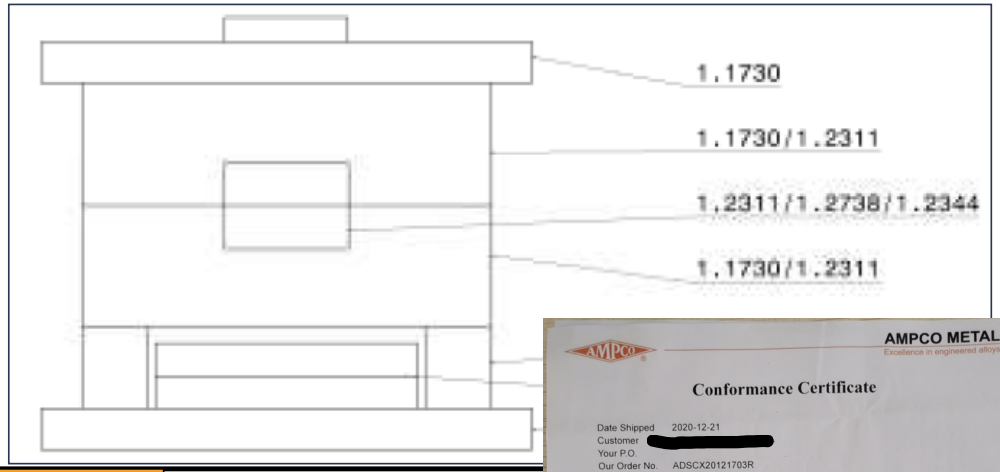
Buy off Report Example

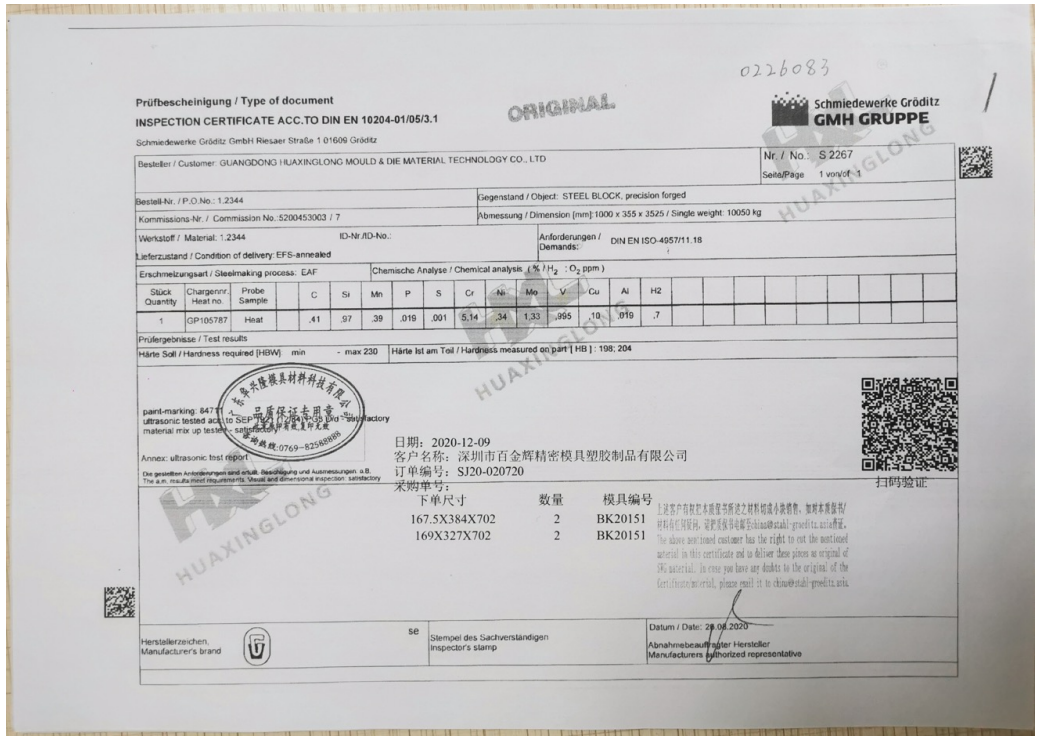
Steel certificates and hardness test

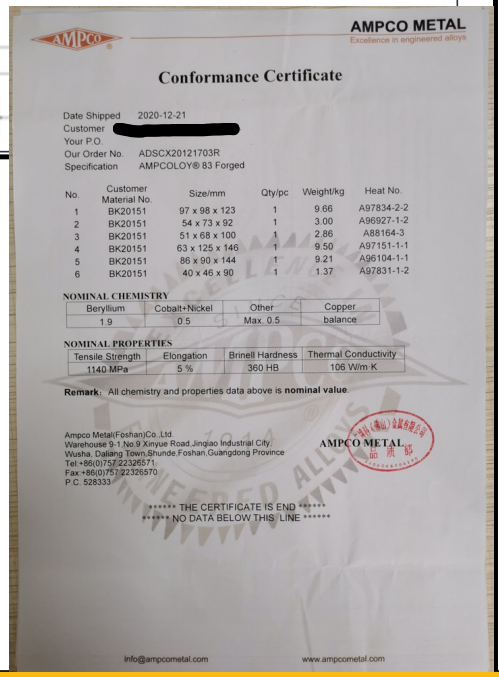
Standard



Design

Mold

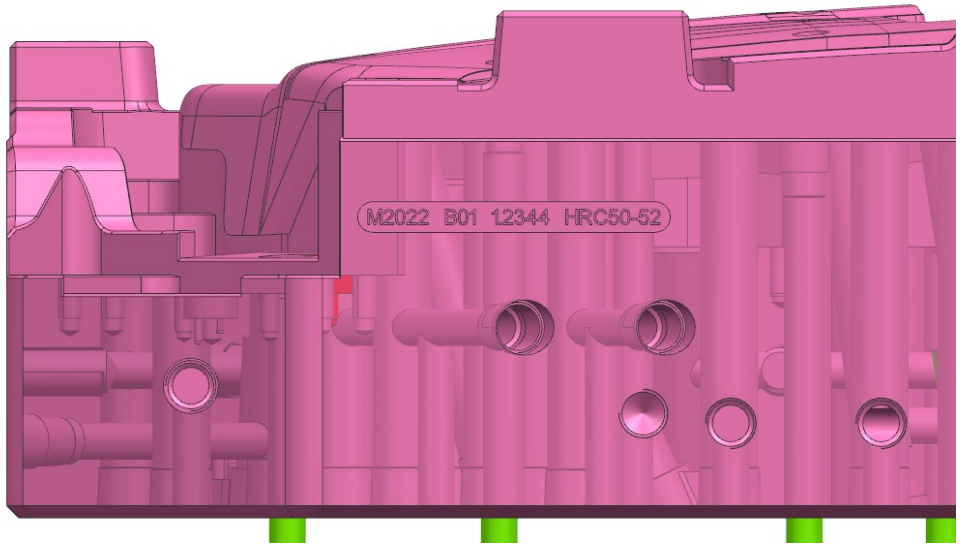




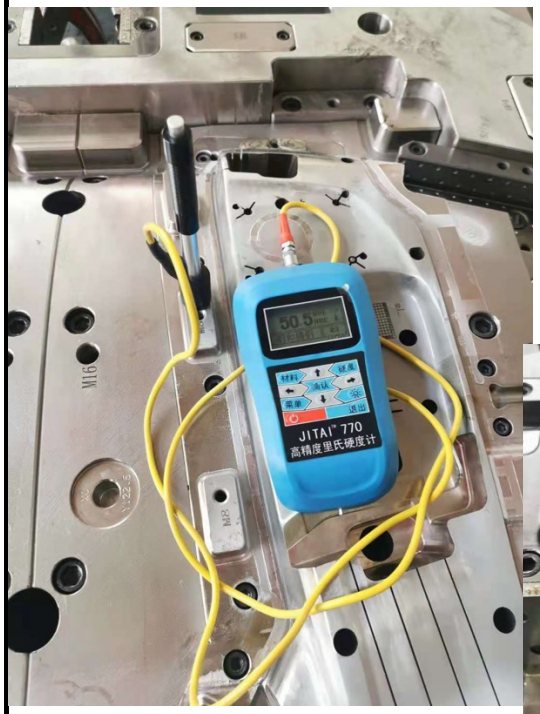
Steel certificates

Steel certificates and hardness test

Standard



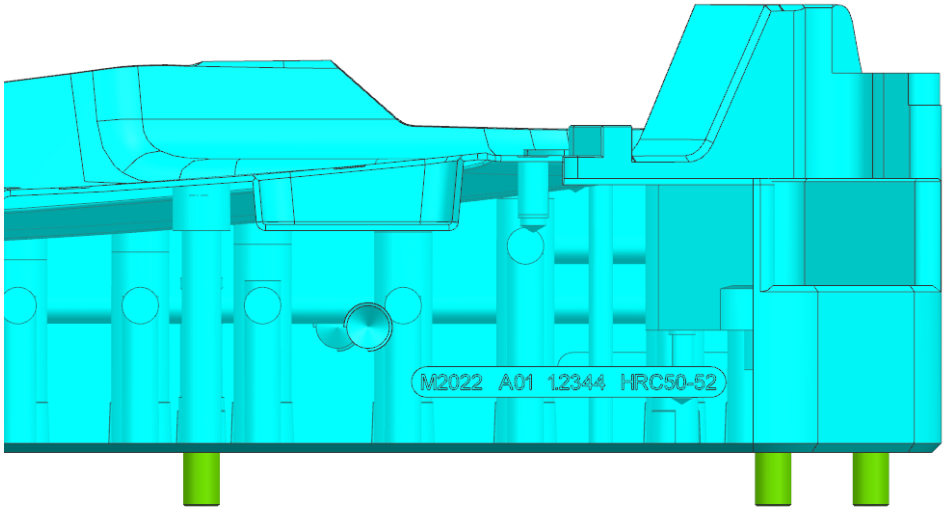
Mold



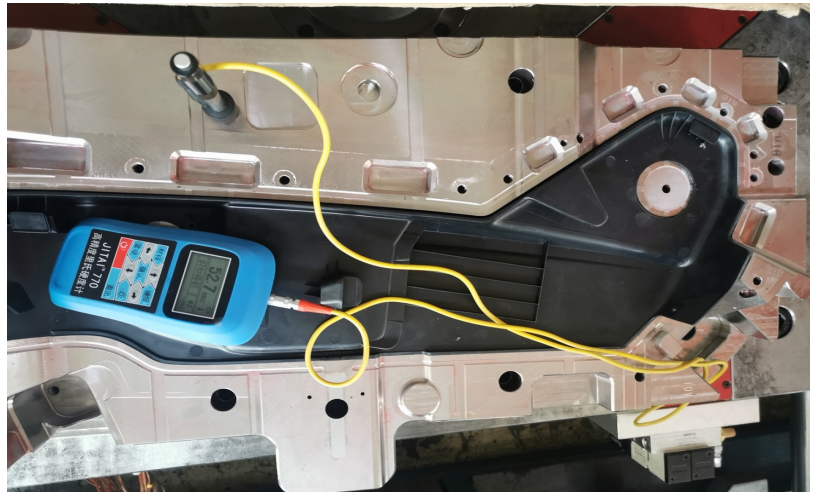
Core hardness

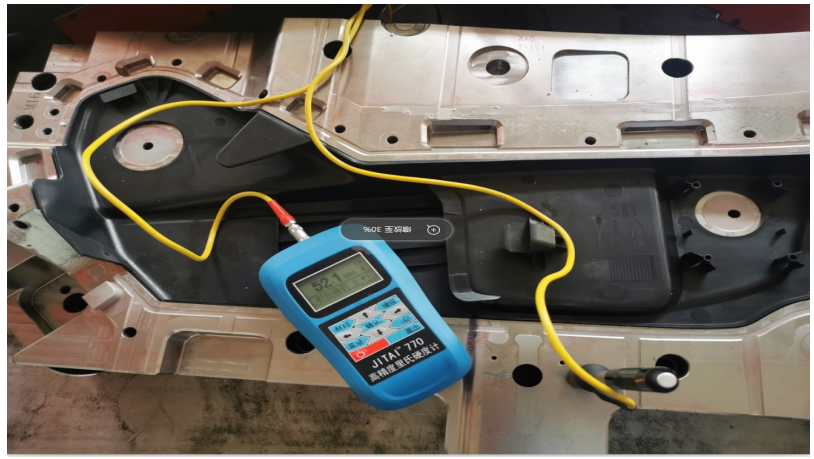
Steel certificates and hardness test

Standard



Mold



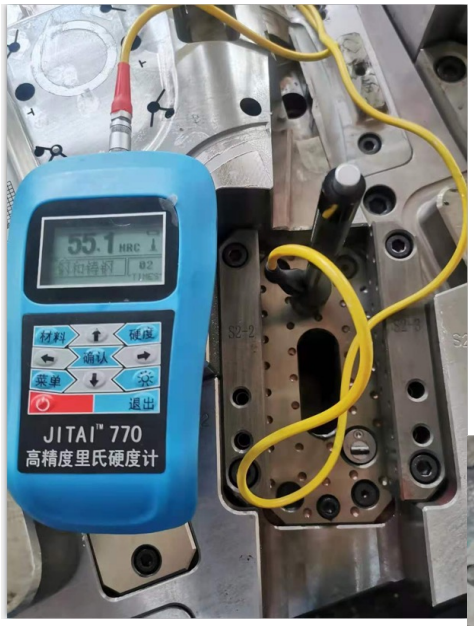


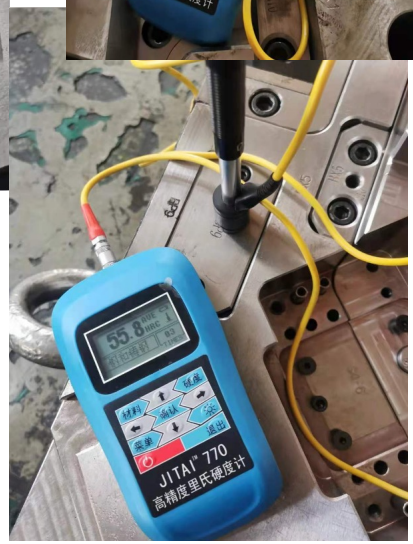
Cavity hardness

Steel certificates and hardness test

Standard

Mold

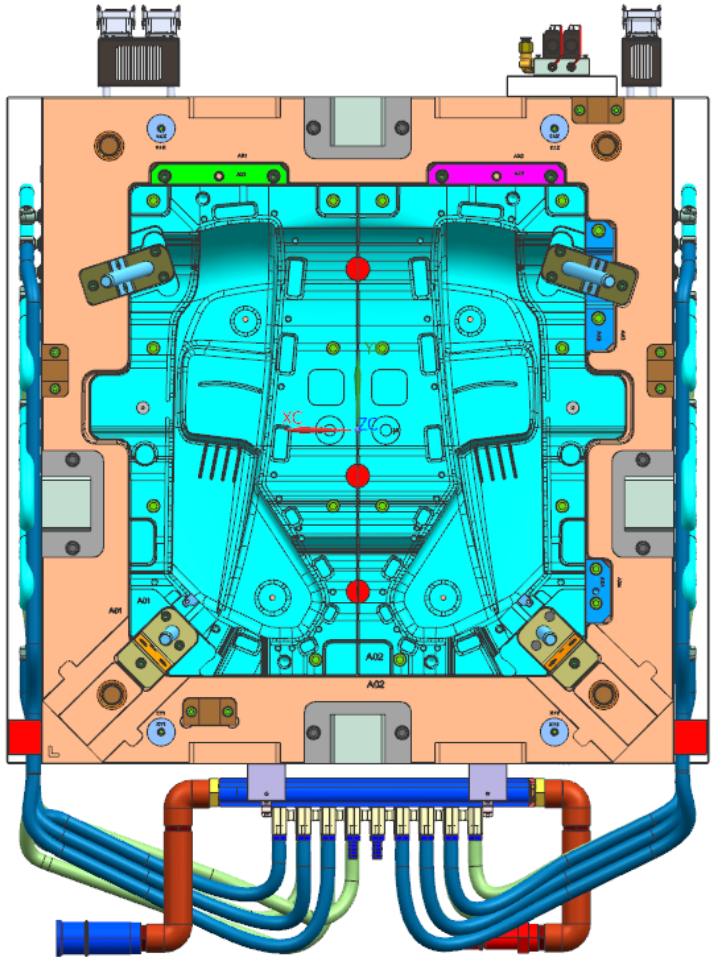




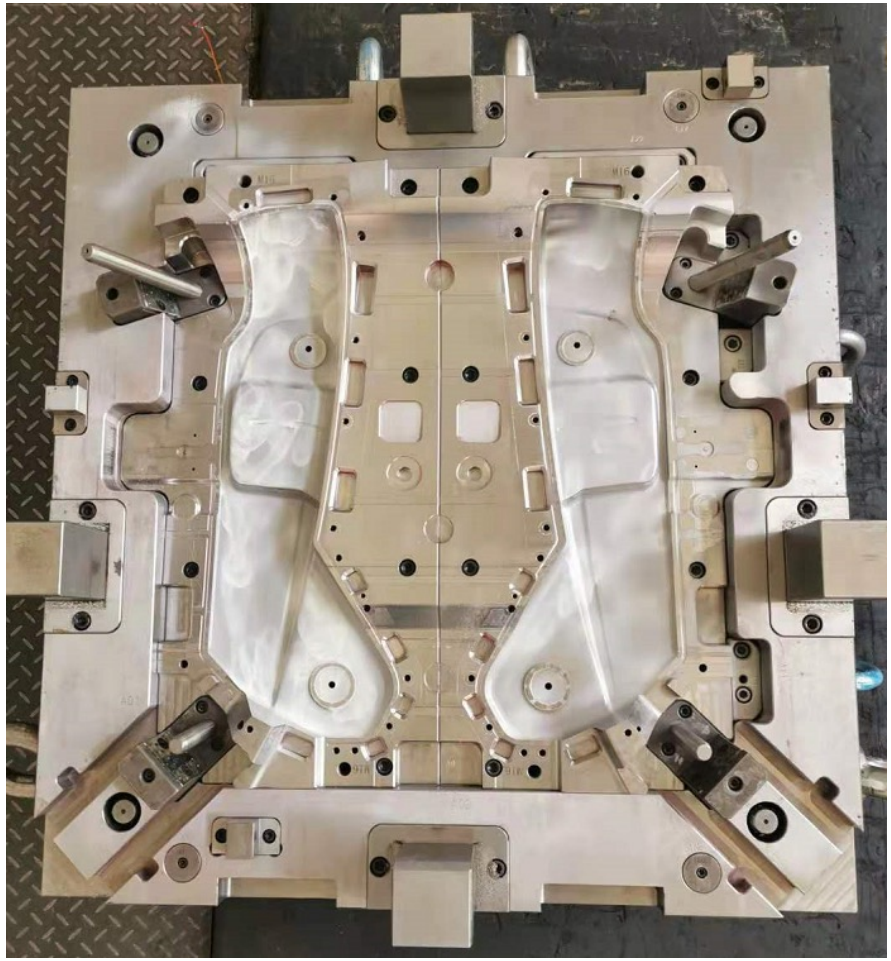
Pad plate hardness

Pictures of the mold

Design



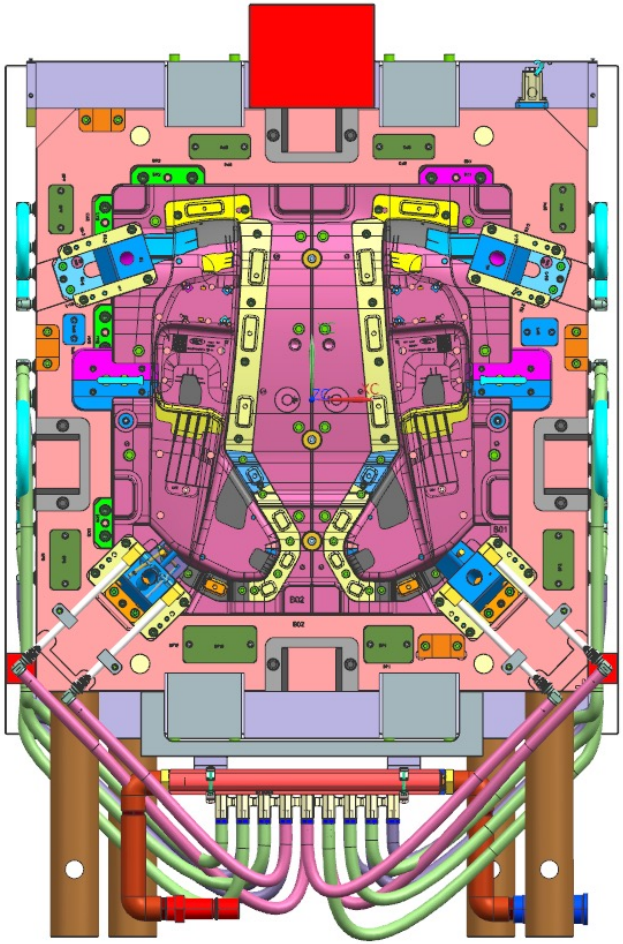
Mold



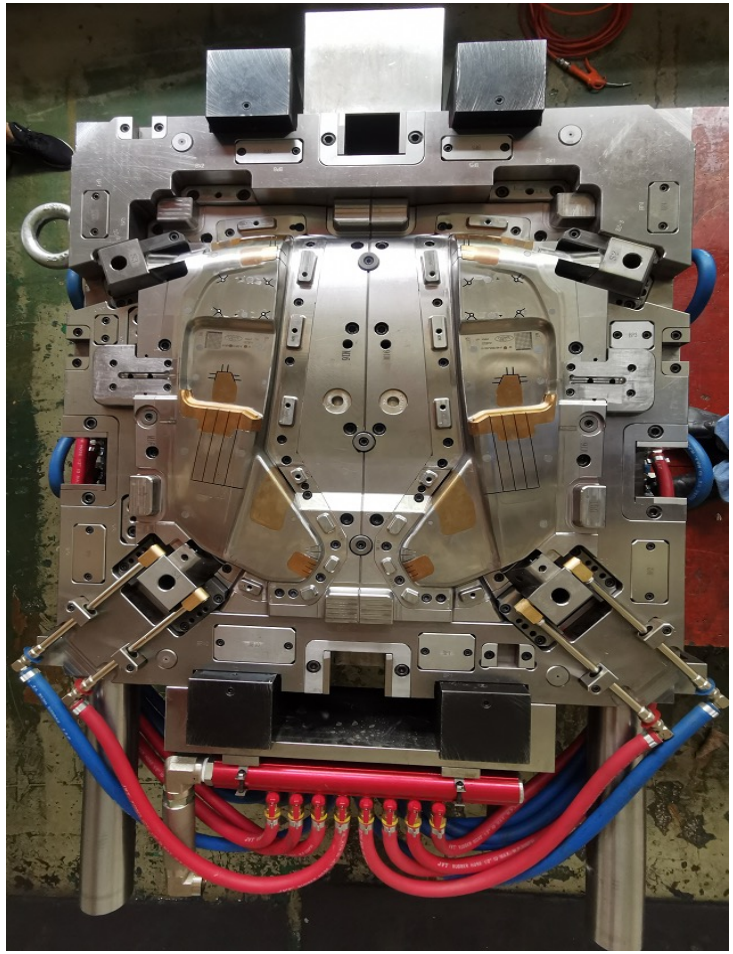
Cavity side

Pictures of the mold

Design



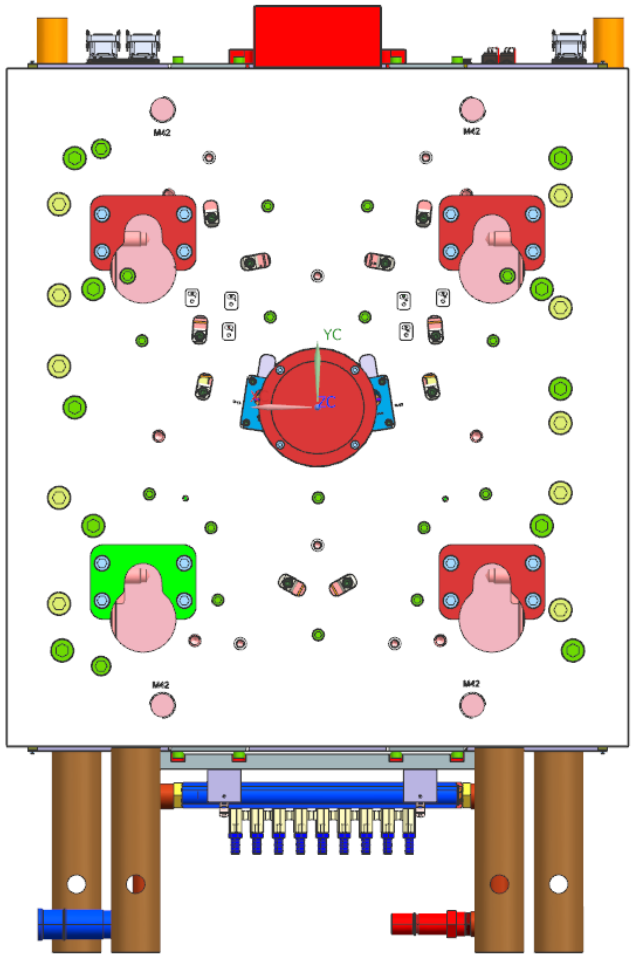
Mold



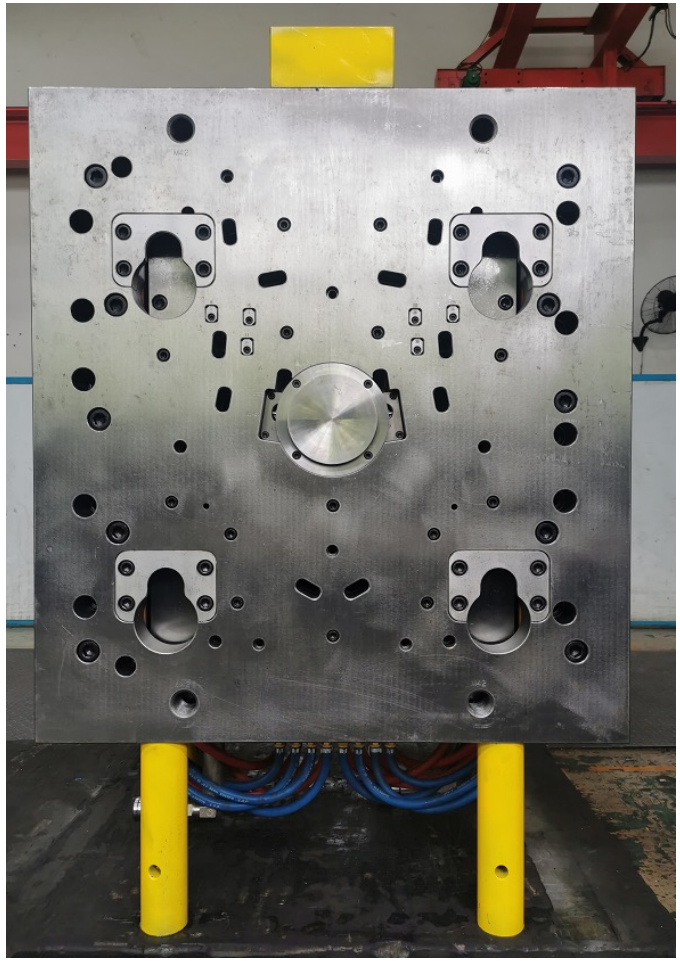
Core side

Pictures of the mold

Design



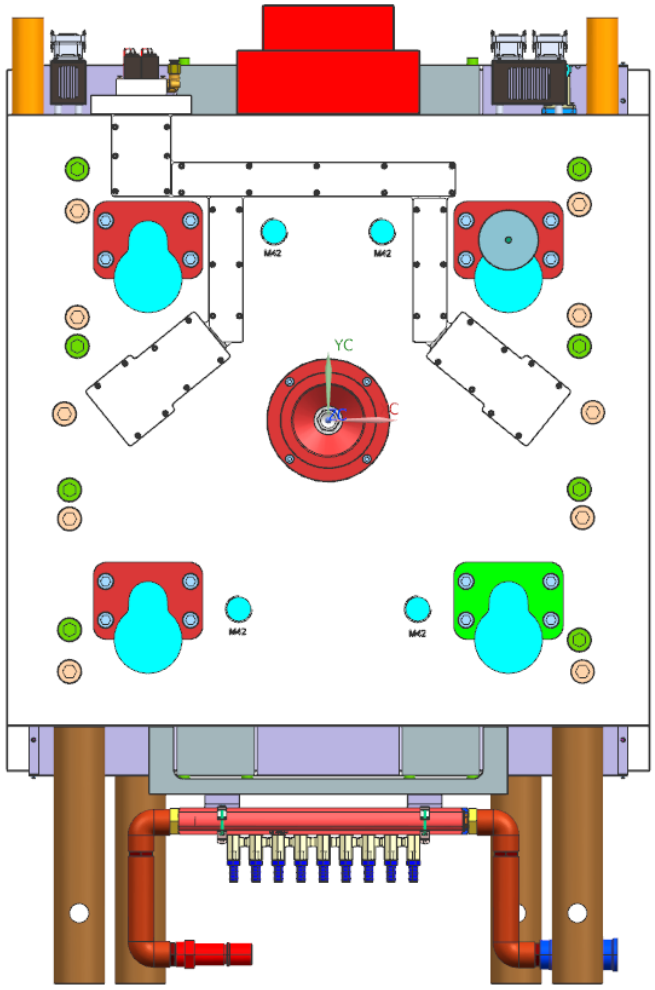
Mold



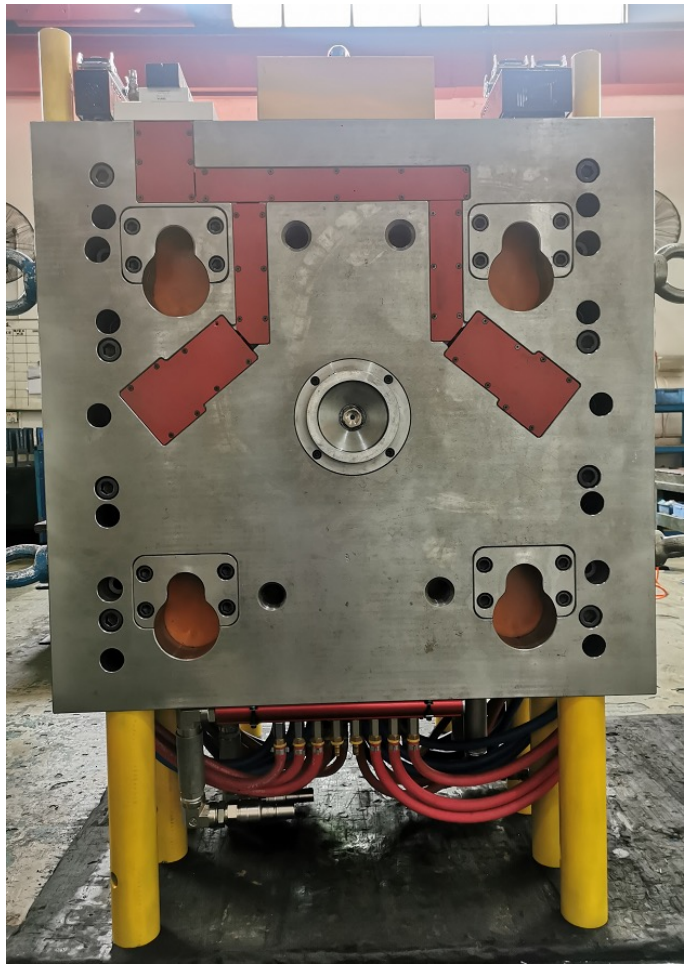
Clamp plate in core side

Pictures of the mold

Design



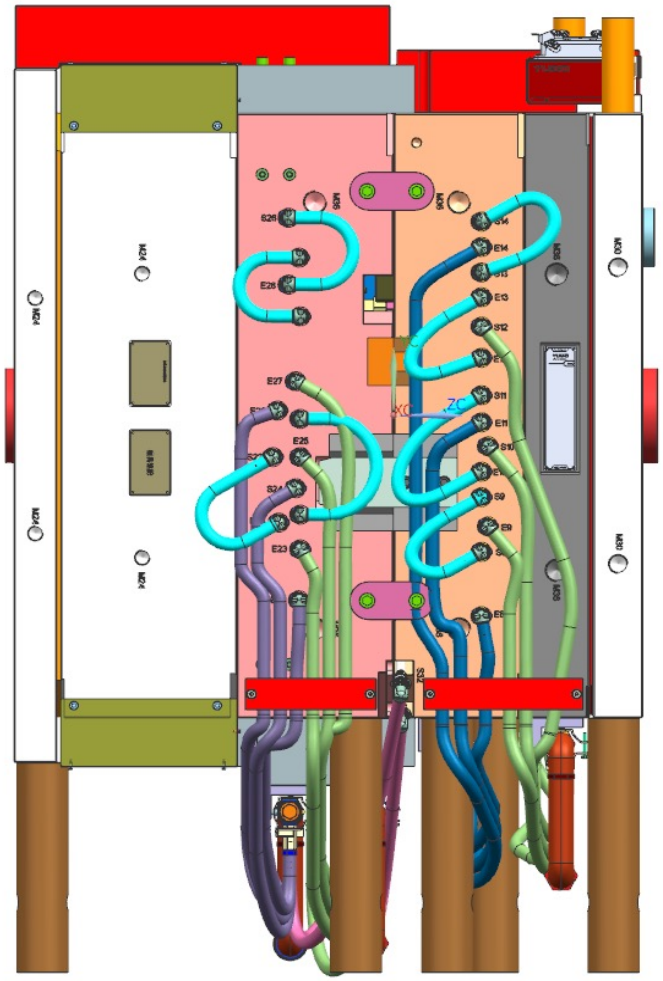
Mold



Clamp plate in cavity side

Pictures of the mold

Design

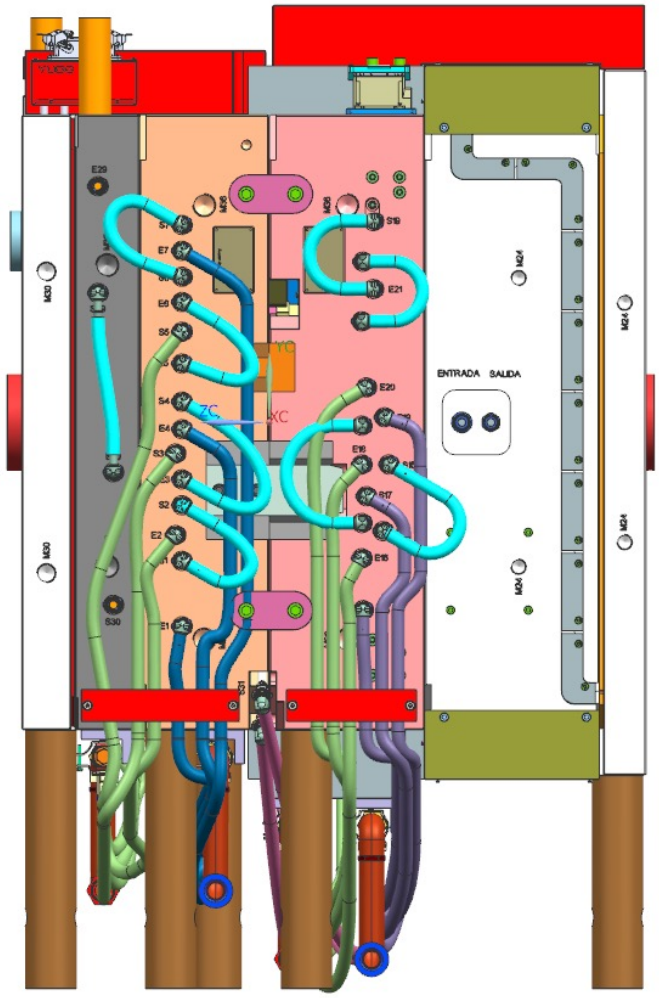


Mold

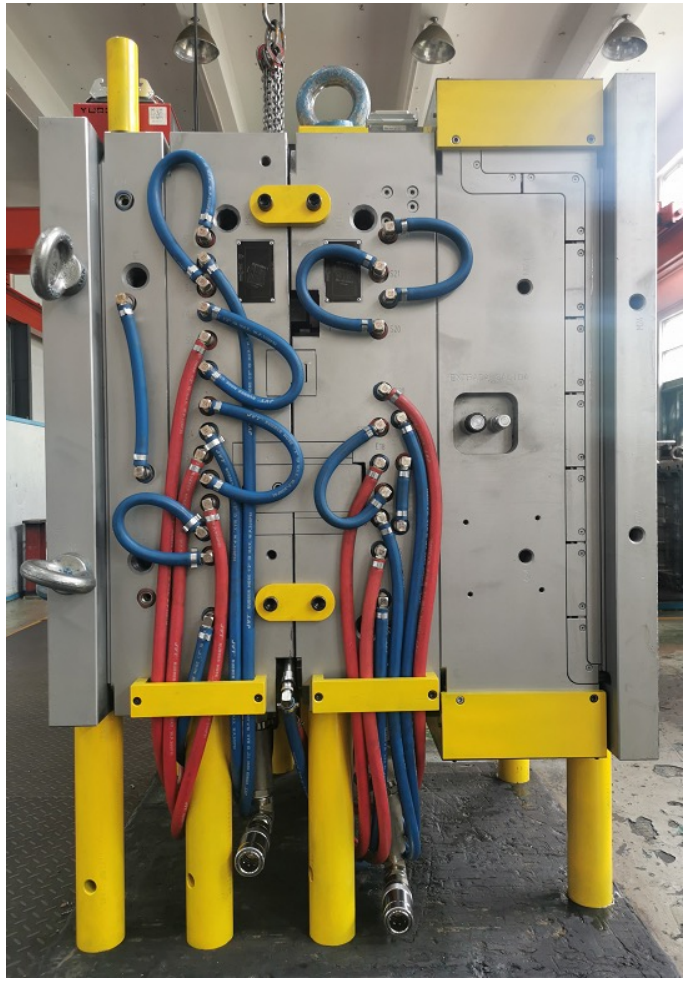
Operator side

Pictures of the mold

Design



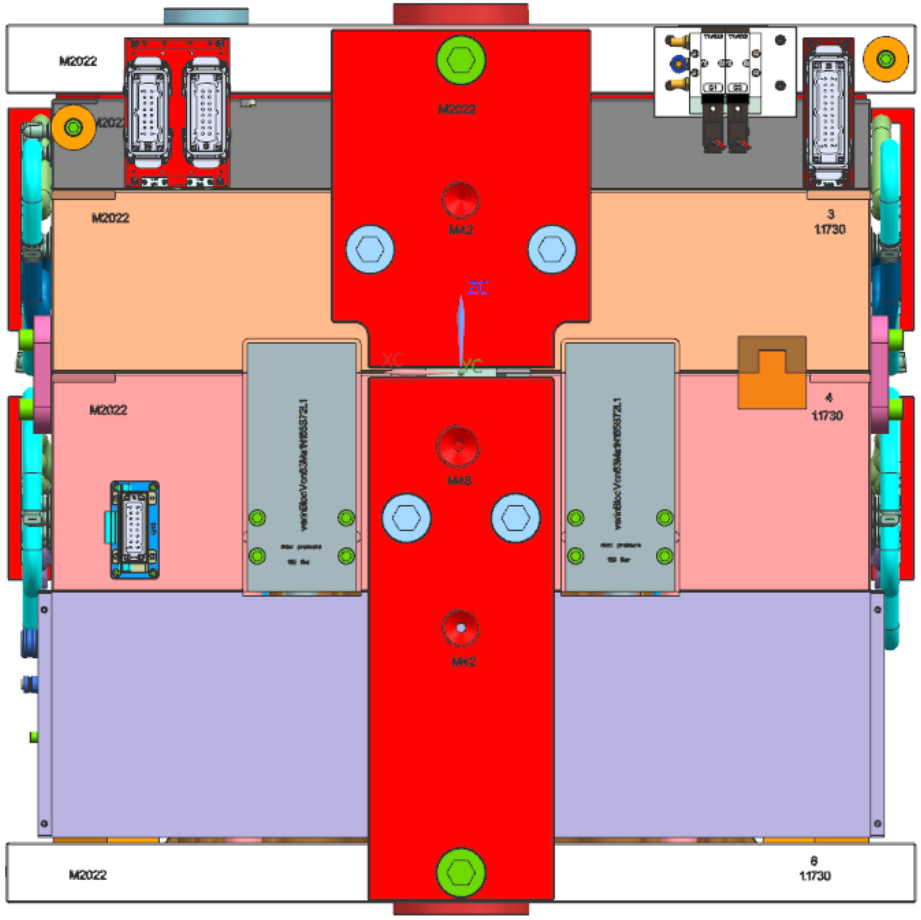
