting the required stroke, fix the scale lever.

Latch Lock

Code: GS

Designed for two steps opening moulds. The gradual scale allows selection of the first opening. The priority of opening depends on position of assembly.
More accurate first plate opening compared to other conventional systems.
Scale lever indicates opening of the first plate. Reduces costs compared to conventional mechanisms.

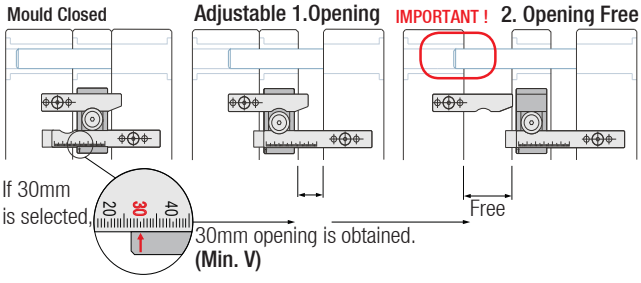
Material: 1.2842 **Hardness:** 55 ± 3 HRC (friction area) Patented System



GS.226616 can be used up to 500 x 500mm in moulds with 3-plate,
GS.368619 can be used up to 800 x 800mm in moulds with 3-plate.
GS.421024 can be used up to 1000 x 1000mm in moulds with 3-plate.
Recommends using 4 units in each mould, which are evenly spaced and symmetrical.

Order	A	B	C	D	E	F	G	H	L
GS.226616	22	66	16	38	75	30	25	32	105
GS.368619	36	86	19	46	102	43	32	42.7	153
GS.421024	42	106	24	56	124	51	40	50.2	190

M	N	P (x2)	R (x4)	S (x2)	T	V	Scale
10	15	6x20	6x30	M6x30	M6x35	10	40
12	20	8x24	8x36	M8x35	M8x40	11.5	60
15	24.5	10x30	10x40	M10x40	10x45	14	80

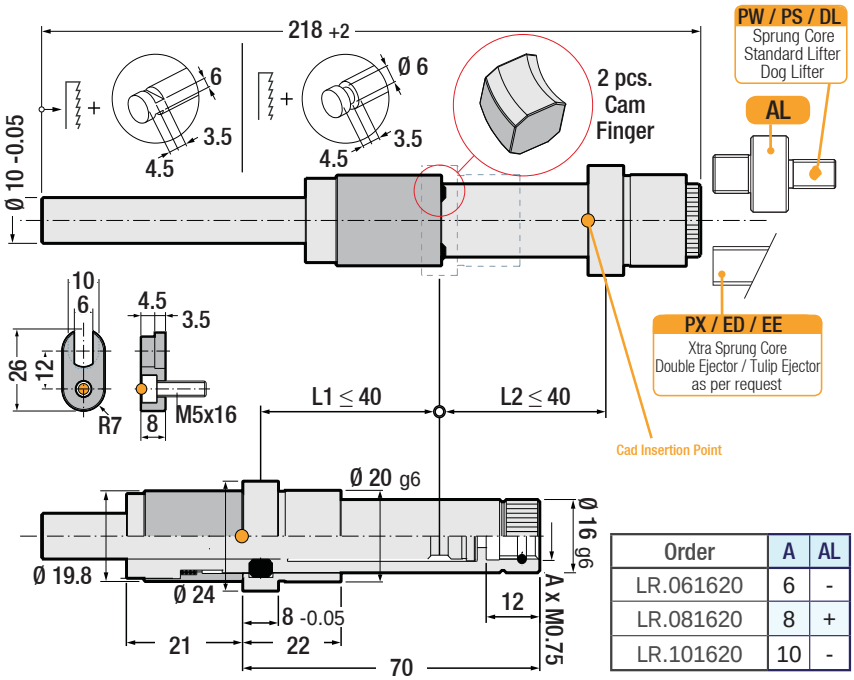


Threaded Limiter

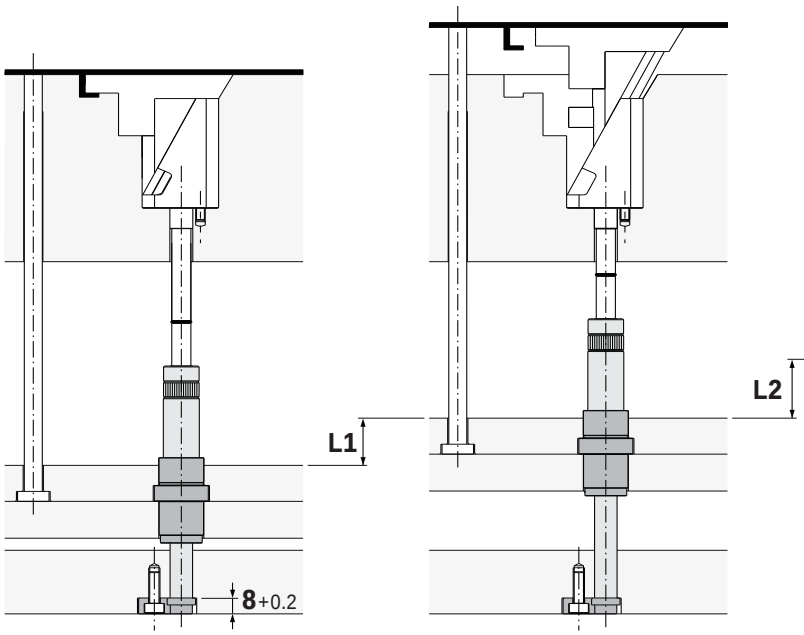
Code: LR

Threaded Limiter **(LR)** is mounted and fixed to mould rear mounting / bearing plate (H5 A).
Movable bush part of the unit is inserted into the ejector plates.
Limits the stroke of a threaded lifter with respect to the ejector stroke.
Enables two stage ejection with only one ejector plate. All movements are 90° to the parting line.

Material: 1.7243 **Hardness:** 58±2 HRC **Max. working temperature:** 150°



Order	A	AL
LR.061620	6	-
LR.081620	8	+
LR.101620	10	-



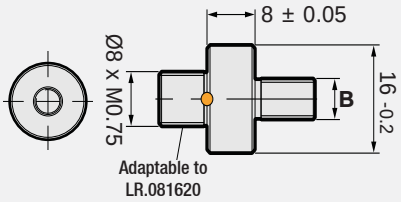
Code: AL

Threaded Limiter Adapter

Allows the use of the **LR** for internal threads.
It is a dual different threaded adapter providing positioning of **LR**.

In Addition:
Fine tread part of **AL** also can be used as joint adapter for **PW** - Sprung Cores & **PS** - Standard Lifters.

Material: 1.5065



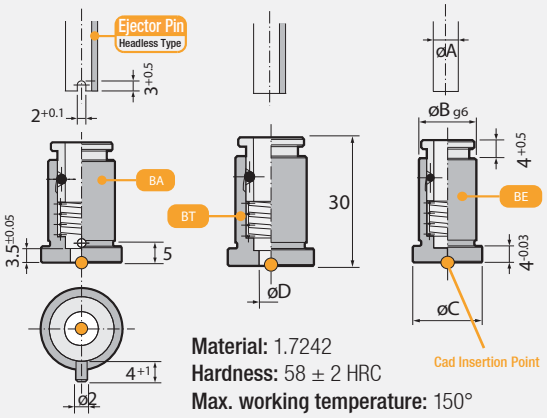
Code: AL

Order	B
AL.0800M4	M4 x 10
AL.0800M5	M5 x 10
AL.0800M6	M6 x 10
AL.0800M8	M8 x 10

Code: BA Code: BT Code: BE

Ejector Pin Base (for headless ejector pins)

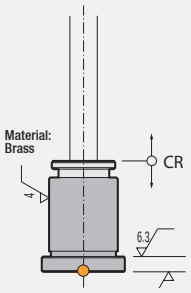
The ejector base unit is an automatic unit which holds the ejector pin in position until the top is actuated. The pins can be taken out from the front of the tool. Enables quick replacement of ejectors, ejector sleeve and moulding inserts without taking the mould from the press. There is no requirement for strip down when repair or maintenance is needed.



