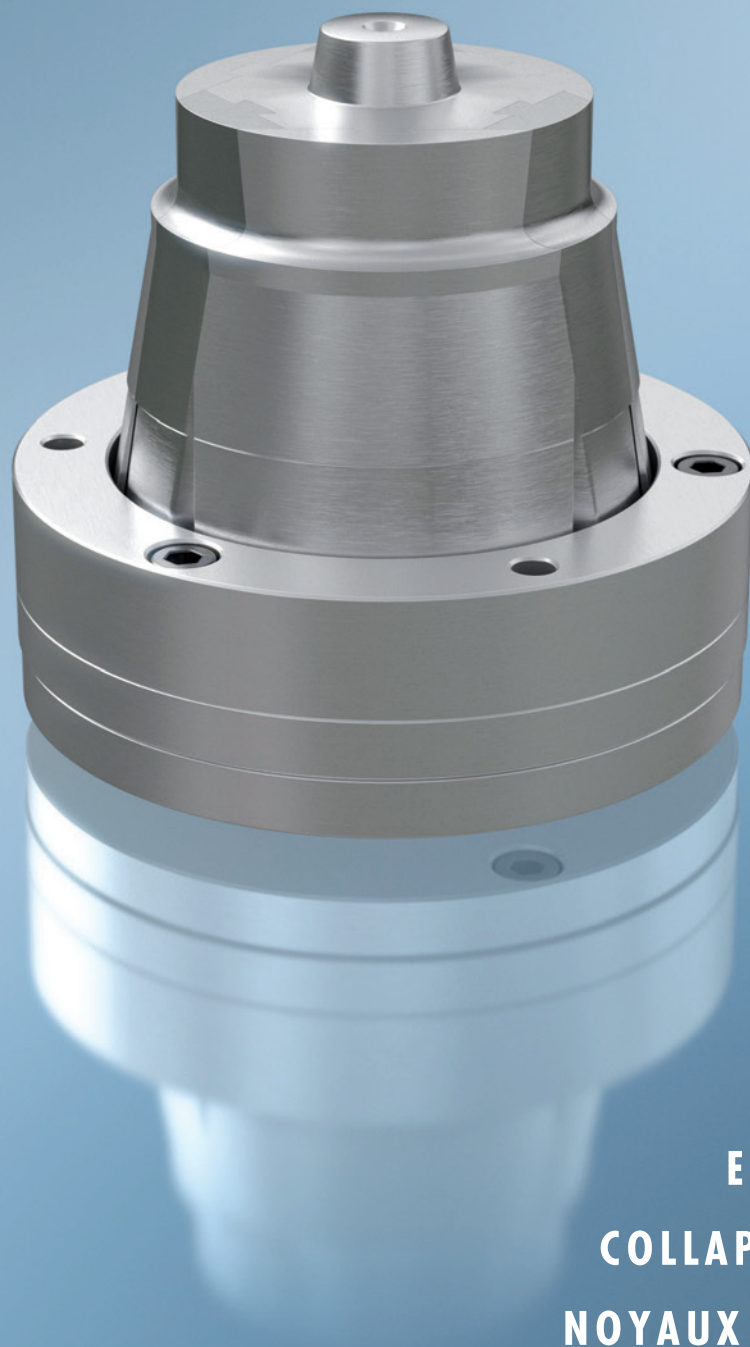


**STRACK**<sup>®</sup>  
NORMALIEN







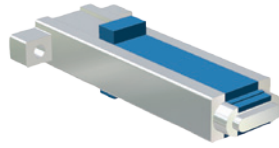
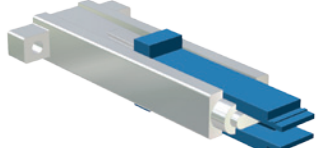
EINFALLKERNE  
COLLAPSIBLE CORES  
NOYAUX ECLIPSABLES

## Einfallkerne

## Collapsible cores

## Noyaux éclipables



Typ	geschlossen / closed / fermé	geöffnet / opened / ouvert
		
		

5

Einfallkerne werden vorzugsweise zum Entformen von Gewinden und innenliegenden Hinterschneidungen in Spritzgießwerkzeugen eingesetzt.