Mold



Opposite side

Pictures of the mold

Design

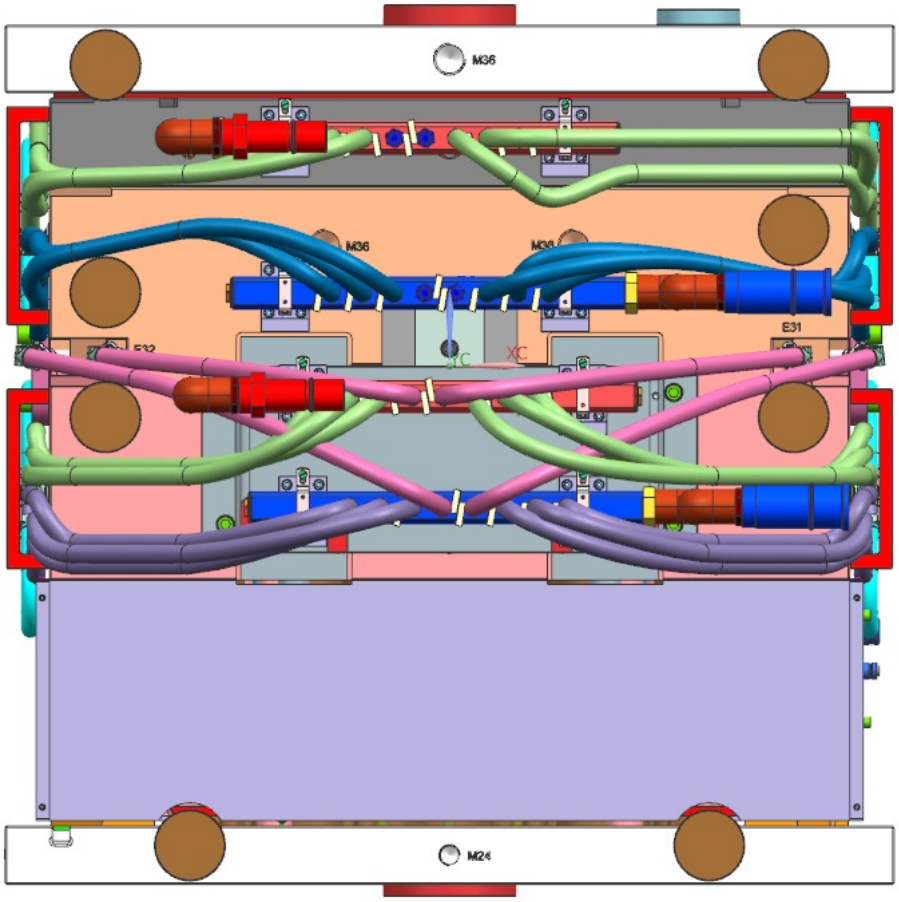


Mold

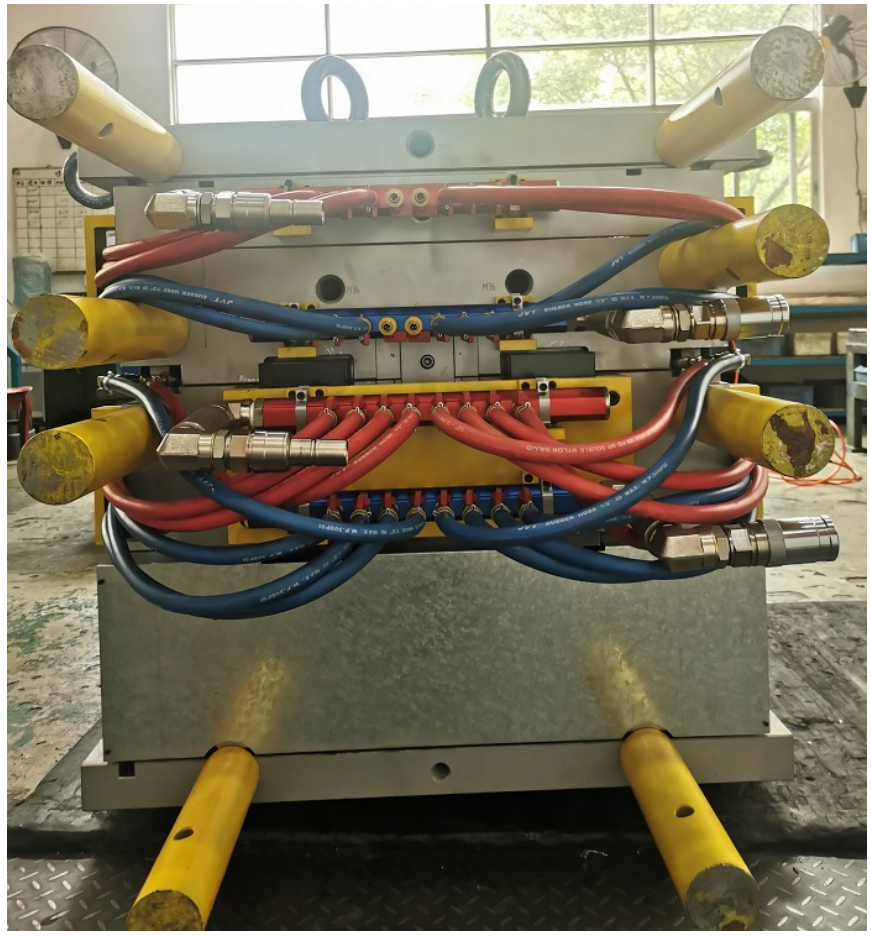
Top side

Pictures of the mold

Design



Mold



Bottom side

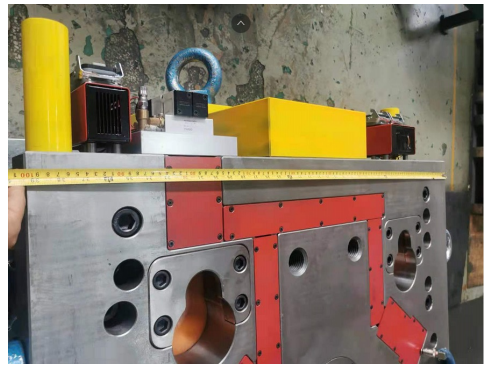
Structure

Standard

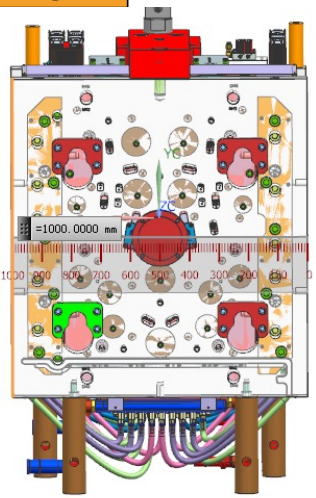
Caption (mm)	
A = width	**F** = thickness of plate to cover ejectors
B = thickness clamping plates	**G** = distance between ejector plates and clamping plate (stops type mushrooms)
C = incision for clamping mold to machine	**d1** = guide columns diameter
D = clamping incision depth	**T1** = Screws for structure
E = thickness of plate to carry up ejectors	**T2** = Screws for ejector plates
* = special dimensions according to injection machine	

Group	A	B	C	D	E	F	d1	T1	T2	G
1	166	26	30	20	20	26	16	M10	M8	5
	246/296	26	30	20	20	26	24	M12	M10	5
	346/396	26	30	20	20	26	30	M12	M10	5
	396	36	40	20	26	36	36	M16	M10	5
	446	36	40	20	26	36	40	M20	M12	5
	496	36	40	20	26	36	40	M20	M12	5
2 y 3	596	60	50	30	36	46	40	M20	M12	5
	696	60	50	30	36	46	40	M20	M12	5
	796	60	50	30	36	46	40	M20	M12	5
	896	60	50	30	36	46	40	M20	M16	5
	>896*	66/76*	50	40	46	56/76*	50/60	M24	M20	5

Mold



Design



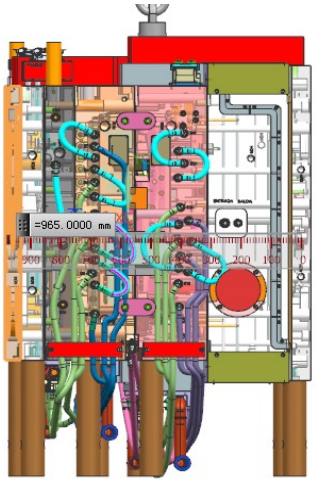


Plate thickness

Standards

Standard

Caption (mm)	
A = width	**F** = thickness of plate to cover ejectors
B = thickness clamping plates	**G** = distance between ejector plates and clamping plate (stops type mushrooms)
C = incision for clamping mold to machine	**d1** = guide columns diameter
