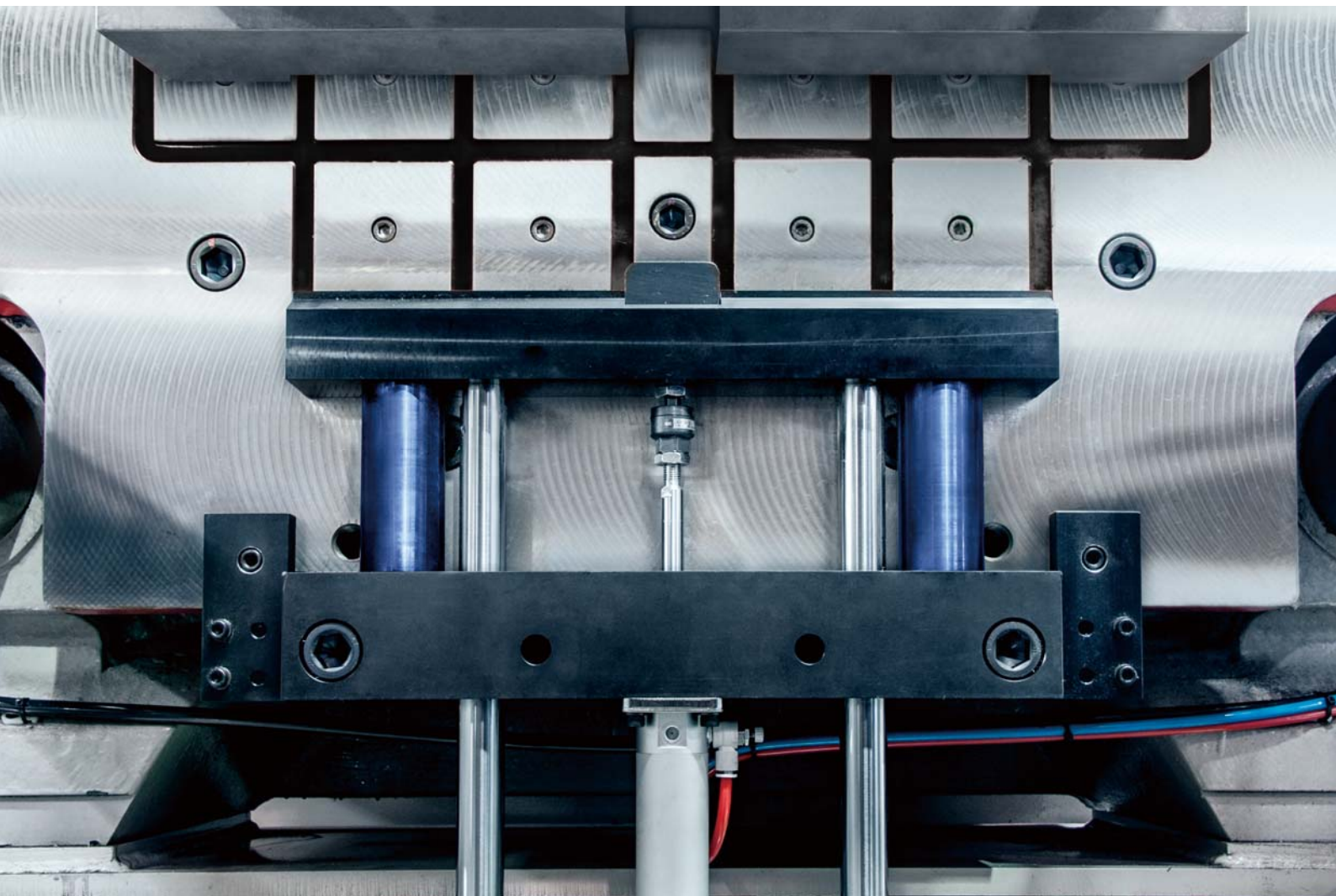


Pascal

Die settler

Die setting system

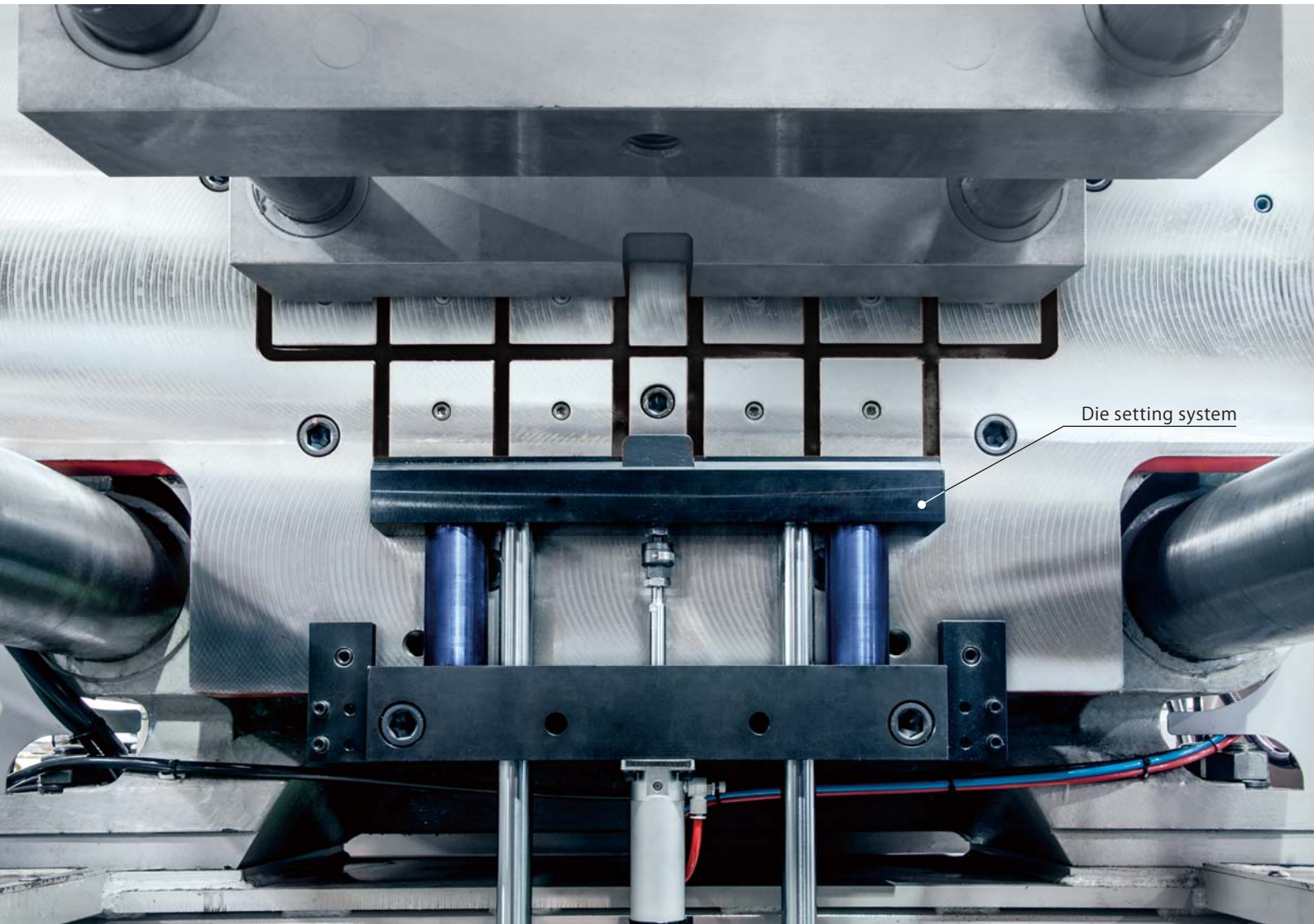


3,500kN IMM vertical loading Die setting system & Mag clamp

Pascal corporation

New proposal in place of conventional locate ring

Introducing a Die setter, the horizontal and vertical positioning can be determined surely and easily by placing a mold on a Die setter and it improves the productivity and set up.



3,500kN (350ton) IMM vertical loading Die setting system & Mag clamp

Die setter operation panel



Die setter operation panel

The lift of Die set block is operated. It is mountable near the IMM control panel with L type bracket.

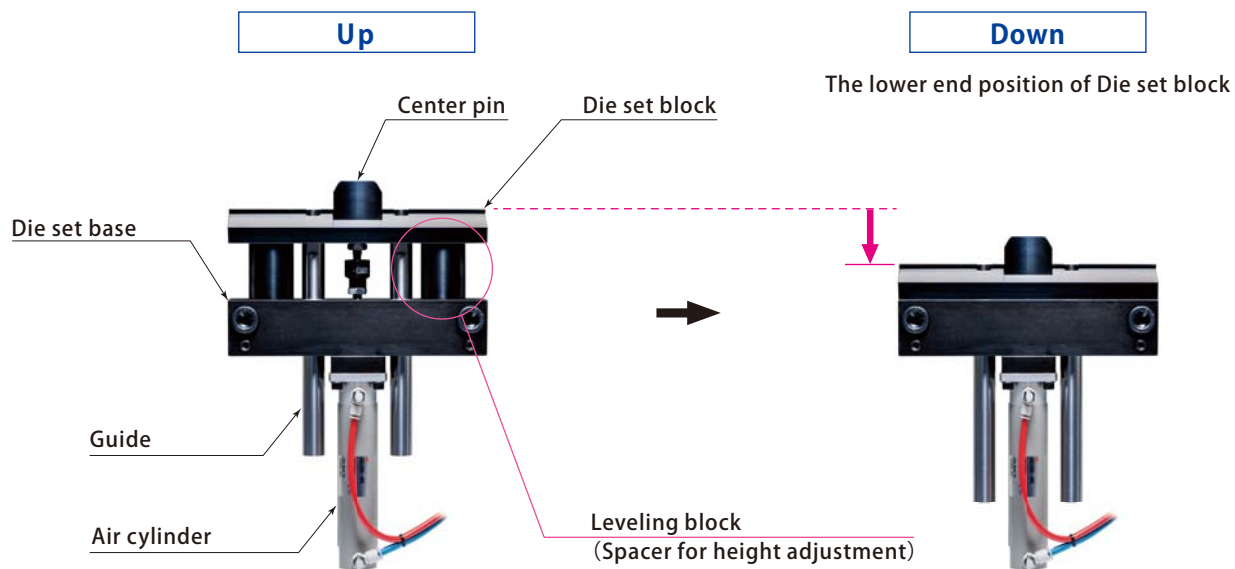
Die setter & Clamp operation panel



Clamp operation button
 Die setter operation button

There is also a model integrated with clamp and die setter.

Contact Pascal for details.



Leveling block

Positioning by putting leveling block between a die set block and die set base.