Jeder Einfallkern ist eine Sonderanfertigung und wird artikelbezogen konstruiert. Hierfür werden Konstruktionsdaten Ihres Artikels benötigt.

### Besondere Merkmale

- Individuelle Anpassung an den Artikel  
Standardgrößen von 12-120 mm  
Sonderausführungen nach Prüfung
- Effektive Kühlung möglich (Mittelkern)
- Jedes Segment zwangsgeführt und somit bei Betätigung gleichförmiger Lauf
- Einfacher Einbau
- Hohe Laufzeit, da keine federnden Elemente vorhanden
- Verschiedene Materialpaarungen möglich (Segmente und Kern)
- Alle Bewegungsteile vakuumgehärtet, drahterodiert und rundgeschliffen
- Gleitbeschichtungen möglich
- Entformfunktion wird durch die Werkzeugbewegung gesteuert
- Für Einfach- und Mehrfachwerkzeuge geeignet

Collapsible cores are preferably used for the removing from the mould of threads and internal undercuts in injection moulding dies.

Each collapsible core is a special design which is particularly constructed for your article. Therefore we need construction data of your article.

### Features

- Individual adjustment to the article  
Standard sizes of 12-120 mm  
Special designs after examination
- Effective cooling possible (center core)
- Each segment has a restricted guidance and therefore during the operation the movement is constant
- Simple mounting
- High running time, because no elastic elements exist
- Different material combinations are possible (segments and core)
- All motion parts are vacuum-hardened, wire-cut and cylindrically ground
- Slide coatings are possible
- The removing function from the mould is actuated by the mould movement
- Suited for single- or multi-impression moulds

Noyaux éclipables sont particulièrement utilisés pour le démoulage des filets et des contresdépouilles à l'intérieur dans les moules à injection.

Chaque noyau éclipable est un modèle spécial qui est particulièrement construit pour votre article. Pour cette raison nous avons besoin de données de construction de votre article.

