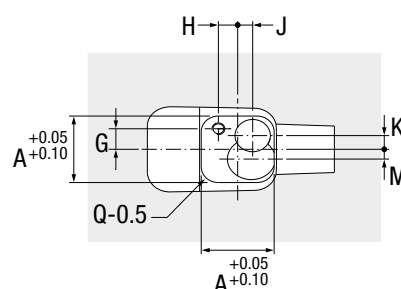
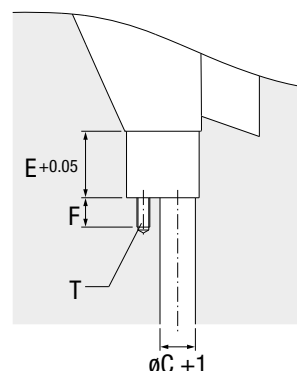
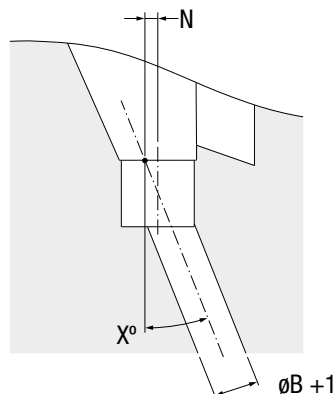
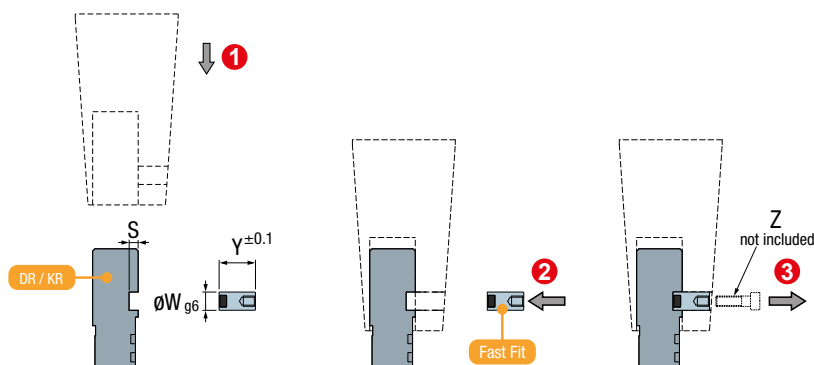


Core Housing
Alojamiento Placa Punzón
Einbaumaße DR Führung
Sede nel Punzone
Alojamento Bucha
Logement dans l'empreinte