Material: 1.7242
Hardness: 58 ± 2 HRC
Max. working temperature: 150°
Ejector Pin Bases: It is only used for headless ejectors.

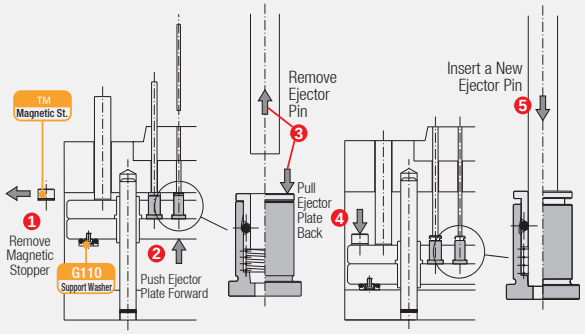
Code: BE

Order	A	B	C	CR(N)
BE.031115	3	11	15	≥ 2550
BE.041216	4	12	16	≥ 2550
BE.051317	5	13	17	≥ 3800



Code: BA Code: BT

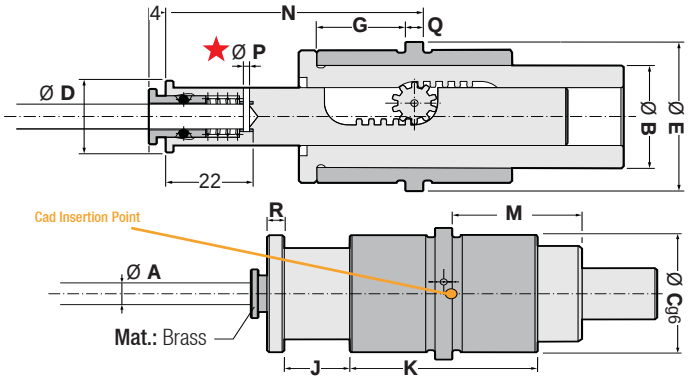
Order		A	B	C	D	
					BA	BT
BA.061418	BT.061418	6	14	18	3.5	4.2
BA.081620	BT.081620	8	16	20	5.5	6.2
BA.101822	BT.101822	10	18	22	7	7
BA.122024	BT.122024	12	20	24	9	9



Accelerated Ejector Code: AE

Allows to increase the stroke of selected ejectors within the tool. It is easy to install due to its cylindrical shape and possible to automate conventional tools Enables 8mm. / 15mm. / 20 mm. additional stroke on one ejector pin. Only round pockets needed to install the part. Possible to key. Enables quick replacement of the ejector pin.

Material: 1.7225
Hardness: 54 ± 2 HRC
Max. working temperature: 150°
Patented System

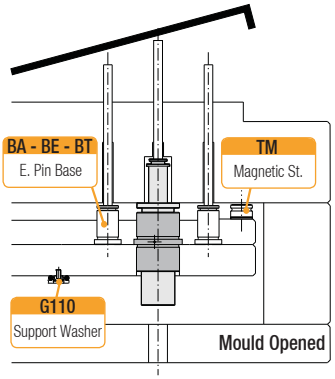


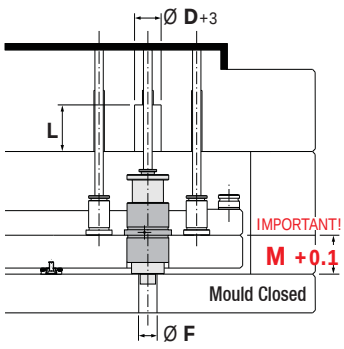
Order	A	B	C	D	E	F	G
AE.031620	3	16	20	12.5	22	13	14
AE.041620	4	16	20	12.5	22	13	14
AE.052430	5	24	30	16	34	16	20
AE.062430	6	24	30	16	34	16	20
AE.082430	8	24	30	17	34	17	20
AE.103036	10	30	36	21.5	40	21	28
AE.123036	12	30	36	21.5	40	21	28

J	K	L	M	N	P	Q	R
8	32	22	17	37	-	4	3
8	32	22	17	37	-	4	3
15	44	36	27	57	2	4	3
15	44	36	27	57	2	4	3
15	44	36	27	57	2	4	3
20	62	46	34	78	2	6	4
20	62	46	34	78	2	6	4

When the internal bushing of this piece gets in contact with the plate, the mechanism starts working. From that point, the ejector of the **AE** goes at double stroke.
The extra strokes of units:
- 8mm (0.315") of extra stroke, with the **AE031620** and **AE041620**.
- 15mm (0.591") of extra stroke, with the **AE052430**, **AE062430** and **AE082430**.
- 20mm (0.787") of extra stroke, with the **AE103036** and **AE123036**.

★ Possibility to key for using a curved ejector pin. (except AE.031620 & AE.041620)



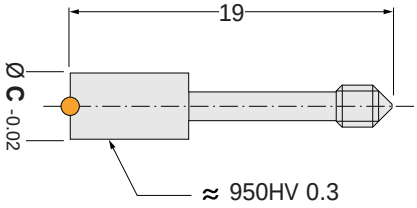


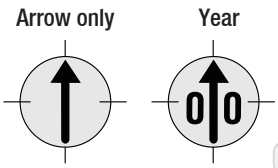
Code: IT

High Temperature Insert for Date Stamp

Due to fact that the insert is adjustable / removable from the front of the mould, there is no need to remove the tool from the machine or disassemble the mould.

Material: 1.2344 Nitrided



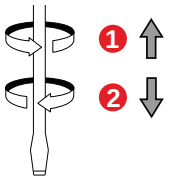


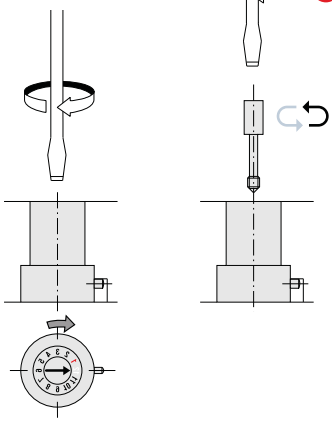
Code: IT

Order Arrow only	Order Year	C
IT.4719SF	IT.4719 ..	4.7
IT.6719SF	IT.6719 ..	6.7

*** Please indicate the desired year after the code.**

IMPORTANT!
When replacing the insert, be sure to tighten until hearing the engagement "click".



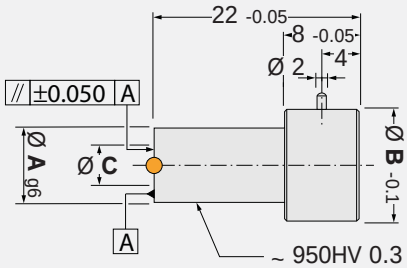


Code: FT

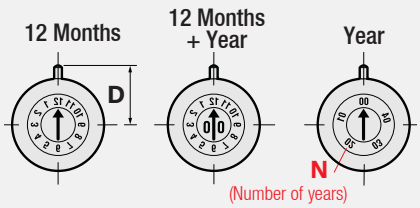
High Temperature Date Stamp

High temperature date stamp. Designed for injection mold tools which operate in high temperature environments,
like: Zamak, Zinc, Polyester, Bakelite, etc..
Possibilty to change annual insert.

Material: 1.2344 Nitrided + Inconel 2.4669
Max. working temperature: 450°



Possibilty to change annual insert.