Model designation

MDL 01 A

1 Die setter block type

A : Fixed side (with center pin)

B : Movable side (without center pin)

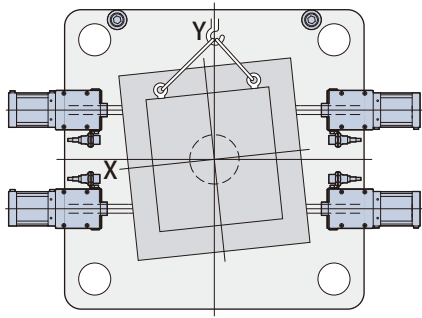
2 Mold weight

Model		MDL01	MDL03	MDL04	MDL06	MDL10	MDL15	
2	Mold weight	kg	1000	3000	4000	6000	10000	15000
Applied IMM	Clamping force	kN (ton)	1000 (100)	2300 (230)	3500 (350)	6500 (650)	8500 (850)	10500 (1050)
	Loading direction	Vertical loading, Horizontal loading						

● Leveling block is attached. (2pcs)

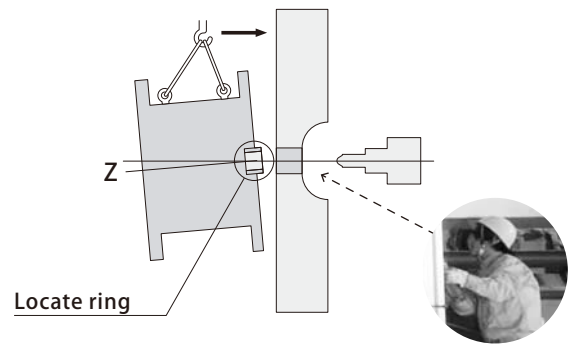
Die setting with locate ring

Mold center (X,Y) is not stable.



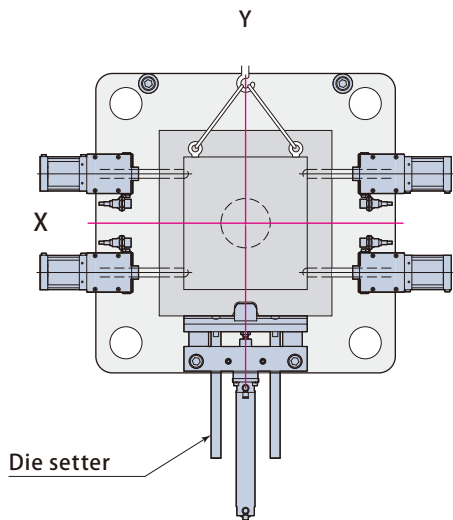
Hard to load the mold

(Visual confirmation from back side of platen (nozzle side) due to the shape of locate ring/Risk of damage of platen or mold when mold loading)

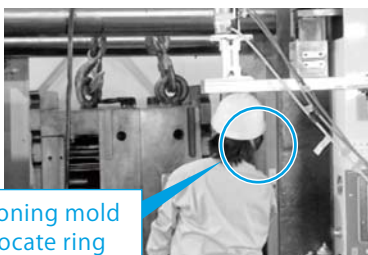
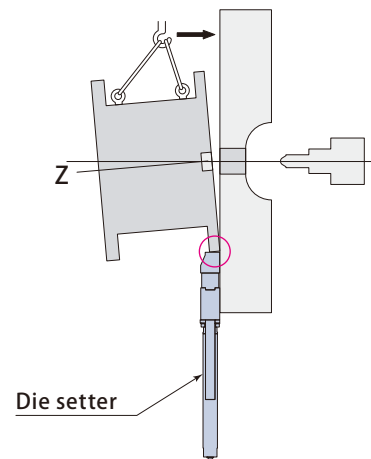


Die setting with die setter

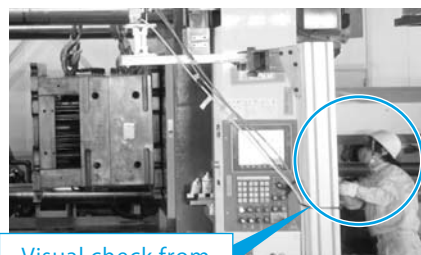
Mold center (X,Y) is quickly secured.



By placing the mold on the die setter, die setting is easy.



Positioning mold with locate ring :Unnecessary

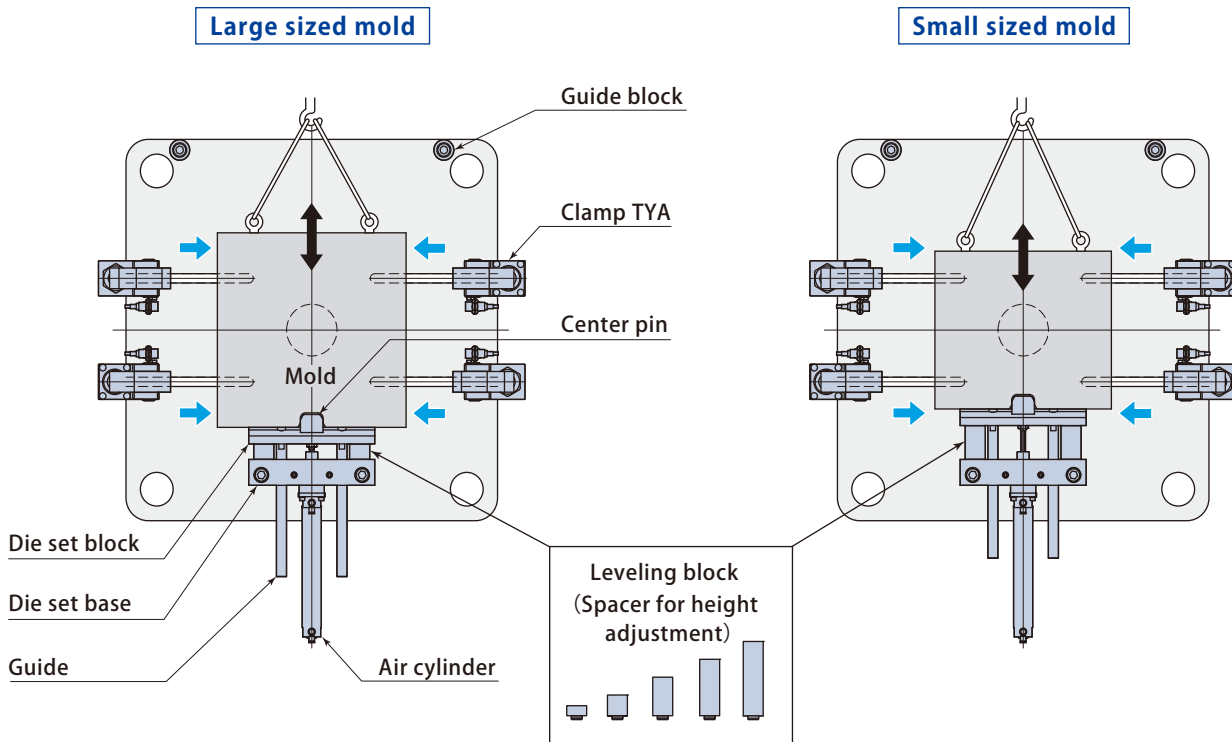


Visual check from injection unit side :Unnecessary

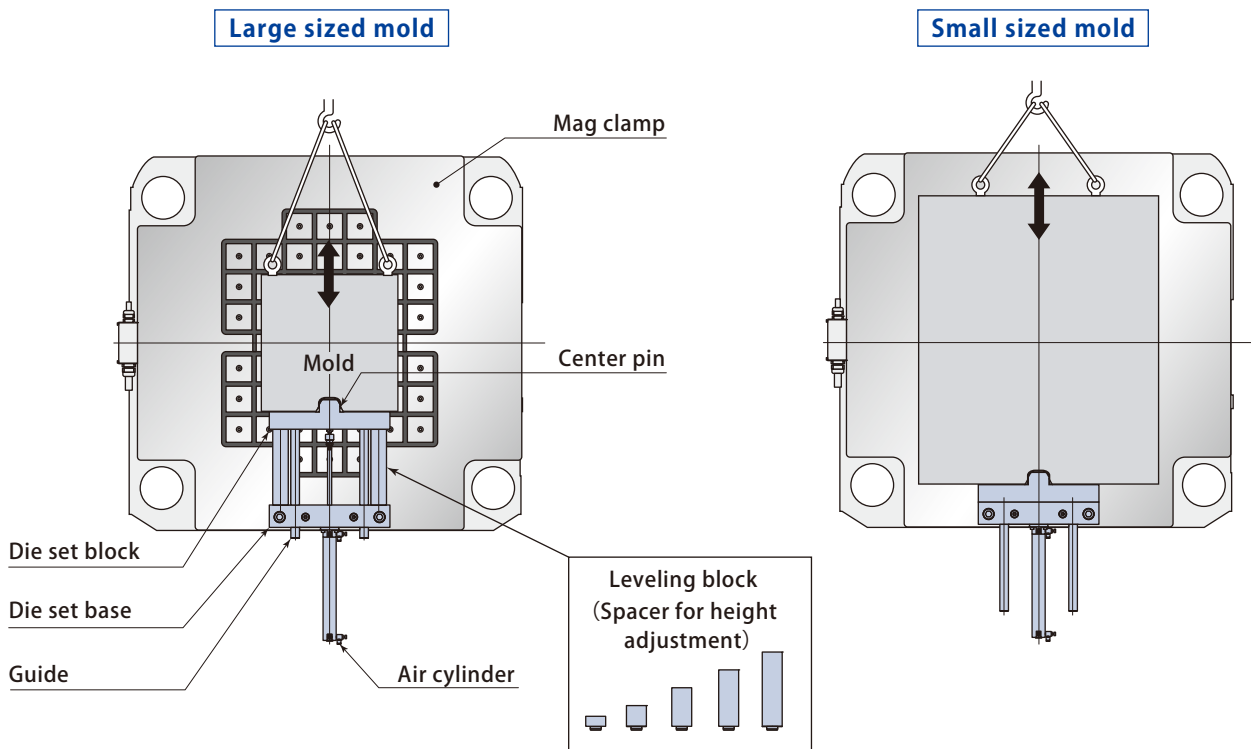


Mold leveling :Unnecessary

Die setting system & Automatic clamp (vertical loading)

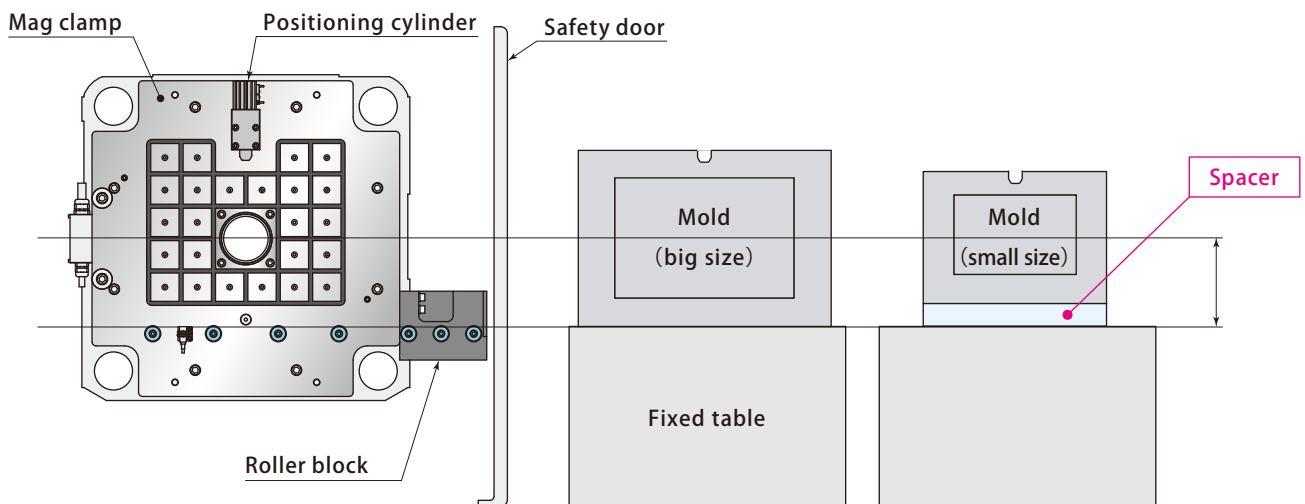


Die setting system & Mag clamp (vertical loading)