D = clamping incision depth	**T1** = Screws for structure
E = thickness of plate to carry up ejectors	**T2** = Screws for ejector plates
* = special dimensions according to injection machine	

Group	A	B	C	D	E	F	d1	T1	T2	G
1	166	26	30	20	20	26	16	M10	M8	5
	246/296	26	30	20	20	26	24	M12	M10	5
	346/396	26	30	20	20	26	30	M12	M10	5
	396	36	40	20	26	36	36	M16	M10	5
	446	36	40	20	26	36	40	M20	M12	5
	496	36	40	20	26	36	40	M20	M12	5
2 y 3	596	60	50	30	36	46	40	M20	M12	5
	696	60	50	30	36	46	40	M20	M12	5
	796	60	50	30	36	46	40	M20	M12	5
	896	60	50	30	36	46	40	M20	M16	5
	>896*	66/76*	50	40	46	56/76*	50/60	M24	M20	5

Mold

NO

Design

Clamp slot injection side

Standards

Standard

Caption (mm)	
A = width	**F** = thickness of plate to cover ejectors
B = thickness clamping plates	**G** = distance between ejector plates and clamping plate (stops type mushrooms)
C = incision for clamping mold to machine	**d1** = guide columns diameter
D = clamping incision depth	**T1** = Screws for structure
E = thickness of plate to carry up ejectors	**T2** = Screws for ejector plates
* = special dimensions according to injection machine	

Group	A	B	C	D	E	F	d1	T1	T2	G
1	166	26	30	20	20	26	16	M10	M8	5
	246/296	26	30	20	20	26	24	M12	M10	5
	346/396	26	30	20	20	26	30	M12	M10	5
	396	36	40	20	26	36	36	M16	M10	5
	446	36	40	20	26	36	40	M20	M12	5
	496	36	40	20	26	36	40	M20	M12	5
2 y 3	596	60	50	30	36	46	40	M20	M12	5
	696	60	50	30	36	46	40	M20	M12	5
	796	60	50	30	36	46	40	M20	M12	5
	896	60	50	30	36	46	40	M20	M16	5
	>896*	66/76*	50	40	46	56/76*	50/60	M24	M20	5