Code: FT

Order 12 Months	A	B	C	D	N
FT. 0847SF	8	12	4.7	11	5
FT. 1267SF	12	16	6.7	12	8

Order 12 Months + Year	A	B	C	D	N
FT. 084712	8	12	4.7	11	5
FT. 126712	12	16	6.7	12	8

Order Year	A	B	C	D	N
FT. 084705	8	12	4.7	11	5
FT. 126708	12	16	6.7	12	8

*** Please indicate the desired year after the code.**

The depth is the engraving on the "FT" Date Stamp:

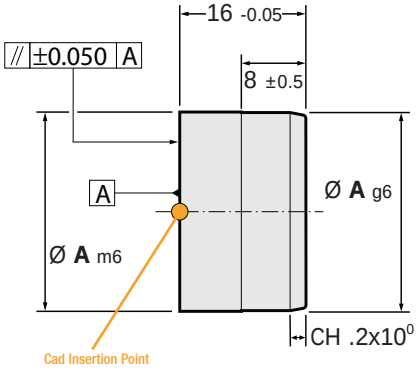
FT.08 (Year) : 0.15-0.25mm
FT.08 (Arrow) : 0.40-0.50mm
FT.12 (Year) : 0.15-0.25mm
FT.12 (Arrow) : 0.50-0.60mm

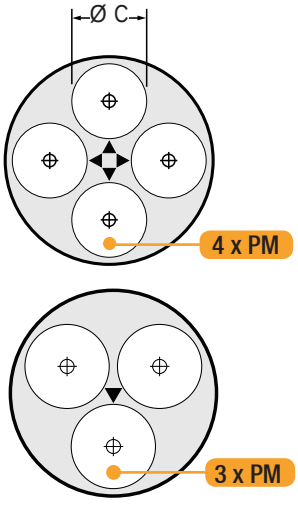
Block Base Insert

Code: BM

Wide range of diameters. Possibility of 3 or 4 information's. Only a H7 pocket required for assembly. No downtime when changing inserts. Guarantee that the insert will be replaced due to internal mechanism.

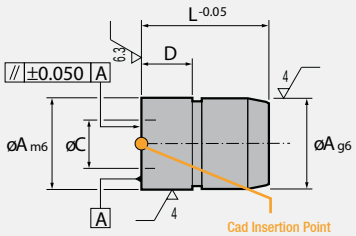
Material: INOX 1.4034
Hardness: 51 ± 3 HRC
Max. working temperature: 150°





Code: BM

Order	A	C	E	#PM
BM.160603	16	6.5	8	3
BM.180604	18	6.5	8	4
BM.220903	22	8.7	10	3
BM.250904	25	8.7	10	4
BM.281103	28	11.5	12	3
BM.321104	32	11.5	12	4



Date Stamp Plus

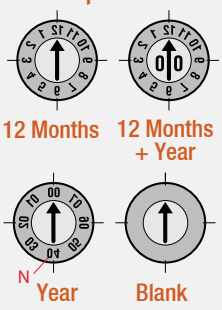
Code: FP..

Possibility for cooling circuits below the date stamp as they are removed from the front (**with the EF**). Inner insert is always at the same level as the body of the date stamp. Exact outer number positioning. Ideal clamping area.

Material: INOX 1.4034 **Hardness:** 51 ± 3 HRC
Max. working temp.: 150°

A	C	D	L	N
4.0	2.2	5.5	12	4
5.0	3.0	5.5	12	4
6.0	3.2	8.0	20	5
8.0	4.7	8.0	20	5
10	5.7	8.0	20	6
12	6.7	8.0	20	8
16	8.7	8.0	20	10
20	10.7	8.0	20	10

Options:



Order:
FP. (options) x A

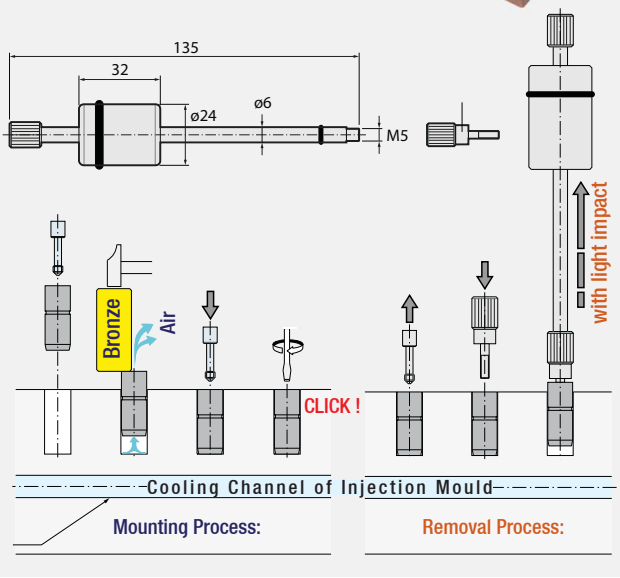
Removal Jig Set

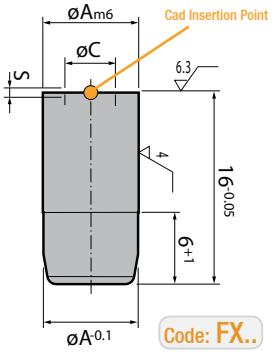
Code: EF

Removal Jig Set for the Date Stamps Plus. The set includes 8 parts, one for each **FP** diameter.

Material: INOX 1.4034
Hardness: 51 ± 3 HRC

Order:
EF. 322405-SET





Xtra Date Stamp

Code: FX..

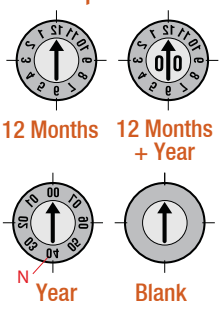
This is a permanent date stamp where only the central year insert is changed. The month is changed by using a screwdriver.
Completely stainless. Only a H7 pocket required for assembly.

Material: INOX 1.4034 **Hardness:** 51 ± 3 HRC
Max. working temp.: 100°

A	C	E	N	S
6.0	3.2	4	5	0.25
8.0	4.7	6	5	0.25
10	5.7	8	6	0.35
12	6.7	10	8	0.35

Order: FX. (options) x A

Options:

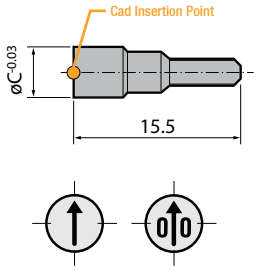


Xtra Insert for Date Stamp

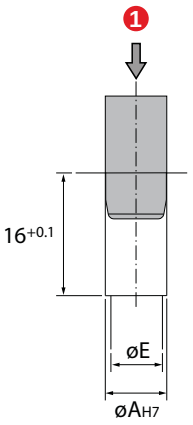
Code: IX..

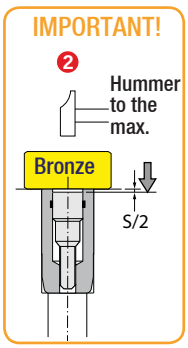
Due to fact that the insert is adjustable / removable from the front of the mold, there is no need to remove the tool from the machine or disassemble the mould.