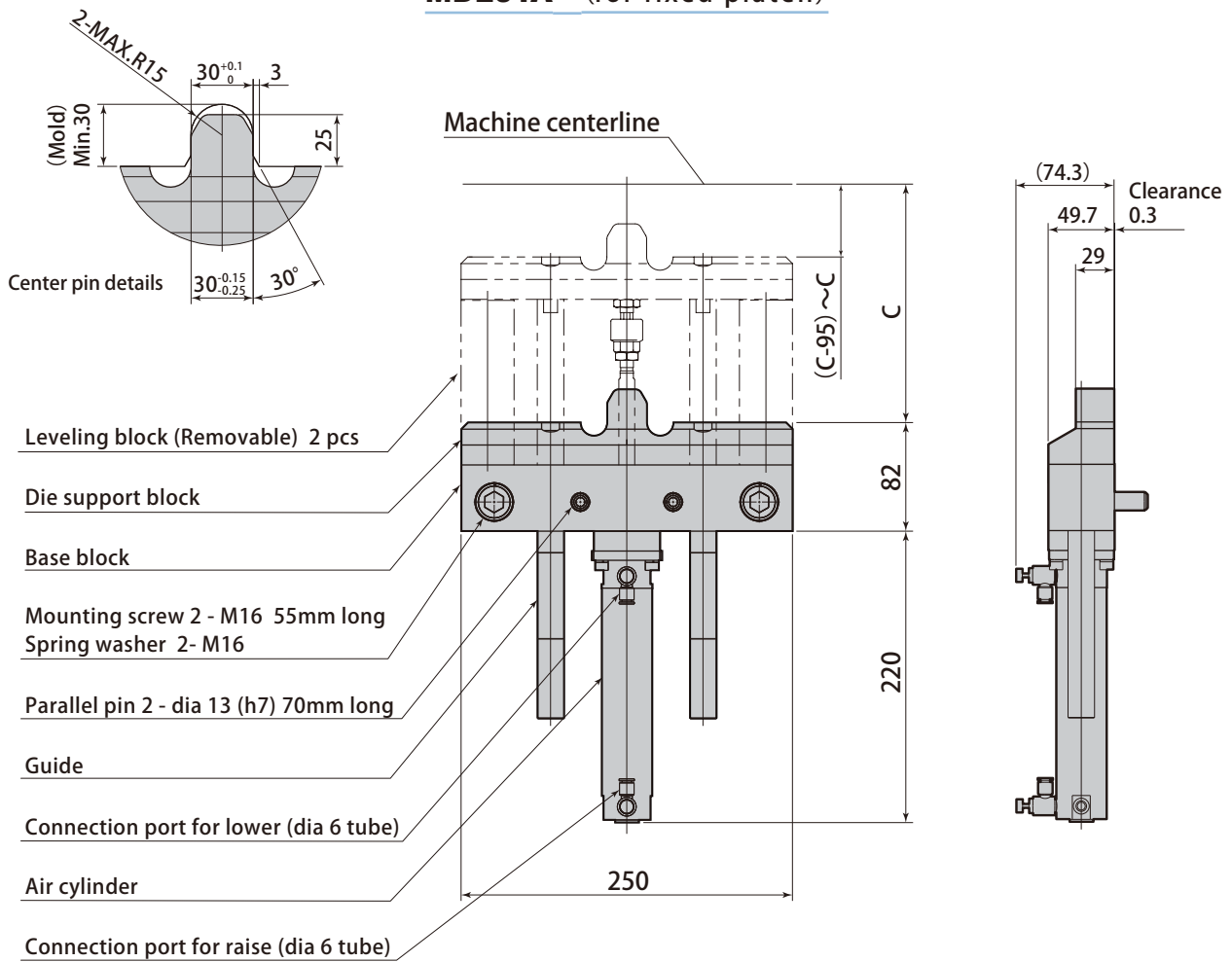


In standard horizontal mag clamp system

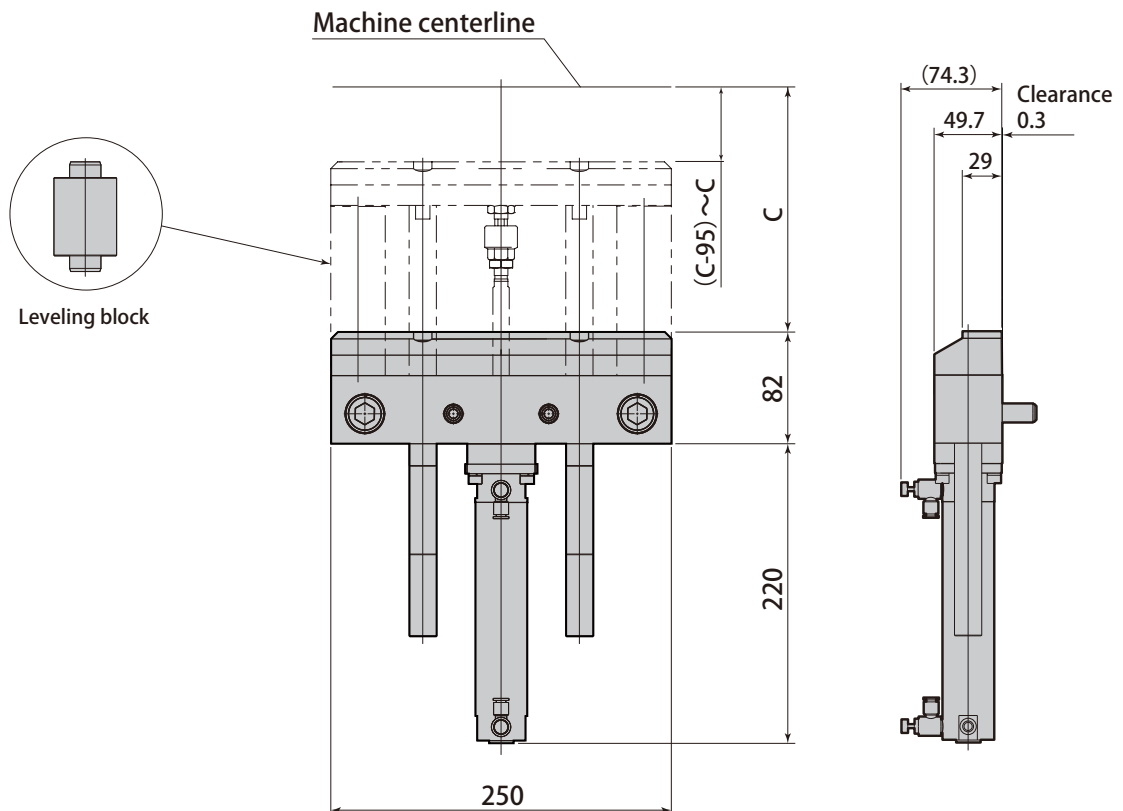
A **spacer should be attached** to the mold to match the transport level.



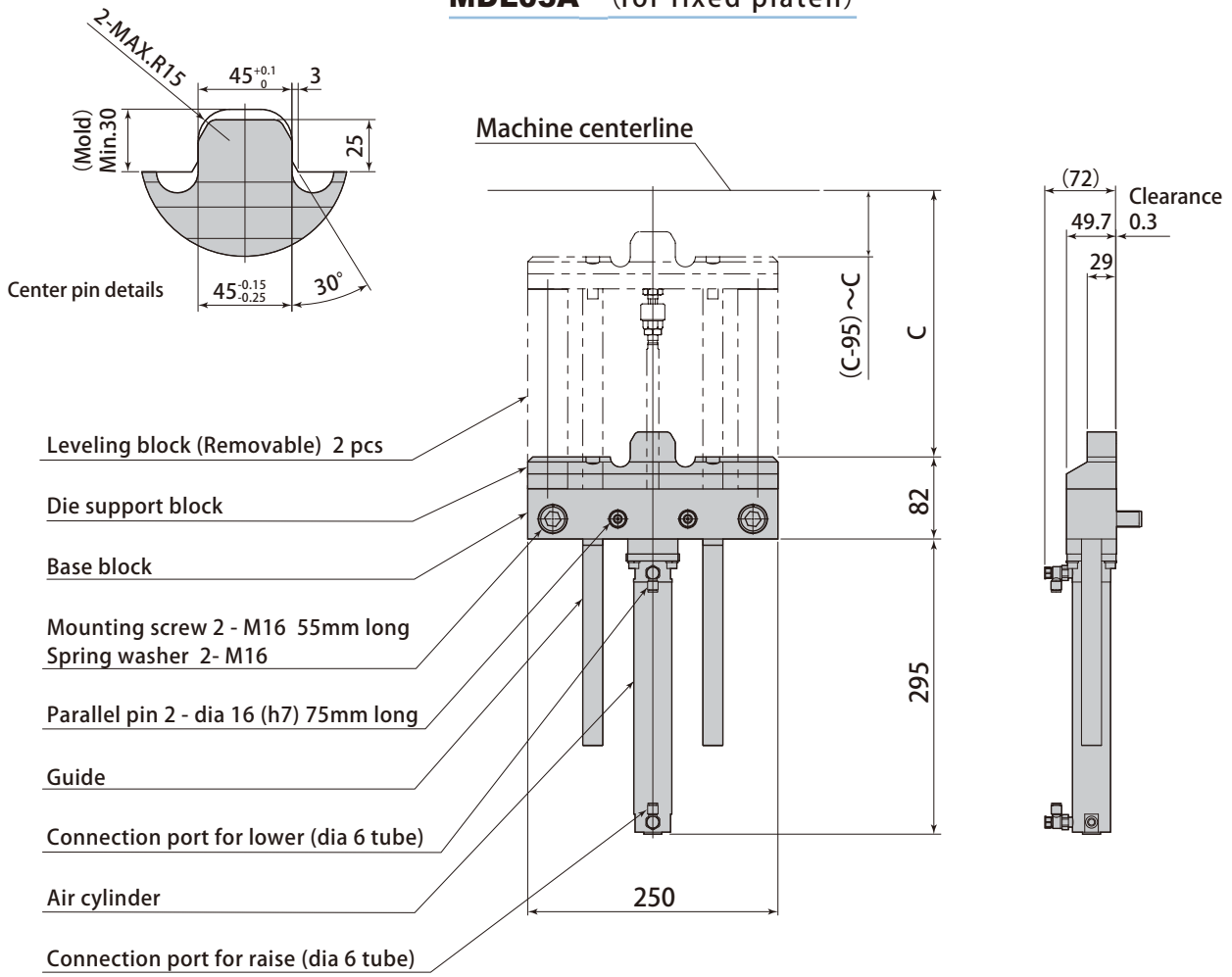
MDL01A (for fixed platen)