Mold

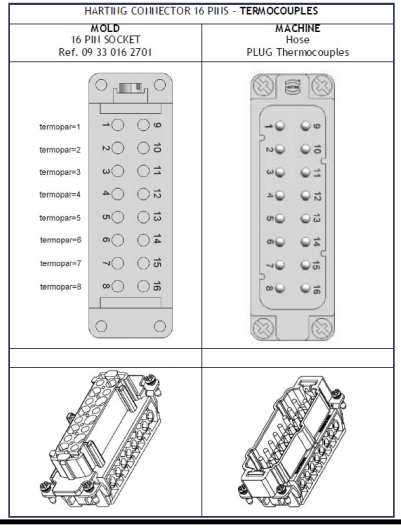
NO

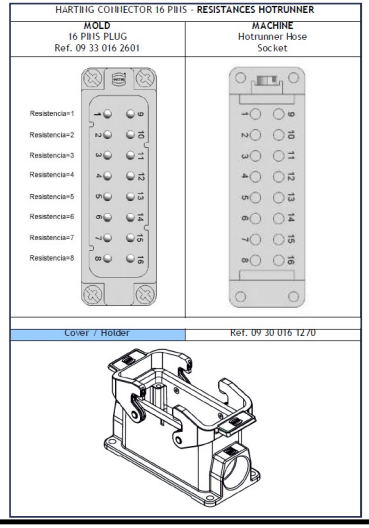
Design

Clamp slot ejection side

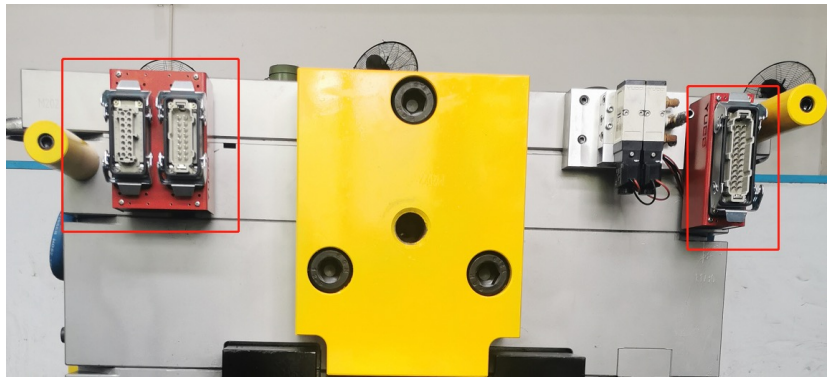
Hot runner

Standard

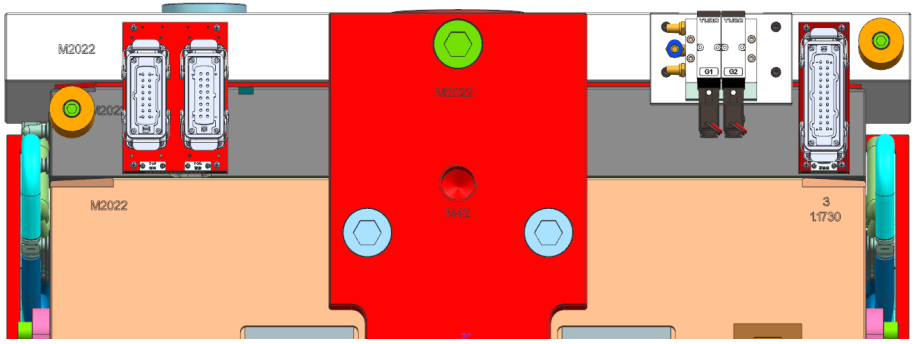


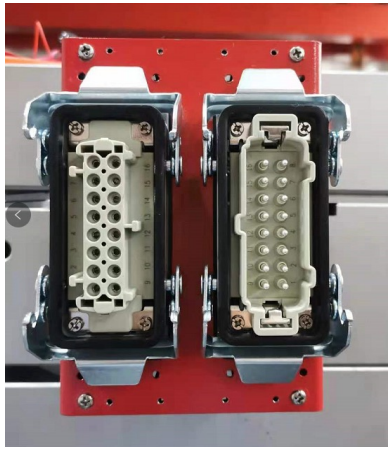


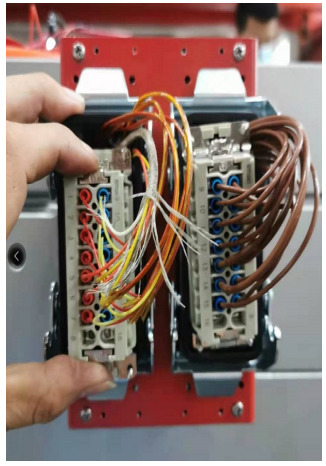
Mold

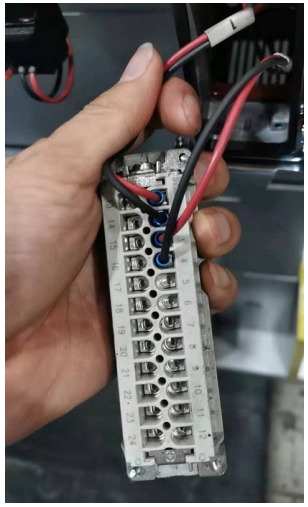


Design









Hot runner connections

Hot runner

Standard

Machines	Sitting radius	∅ Mold Sprue	∅ Machine Sprue
110TM - 170TM	R25.4	∅ 6	∅ 5
250TM - 650TM		∅ 8	∅ 7
680TM -1800TM		∅ 10	∅ 9

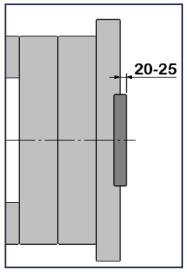
Mold

Design

Injector screw radius

Standards

Standard



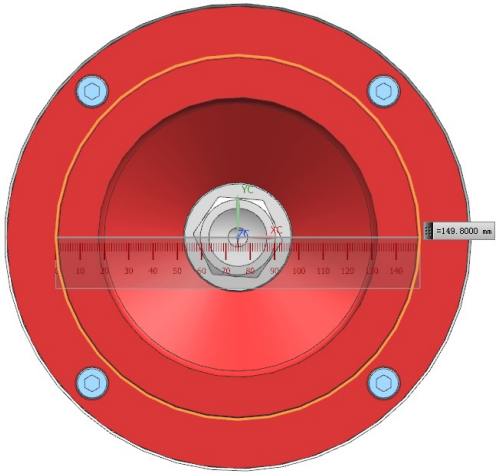
Spain

Machine	Cavity centering ring (mm)	Core centering ring (mm)
110Tn - 170Tn	∅ 99.8	NO
250Tn - 1800Tn	∅ 149.8	∅ 149.8

Romania

Machine	Cavity centering ring (mm)	Core centering ring (mm)
40Tn - 320Tn	∅ 99.8	∅ 79.8
550Tn - 1300Tn	∅ 149.8	∅ 149.8

Design

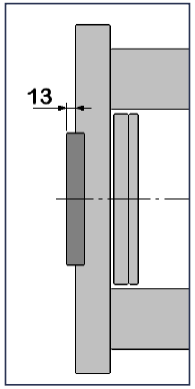


Mold

Location ring injection side

Standards

Standard



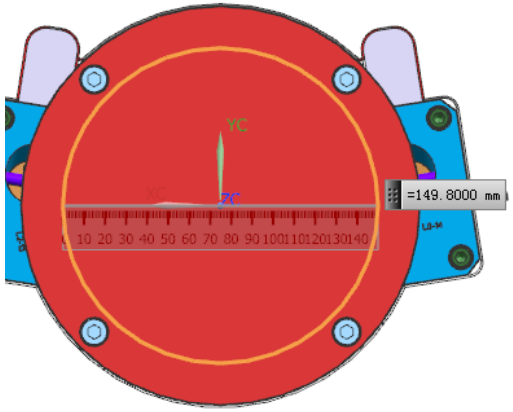
Spain

Machine	Cavity centering ring (mm)	Core centering ring (mm)
110Tn - 170Tn	∅ 99.8	NO
250Tn - 1800Tn	∅ 149.8	∅ 149.8

Romania

Machine	Cavity centering ring (mm)	Core centering ring (mm)
40Tn - 320Tn	∅ 99.8	∅ **79.8**
550Tn - 1300Tn	∅ 149.8	∅ 149.8

Design

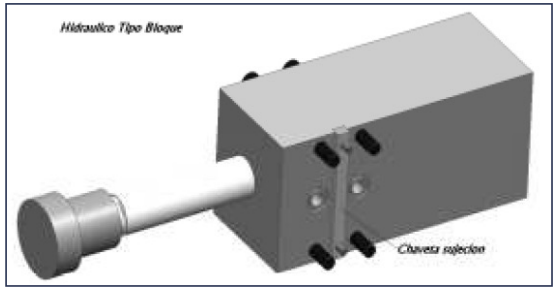


Mold

Location ring ejection side

Standards

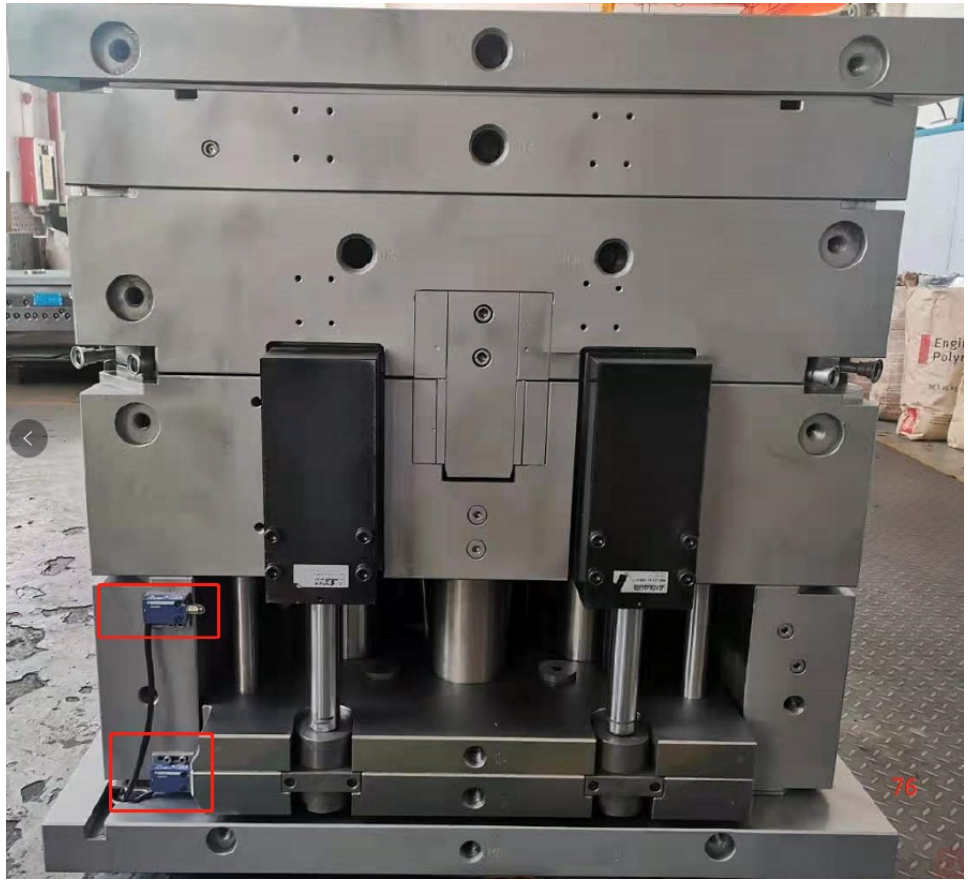
Standard



Machines	Ø Piston (mm)
110 TM -250 TM	∅32
320 TM -700 TM	∅50-∅63
700 TM -1800 TM	∅63-∅80

Design

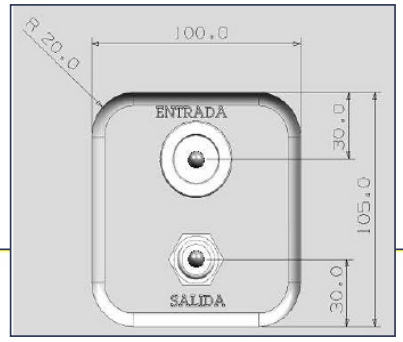
Mold



Hydraulics

Standards

Standard



* Available with Nitrile seal (NBR) : cancel "/JV" code in the part-number

MPX 10

Threads	Dimensions (mm)						Part numbers	
	Socket			Plug		Plug and socket connected	Socket	Plug
F	A	B	C/flats	D	E/flats	G		
G 3/8	65	32	30	60	27	109	MPX 10.1102 / JV *	MPX 10.7102 / JV *

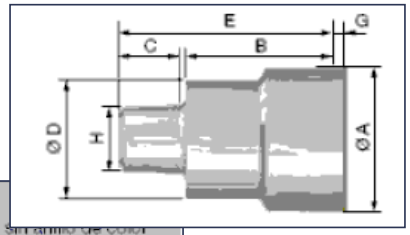
Mold

Design

Hydraulic connections

Standards

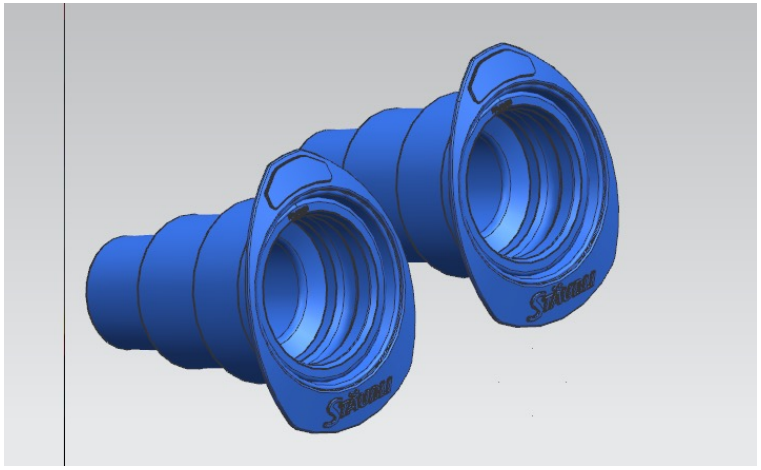
Standard



Modelo	Rosca H	Dimensiones (mm)							Sin anillo de color
		ØA	B	C	ØD	E	G	Llave hexagonal	
RPL 06	R 1/8	17	18.5	7.5	14	28.5	1.5	6	RPL 06.1150
	NPT 1/8	17	18.5	7	14	28.5	1.5	6	RPL 06.1250
	R 1/4	17	15.5	11	14	28.5	1.5	6	RPL 06.1151
	NPT 1/4	17	-	11	-	29.5	1.5	6	RPL 06.1251
RPL 08	R 1/8	21	22	8	17.5	32	1.5	6	RPL 08.1150
	NPT 1/8	21	22	7	17.5	32	1.5	1/4"	RPL 08.1250
	R 1/4 (G)	21	21	10	17.5	33	1.5	8	RPL 08.1151
	NPT 1/4	21	21	11	17.5	33	1.5	5/16"	RPL 08.1251

Mold

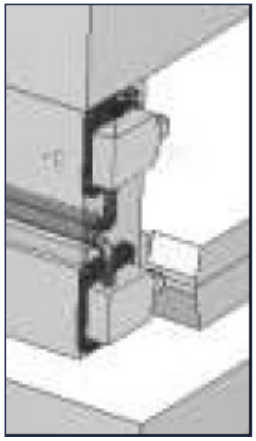
Design

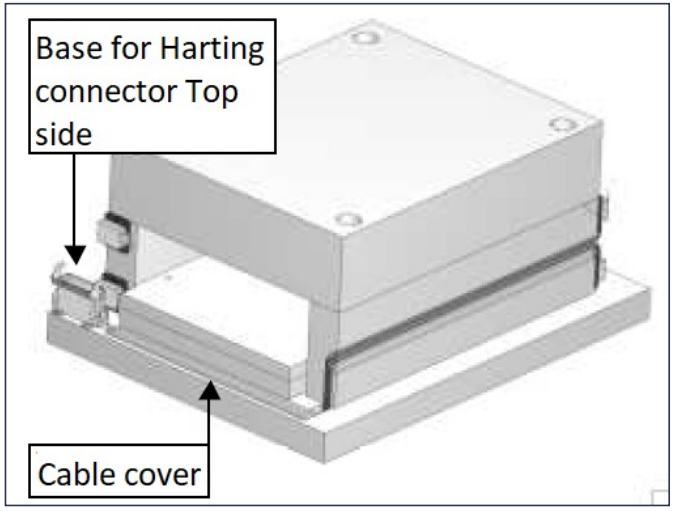


Cooling connector plug

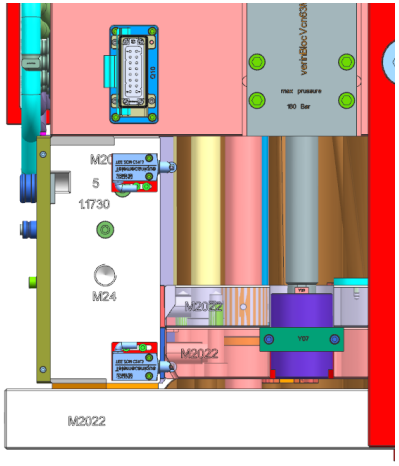
Standards

Standard

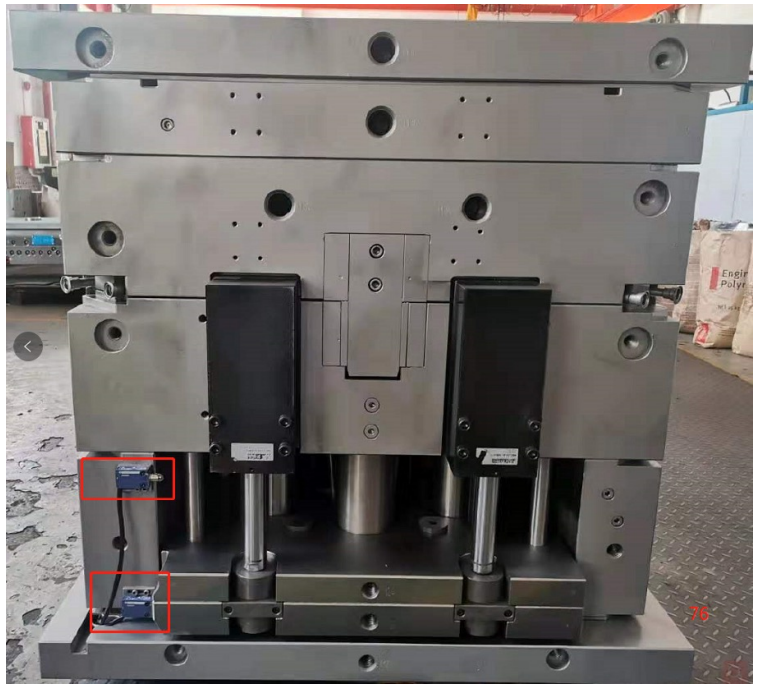




Design



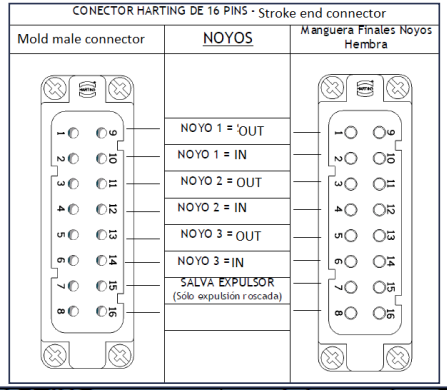
Mold



Location of limit switch with connector plug

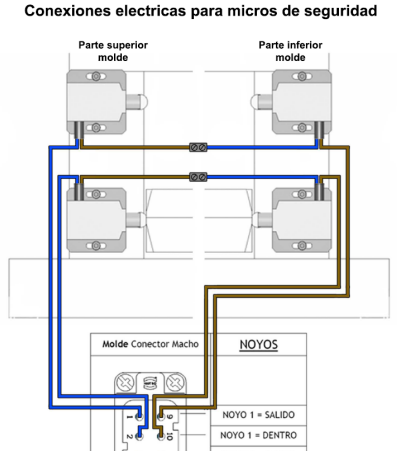
Standards

Standard



Conector HARTING	Interruptor TELEMECANIQUE
Macho-09 20 016 2612 Hembra-09 20 016 2812 Base- 09 20 016 0252	XCMD-A1023