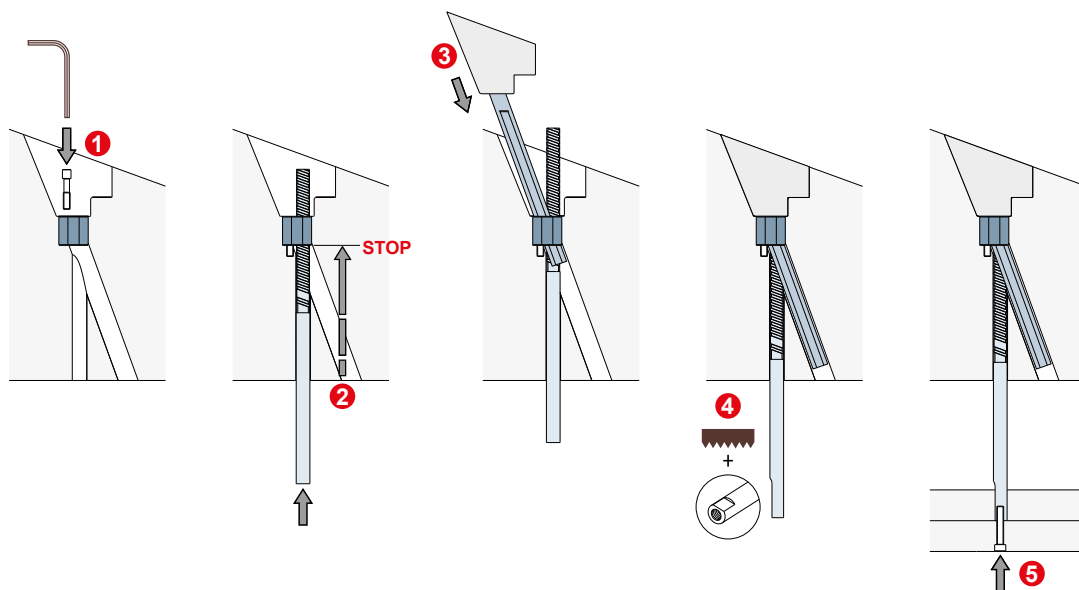


Stroke 100	Stroke 125	Stroke 200	F	G	H	J	K	M	N	S	T	W	Y	Z
DR.16100L-..	-	-	10	4.6	4.6	3	2.35	3	2.8	2.5	M5	6	9	M4
DR.22100L-..	DR.22125L-.. / KR.22125L-..	-	13	5.6	5.6	4.2	3.7	4.2	3.5	2.5	M6	8	12	M4
DR.28100L-..	DR.28125L-.. / KR.28125L-..	-	16	7.5	7.5	5	5.4	4.8	4.8	2.5	M8	8	13.5	M4
DR.34100L-..	DR.34125L-.. / KR.34125L-..	-	16	10.5	8	7	7	5	6	4	M8	8	16	M4
DR.40100L-..	DR.40125L-..	-	20	11	11	7	8	7	7	4	M10	10	20	M6
DR.46100L-..	DR.46125L-..	-	25	13	13	8	8	9	9	5	M12	10	24	M6
-	-	KR58200L-..	28	15.5	15.5	10	12.2	11.2	10	5	M14	12	30	M6
-	-	KR76200L-..	36	21	21	13	15.2	15.2	12	6	M18	12	36	M6

FAST FIT: Installation and removal
FAST FIT: Instalación y desinstalación
FAST FIT: Montage und Demontage
FAST FIT: Montaggio e smontaggio
FAST FIT: Instalação e desinstalação
FAST FIT: Montage et démontage



Installation
Instalación
Einbau
Installazione
Instalação
Installation



DR & KR



DOUBLE RACK SYSTEM by CUMSA

EN

DOUBLE RACK SYSTEM BENEFITS

De-moulding strokes from 14mm to 60mm.
Customized drafts.
Big savings in time & cost for machining and adjustments.
Significant reduction to the ejection stroke.
"Mirror" parts available for 1+1 cavities moulds.

ES

VENTAJAS DEL DOUBLE RACK SYSTEM

Permite desmoldear negativos desde 14mm hasta 60mm.
Adaptamos el DR al ángulo de su pieza.
Gran ahorro de tiempo y costes en los mecanizados y el ajuste.
Reducción significativa del recorrido de expulsión.
Piezas simétricas para moldes de 1+1 cavidades.

DE

VORTEILE DES DOUBLE RACK SYSTEM

Bietet Entformungswege von 14 bis 60mm.
Sonder-Entformungswinkel auf Anfrage.
Hohe Zeit- und Kosteneinsparungen für die Bearbeitung und Anpassung.
Erhebliche Verringerung des Auswerferhubs.
Gespiegelte DR für Symmetrische Artikel in 1+1 Fach Werkzeuge.

IT

VANTAGGI DEL DOUBLE RACK SYSTEM

Permette di liberare sottosquadra da 14 a 60mm.
Adattiamo l'angolo a quello del suo pezzo.
Grande risparmio di tempo e costi nella lavorazione e nell'aggiustaggio.
Riduzione importante della corsa d'estrazione necessaria.
Elementi simmetrici per stampi a 1+1 cavità.

PT

VANTAGENS DO DOUBLE RACK SYSTEM

Cursos de desmoldação entre 14 e 60mm.
Execução de ângulos segundo a necessidade do cliente.
Grande poupança em custos de maquinação e montagem / afinação.
Redução significativa do curso de extracção.
Peças simétricas para moldes de 1+1 cavidades.