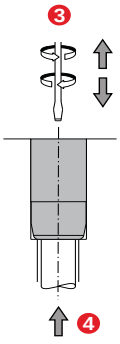
Material: INOX 1.4034
Hardness: 51 ± 3 HRC

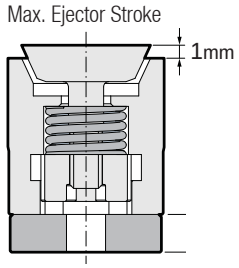


Order		C
Arrow Only	Year	
IX.3215SF	IX.3215 ..	3.2
IX.4715SF	IX.4715 ..	4.7
IX.5715SF	IX.5715 ..	5.7
IX.6715SF	IX.6715 ..	6.7







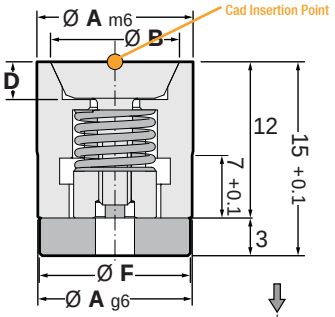


Air Valve for High Pressure

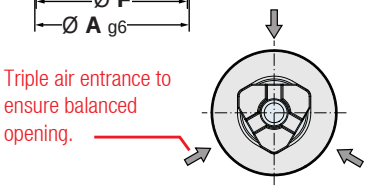
Code: VH

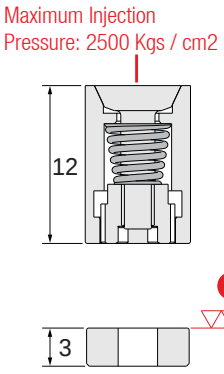
Developed for high injection pressures and high speed cycles. Incorporates an internal stopper to sustain injection loads, preventing the system to block. Keyed unit to allow the installation in angled or shaped surfaces. Easy installation thanks to its adjusting ring, as well as allowing uninstallation if needed.

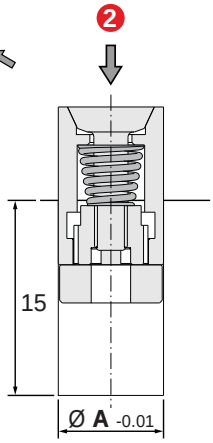
Material: INOX 1.4034
Hardness: 51 ± 3 HRC
Max. working temp.: 150°
Working pressure: 2-10 Bar
1 Bar ≃ 1 Kg. / cm²

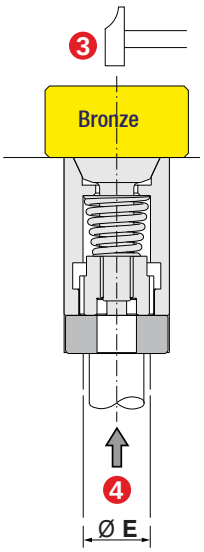


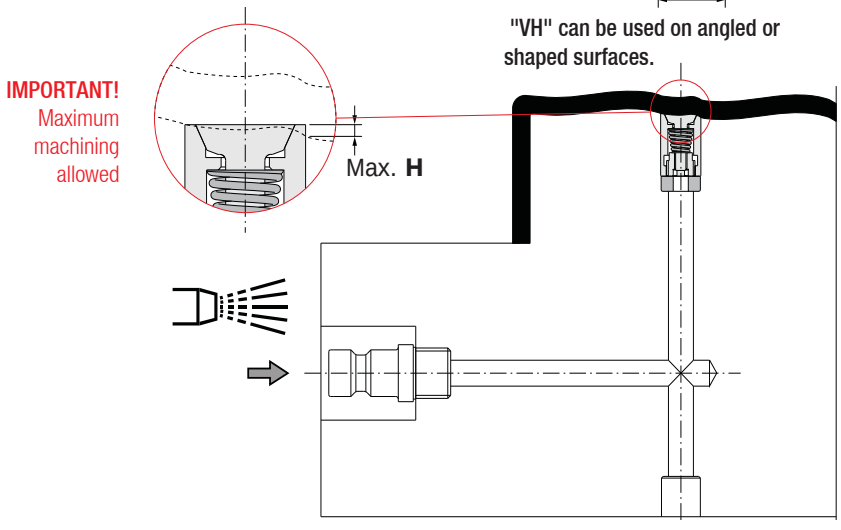
Order	A	B	D	E	F	H
VH.065215	6	5.3	1.9	4	5.8	0.25
VH.086515	8	6.7	2.1	5	7.8	0.75
VH.121015	12	9.8	2.9	5	11.8	1.0











Air Poppet Valve

Code: VA

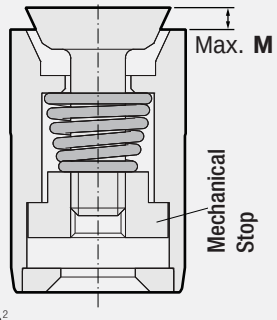
Manufactured completely from stainless steel this unit has the advantage of high airflow.
Helps part ejection with air. Recommended working under 150°C (302°F). Above that temperature, steel starts dilatation, so the resort introduced on the Air Valve would lose efficiency. If so, the plastic material could go in and the Air Valve would be damaged.

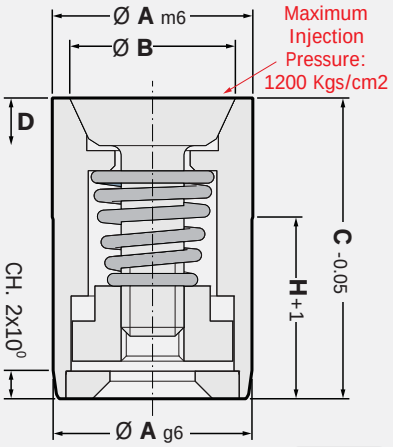
Material:
INOX 1.4034

Hardness:
51 ± 3 HRC

Max. working temp.: 150°

Min. working pressure: 3 Bar
1 Bar ≃ 1 Kg. / cm²





Code: VA

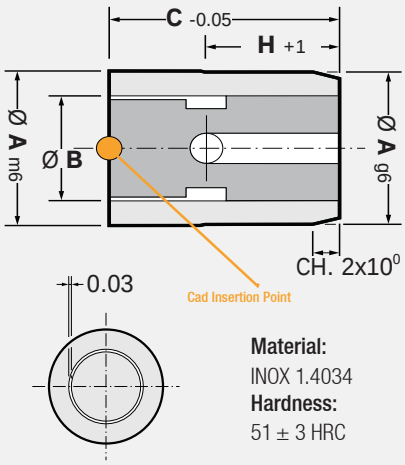
Order	A	B	C	D	E	H	M
VA.050412	5	3	12	1.5	4	7	2.5
VA.065212	6	5.2	12	1.5	4	7	0.95
VA.086512	8	6.5	12	1.5	4	7	0.95
VA.100812	10	8	12	2	8	7	0.95
VA.121012	12	10	12	2.5	10	7	0.95
VA.161320	16	13	20	3	12	12	1.55
VA.201720	20	17	20	3.5	16	12	1.55

* Product **VA.050412** does not contain mechanical stop.

Double Air Valve

Code: VD

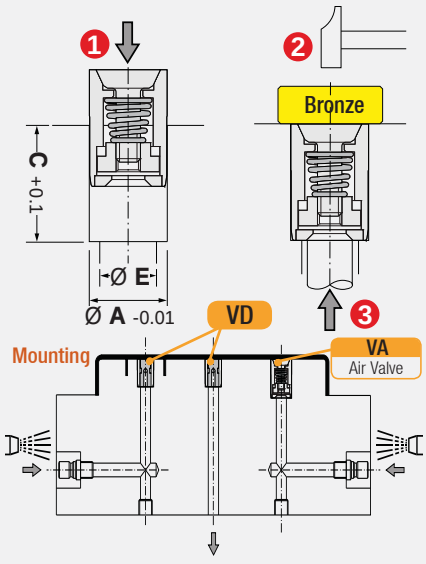
An effective method of semi pneumatic ejection, for moulds with ribs (in thin walled mould) or areas forming gas traps or vacuum conditions. Helps part ejection with air. Allows venting.