Design



Mold

Connections of limit switch with connector plug

Standards

Standard

-***Quick Clamp 280 x 560*** : for injection machines from 250 to 320 TM

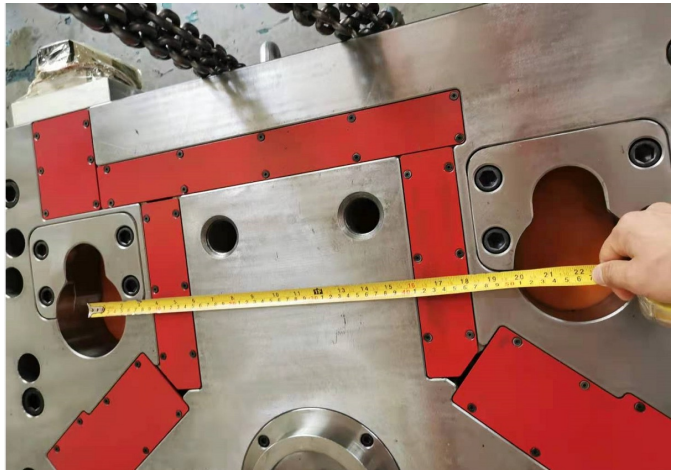
-***Quick Clamp 560 x 560*** : for injection machines from 450 to 850 TM

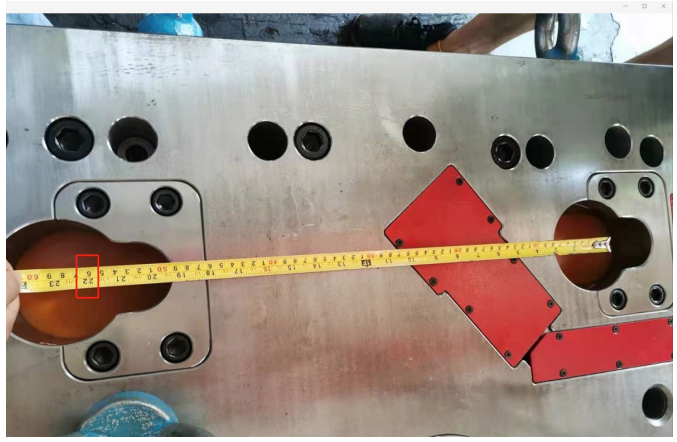
-***Double Quick Clamp 560 x 560 - 840 x 840*** : for injection machines from 1000 Tn. This distribution only is required if the mold could be mounted over 800 TM injection machines because the dimension allows the assembly

-***Quick Clamp 840 x 840*** : for injection machines from 1000 to 1800 TM

Design

Mold





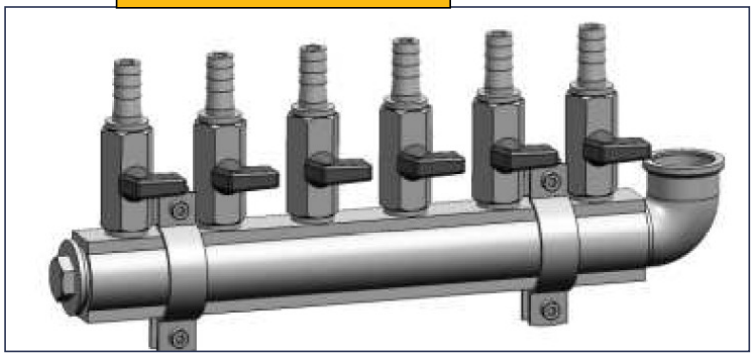
Quick clamping plates

Standards

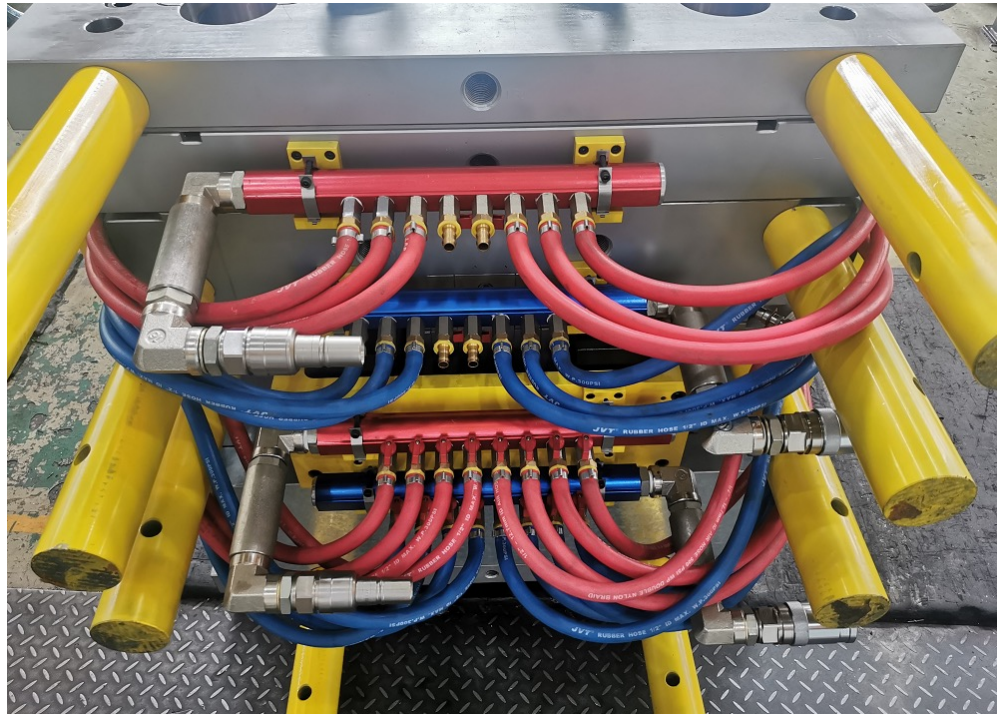
Standard

BLUE = ENTRY

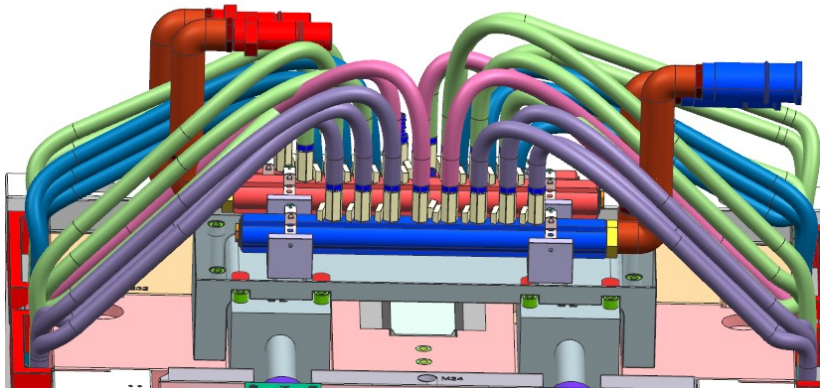
RED = EXIT



Mold



Design



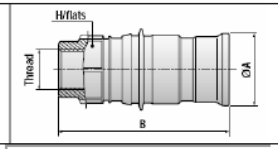
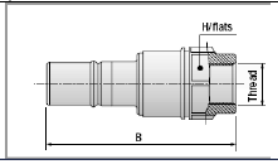
Water manifolds

Standards

Standard

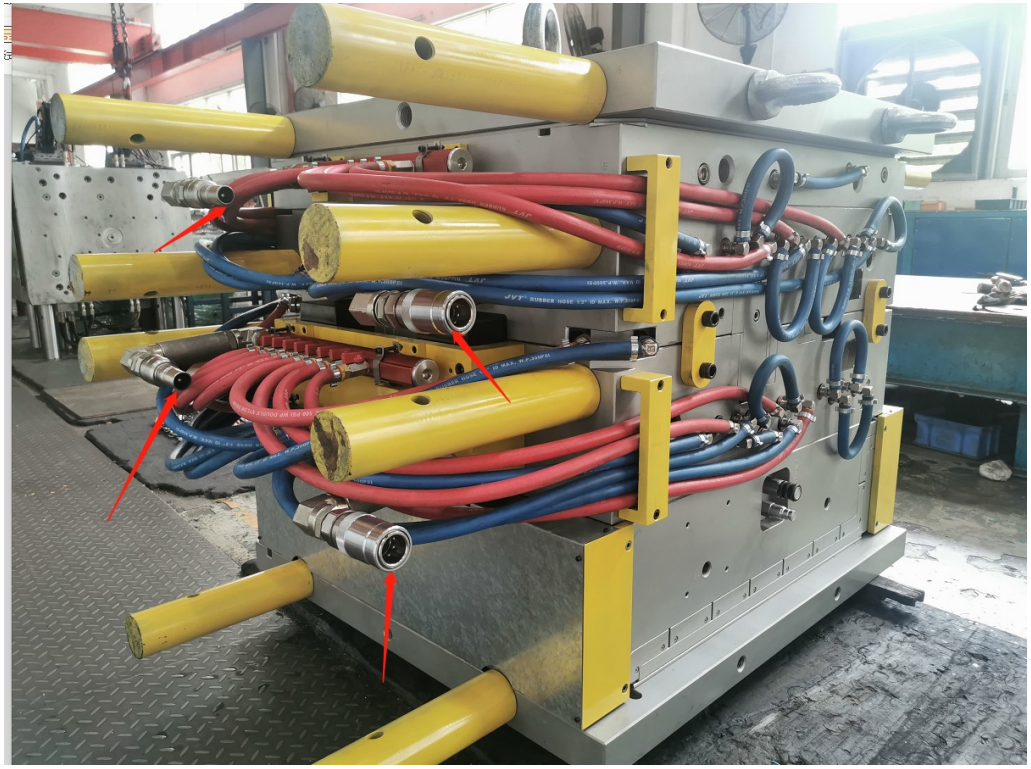
FEMALE = ENTRY

MALE = EXIT

DESIGNATIONS	MODELS	DIMENSIONS (mm)					PART-NUMBERS
		F	ØA	B	H/flats	D	
	RMI 20	G 3/4	53	119.5	42		RMI 20.1104/EA/JV
	RMI 20	G 3/4	126.5		42		RMI 20.7104/EA/JV

Design

Mold



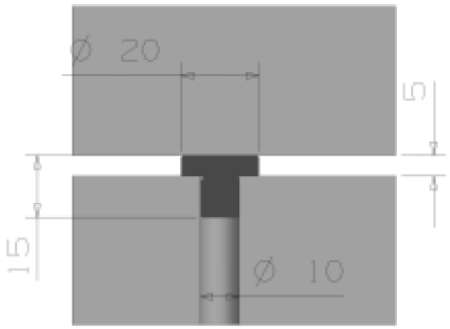
Staubli original components

Standards

Standard

7.3 EJECTION STOPPERS (EJECTION MUSHROOMS)

The ejection stoppers will be the same for all the molds. See below picture:



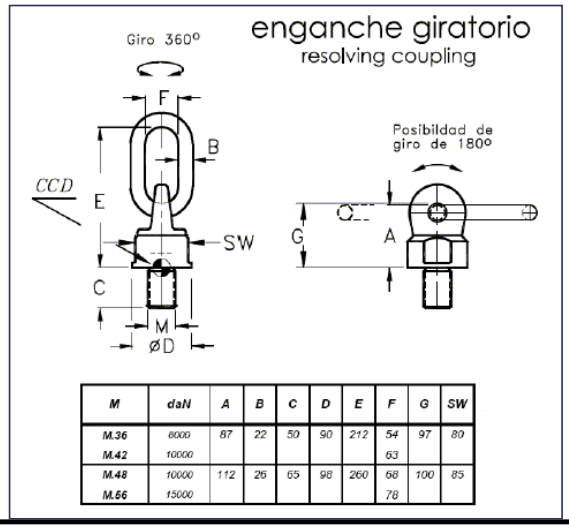
Design

Mold

Ejection stoppers

Standards

Standard



M	daN	A	B	C	D	E	F	G	SW
M.36	8000	87	22	50	90	212	54	97	80
M.42	10000						63		
M.48	10000	112	26	65	98	260	68	100	85
M.56	15000						78		