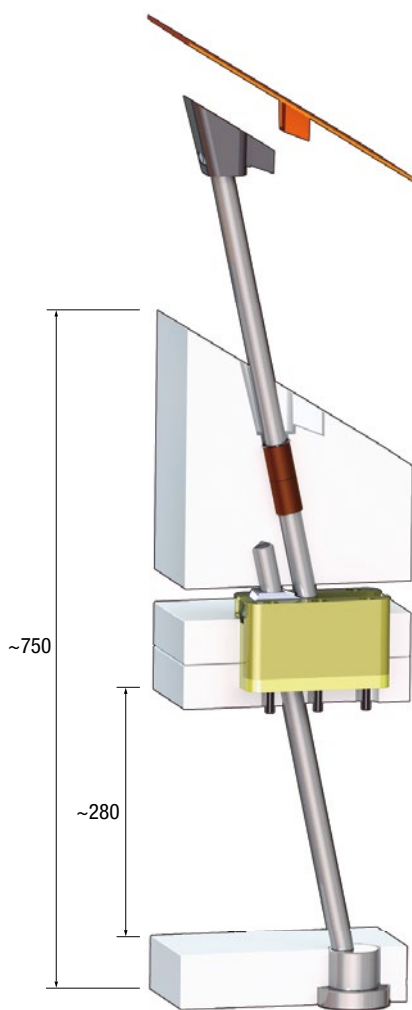
FR

AVANTAGES DU DOUBLE RACK SYSTEM

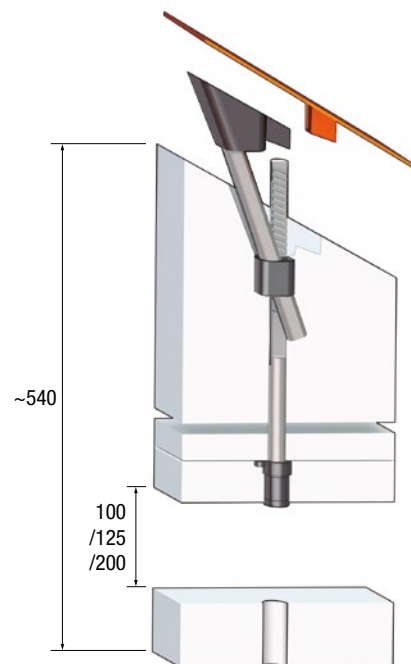
Course de demoulage de contre depouille compris entre 14 et 60mm.
Realisation de l'angle suivant votre besoin.
Grande economie de temps, de couts de realisations, de montage et d'ajustage.
Reduction significative de la course d'ejection.
Pièces symétriques pour moules ayant pour empreinte 1+1.

COMPARE / COMPARATIVA / VERGLEICH CONFRONTO / COMPARATIVO/ COMPARATIF

- > Eliminates the need for high-precision angled housings in the core plates.
- > Elimina los complicados taladros inclinados de alta precisión.
- > Es wird keine hochpräzise Schrägbohrung in der Formplatte benötigt.
- > Elimina le complicate lavorazioni inclinate ad alta precisione.
- > Elimina a necessidade de furos inclinados com precisão.
- > Terminé les logements inclinés de haute précision.
- > Vertical function maximizing strength. Smaller and less expensive injection machine required.
- > Funcionamiento vertical que minimiza el esfuerzo del conjunto. Permite usar una máquina de inyección más pequeña y económica.
- > Vertikale Funktion mit maximaler Kraft. Ein kleineres Werkzeug kann eventuell eine kleinere und günstigere Spritzgießmaschine benötigen.
- > Funzionamento verticale che minimizza lo sforzo. Permette di usare una macchina d'iniezione più piccola ed economica.
- > Funcionamento na vertical minimizando o esforço. Permite o uso de maquinas de injeção de menores dimensões e mais económicas.
- > Fonctionnement vertical réduisant les efforts. Permet de réduire la dimension de la presse d'injection et ainsi de réaliser des économies.



