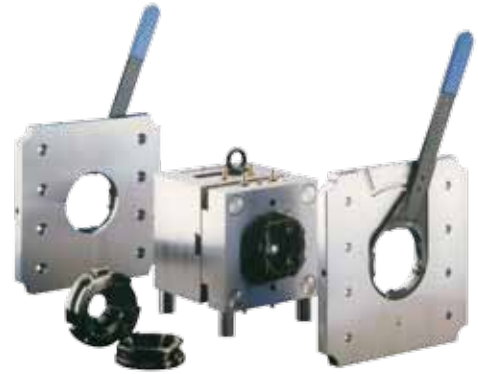




- Maintenance-free, self locking bayonet type quick-action clamping system suitable for mold weights up to 1000 kg.
- Multi-purpose application suitable for all horizontal and vertical injection molding machines with 2 or 4 tiebars, as well as barless design up to approx. 1800 kN.
- Quick mold-change without requiring additional tools.
- The system only requires interchanging locating rings on the mold.
- The set also includes compact adapter plates, to be mounted on the machine with thermal insulating sheets and cooling connectors when required.
- Step-by-step retooling of molds and machines possible.



Part list

1 Mold Clamping Plate	5 Adapter Plate	9 Retention Pin
2 Locating Ring	6 Wrench	10 Spring Loaded Set screw
3 SHC-screw	7 Locking Ring	
4 SHC-screw	8 Thermal Insulating Sheet	

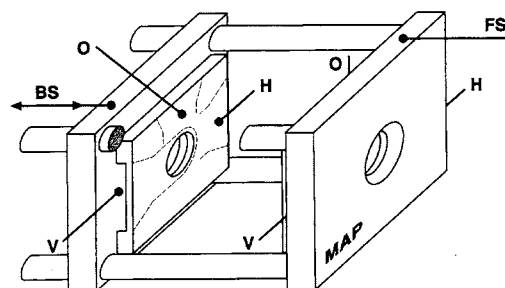
Cost-efficiency comparison for mold-change on a 1000 kN injection molding machine.

	Clamp DIN 6316 and clamping screw	Bakra
No. of mold changes / year	150	150
No. of operators / change	2	1
Hours required / change	2 x (0,5 h (= 30 Min.))	0,083 h (= 5 Min)
Purchase costs / 5-year depreciation	€ 400 (€ 80 / a)	€ 3800 (€ 760 / a)
Wages / year (€ 41 / h person)	€ 6150	€ 512,50
Machine down times / year (€ 51 / h)	€ 3825	€ 637,50
Costs / year	€ 10055	€ 1910
Savings / year		81%

The complete set contains the following items:

- 2 Adapter plates (BS/FS)
- 2 Locking rings (BS/FS)
- 1 Wrench
- 2 Locating rings (BS/FS)

Please specify type of molding machine.
Insulating sheets upon request.
Screws are included.



BS = moveable half
FS = fixed half
H = rear *

O = top*
V = front*

* Please specify side of locking system



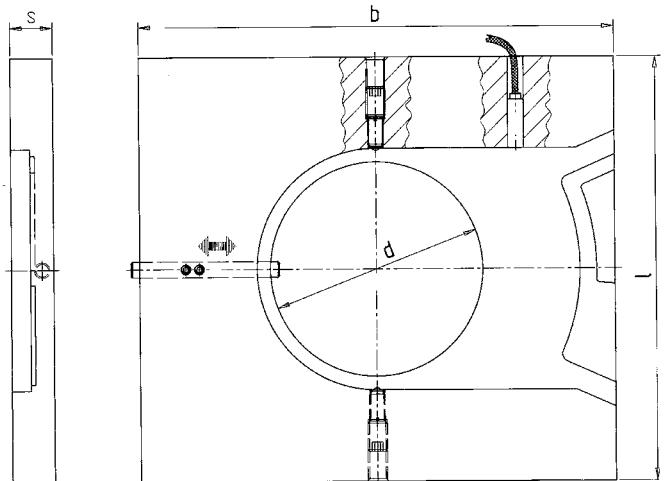


AD

Adapter plates

Mat.: 1.2312
BS and FS are mirror-inverted

Mold safety device is available as option.