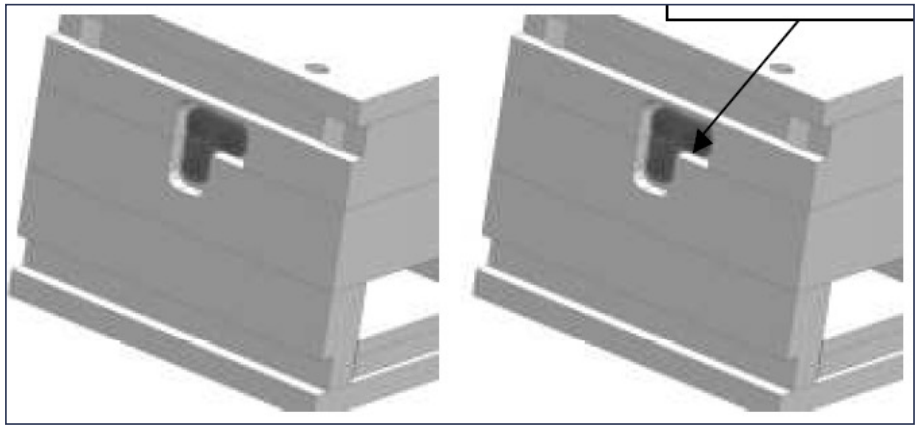
Design

Mold

Eyebolts

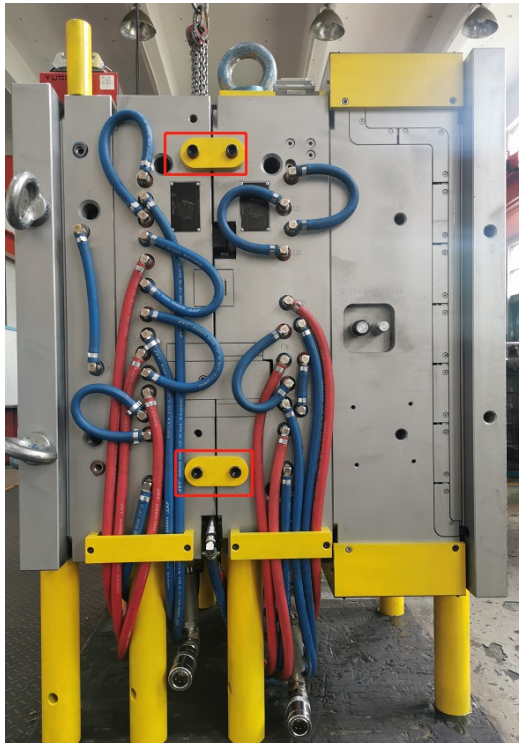
Standards

Standard



Design

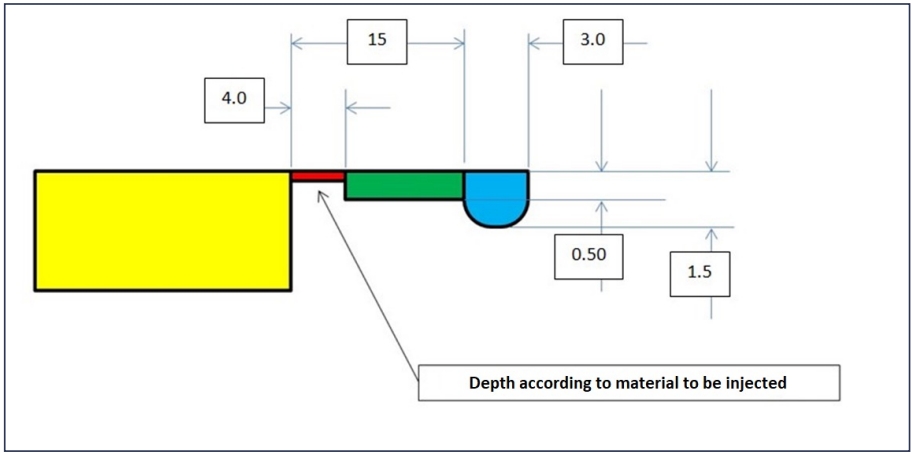
Mold



Safe locks

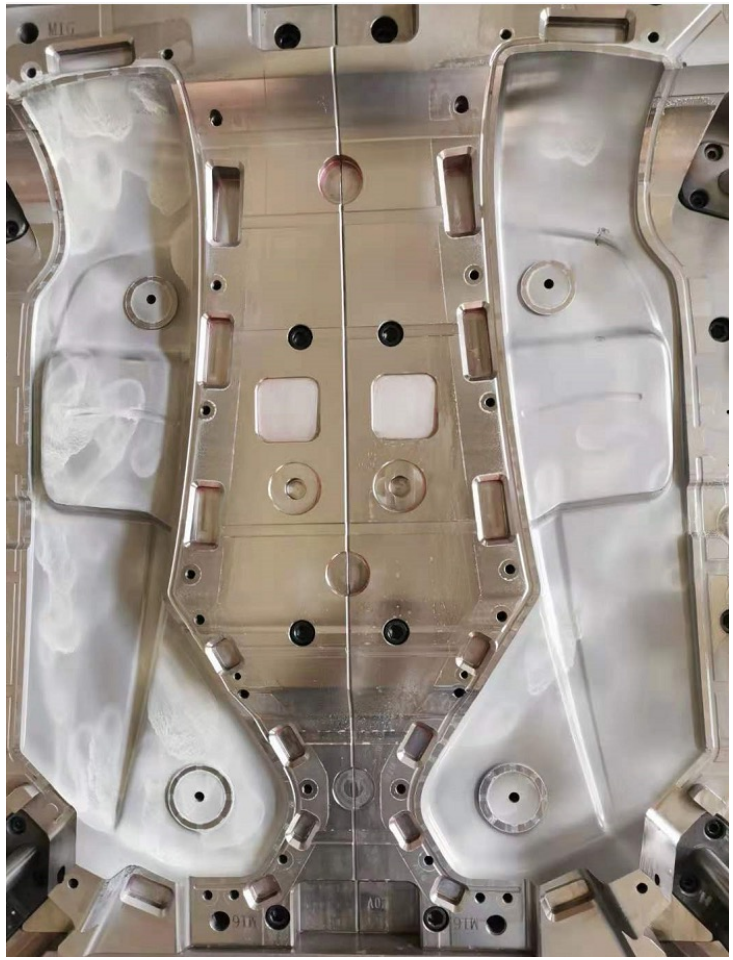
Standards

Standard



Design

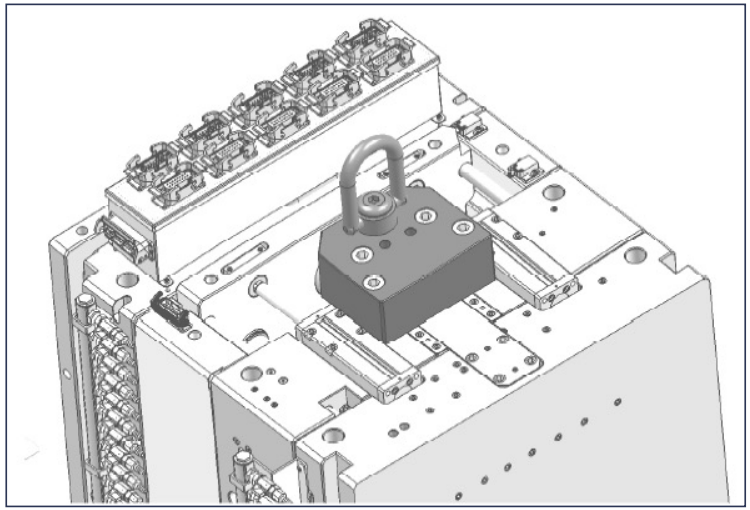
Mold



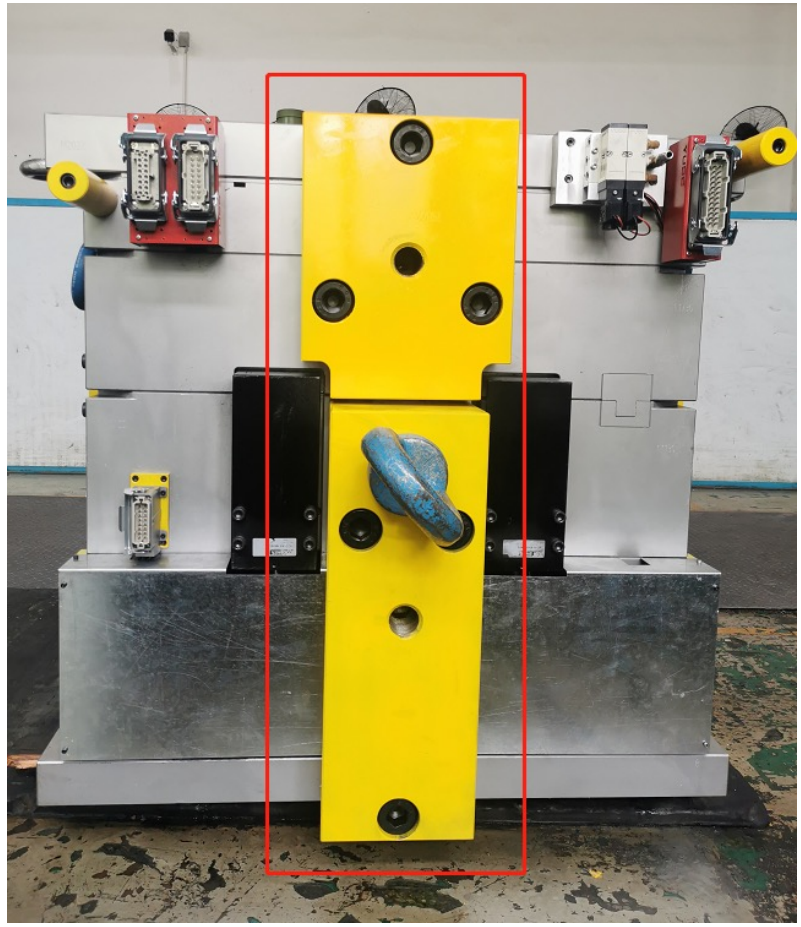
Gas venting 排气

Standards

Standard



Mold



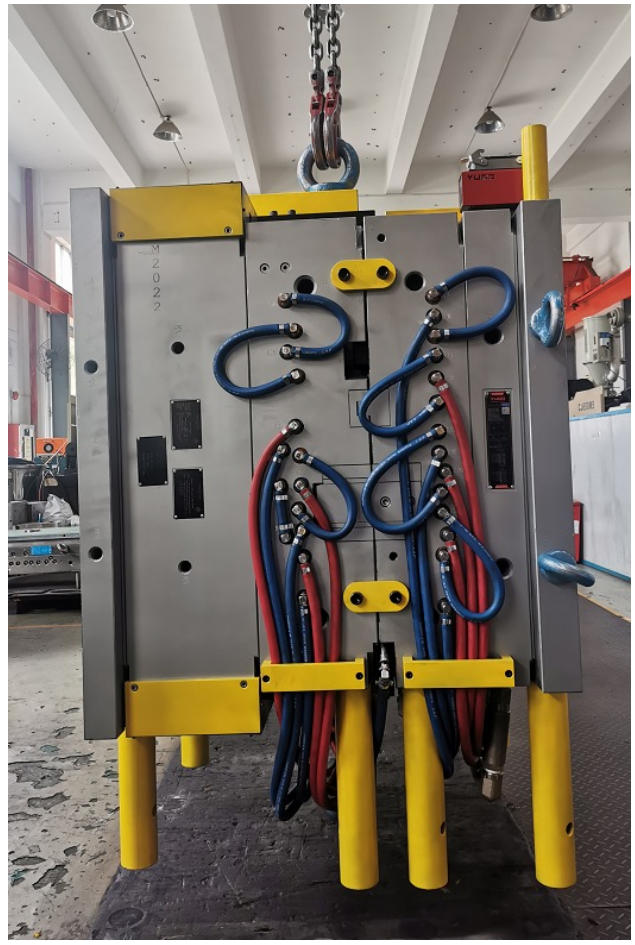
Design

Lift bar

Standards

Design

Mold



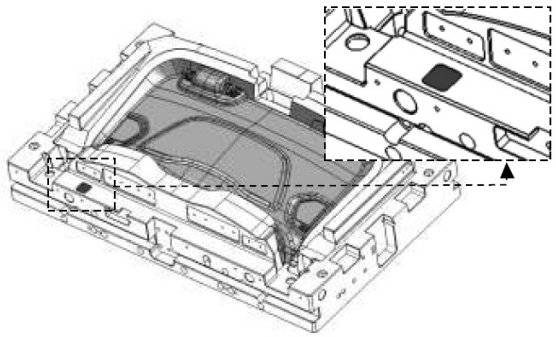
Balanced lifting

Texture

Standard

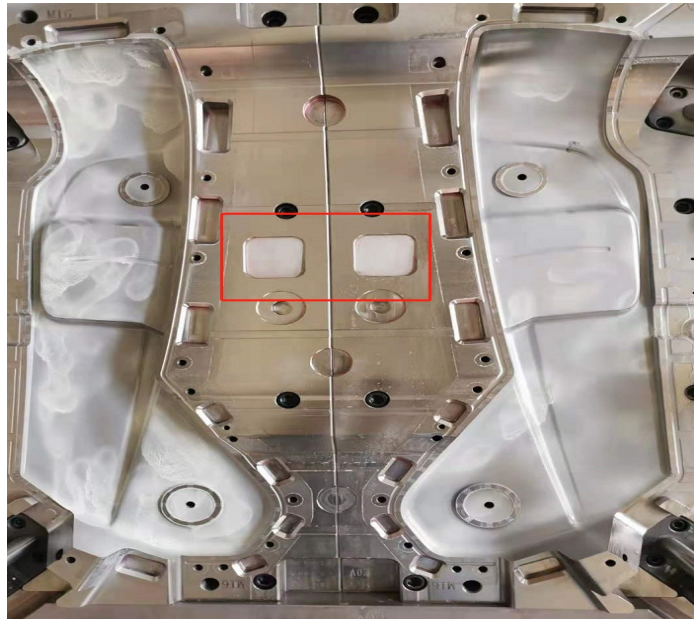
2.6.2 SAMPLE FOR TEXTURE

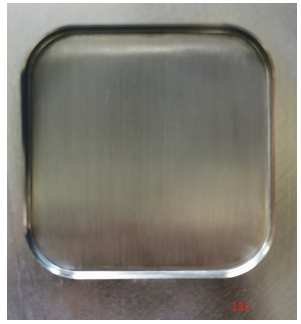
The cavities will be being acid etched or textured must have a 50x50mm area in the closing area and must be marked. This area must be polished as the rest of cavity to be etched and to be test of texture during lifecycle of mold.