Material:
INOX 1.4034
Hardness:
51 ± 3 HRC

Code: VD

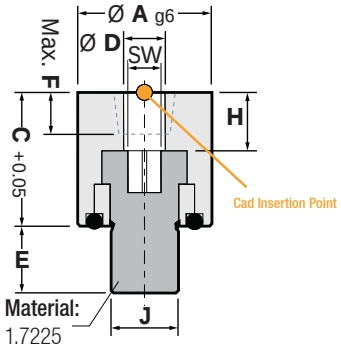
Order	A	B	C	E	H
VD.080512	8	5	12	4	7
VD.100612	10	6	12	5	7
VD.120812	12	8	12	7	7
VD.161020	16	10	20	9	12



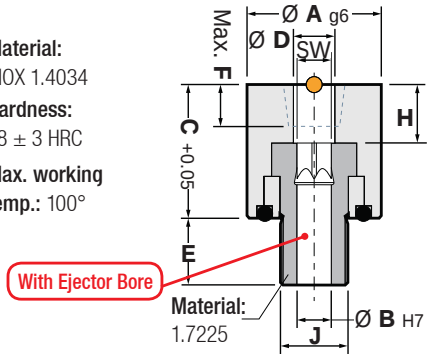
Sprue Adjuster

Code: SA

It is suitable to use on high injection pressure and fast / mass production stamps.
This unit allows runner shut off directly from the parting line.
Two models are available, depending if an ejector pin is required or not.
It can be installed in the cavity or in the core, allowing trapezoidal or full round runners.



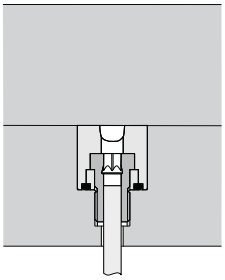
Material:
INOX 1.4034
Hardness:
48 ± 3 HRC
Max. working temp.: 100°



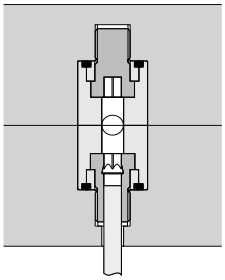
Order	A	C	D	E	F	H	J	SW
SA.120014	12	14	4	6	3	5	M6	3
SA.160016	16	16	5	8	5	7	M8	4
SA.200018	20	18	6	10	6	9	M10	5

Order	A	B	C	D	E	F	H	J	SW
SA.120314	12	3	14	4	6	3	5	M6	3
SA.160416	16	4	16	5	8	5	7	M8	4
SA.200518	20	5	18	6	10	6	9	M10	5

Runner Position Configurations

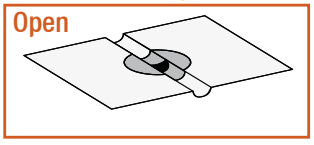


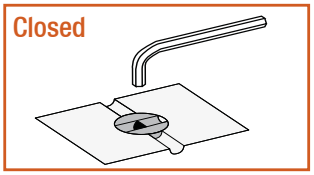
Trapezoidal Runner

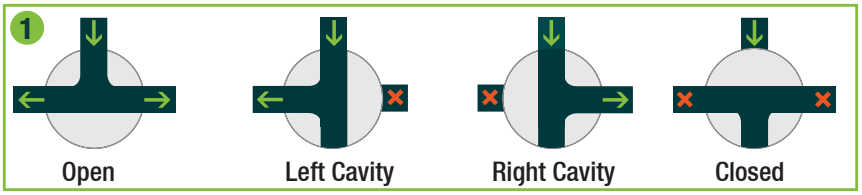


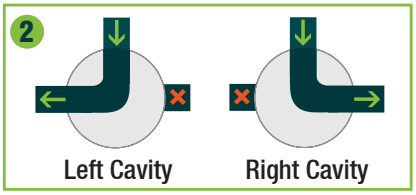
Full Round Runner

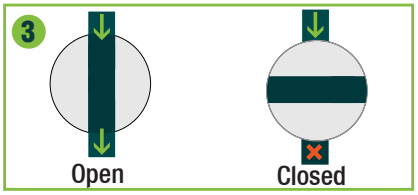
Runner Adjuster











CUMSA
End of Cumsa Products Section...

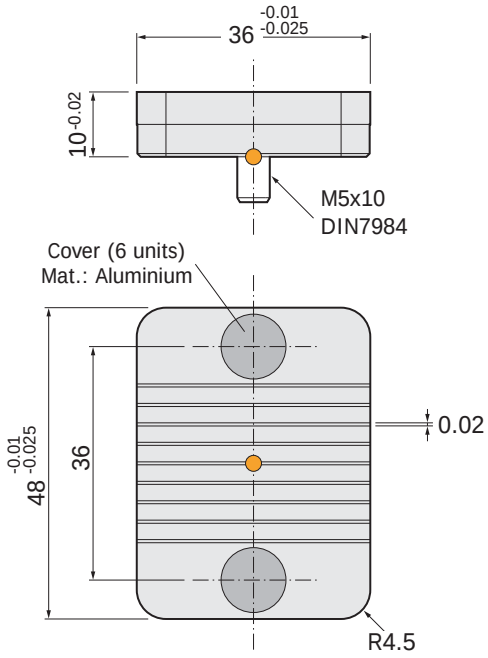
NEW

Laminar Gas Vent

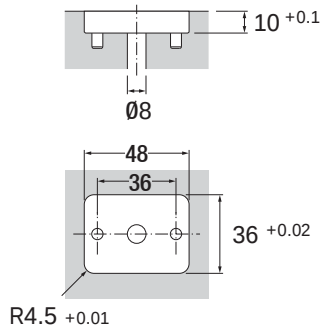
Order Code: LV.483610

Helps venting the mould cavity and the pneumatic ejection of the plastic part (allows air passing in both directions). Maximize performance installing at the end of the plastic flow. Supplied with 6 covers for maintenance purposes. Also designed for use with Cumsa VB and SV systems.

Material: 1.4021



Pocket / Housing Detail:



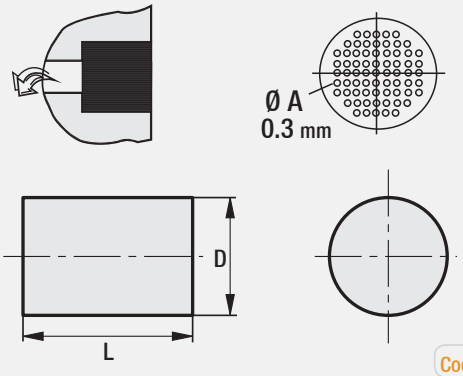
NEW

Gas Venting Filter for Diecasting

Code: AHV

(aluminium & zamak moulds)

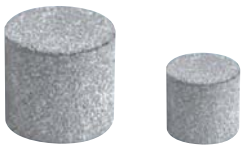
It is designed / produced with heat treated and large discharge poles.
It is a specially designed and highly productive product for Diecasting Moulds & Injection Moulds.
The service life of the product is longer than the equivalent products.
You can minimize product replacement times by increasing productivity levels.



Code: AHV

Order	D (Ø)	L (mm)	A (Pore pcs.)
AHV.03	3.0	10	40
AHV.04	4.0	10	40
AHV.05	5.0	10	90
AHV.06	6.0	10	90
AHV.08	8.0	10	200
AHV.10	10	10	340
AHV.12	12	10	340
AHV.16	16	15	340
AHV.20	20	15	550

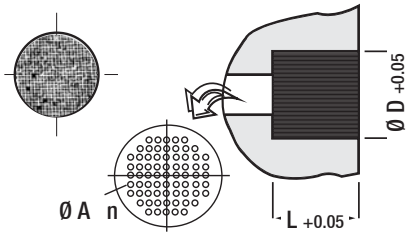
It is resistant to high temperature and pressure.