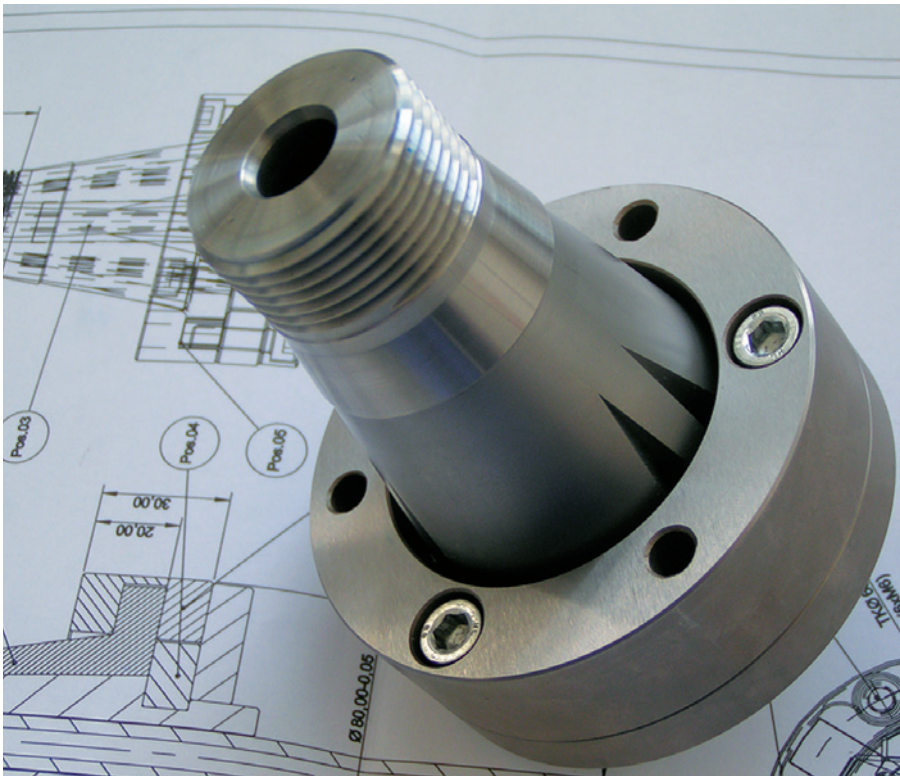
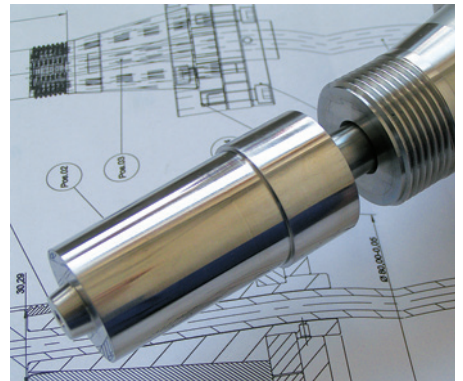
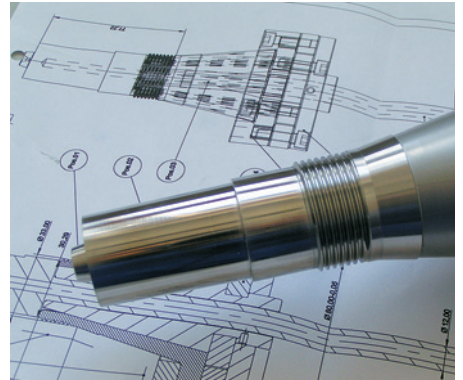
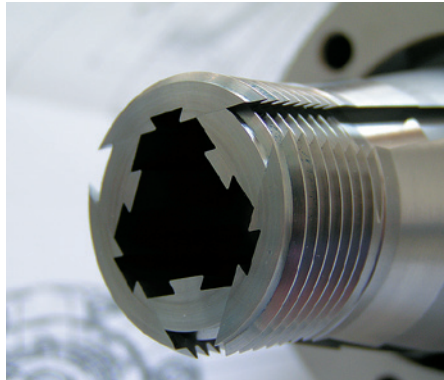
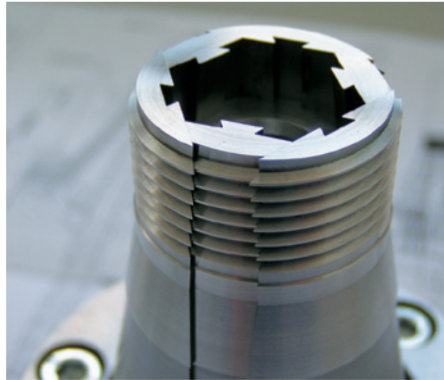
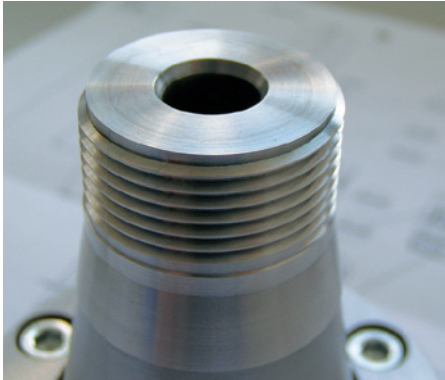
### Particularités

- Ajustement individuel à l'article  
Grandeurs standard de 12-120 mm  
Modèles spéciaux après examen
- Refroidissement effectif possible (noyau central)
- Chaque segment avec guidage forcé et donc une marche constante pendant l'actionnement
- Montage simple
- Temps élevé de l'usinage, parce que des éléments élastiques n'existent pas
- Combinaisons des matières sont possibles (segments et noyau)
- Tous les parties de mouvement sont trempées sous vide, découpées par électroérosion à l'aide d'un fil et rectifiées cylindriques
- Revêtement de glissement possible
- Fonction de démoulage est actionnée par le mouvement du moule
- Convenable pour moules à empreinte unique et moules à plusieurs empreintes