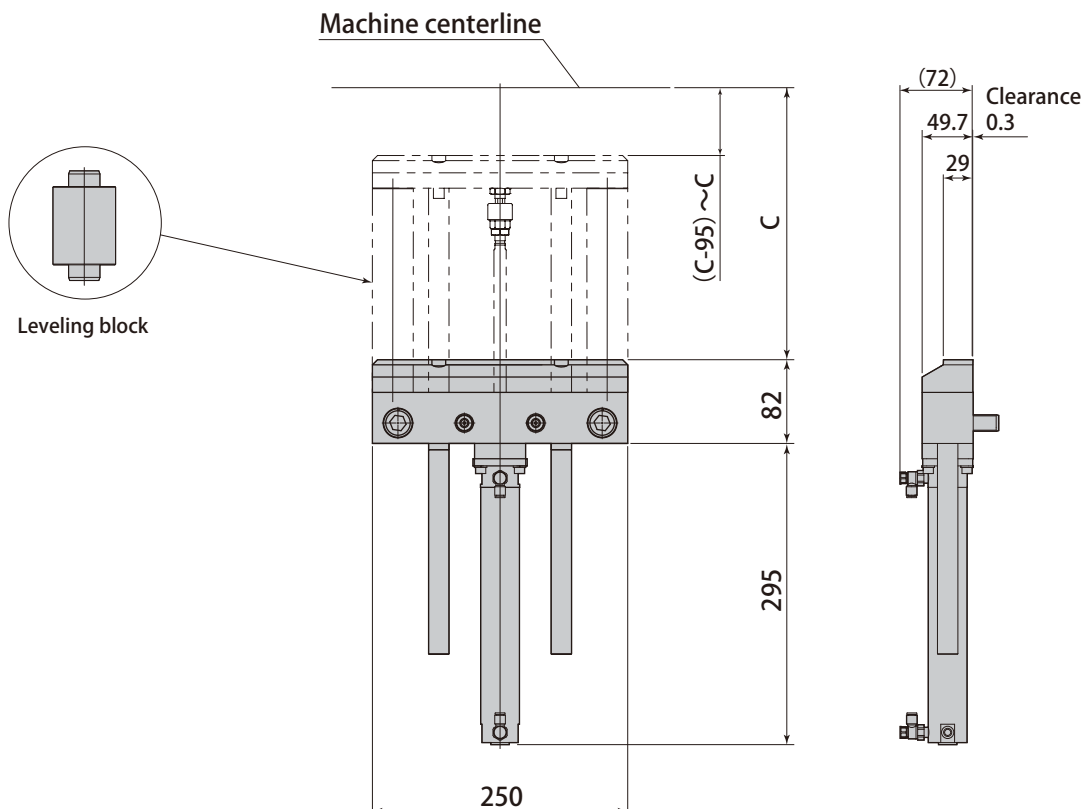
MDL01B (for movable platen)



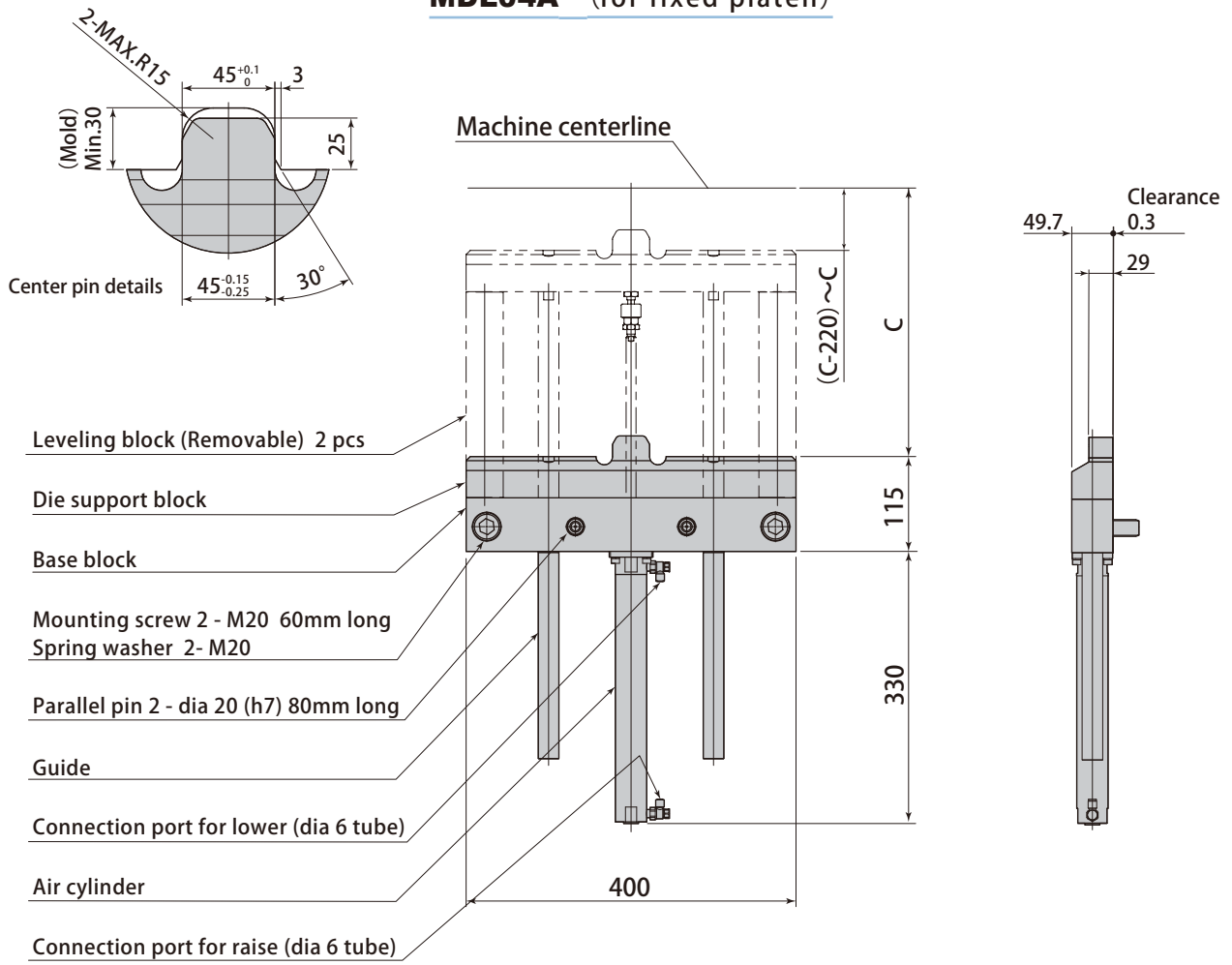
MDL03A (for fixed platen)



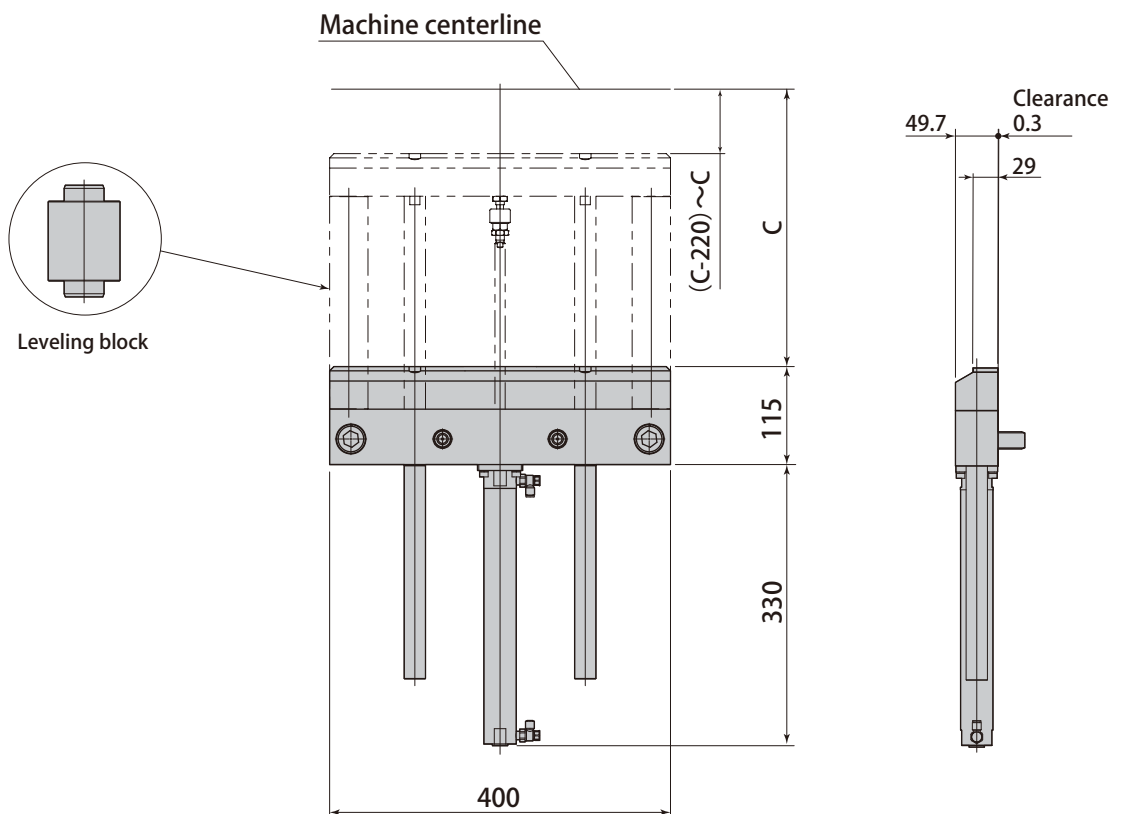
MDL03B (for movable platen)



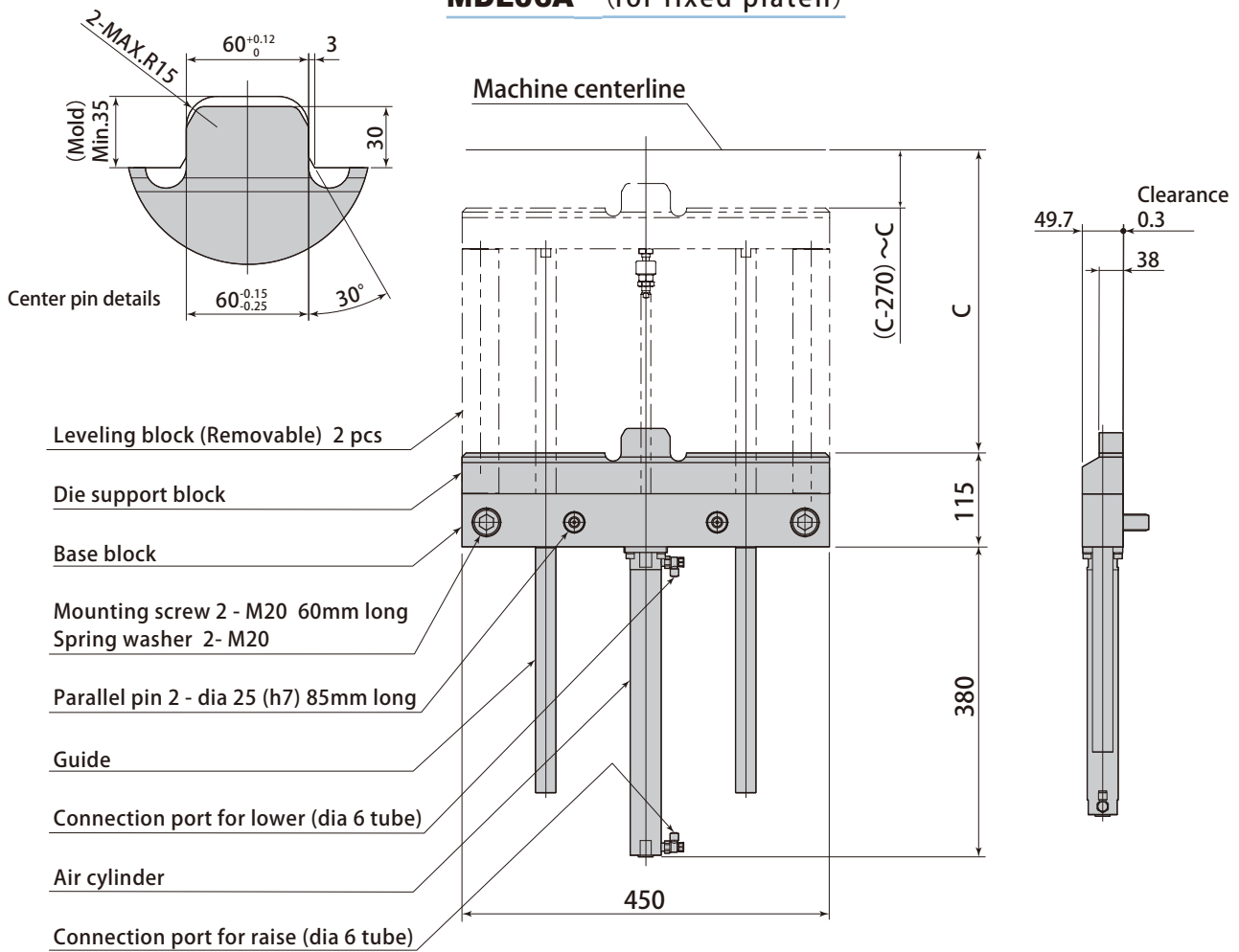
MDL04A (for fixed platen)