Code: SGA

Sintered Gas Venting Filter

With its sintered & multi-pores structure, it is a special product which discharges compressed gas in injection moulds. Sintered Gas Venting Filters are used for optimum venting of the mould cavity.
It is a high quality, stainless product which does not leave marks on injected objects and can resist high pressures.



D	L	A	n
1.6	5	0.03	250 / 400
2.0			
2.5			
3.6			
4.1	9		880
5.0	10		

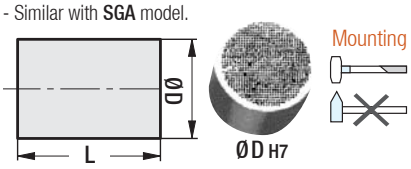
D	L	A	n
6.5	10	0.05	880
9.0			
10			
12.5			
15			1200
20			

Order: **SGA.** D x L

Code: GVSY

Sintered Gas Venting Filter with Steel Casing

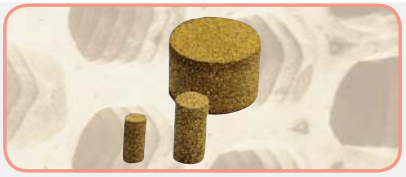
- External surface grinded.
- Sintered structure.
- Similar with **SGA** model.



Material: Stainless Sintered Steel
Filter Fineness: 10 Microns
Tension: 300 N / mm²
Resistance: Weak bases - Organic acids, Plastic melts - Synthetic resins

Order	D	L
GVSY.04	4	10
GVSY.06	6	
GVSY.08	8	
GVSY.10	10	12

Order	D	L
GVSY.12	12	12
GVSY.16	16	14
GVSY.20	20	15
GVSY.28	28	



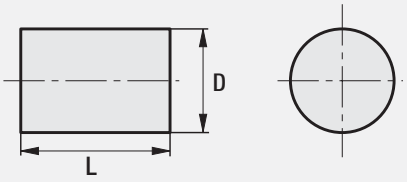
Code: GGA

Gas Venting Filter - Yellow Wired

In injection moulds, it drains unwanted gas created by melted raw material fast via wide channels. Does not resist to very high pressures, can dent and leave a mark on objects in stamp. It is mostly suitable to be used inner parts. It can be used in metal injection moulds which do not require very high temperature. **It is an economical product.**

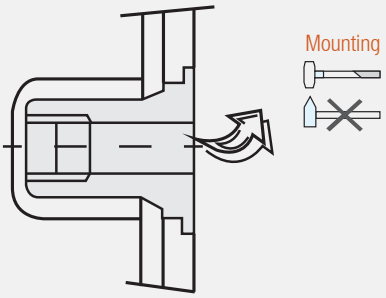
In Mounting: Please use copper / rubber hammer. Do not make any mechanic or polishing / levelling process on filter unit, since this would clog up the pores.

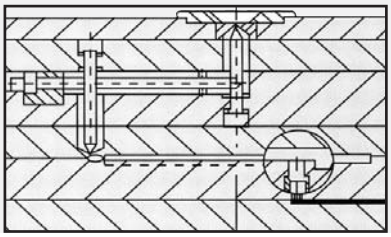
In Production: Never touch Venting Filters on operating moulds by hand.



Code: GGA

Order	D	L
GGA.03	**3.0**	8
GGA.04	**4.0**	10
GGA.05	**5.0**	10
GGA.06	**6.0**	10
GGA.08	**8.0**	10
GGA.10	**10**	10
GGA.12	**12**	10
GGA.16	**16**	10



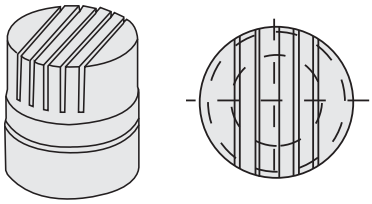


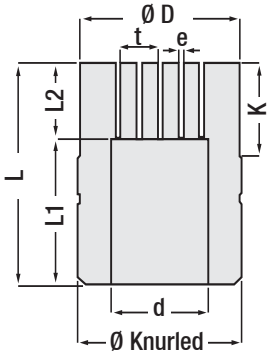
Code: STV

Air Venting Valve for Blow Moulding

It is used in blow mouldings for optimum ventilation to mould cavity. Due to the air channels of valve being parallel and wide, it drains the air in mould rapidly, also air chamber inside of the unit acts as a pool in drainage of the air. If the burrs become on the product that should be cleaned instantly.
Those burrs causes adhesion to pores. For cleaning, the compressed air or cleaning spray can be used. (**Guvenal Cleaning Spray Code:** W170104).

Mounting: It provides tight keep and inside the safe of hole thanks to its knurled outer part.





Code: STV

Order	STV. 0610	STV. 0810	STV. 1010	STV. 1210
D	**6**	**8**	**10**	**12**
L	10	10	10	10
d	4.3	5.7	6.1	8.1
t	2.0	2.0	2.0	2.0
e	0.3	0.3	0.3	0.3
K	4.0	4.5	4.5	4.5
L1	7.0	6.5	7.0	7.0
L2	3.0	3.5	3.0	3.0
Knurled	6.1	8.1	10.1	12.1

Recycling Date Stamp

Code: GDM

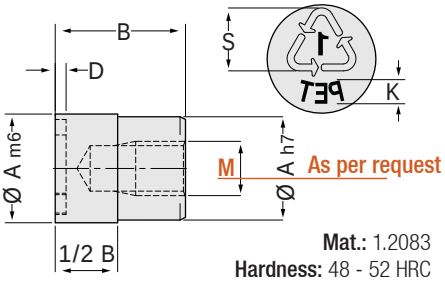
(Plastic raw material data, definition & recycling stamps)

Text and Definition Characters: It is for precise sign / mark and definition of plastic raw material that is inlaid in 0.2 depth (conical graduated) processing on moulds in production according to diameters. In Addition, it facilitates to recognize raw material that is about to break.

Stamp: It is compatible with DIN 6120 single symbol, ISO 1043-1 normal sign / mark and international codes.

Types

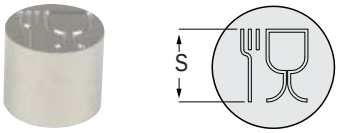
- Logo — GDM01
- Blank — GDM02
- PET — GDM03
- HDPE — GDM04
- PE-HD — GDM05
- PVC — GDM06
- LDPE — GDM07
- PE-LD — GDM08
- PE-BD — GDM09
- PP — GDM10
- PS — GDM11
- Other — GDM12
- Other (0) — GDM13
- Foodmark — GDM14



As per request

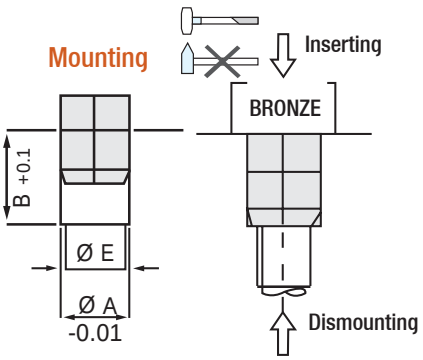
Mat.: 1.2083
Hardness: 48 - 52 HRC

Order	A	B	D	E	K	S	M
GDM... 06	6	10	0.3	6	-	4.0	M4
GDM... 08	8	10		6	-	4.0	M4
GDM... 10	10	12		8	1.6	5.6	M5
GDM... 12	12	12		10	2.0	6.8	M6
GDM... 16	16	14		12	2.6	9.0	M6
GDM... 20	20	16		16	3.2	11.5	M6