REF	d	l x b	s	REF	d	l x b	s	REF	d	l x b	s	REF	d	l x b	s
AD	110	218 x 246	22	AD	110	410 x 446	22	AD	125	218 x 246	27	AD	125	410 x 446	27
AD	110	246 x 246	22	AD	110	446 x 446	22	AD	125	246 x 246	27	AD	125	446 x 446	27
AD	110	246 x 296	22	AD	110	496 x 496	22	AD	125	246 x 296	27	AD	125	496 x 496	27
AD	110	265 x 396	22	AD	110	496 x 546	22	AD	125	265 x 396	27	AD	125	496 x 546	27
AD	110	280 x 400	22	AD	110	520 x 520	22	AD	125	280 x 400	27	AD	125	520 x 520	27
AD	110	296 x 296	22	AD	110	530 x 530	22	AD	125	296 x 296	27	AD	125	530 x 530	27
AD	110	296 x 346	22	AD	110	546 x 596	22	AD	125	296 x 346	27	AD	125	546 x 596	27
AD	110	346 x 346	22	AD	110	580 x 580	22	AD	125	346 x 346	27	AD	125	580 x 580	27
AD	110	346 x 396	22	AD	110	596 x 596	22	AD	125	346 x 396	27	AD	125	596 x 596	27
AD	110	396 x 396	22	AD	110	596 x 646	22	AD	125	396 x 396	27	AD	125	596 x 646	27
AD	110	396 x 646	22	AD	110	646 x 646	22	AD	125	396 x 646	27	AD	125	646 x 646	27
AD	110	400 x 450	22	AD	110	646 x 696	22	AD	125	400 x 450	27	AD	125	646 x 696	27
AD	110	410 x 410	22	AD	110	696 x 696	22	AD	125	410 x 410	27	AD	125	696 x 696	27

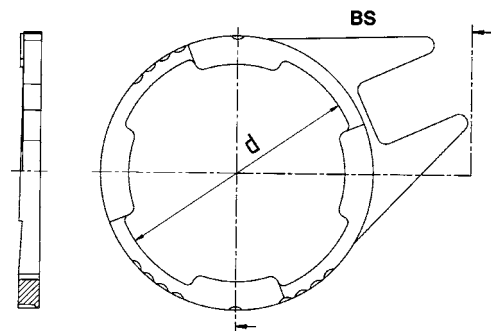
SP

Locking rings

Mat.: 1.2312 ~ 1030 N/mm²
BS and FS are mirror-inverted

REF	d	Type
SP	110	BS*
SP	110	FS*
SP	125	BS*
SP	125	FS*

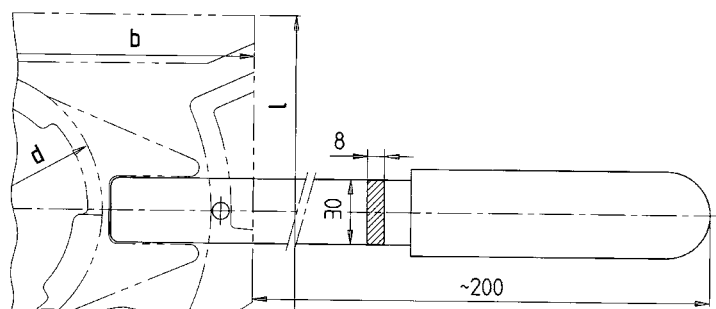
*BS = moveable half
*FS = fixed half



SPS

Wrench

Mat.: St 50
When ordering please specify:
Flange dia., size of adapter plate,
wrench opening, Type of molding machine.