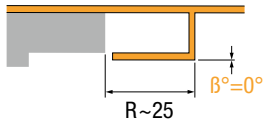
CONVENTIONAL
SYSTEM



DOUBLE RACK
SYSTEM

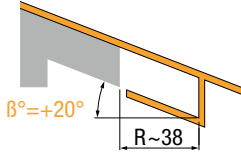
SELECTION TABLE: Which DR / KR do I need?
 TABLA DE SELECCIÓN: Qué DR / KR necesito?
 AUSWAHLTABELLE: Welcher DR / KR ist am besten geeignet?
 TABELLA PER SCELTA: Di quale DR / KR ho bisogno?
 TABELA DE SELEÇÃO: Qual é o DR / KR que preciso?
 TABLEAU DE CORRESPONDANCE: Quel est le DR / KR que j'ai besoin?

Neutral angles ($\beta=0^\circ$)



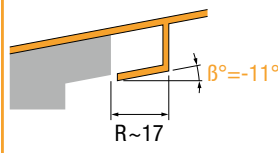
DR.xx100L-16 or DR.xx125L-12
or KR.xx125L-12

Positive angles ($\beta>0^\circ$)

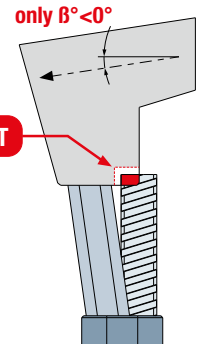


DR.xx100L-20 or DR.xx125L-16
or KR.xx125L-16

Negative angles ($\beta<0^\circ$)



DR.xx100L-12 or DR.xx125L-8
or KR.xx125L-8



IMPORTANT

Stroke 100
Stroke 200 (Multiply S value x2)

β°	DR.xx100L-8		DR.xx100L-12		DR.xx100L-16		DR.xx100L-20	
	KR.xx200L-8		KR.xx200L-12		KR.xx200L-16			
	S (- β°)	S (+ β°)	S (- β°)	S (+ β°)	S (- β°)	S (+ β°)	S (- β°)	S (+ β°)
0	14.0		21.2		28.6		36.4	
1	14.0	14.0	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	35.9	36.8
3	13.9	14.1	21.0	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	35.0	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	22.0	27.4	30.0	34.4	38.6
10	13.7	14.4	20.4	22.0	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	27.0	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	40.0
15	13.5	14.6	20.1	22.5	26.6	31.0	33.1	40.3
16	13.5	14.6	20.0	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	23.0	25.9	32.0	32.1	41.9
21	13.3	14.8	19.6	23.1	25.8	32.2	31.9	
22	13.2	14.9	19.5	23.2	25.6	32.4	31.7	
23	13.2	14.9	19.4	23.3	25.5	32.6	31.5	
24	13.2	14.9	19.4	23.4	25.4	32.8	31.3	
25	13.1	15.0	19.3	23.5	25.2	33.1	31.1	
26	13.1	15.0	19.2	23.7	25.1		30.9	
27	13.1	15.1	19.1	23.8	25.0		30.7	
28	13.0	15.1	19.0	23.9	24.8		30.4	
29	13.0	15.2	19.0	24.0	24.7		30.2	
30	12.9	15.2	18.9	24.2	24.6		30.0	
31	12.9	15.3	18.8		24.4		29.8	
32	12.9	15.4	18.7		24.3		29.6	
33	12.8	15.4	18.6		24.1		29.4	
34	12.8	15.5	18.5		24.0		29.2	
35	12.7	15.5	18.5		23.8		29.0	
36	12.7		18.4		23.7		28.7	
37	12.7		18.3		23.5		28.5	
38	12.6		18.2		23.4		28.3	
39	12.6		18.1		23.2		28.1	
40	12.5		18.0		23.1		27.8	
41	12.5		17.9		22.9		27.6	
42	12.4		17.8		22.7		27.4	
43	12.4		17.7		22.6		27.1	
44	12.3		17.6		22.4		26.9	
45	12.3		17.5		22.2		26.6	