**Einfallkerne**

**Collapsible cores**

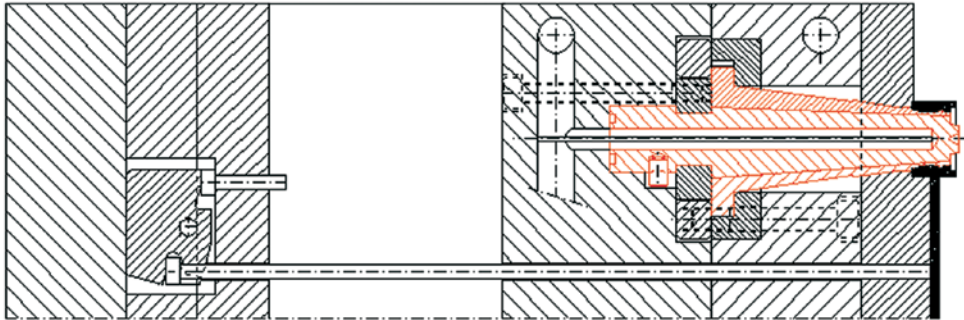
**Noyaux éclipables**



**Einfallkerne**  
Anwendungsbeispiel

**Collapsible cores**  
Application example

**Noyaux éclipables**  
Exemple d'utilisation

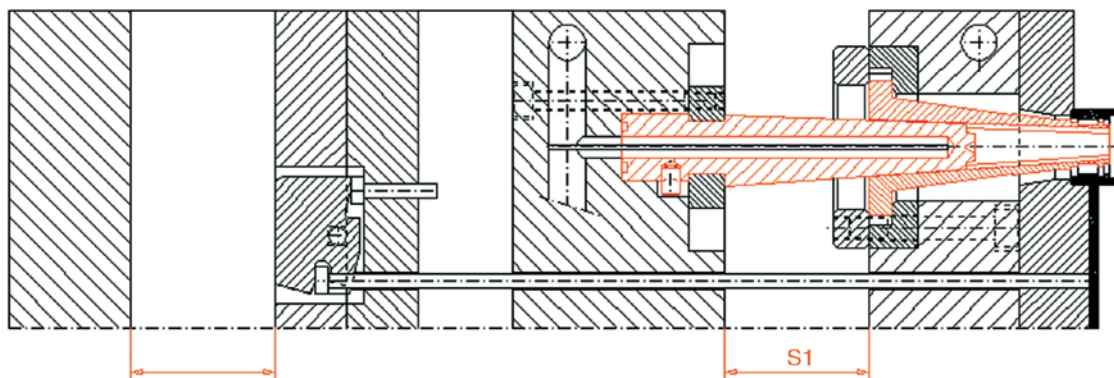


Das Werkzeug ist geöffnet. Die Auswerferseite befindet sich in Ausgangsstellung.

The mould is open. The ejector side is in the initial position.

Le moule est ouvert. Le côté de l'éjecteur se trouve en position de départ.

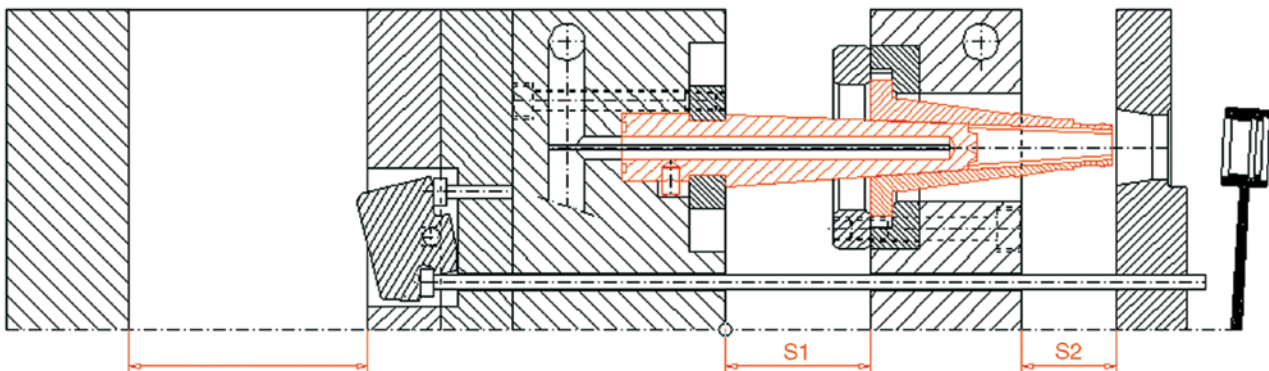
5



Zwischenplatte und Abstreiferplatte fahren den Hub „S1“. Die beweglichen Segmente fahren zusammen und geben somit das Spritzteil frei.