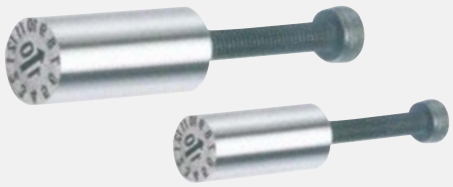


Date Stamp for Food Legislation

Order	A	B	D	E	S	M
GDM14.10	10	12	0.3	10	6.10	M5
GDM14.16	16	14		16	9.08	M6
GDM14.20	20	16		20	12.30	M6



+ Production
+ Economic Price
+ High Quality



Date Stamp - Screwed

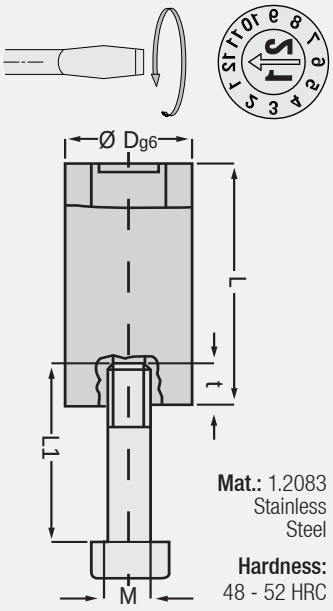
Code: VKT

The Date Stamps which are mostly preferred for medium and small dimensional moulds.

Easy to mount and can be mounted on tools such as Ejector Pins.
Rotary inner hub of Date Stamps can be adjusted as limitless (worm gear). Mounting is completed by pressing on inner hub arrow and pulling with screw from lower part. **We offer wide range of options with our affordable prices.**

Types

- Month — VKT01
- Month + Year — VKT02
- Year — VKT03
- Weekly — VKT04
- Daily — VKT05
- Shift — VKT06
- Number (figure) — VKT07
- Letter from A to M — VKT08
- Letter from N to Z — VKT09
- Arrowed (blank) — VKT10
- Custom-Made — VKT11

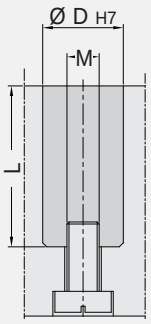


Mat.: 1.2083 Stainless Steel
Hardness: 48 - 52 HRC

D	L	t	L1	M
4	12.5	3	4	M2
5	14	3	4	M2.5
6	16	3	4	M3
8	18	4	4	M3
10	22	4	4	M3
12	25	6	6	M4

Order:
VKT (type). D x L

Mounting



Date Stamp "FT" (Cumsa) product should be selected for metal injection moulds which require high temp.

Date Stamp

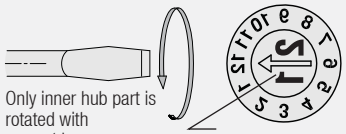
Code: KT

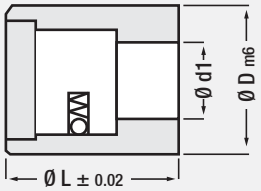
Standard Models

It is suitable to be used in all injection mould systems. Only a hole as product diameter (H7 - Reamed) is sufficient for mounting to mould.
Mounting: Drill a suitable hole in the desired part of mould and place Date Stamp into it (with bronze or rubber hammer). Making a tight hole (not to rotate date stamp) is useful.
A wide range of options are available at affordable prices.

Types

Month	KT01
Month + Year	KT02
Year	KT03
Weekly	KT04
Daily	KT05
Shift	KT06
Number (figure)	KT07
Letter from A to M	KT08
Letter from N to Z	KT09
Arrowed (blank)	KT10
Custom-Made	KT11

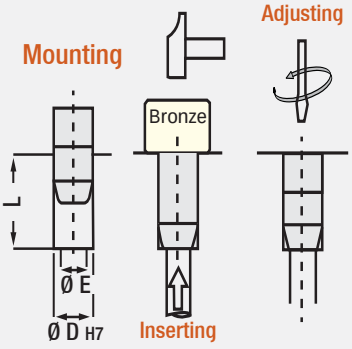




*** KT02 & KT04:** Pls. specify "year" for your KT02 & KT04 orders.

D	L	d1	S	E
4	6	2	0.2	3.5
5	8	2.5	0.2	3.5
6	8	3.5	0.2	4.0
8	10	4.5	0.2	6.0
10	10	4.8	0.2	8.0
12	12	6.0	0.25	10
16	14	7.8	0.35	12
20	14	9.7	0.35	14
25	25	12.7	0.35	16

Order:
KT (type). D x L

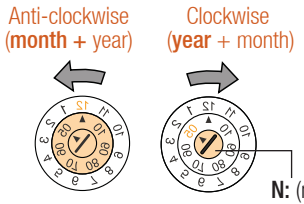


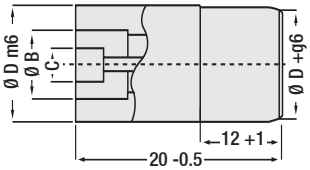
Multi-Date / Double Date Stamp

Code: DKT

Two different Date Stamps, with a unit as months + years.

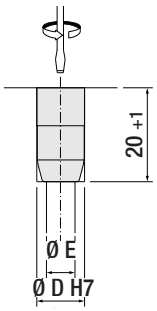
This Guvenal product reducing needs and area required for cost and two different Date Stamp, shows two different criteria on one unit. Its standard model is as 12 month + 6 year, in other words is not required any change along 6 years.
The length of all Date Stamps are same (20 mm).





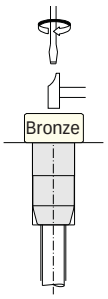
Code: DKT

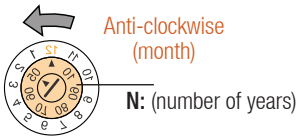
Order	D	B	C	E	N
DKT.08	8	5.5	3	6	5
DKT.10	10	6	3	10	6
DKT.12	12	8	4	10	6
DKT.16	16	10.5	5.3	12	10
DKT.20	20	12	6	16	12

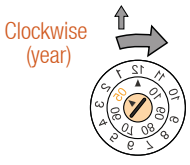


Important:
To change the month; the hub arrow on the unit is turned counter clockwise (anti-clockwise) and the inner two parts are rotated.
To change the year; please turn it clockwise.

Material: 1.2083 / Stainless Steel
Hardness: 48 - 52 HRC







Mini Screwdriver Set

Order Code: CRP

Date Stamp Adjusting Kit

Mini Screwdriver Series:
6 pcs. rotary head set;
+ 4 pcs, 1.5 - 2 - 2.5 - 3 head mini screwdriver.
+ 2 pcs, PH0 - PH1 phillips head mini screwdriver.

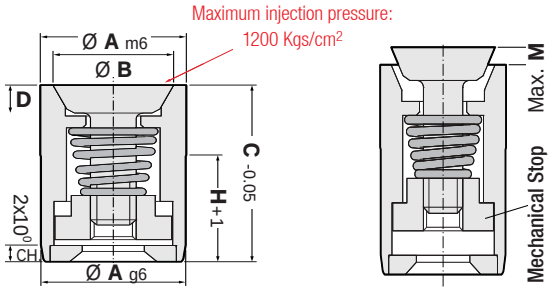
* Chrome vanadium steel.
* Blackened stainless ends.
* Ergonomic handles.
* Upper part of handle is rotary head.

Air Venting Valve

Code: CHV

"CHV" Air Venting Valves produced from stainless steel.
It provides high air discharge. Also, the conical ejector rises and helps the product exit from mould. The operating temperature under 150ºC is recommended.

In higher temperature than 150ºC; steel starts to expand and melt plastic raw material gets into valve and prevents operation.



