

Flat mold clip



Refer carefully to this manual before operation.

Introduction

- It's well-designed, full of strength, not easily deformed, of small size, flexible and easy to operate, a fixture frequently used in mold processing, mainly for making the work piece not vibrate and not move during processing to ensure the accuracy and fine finish. Its quality has direct impact on the process precision and of product quality. Therefore, mold folder is playing an important role in the mold manufacturing process.
- Manufacturing process of mold folder: Press plate is made of ductile iron casting, and is specially treated to achieve high mechanical properties. Besides, the surface paint is given to prevent rust. Furthermore, add embossing on the contact surface to fix the mold better. Finally, it's made of parts of high strength, excellent performance.

Use and precautions flatbed die folder

Work piece clamping clip with a flat mode is a method commonly used in the milling machine, especially when using end milling cutter on horizontal milling machine.

Things to pay attention when using flat-folder:

- (1) It's necessary to put the folder at a proper position where the stiffness of the work piece is the best. The rigid clamping force also should be appropriate. Otherwise, work piece with poor rigidity will be easy to be deformed.
- (2) The pad iron must be properly placed under the press plate. It should be as high as the work piece or a little higher than it. Otherwise, it will weaken the compression effect.
- (3) Pressure plate bolts must be close to the work piece as much as possible. The distance from the bolt to the work piece should be less than the one from the bolt to the pad iron to enhance the pressing force.
- (4) The bolt must be tightened. Otherwise, it may make the work piece move because the pressure is not enough, and thus cause damage to the work piece, machine tools and cutting tools.
- (5) There are many holes on the injection molding machine template. The screw slide wire will occur occasionally after being used for a period of time. The usual way to repair is to expand the screw hole, which means to enlarge the hole to a larger thread and then tap. Equipped with larger plates and bolts. Generally, the screw used more frequently is prone to damage. It's still possible to enlarge the thread again and again due to the screw slide after being repaired by the above method. There are two reasons for holes slide wire: One is that the bolt goes too deep into the hole. When the pulling force goes beyond the tensile strength of the thread, it will be damaged. Another one is that there is burr or dirt with the thread of the bolt and screw mouth, which scratches the bolt hole and accelerates the wear of thread. Consequently, the tensile strength will slowly drop to failure. Press plate with a big head bolt causes bolt rollover and thus damage the template table because of deformation.

Specification and material

Model Project	M12	M16	M20	M24
Bolt size	M12	M16	M20	M24
Length(mm)	95	130	150	195
Width(mm)	36	42	50	85
Height(mm)	21	32	35	36
The slot length(mm)	50	70	82	105
The slot width(mm)	14	18	22	30
The screw height/(mm)	150	150	150	150
Weight(kg)	0.55	1.1	1.85	4.1
Parallel plate	FCD600			
Hexagon nut	Carbon Stee8.8			
Thickening gasket	Steel45#			
Hexagon bolt	Galvanized 4.8			
The double headed screw	Carbon Stee8.8			

Note:

- 1) It will be available to accept the order if the specifications which customers require are different with ours and the required quantity is not less than 1000PCS.
- 2) Please contact us for more details.

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