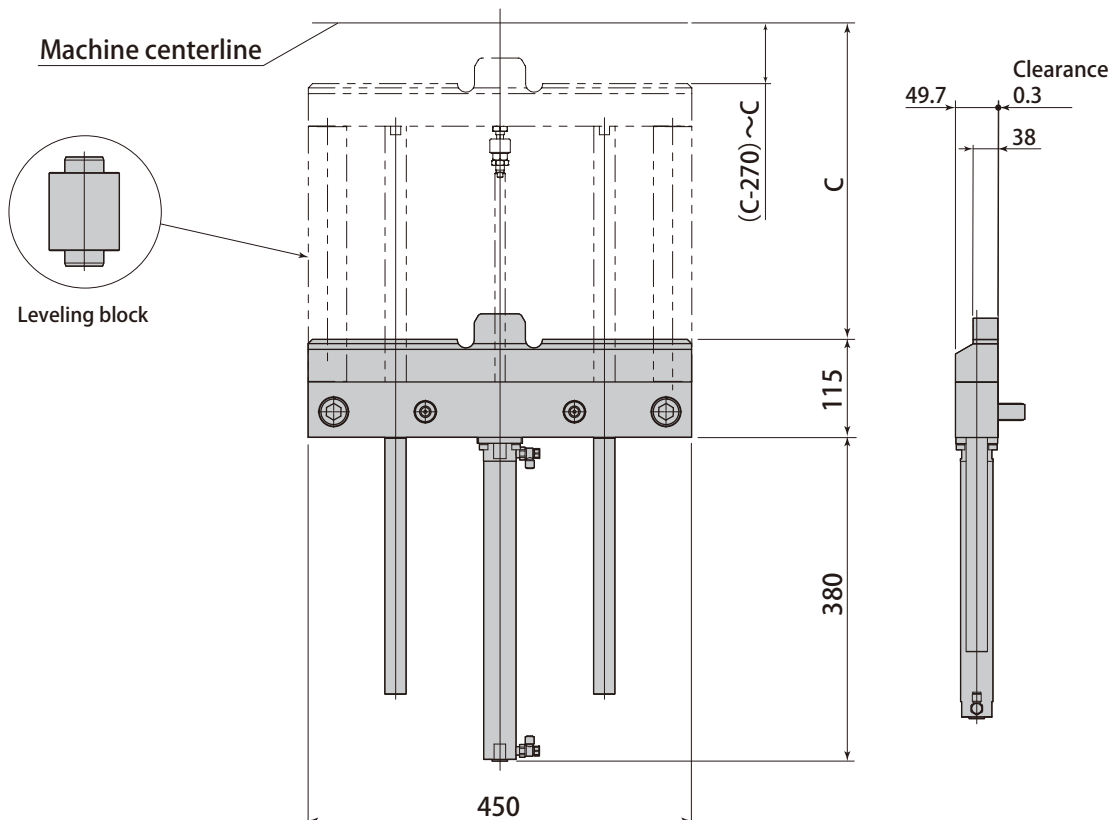
MDL04B (for movable platen)



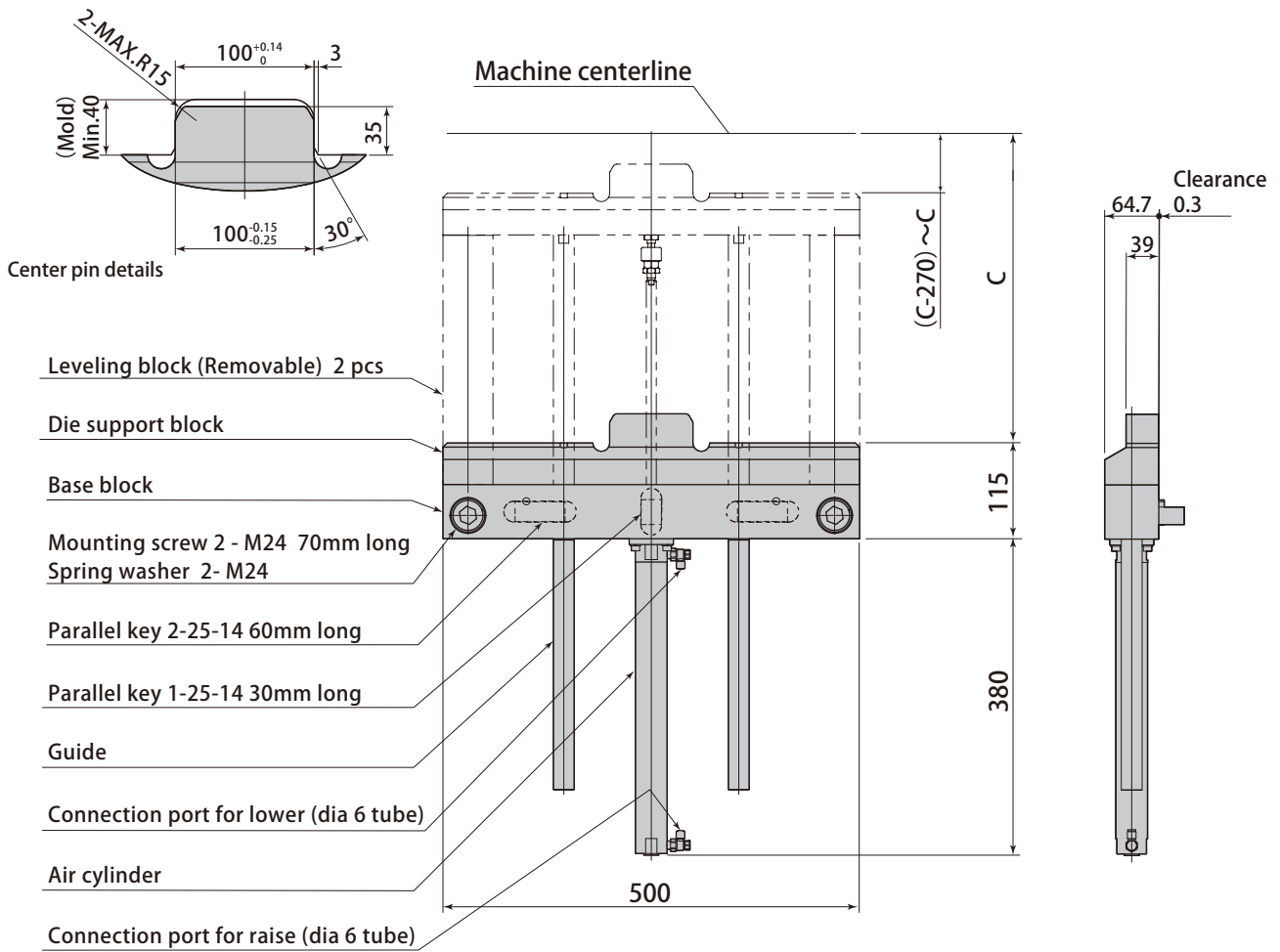
MDL06A (for fixed platen)



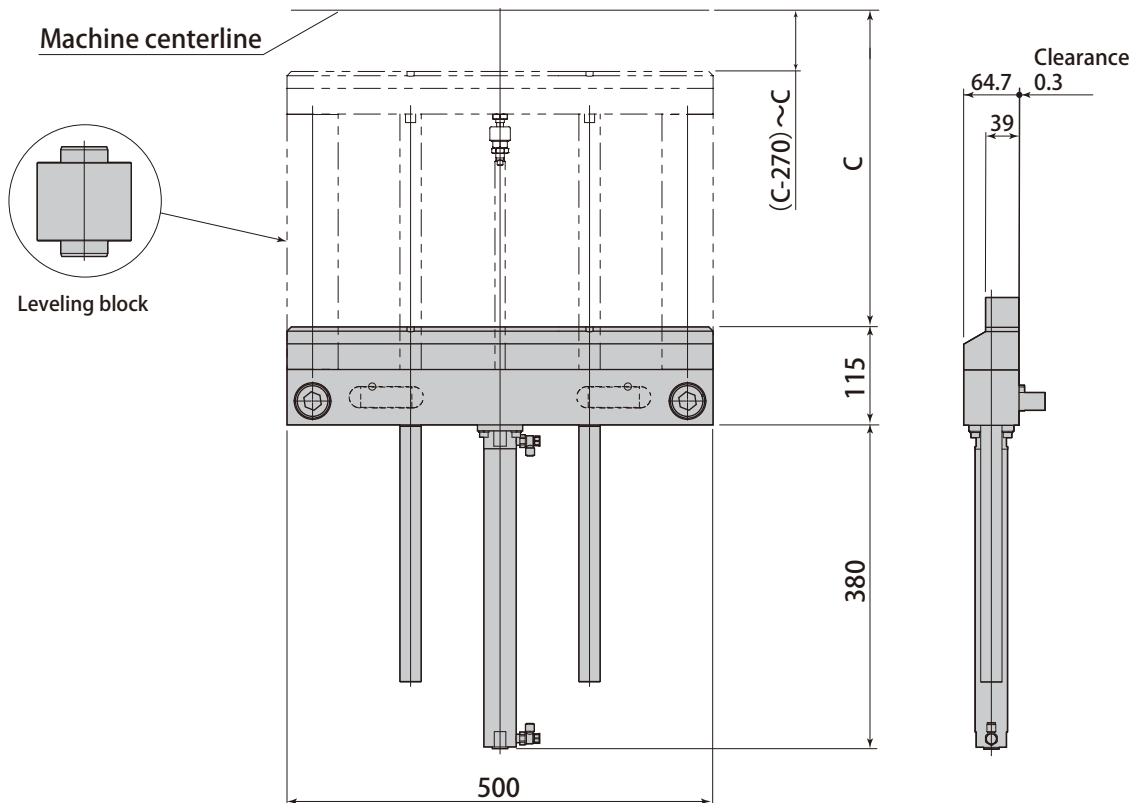
MDL06B (for movable platen)