CAD reference point

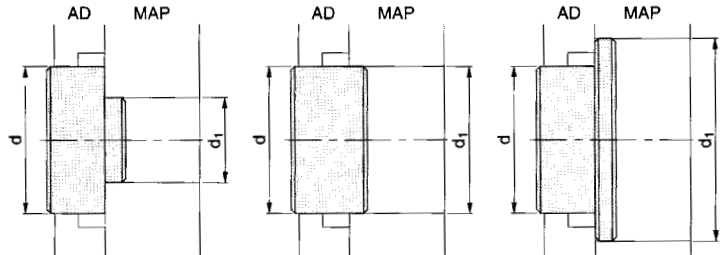


Centering device

ZV

Centering Device
Mat.: 1.1730
MAP = Machine plate

REF	d x d ₁
ZV	110 x 60
ZV	110 x 80
ZV	110 x 90
ZV	110 x 100
ZV	110 x 110
ZV	110 x 125
ZV	110 x 160
ZV	110 x 175
ZV	125 x 60
ZV	125 x 80
ZV	125 x 90
ZV	125 x 100
ZV	125 x 110
ZV	125 x 125
ZV	125 x 160
ZV	125 x 175

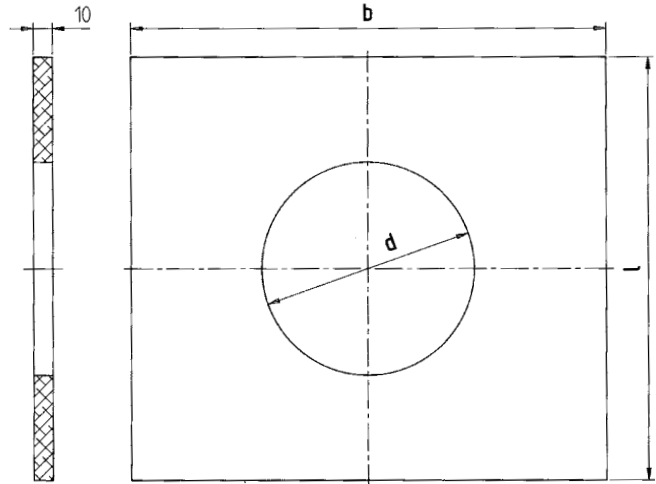


Thermal Insulating sheets

WP

Thermal conductivity : 0,2 W/mK
T max: 200°C
Compressive strength (20°C): 600 N/mm²

Screw holes and recesses for tiebars will be provided according to your drawing.



REF	d	l x b
WP	110	218 x 246
WP	110	246 x 246
WP	110	246 x 296
WP	110	265 x 396
WP	110	280 x 400
WP	110	296 x 296
WP	110	296 x 346
WP	110	346 x 346
WP	110	346 x 396
WP	110	396 x 396
WP	110	396 x 646
WP	110	400 x 450
WP	110	410 x 410

REF	d	l x b
WP	110	410 x 446
WP	110	446 x 446
WP	110	496 x 496
WP	110	496 x 546
WP	110	520 x 520
WP	110	530 x 530
WP	110	546 x 596
WP	110	580 x 580
WP	110	596 x 596
WP	110	596 x 646
WP	110	646 x 646
WP	110	646 x 696
WP	110	696 x 696

REF	d	l x b
WP	125	218 x 246
WP	125	246 x 246
WP	125	246 x 296
WP	125	265 x 396
WP	125	280 x 400
WP	125	296 x 296
WP	125	296 x 346
WP	125	346 x 346
WP	125	346 x 396
WP	125	396 x 396
WP	125	396 x 646
WP	125	400 x 450
WP	125	410 x 410

REF	d	l x b
WP	125	410 x 446
WP	125	446 x 446
WP	125	496 x 496
WP	125	496 x 546
WP	125	520 x 520
WP	125	530 x 530
WP	125	546 x 596
WP	125	580 x 580
WP	125	596 x 596
WP	125	596 x 646
WP	125	646 x 646
WP	125	646 x 696
WP	125	696 x 696

CAD reference point

ZF...

