Undercut Base Unit

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

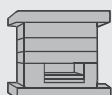| Order	A	B	C	D	L	M	P
SD.3220GR	32	37	20	27	80	180	10
SD.3824GR	38	40	24	28	80	210	12
SD.4528GR	45	44	28	30	100	250	16

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.

62 ± 2 HRC
Ø **P** g6

Mounting

Mould Closed   **Mould Opened**

Max. 20⁰
M
Ø **P**
A
L

⊙ 3D file can be downloaded from www.cumsa.com

Ø **A** g6
X⁰
T Havşa İmbus
G
Ø **D**
H
Ø **U**
B
5
S
C
E

Angled Guide Bush

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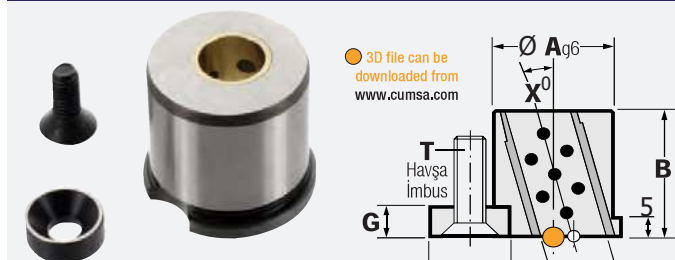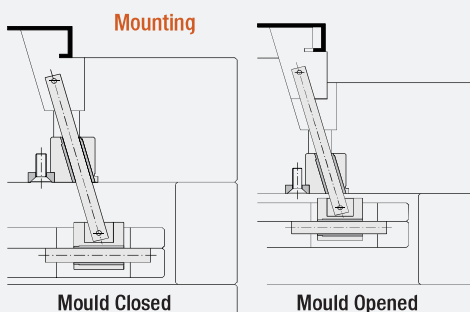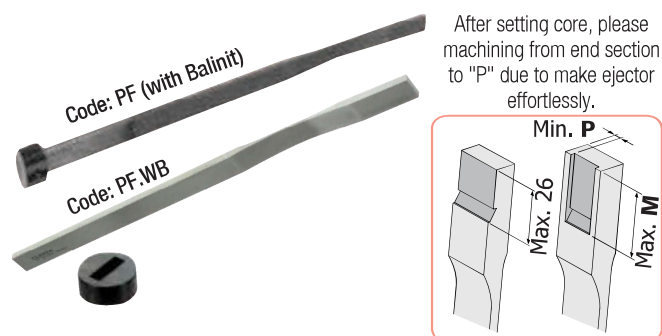
Material: 1.7242   **Hardness:** 58 ± 3 HRC

| 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	

Injection Moulds

"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.

Code: PF (with Balinit)
Code: PF.WB
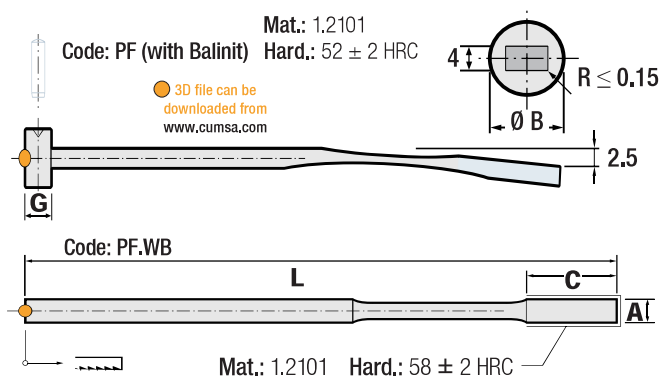
Min. **P**
Max. 26
Max. **M**

Flexible Sprung Core

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.

0   5   10   15   20   25   30   **Opening Dimensions**
2.5   2.3   2   1.8   1.6
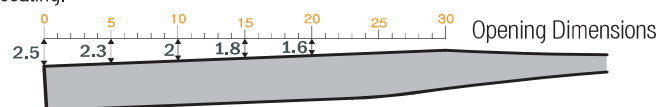
The opening of the sprung cores is a radial movement.
Due to this, at the edge of the stroke, the opening is 2.5mm (0.098").

Code: PF (with Balinit)   **Mat.:** 1.2101 **Hard.:** 52 ± 2 HRC

⊙ 3D file can be downloaded from www.cumsa.com

G
4
Ø **B**
R ≤ 0.15
2.5

Code: PF.WB
L
C
A

Mat.: 1.2101   **Hard.:** 58 ± 2 HRC

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						-

R ≤ 0.15   4 H7 X A H7
>0.1
>5⁰

Mounting

Min. **R**
Ø **H**

G110
Mounting Flange
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Mould Closed   **Mould Opened**