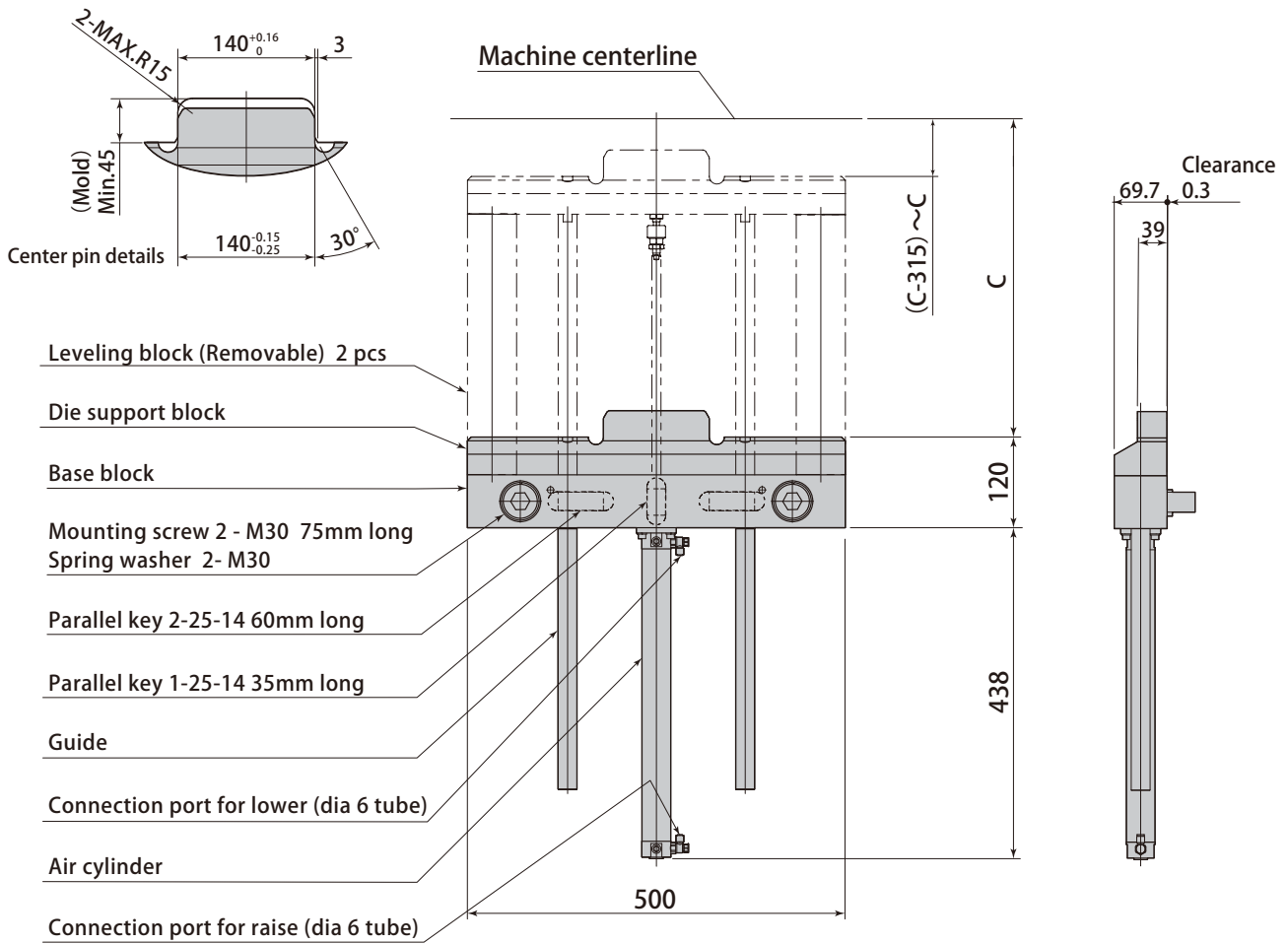
MDL10A (for fixed platen)



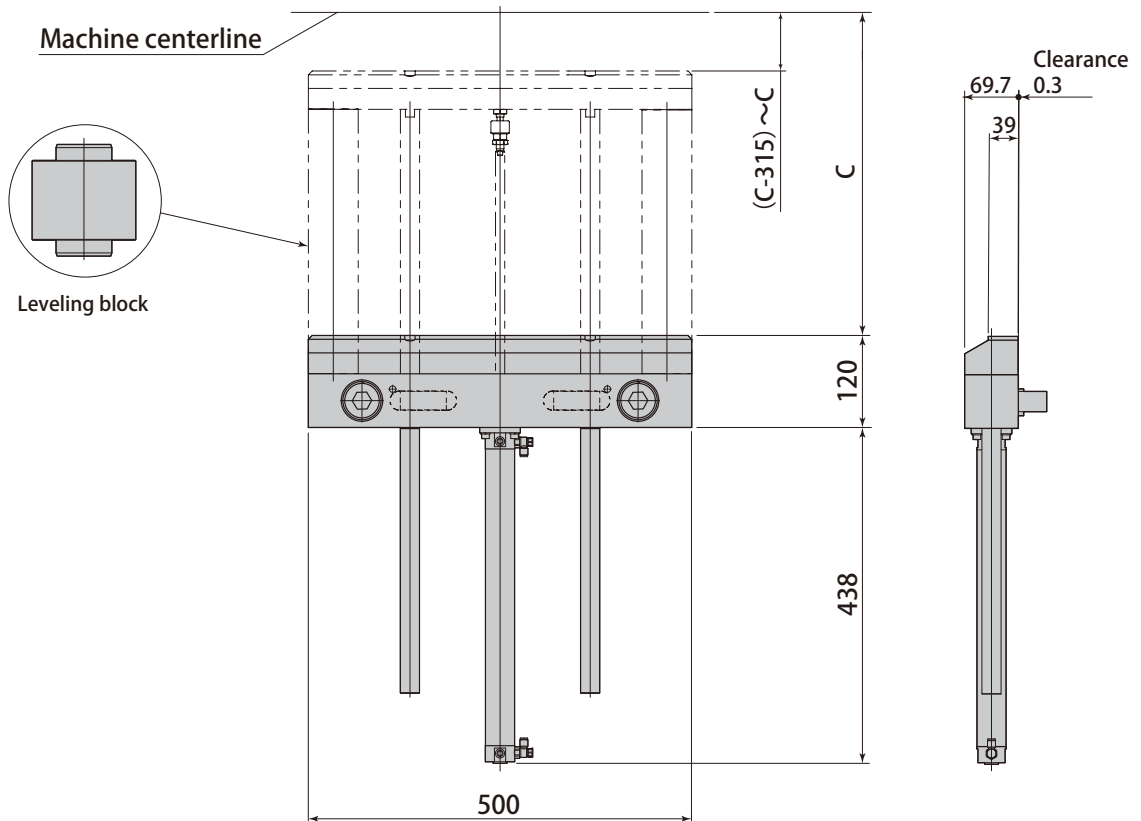
MDL10B (for movable platen)



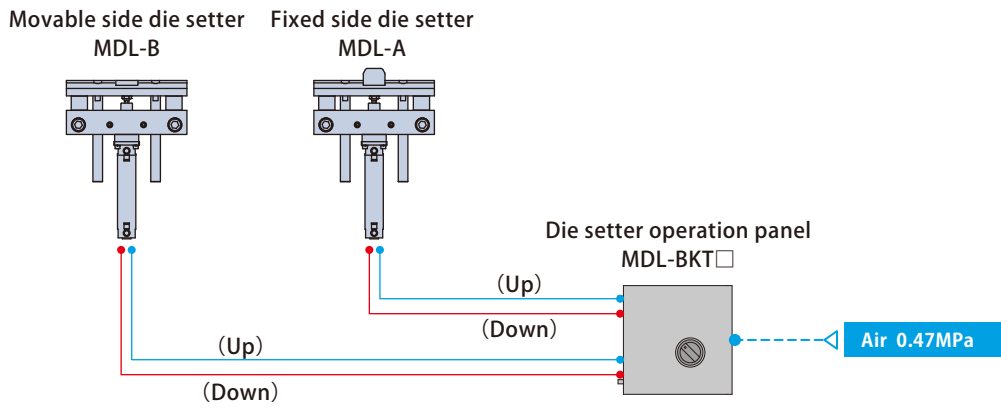
MDL15A (for fixed platen)



MDL15B (for movable platen)

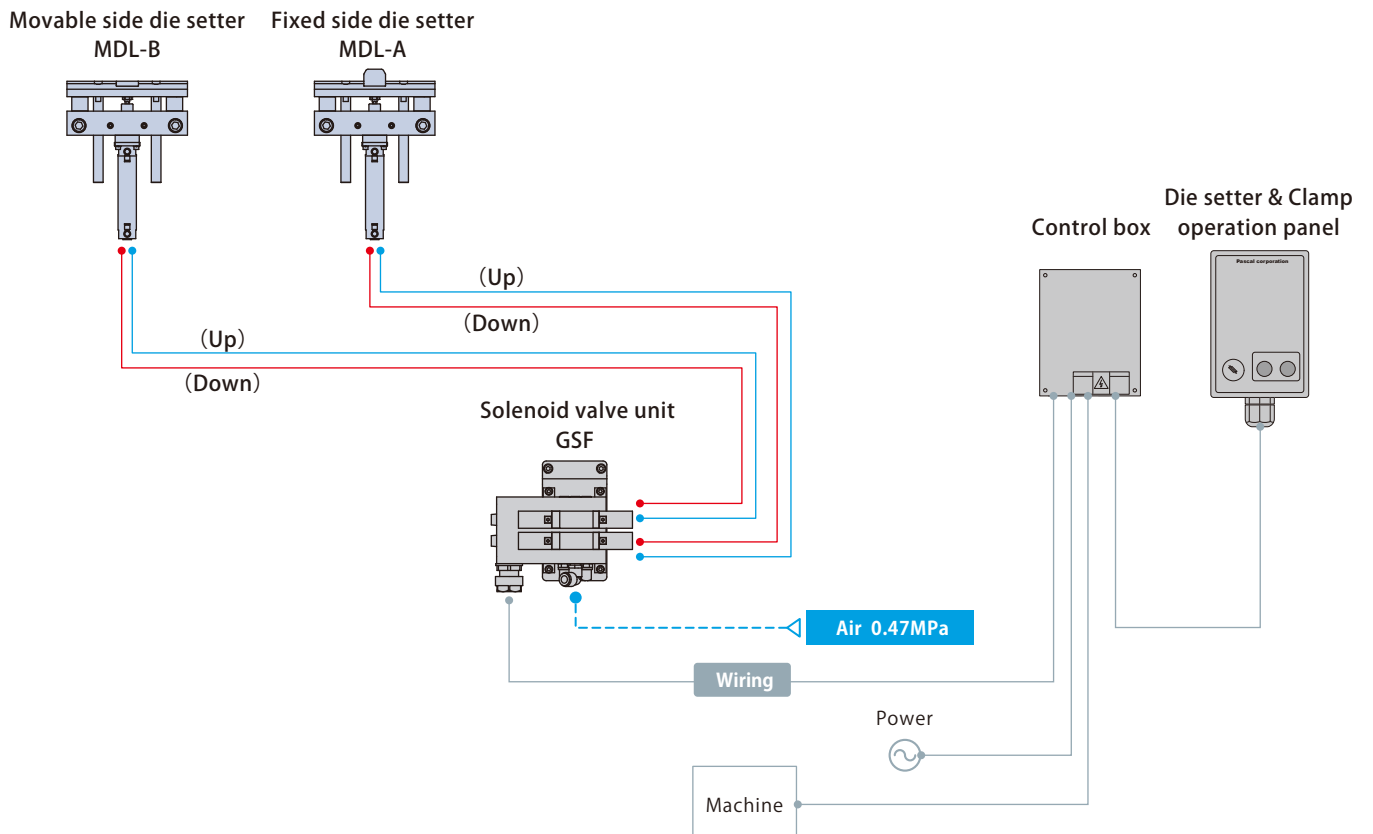


Die setter operation panel is used (in case it is controlled with hand valve)



Die setter and clamp operation panel is used (in case it is incorporated in the control device)

It does not correspond to some clamps. Contact Pascal for details.