Material: INOX 1.4034
Operating air pressure: 1.5 - 6 Bar
1 BAR ≃ 1 Kg. / cm²

Order	A	B	C	D	H	M
CHV.05	5	3	12	1.5	7	2.5
CHV.06	6	5.2	12	1.5	7	0.95
CHV.08	8	6.5	12	1.5	7	0.95
CHV.10	10	8	12	2	7	0.95
CHV.12	12	10	12	2.5	7	0.95
CHV.16	16	13	20	3	12	1.55
CHV.20	20	17	20	3.5	12	1.55

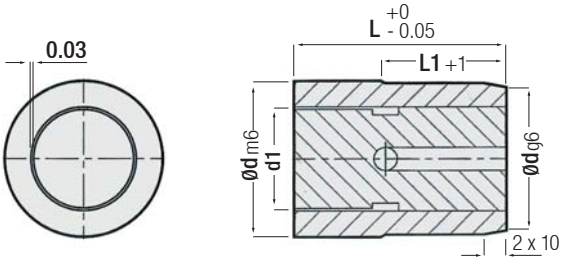
NEW

Double Air Venting Valve

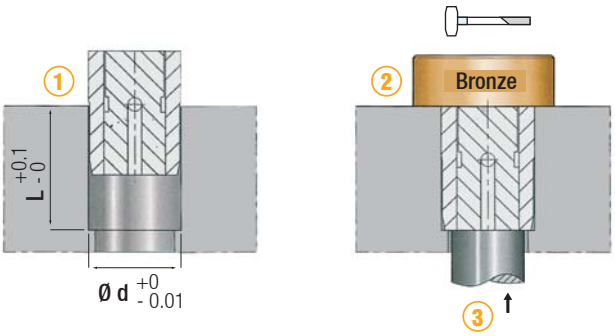
Code: DHV

"DHV" Double Air Venting Valves produced from stainless steel.
The product is effective for the semi-pneumatic ejection method.
It is effective in discharging gas and air trapped in the final filling areas of deep details in the moulds or in other possible areas and it helps the product exit from mould.

In mounting; please use the copper or rubber hammer and bronze wedge.

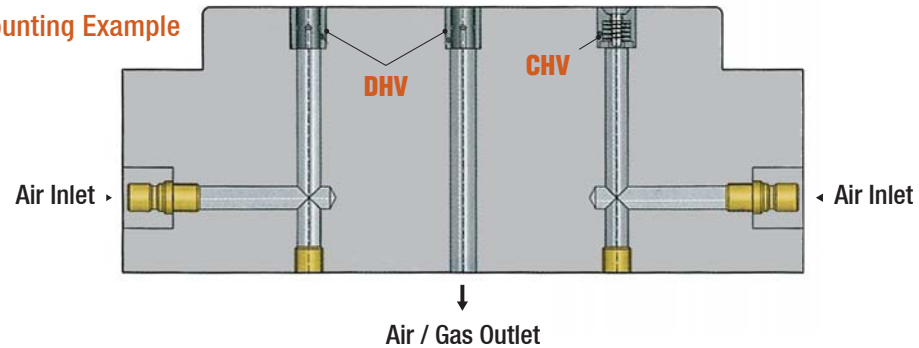


Material: INOX 1.4034



Order	d	d1	L	L1
DHV.08	8	5	12	7
DHV.10	10	6	12	7
DHV.12	12	8	12	7
DHV.16	16	10	20	12

Mounting Example



Code: VHV

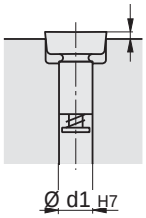
Venting Valve for High Pressure

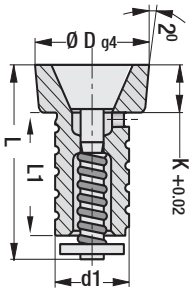
- Metal Injection gas venting & pneumatically activated ejector.
- 2⁰ conical head / mounting with special reamer.

Mounting: It should be provided with special reamer **(VHR)** and should be approx. 0.9mm out / above from mould parting line.
It is compatible with metal injection moulds.

Please use copper hammer!

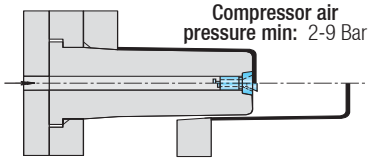
Material: 1.4301 INOX
Max. temp.: 250⁰C



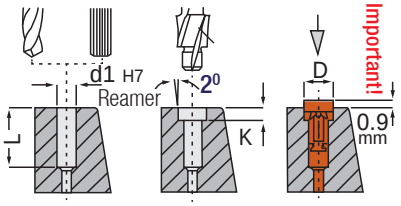


Mounting:
VHV should be approx. 0.9mm out / above from mould parting line.

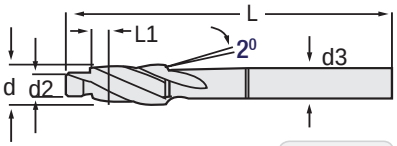
Order	D	d1	K	L1	L
VHV.08	8	6	5	8	16
VHV.12	12	8	5	13	21
VHV.16	16	10	6	14	22



Compressor air pressure min: 2-9 Bar



Special Reamer for "VHV" Valve



Code: VHR

Order	d	d2	d3	L1	L
VHR.08	8	6	10	5	69
VHR.12	12	8	12	5	100
VHR.16	16	10	12	6	122

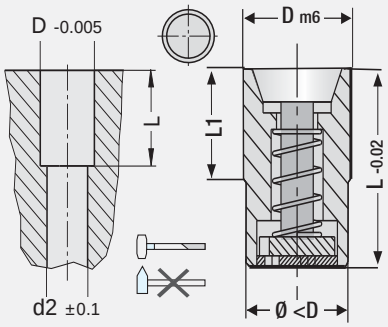
Air Venting Valve

Code: KHV

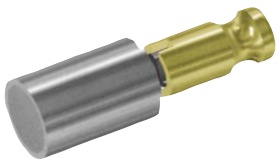
It is the most suitable method for dissolving vacuum during injection. **In wide and narrow walled objects;** it continues to discharge compressed air by vacuum in mould. All casing and machined surfaces have been produced from stainless steel.
In comparison with PHV (pinned type), the shorter length is advantageous.

"in vacuumed objects"

Compressor air pressure min: 3-10 Bar
Material: 1.4034 **Hardness:** 52-55 HRC
Max. temp.: 150⁰



Order	D	L	L1	d2
KHV.06	6	12	7	3.5
KHV.08	8	15	9	5
KHV.10	10	20	13	6
KHV.12	12	25	15	8
KHV.16	16	30	17.5	8
KHV.20	20	30	19	10
KHV.25	25	30	19	12
KHV.30	30	30	27.5	15



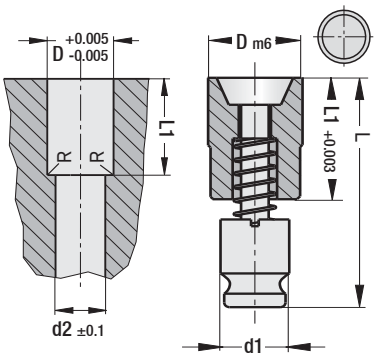
Air Venting Valve with Pin

Code: PHV

It is the most efficient air venting product.
It is especially ideal for deep and large moulds.
In mounting; please use the copper or rubber hammer and bronze wedge.

"in high and deep objects"

Compressor air pressure min: 2-9 Bar
Material: 1.4031 **Hardness:** 52-55 HRC
Max. temp.: 150⁰



Order	D	L	L1	d1	d2	R
PHV.08	8	28	11	6	7	01
PHV.10	10	28	11	7	8	01
PHV.12	12	30	11	8	9	02
PHV.16	16	43	20	10	14	02
PHV.18	18	43	20	10	14	03
PHV.20	20	43	20	10	16	03
PHV.25	25	60	20/28	16	16	04