Design

Mold

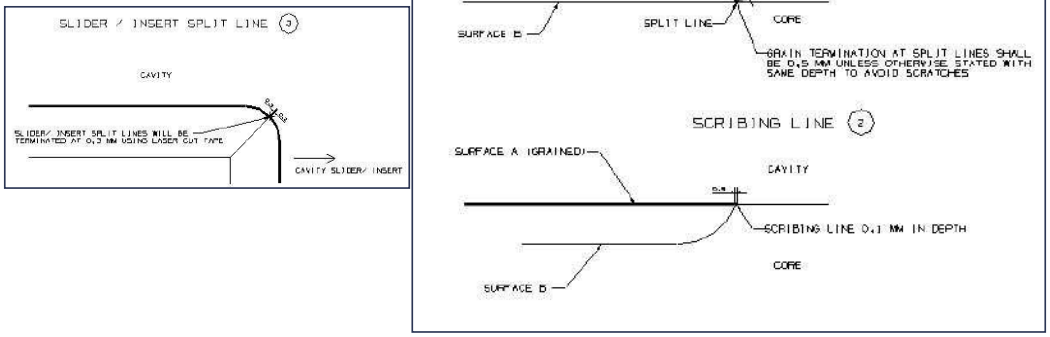




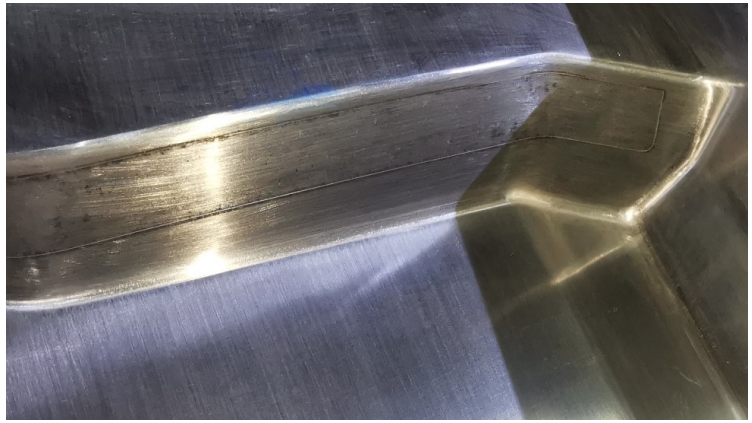
Texture sample

Texture

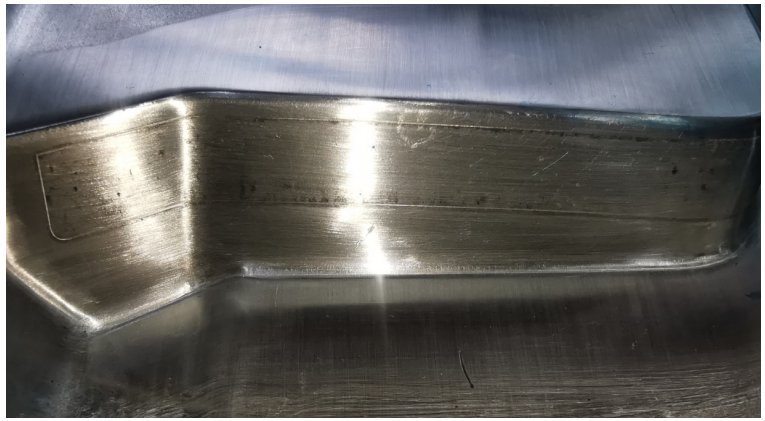
Standard



Mold



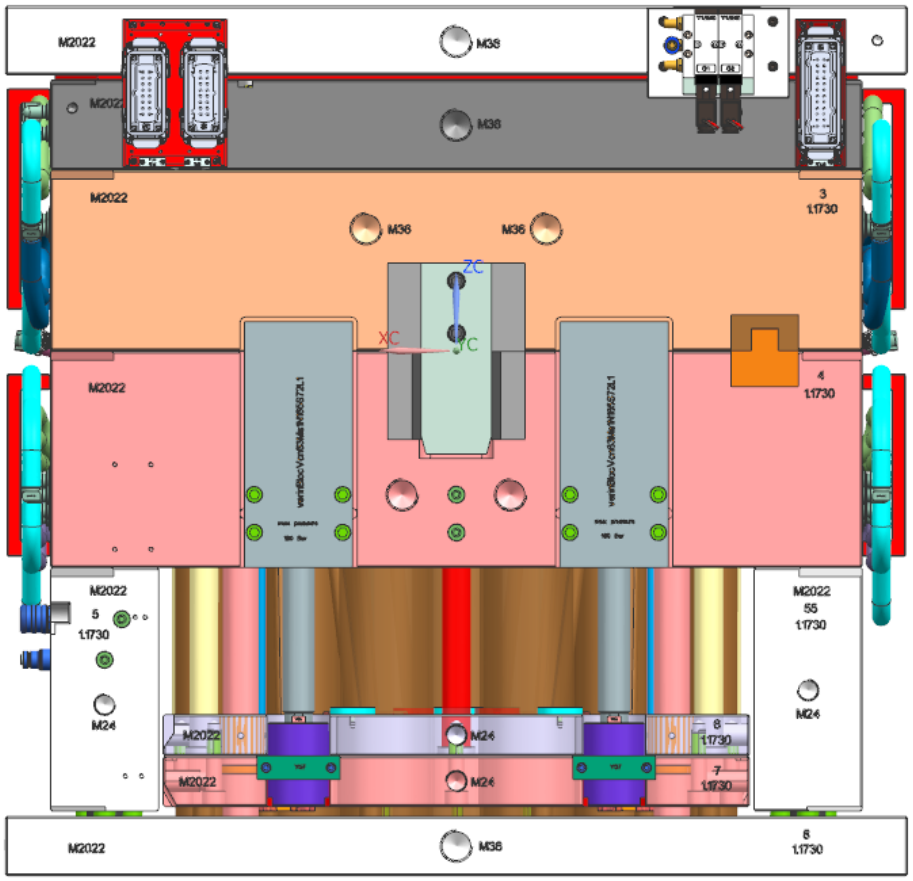
Design



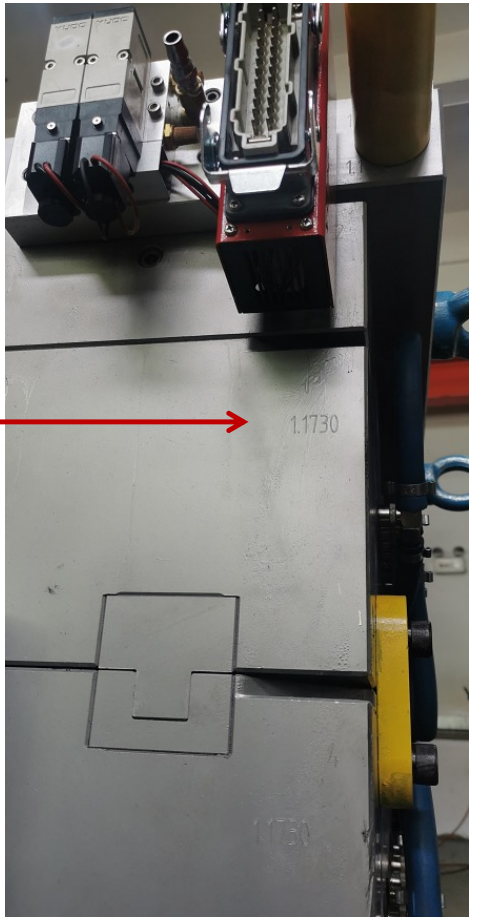
Scribing lines

Engravings

Design



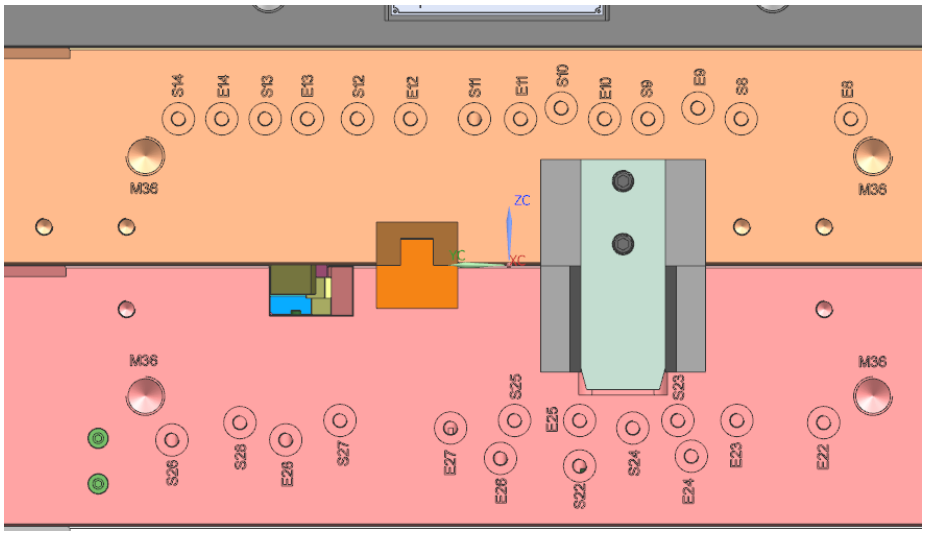
Mold



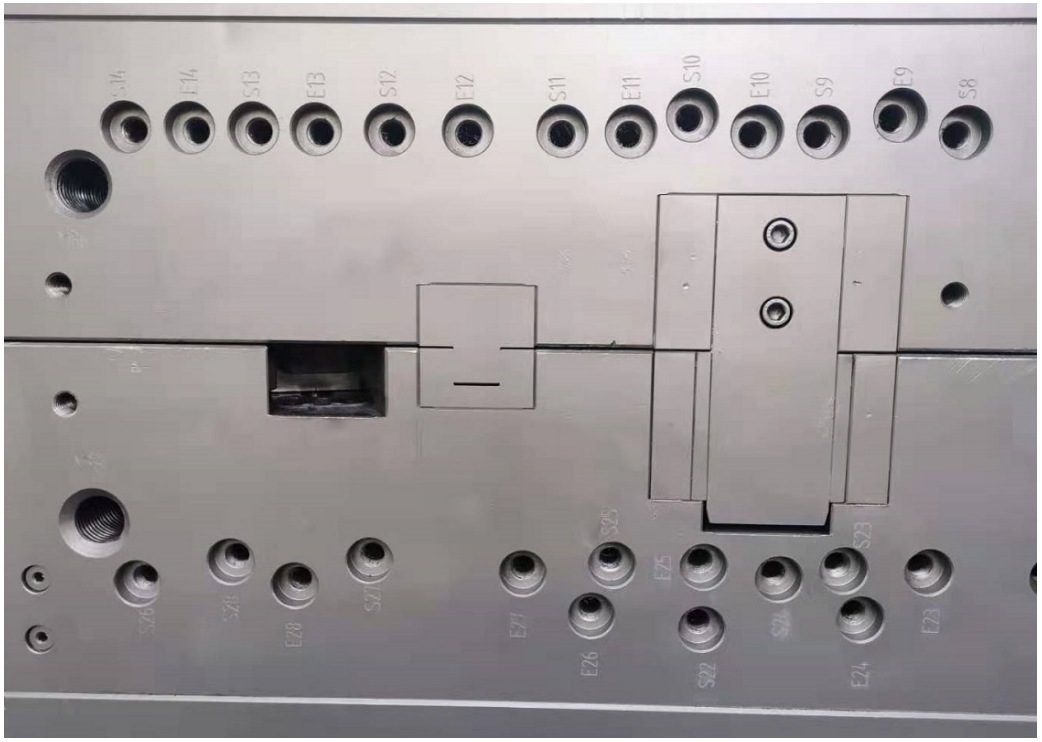
Mold base

Engravings

Design



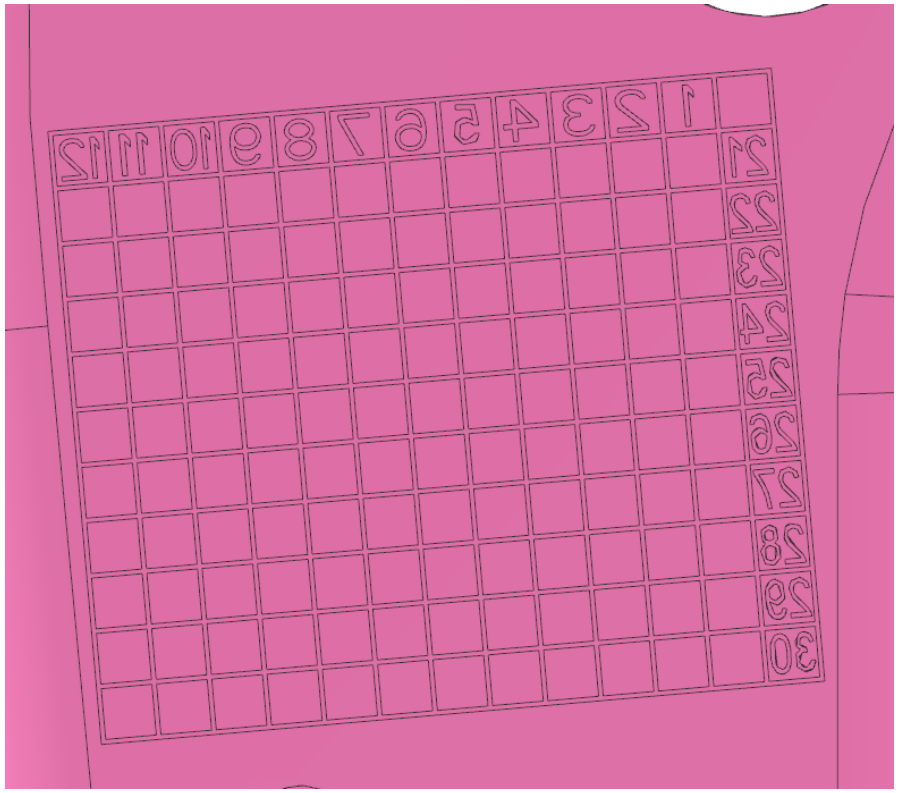
Mold



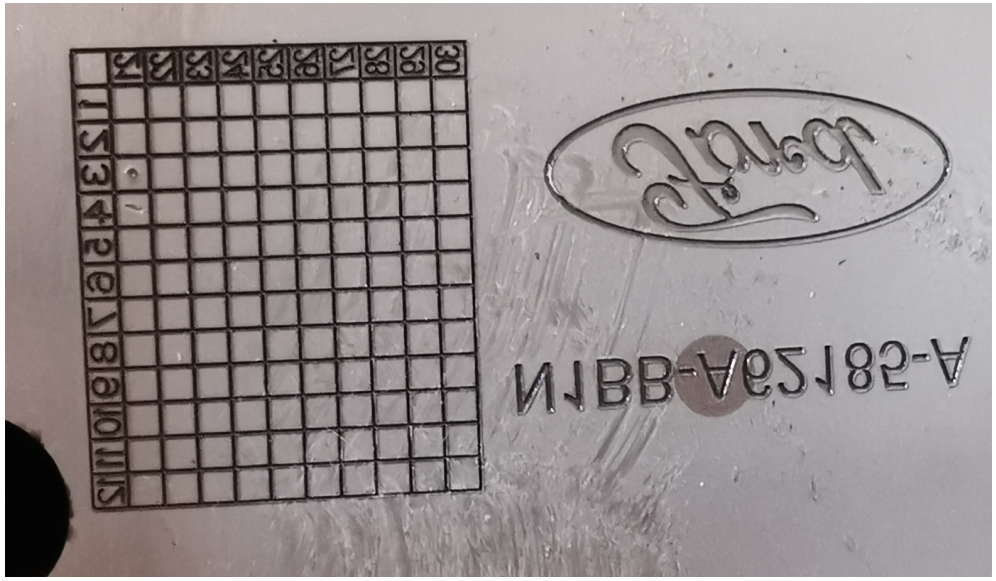
Cooling

Engravings

Design



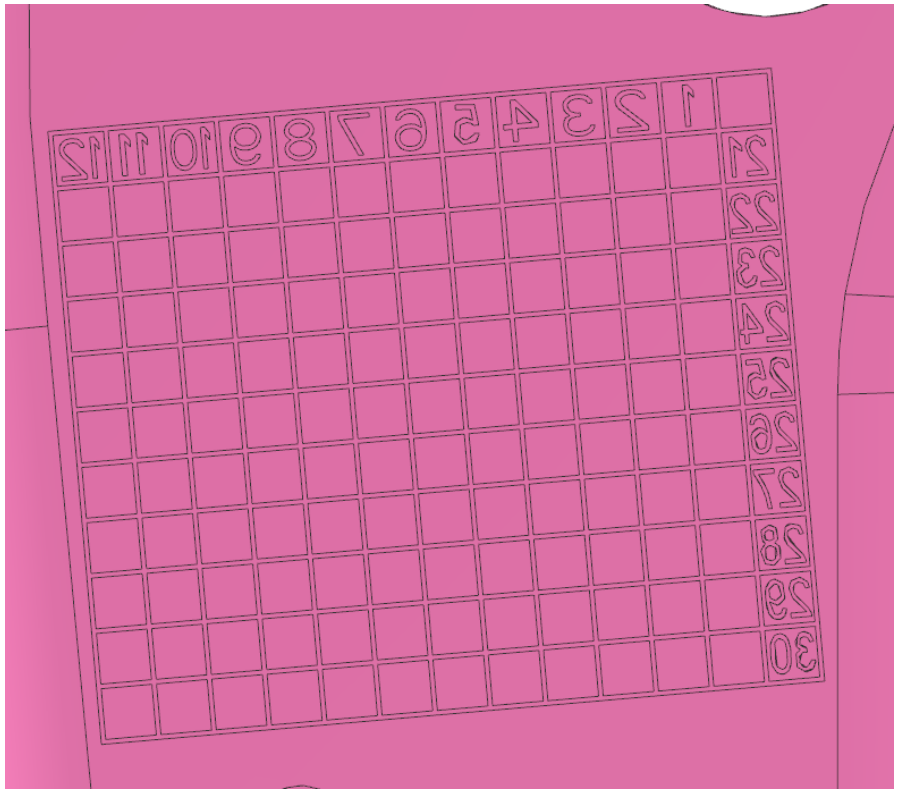
Mold



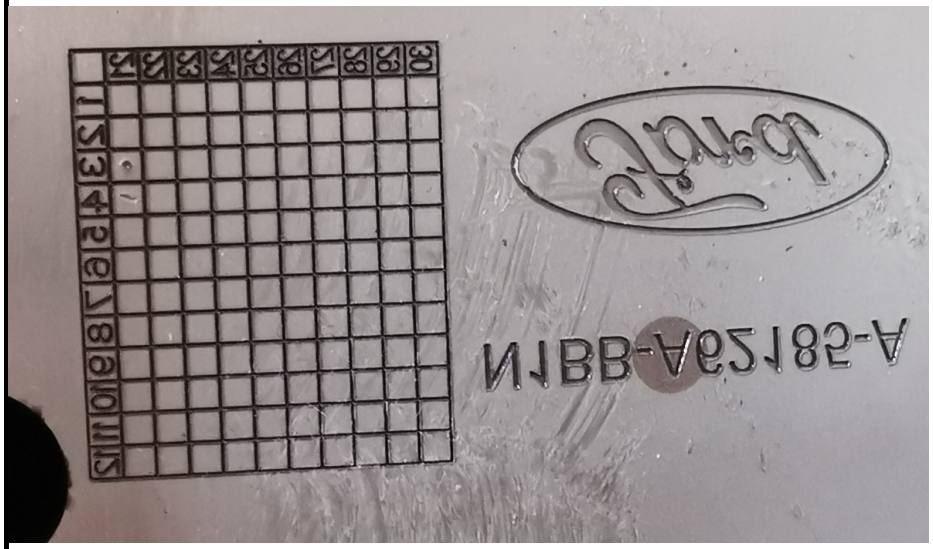
Position of original CUMSA date clocks

Engravings

Design



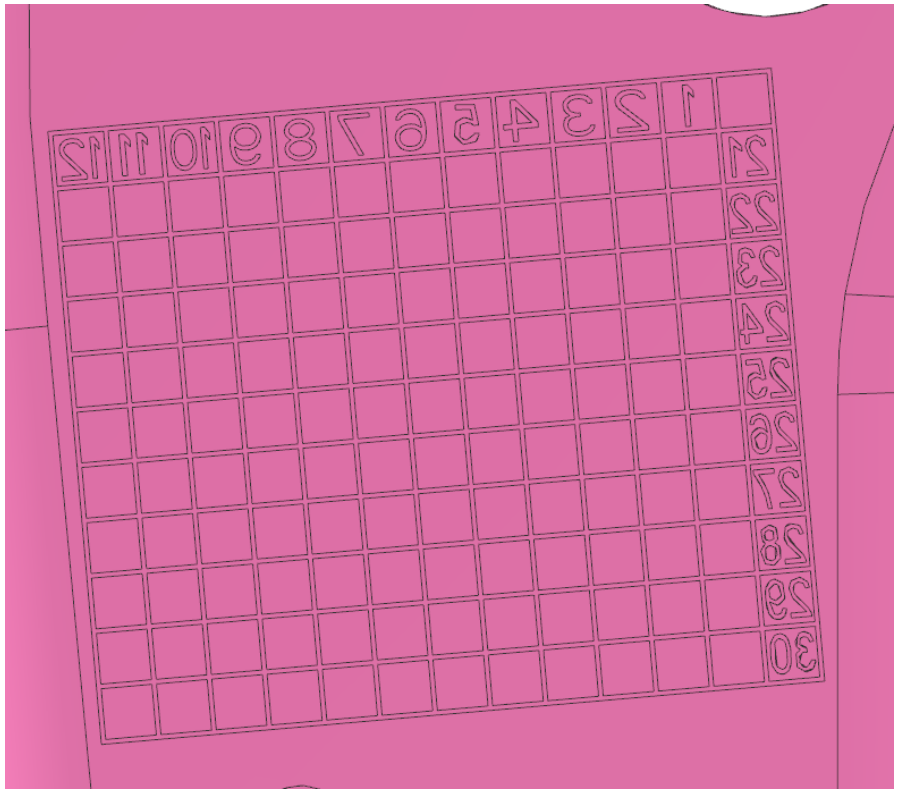
Mold



Dimensions of original CUMSA date clocks

Engravings

Design



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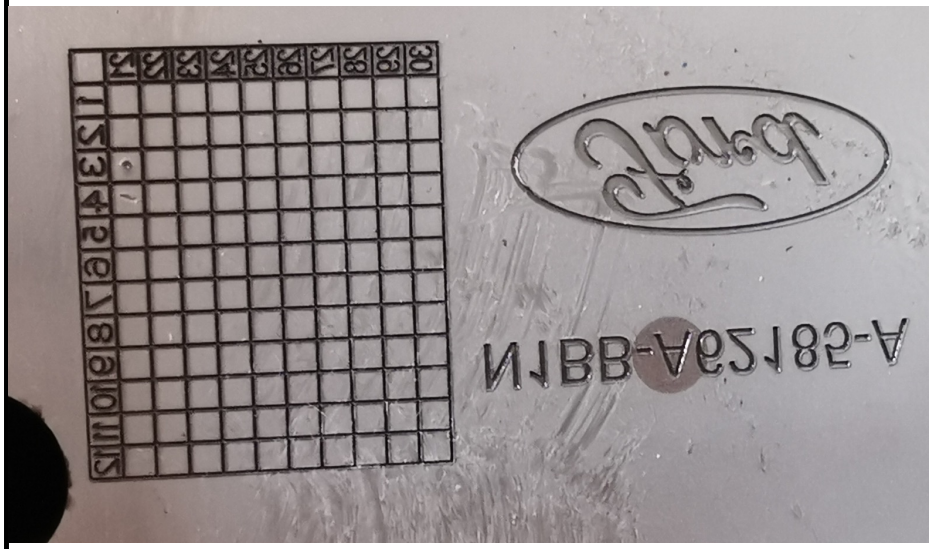
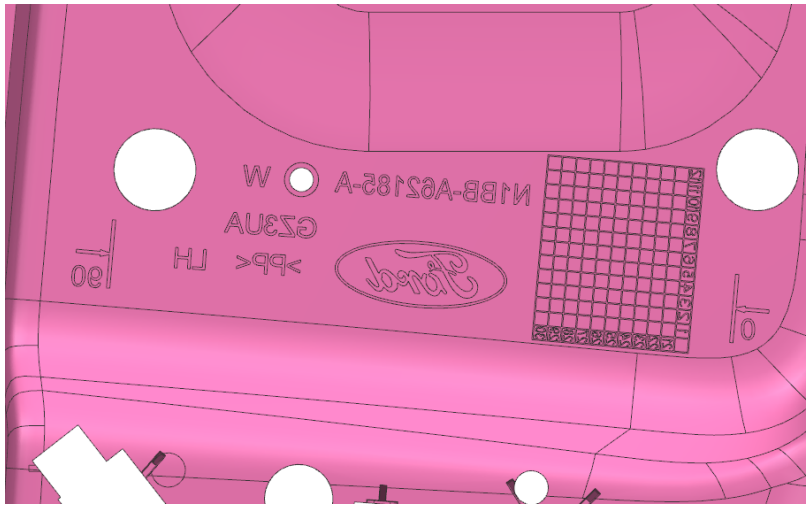
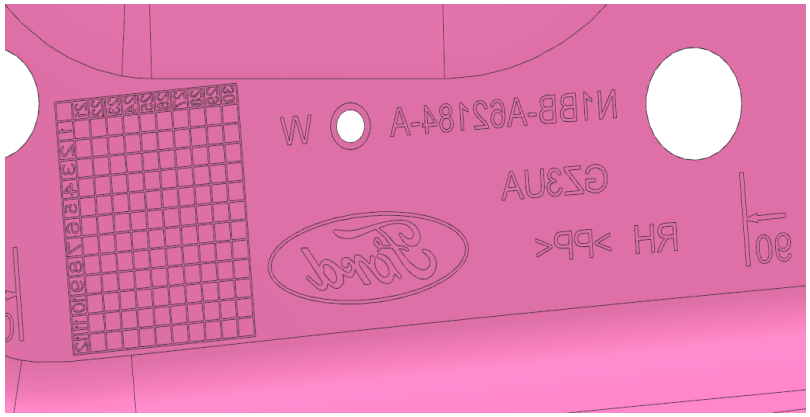