The intermediate plate and the stripper plate travel stroke "S1". The moving segments move together and release the moulding.

La plaque intermédiaire et la plaque de démoulage effectuent la course «S1». Les segments mobiles se déplacent ensemble et libèrent ainsi la pièce moulée.



Die Abstreiferplatte fährt den Hub „S2“ und das Spritzteil wird vom Außenkern abgestreift.

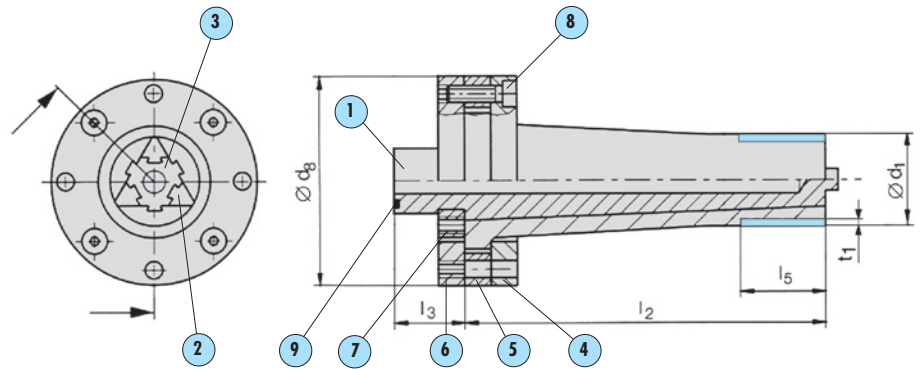
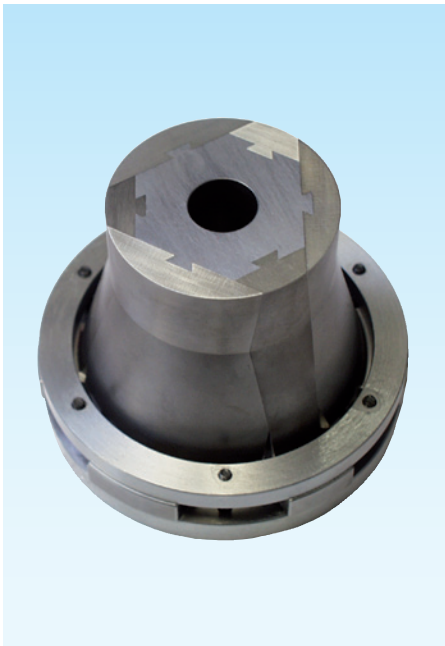
The stripper plate travels stroke "S2" and the moulding is stripped-off from the external core.

La plaque de démoulage effectue la course «S2» et la pièce moulée est décollée du noyau extérieur.

**Einfallkerne**  
Anfrage

**Collapsible cores**  
Inquiry

**Noyaux éclipables**  
Demande de devis



**Z 4260-**

Z 4260-d1-t1-l5-  
l2-s1



d <sub>1</sub>	t <sub>1</sub>	l <sub>5</sub>	l <sub>2</sub>	Stück / Piece / Pièce	S <sub>1</sub> (siehe Seite 2.58) (see page 2.58) (cf. page 2.58)	d <sub>8</sub>	l <sub>3</sub>
----------------	----------------	----------------	----------------	-----------------------	---	----------------	----------------

t<sub>1</sub> = Tiefe der Hinterschneidung pro Seite  
Depth of undercut per side  
Profondeur de la contre-dépouille par côté

Eine angemessene Öffnungsgeschwindigkeit des Einfallkerns wird vorausgesetzt.