Locating rings

Mat.: 1.2312 ~ 1030 N/mm²

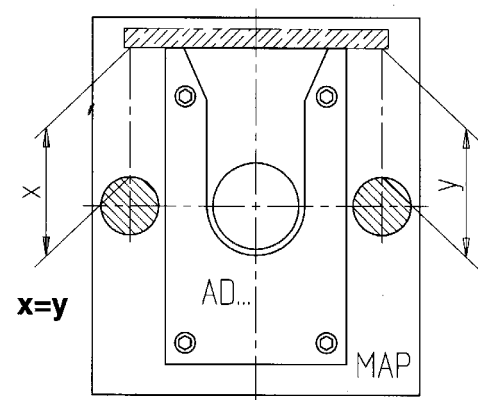
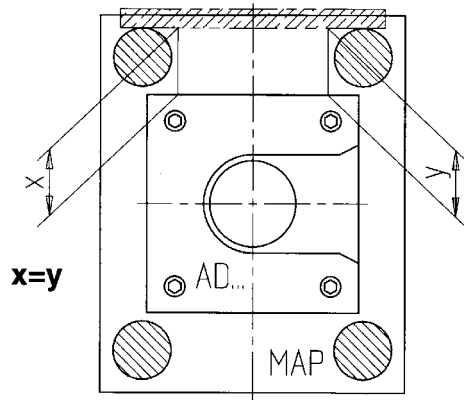


ZF 110		ZF 125	
Moveable half (BS)	Fixed half (FS)	Moveable half (BS)	Fixed half (FS)
<p>ZF 110/BS/3</p> <p>4 x Ø 10</p>	<p>ZF 110/FS/3</p> <p>4 x Ø 10</p>	<p>ZF 125/BS/1</p> <p>4 x Ø 12</p>	<p>ZF 125/FS/1</p> <p>4 x Ø 12</p>
<p>ZF 110/BS/4</p> <p>4 x Ø 10</p>	<p>ZF 110/FS/4</p>	<p>ZF 125/BS/2</p>	<p>ZF 125/FS/2</p>
<p>ZF 110/BS/5</p>	<p>ZF 110/FS/6</p> <p>6 x Ø 8</p>	<p>ZF 125/BS/3</p> <p>4 x Ø 12</p>	<p>ZF 125/FS/3</p> <p>4 x Ø 12</p>
<p>ZF 110/BS/7</p> <p>6 x Ø 8</p>	<p>ZF 110/FS/8</p> <p>4 x Ø 10</p>	<p>ZF 125/BS/4</p>	<p>ZF 125/FS/4</p>
<p>ZF 110/BS/8</p> <p>6 x Ø 8</p>	<p>ZF 110/FS/9</p> <p>4 x Ø 10</p>	<p>ZF 125/BS/5</p> <p>6 x Ø 10</p>	<p>ZF 125/FS/5</p> <p>6 x Ø 10</p>
<p>ZF 110/BS/10</p> <p>6 x Ø 8 / 4 x Ø 10,5</p>	<p>ZF 110/FS/10</p> <p>6 x Ø 8 / 4 x Ø 11</p>	<p>ZF 125/BS/7</p> <p>8 x M10 x 20</p>	<p>ZF 125/FS/7</p> <p>6 x M10 x 20</p>
<p>ZF 110/BS/16</p> <p>4 x Ø 10</p>	<p>ZF 110/FS/11</p> <p>6 x Ø 8</p>		
	<p>ZF 110/FS/16</p>		

CAD reference point

Mounting instructions

Info



1. Mount mold-specific locating rings ZF on the mold.
2. Open injection molding machine, move back injection unit and machine ejector system.
3. Mount thermal insulating sheets WP (if available) onto the adapter plates AD using small SHC-screws.
4. Push back retention pins fixed to the adapter plates.
5. Insert centering device ZV into centering hole Dia. 110 mm or 125 mm of the adapter plates.
6. Position these subgroups according to the markings FS or BS onto the machine plates and mount them with SHC-screws. Don't screw in completely so that adjustment is still possible.
7. Align horizontal position of adapter plates according to sketch above and tighten screws.
8. Remove ZV, if necessary make thread in ZV.
9. In case mold set-up in horizontal direction is required, retention pins located in the adapter plates have to be pushed back.
10. For mold set-up into the molding machine proceed as usual. With mold and machine in closed position, mold must be interlocked at the fixed and moveable half using wrench. Remove wrench from the adapter plate.