Functioning of original CUMSA date clocks

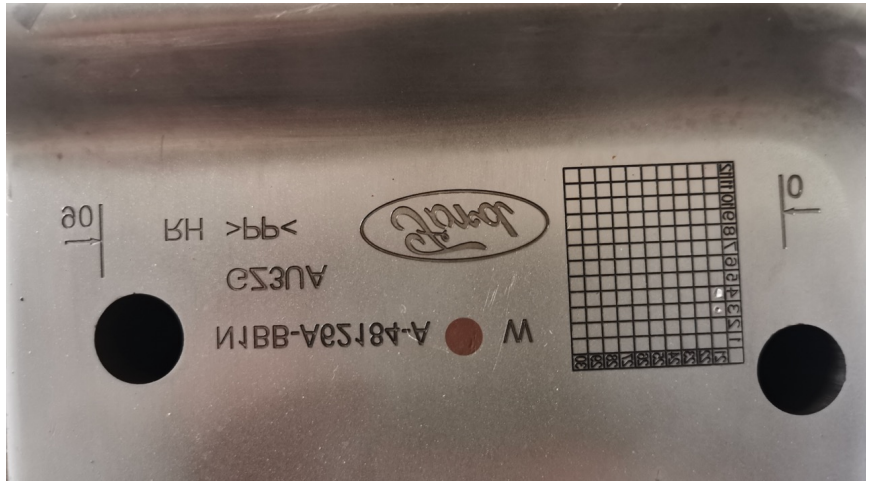
Engravings

Design





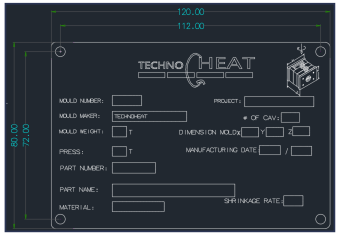
Mold

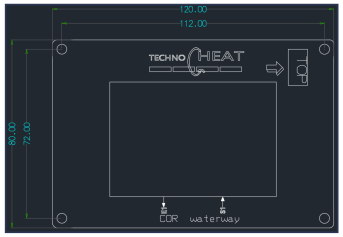


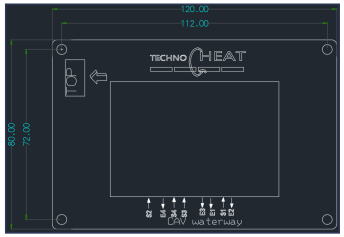
Part reference

Engravings

Standard







1234

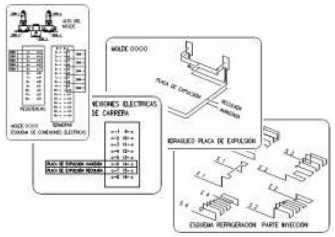
CVR ASY TRIM BDY PLR (PILLAR TYPE)

B-XXX

PROPERTY OF CLIENT

WEIGHT – 9.999 Kgs

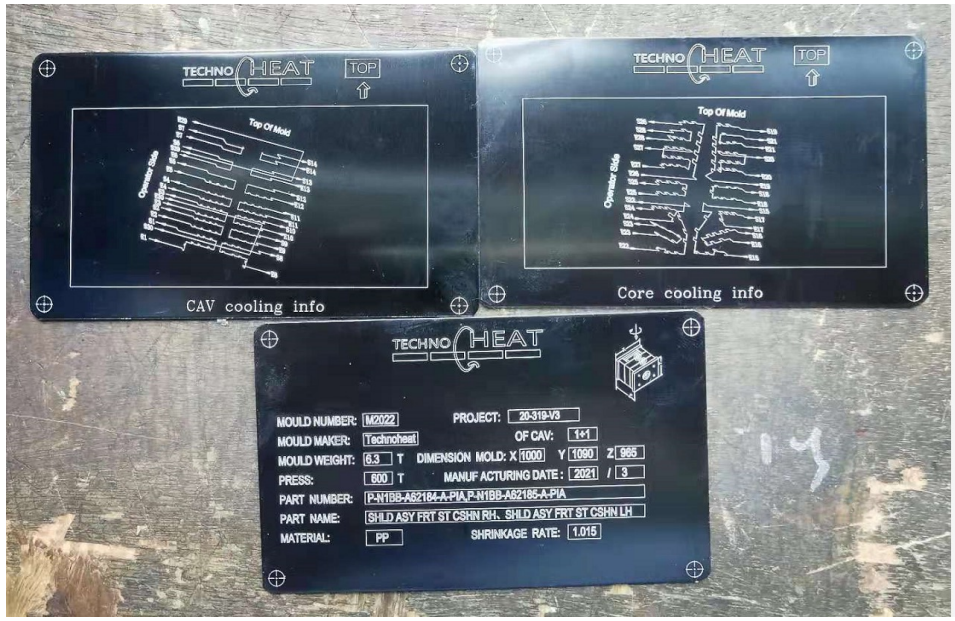
- Hot runner system
- Oil Circuits
- Cooling Circuits
- Mold Kinematics
- Electrical Connection

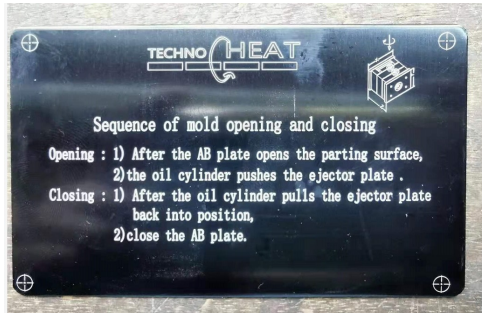


ALUMINIUM BACKGROUND with con ENGRAVING IN BLACK COLOR

Design

Mold



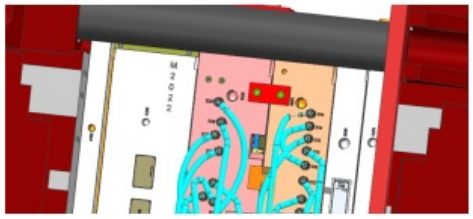


Nameplates

Engravings

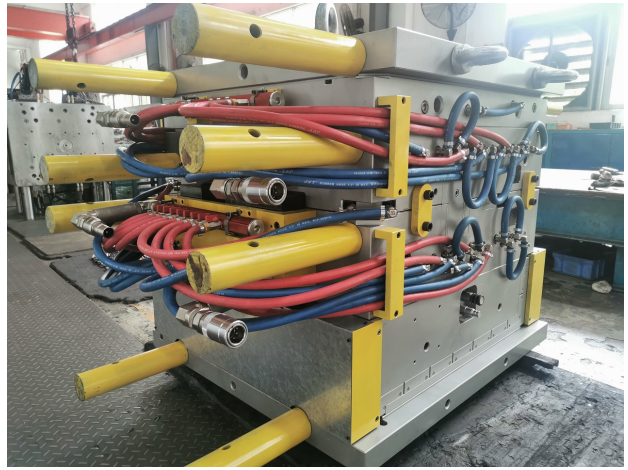
Standard

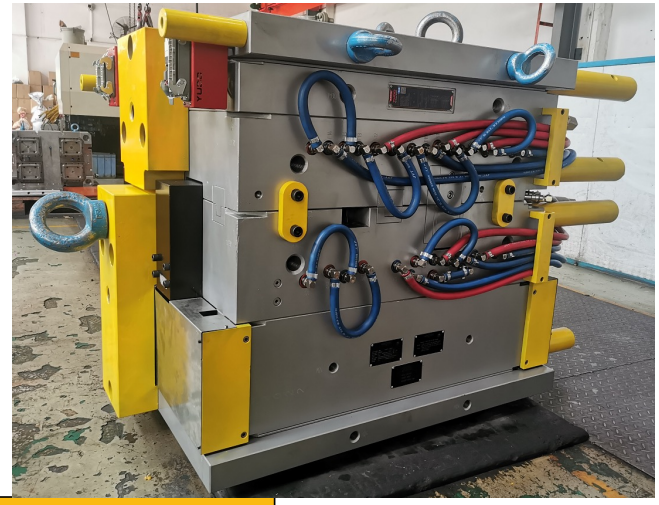
	Colour Name	Descripcion de Color	RAL
	Sulphur Yellow	Amarillo Azufre	1016
	Dahlia Yellow	Amarillo Dalia	1033
	Pure Orange	Naranja Puro	2004
	Wine Red	Rojo Vino	3005
	Light Pink	Rosa Claro	3015
	Traffic Red	Rojo Tráfico	3020
	Blue Lilac	Lila Azulado	4005
	Signal Violet	Violeta Señal	4008
	Magenta	Magenta	4010
	Light Blue	Azul luminoso	5012
	Turquoise Blue	Azul Turquesa	5018
	Pastel Green	Verde Blanquecino	6019
	Mint Green	Verde Menta	6029
	Traffic Grey A	Gris Tráfico A	7042
	Traffic Grey B	Gris Tráfico B	7043
	Ochre Brown	Marrón Ocre	8001
	Signal Brown	Marrón Señales	8002
	Jet Black	Negro Intenso	9005
	Pure White	Blanco Puro	9010



	Pearl Grey	Gris perla	7025	SPORT SEAT

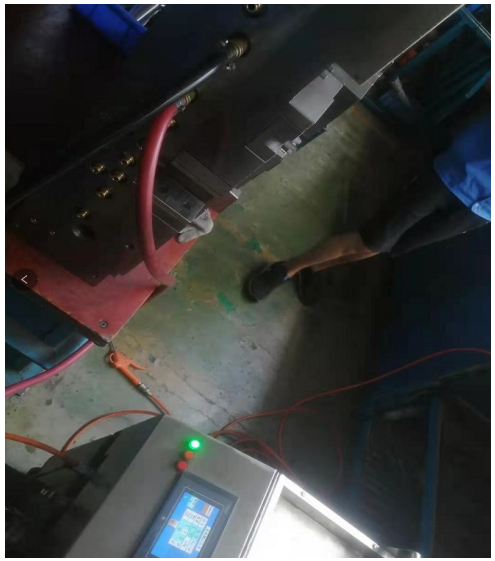
Mold





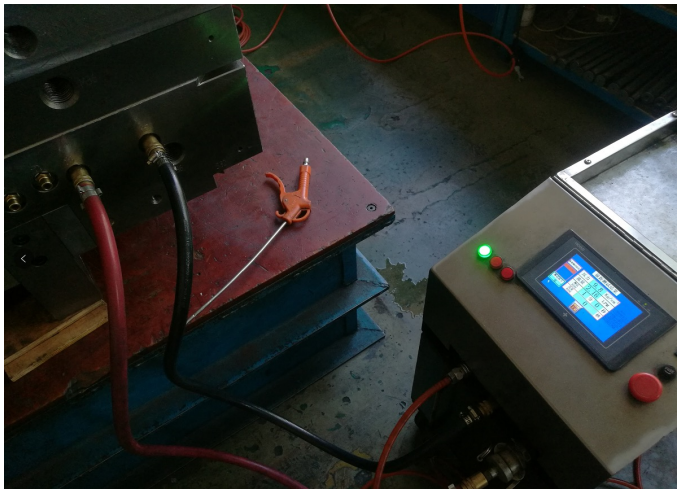
Mold color

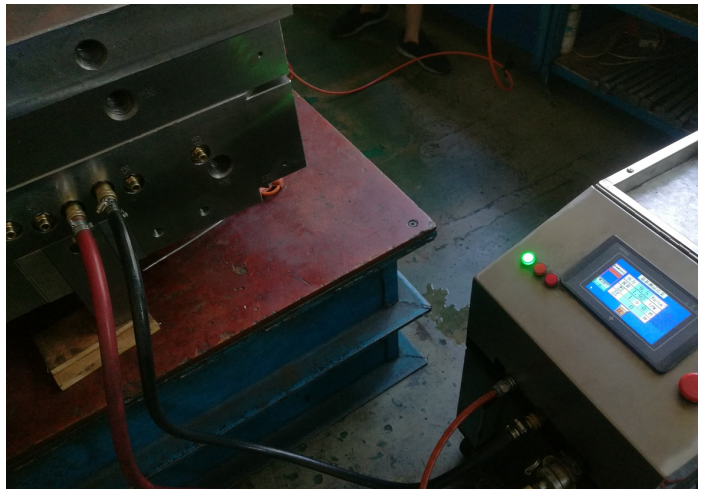
Cooling test

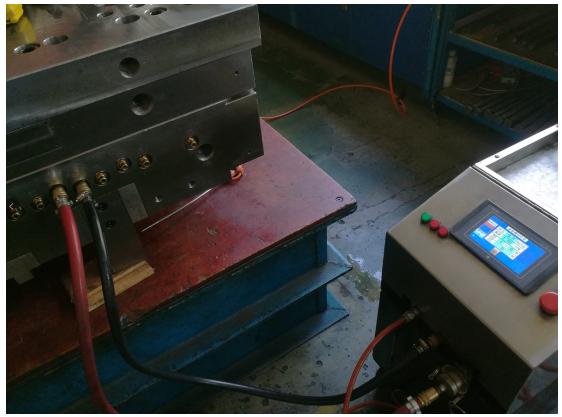


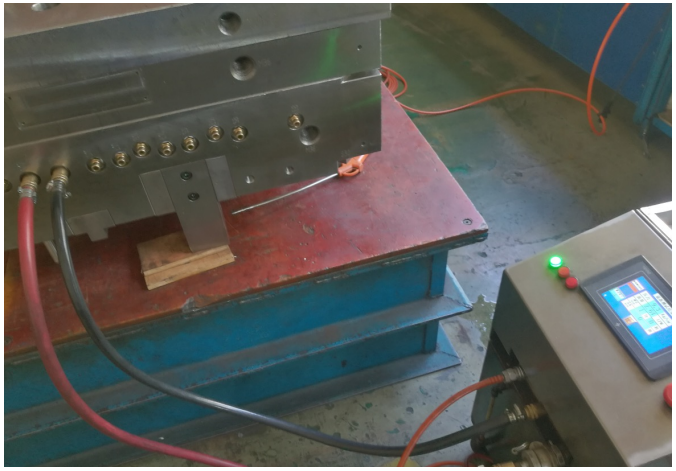
Core cooling test

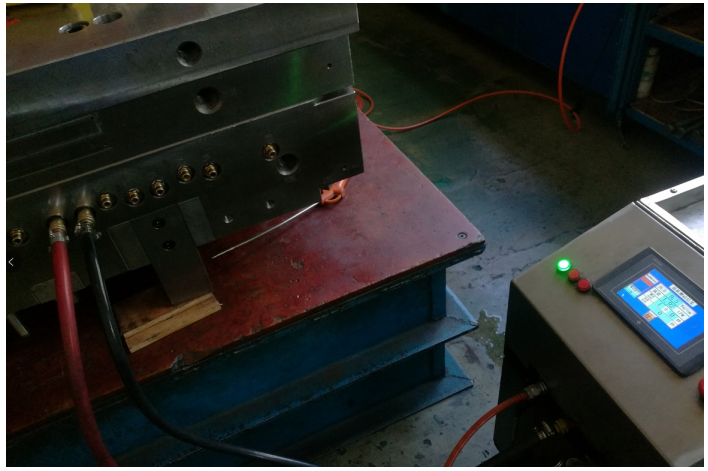
Cooling test





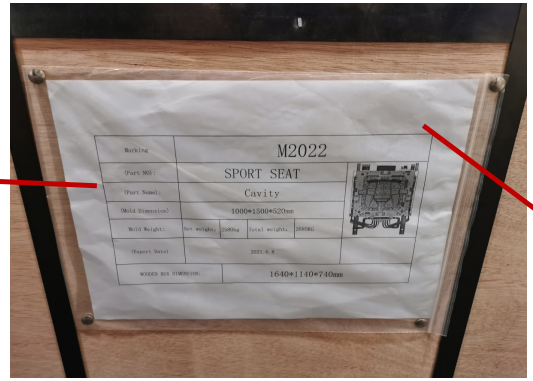


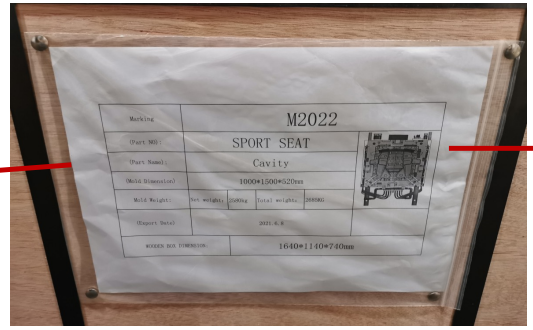




Cavity cooling test

Packaging





Packaging