Hand valve switch

Model designation

MDL – BKT 01

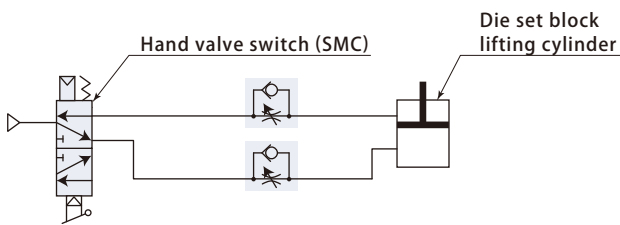
..... 1 Number of circuits

01 : 1 circuit (Only fixed side)

02 : 2 circuits (Fixed side & Movable side)

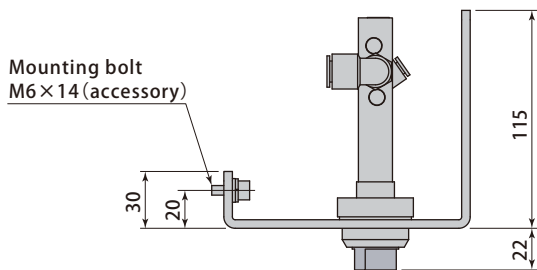
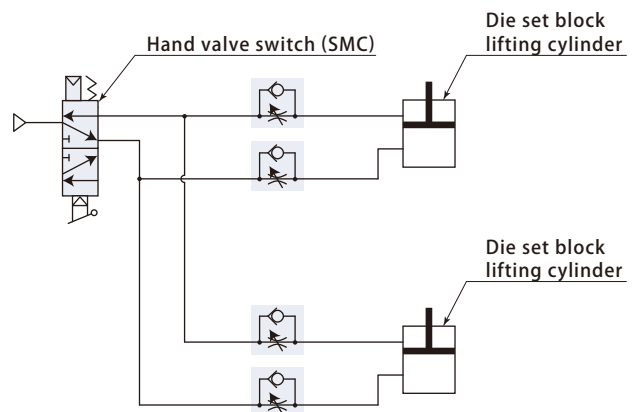
MDL – BKT 01

Pneumatic circuit

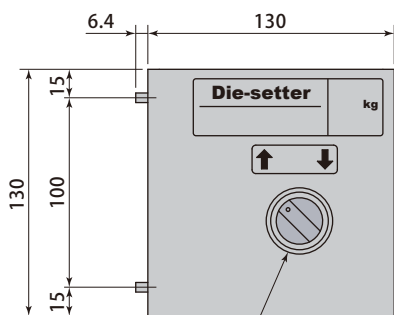


MDL – BKT 02

Pneumatic circuit

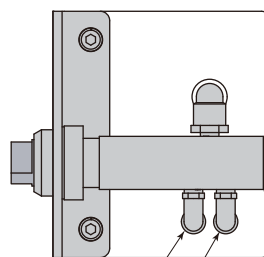


Model	MDL-BKT01	MDL-BKT02
Weight	kg	1.5



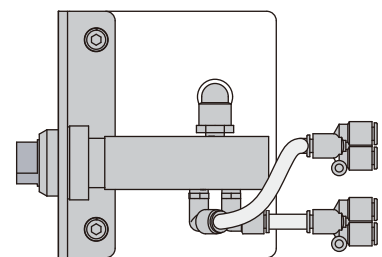
Die setter block up/down switch

MDL-BKT01



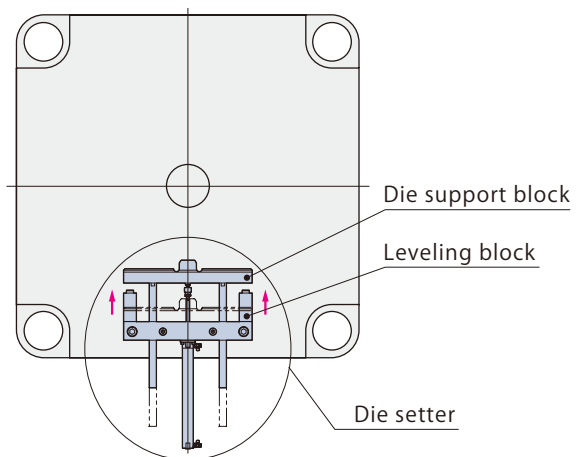
Upward port to speed controller
Downward port to speed controller

MDL-BKT02

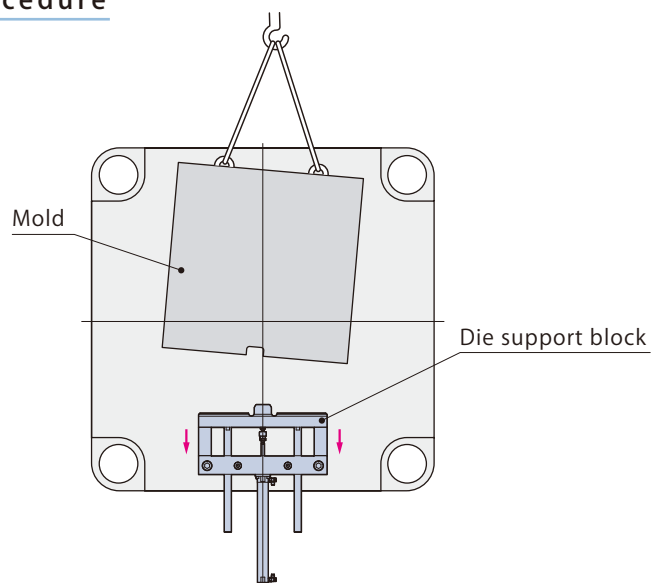


Hand valve switch (SMC)

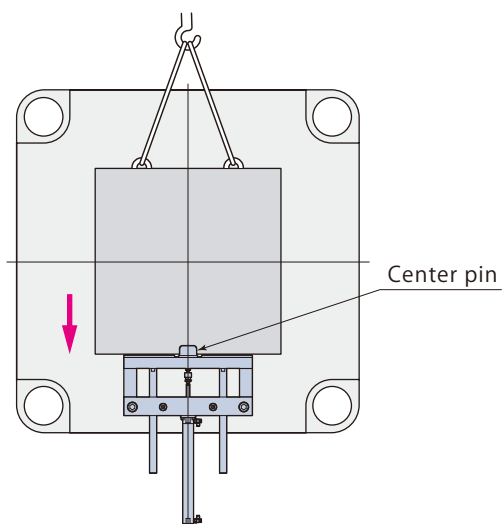
Operational procedure



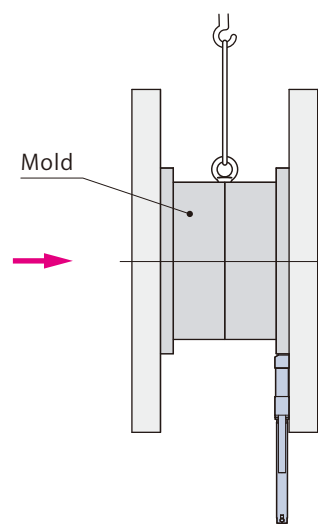
- 1 Raise the support block and place the leveling blocks on the base block.



- 2 Lower the support block to accept the mold loading.



- 3 Place the mold onto the support block by dowelling the center pin to the mold cutout.

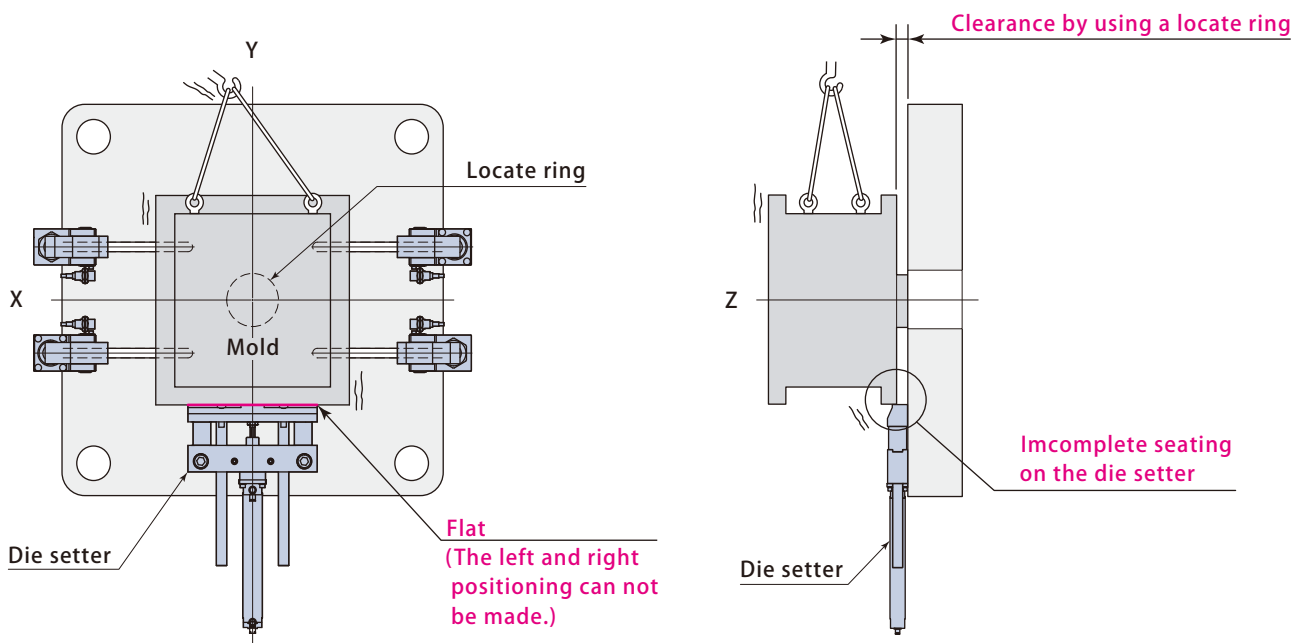


- 4 Clamp the mold by platens and die setting is completed.

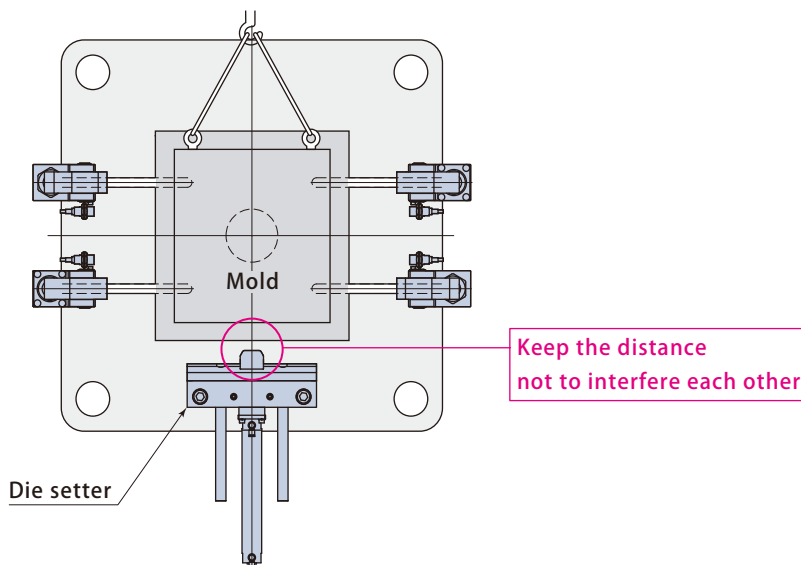
Do not use the locate ring and the die setter with center pin removed at the same time simply because there is no cutout on the mold for the center pin.