S ≥ R

Stroke 125

β°	DR.xx125L-8		DR.xx125L-12		DR.xx125L-16		DR.xx125L-20	
	KR.xx125L-8		KR.xx125L-12		KR.xx125L-16		KR.xx125L-20	
	S (- β°)	S (+ β°)	S (- β°)	S (+ β°)	S (- β°)	S (+ β°)	S (- β°)	S (+ β°)
0	17.5		26.5		35.8		45.4	
1	17.5	17.6	26.4	26.6	35.6	36.0	45.2	45.7
2	17.4	17.6	26.3	26.7	35.4	36.2	44.9	46.0
3	17.4	17.6	26.2	26.8	35.3	36.3	44.6	46.3
4	17.3	17.7	26.1	26.9	35.1	36.5	44.3	46.6
5	17.3	17.7	26.0	27.0	34.9	36.7	44.0	46.9
6	17.3	17.8	25.9	27.1	34.7	36.9	43.8	47.3
7	17.2	17.8	25.8	27.2	34.6	37.1	43.5	47.6
8	17.2	17.9	25.7	27.3	34.4	37.3	43.2	47.9
9	17.1	17.9	25.7	27.4	34.2	37.5	43.0	48.2
10	17.1	18.0	25.6	27.6	34.1	37.7	42.7	48.6
11	17.1	18.0	25.5	27.7	33.9	37.9	42.4	48.9
12	17.0	18.1	25.4	27.8	33.7	38.1	42.2	49.3
13	17.0	18.1	25.3	27.9	33.6	38.3	41.9	49.6
14	16.9	18.2	25.2	28.0	33.4	38.6	41.7	50.0
15	16.9	18.2	25.1	28.1	33.2	38.8	41.4	50.4
16	16.8	18.3	25.0	28.2	33.1	39.0	41.1	50.7
17	16.8	18.3	24.9	28.4	32.9	39.2	40.9	51.1
18	16.8	18.4	24.8	28.5	32.7	39.5	40.6	51.5
19	16.7	18.4	24.7	28.6	32.6	39.7	40.4	52.0
20	16.7	18.5	24.6	28.7	32.4	40.0	40.1	52.4
21	16.6	18.5	24.5	28.9	32.2	40.2	39.9	
22	16.6	18.6	24.4	29.0	32.1	40.5	39.6	
23	16.5	18.6	24.3	29.2	31.9	40.8	39.4	
24	16.5	18.7	24.2	29.3	31.7	41.0	39.1	
25	16.4	18.7	24.1	29.4	31.6	41.3	38.8	
26	16.4	18.8	24.0	29.6	31.4		38.6	
27	16.3	18.9	23.9	29.7	31.2		38.3	
28	16.3	18.9	23.8	29.9	31.1		38.1	
29	16.2	19.0	23.7	30.1	30.9		37.8	
30	16.2	19.1	23.6	30.2	30.7		37.5	
31	16.1	19.1	23.5		30.5		37.3	
32	16.1	19.2	23.4		30.3		37.0	
33	16.0	19.3	23.3		30.2		36.7	
34	16.0	19.4	23.2		30.0		36.5	
35	15.9	19.4	23.1		29.8		36.2	
36	15.9		23.0		29.6		35.9	
37	15.8		22.9		29.4		35.7	
38	15.8		22.7		29.2		35.4	
39	15.7		22.6		29.0		35.1	
40	15.7		22.5		28.8		34.8	
41	15.6		22.4		28.6		34.5	
42	15.5		22.3		28.4		34.2	
43	15.5		22.1		28.2		33.9	
44	15.4		22.0		28.0		33.6	
45	15.4		21.9		27.8		33.3	

Special β° angles possible under request / Posibilidad de ángulos β° especiales / Sonderwinkel auf Anfrage möglich (β°)
 E' possibile avere angolazioni β° speciali su richiesta / Possibilidade de ângulos β° especiais / Possibilité de réaliser des angles β° spéciaux