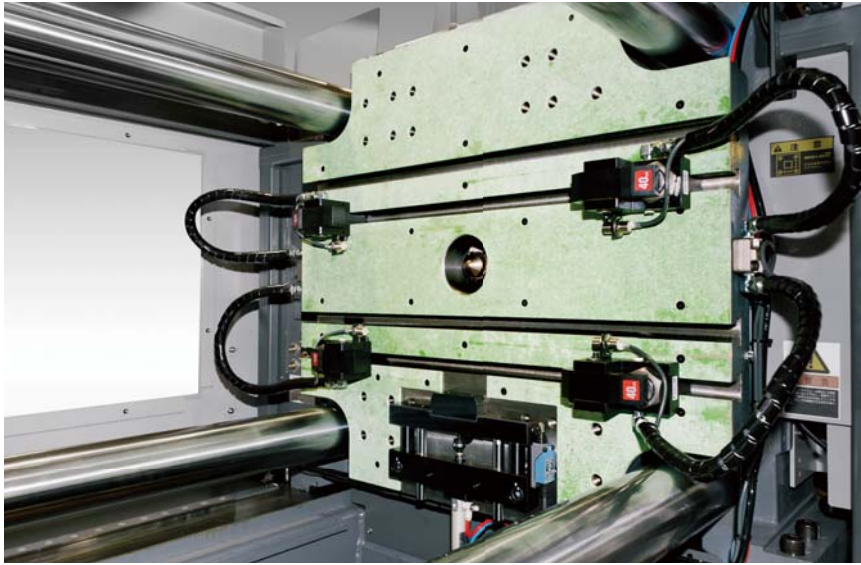
✗ Danger

- The right and left(X) positioning can not be made by simply placing the mold on die setter.
- There is a risk of sudden movement of the mold when it starts skidding on the die setter.
- When the mold leans to one side, the die setter may incline due to the uneven load.

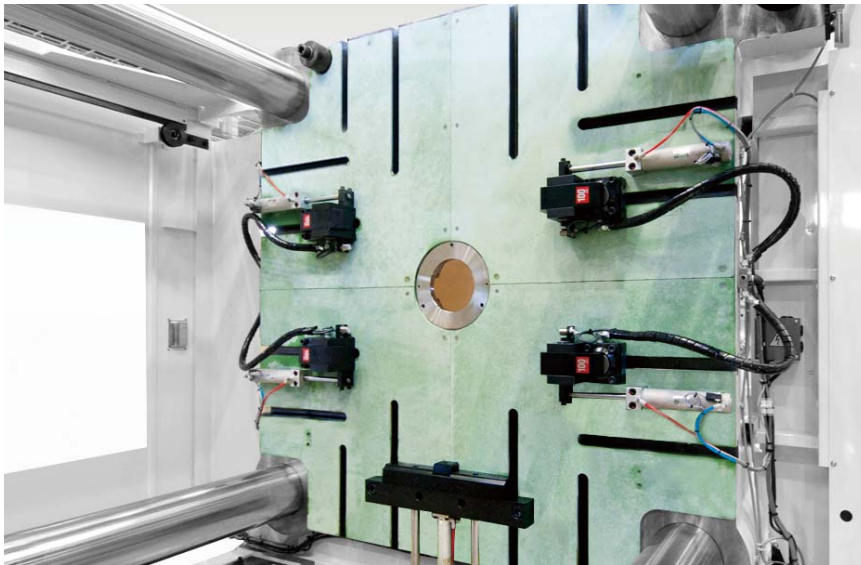


In case of using die setter for the mold with no U-cut, keep it out of the range of the mould mount area in advance not to interfere each other.

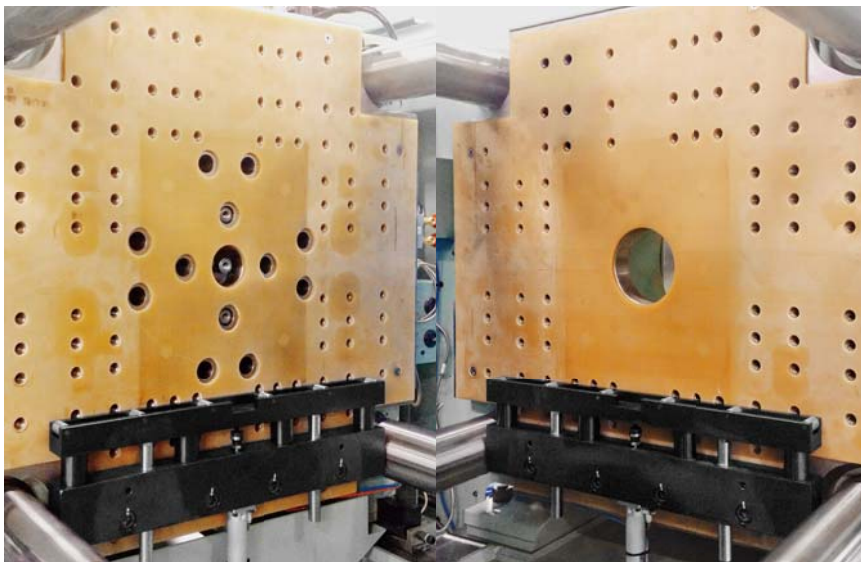




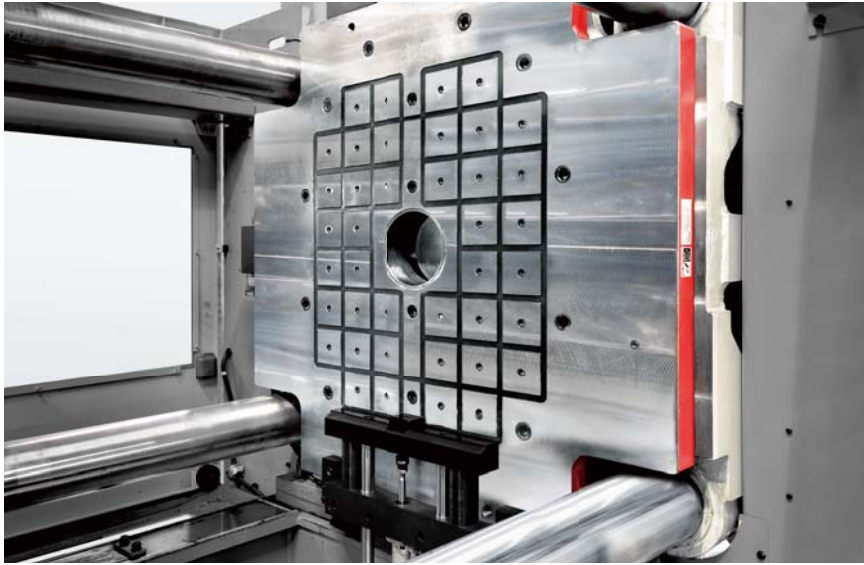
1,800kN (180ton) IMM vertical loading Die setting system & Hydraulic clamp, slidable type TYA040



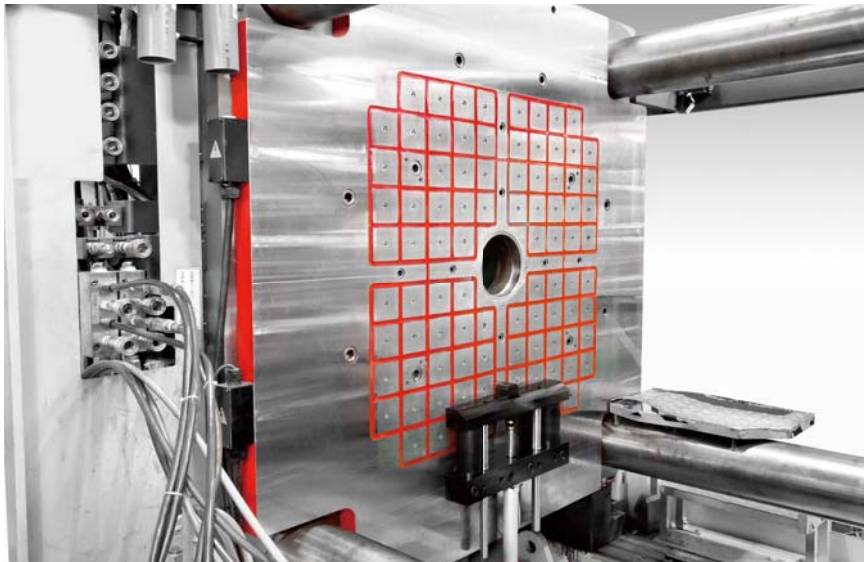
6,500kN (650ton) IMM vertical loading Die setting system & Hydraulic clamp, automatic slidable type TYC100Z



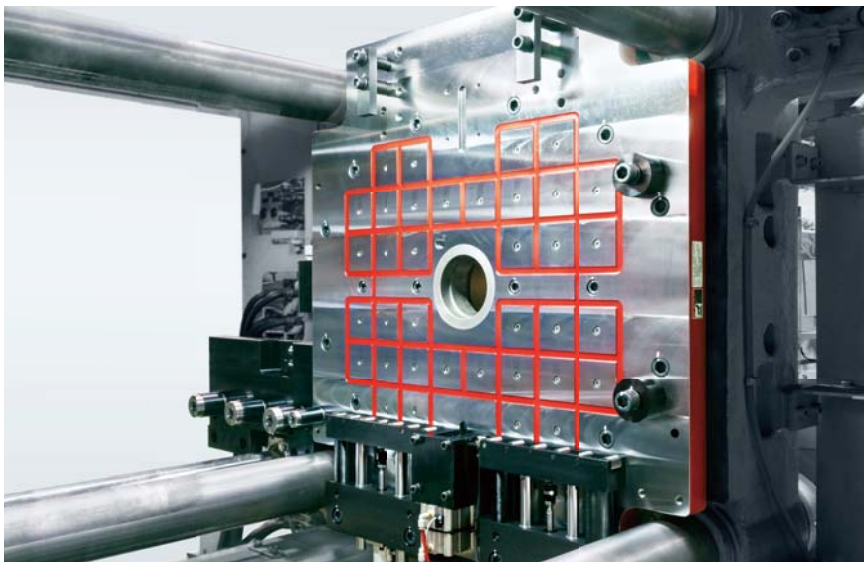
3,500kN (350ton) IMM horizontal loading Die setting roller



3,500kN (350ton) IMM vertical loading Die setting system & Mag clamp



8,500kN (850ton) IMM vertical loading Die setting system & Mag clamp



3,500kN (350ton) IMM horizontal loading Die setting roller & Mag clamp

Pascal

Itami, Hyogo, Japan 664-8502
TEL. +81-72-777-3333 FAX. +81-72-777-3520

Chicago, U.S.A.	TEL. +1-847-427-1234
Stuttgart, Germany	TEL. +49-711-782-850-0
Dalian, China	TEL. +86-411-8732-2988
Shanghai, China	TEL. +86-21-5263-4122
Changwon, Korea	TEL. +82-55-274-0971
Bangkok, Thailand	TEL. +66-2173-5855