An adequate opening speed of the collapsible core is provided.

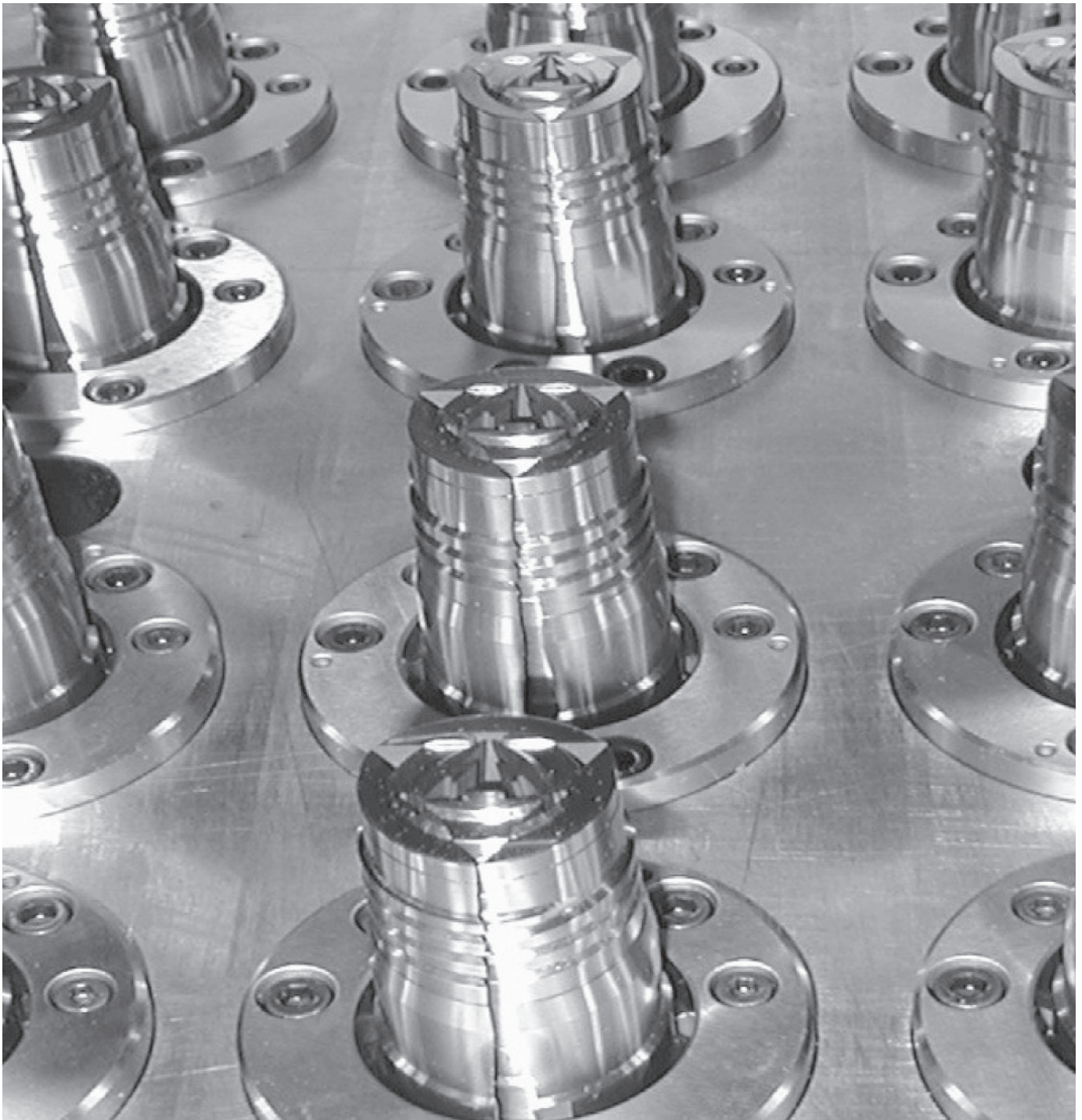
Une vitesse d'ouverture du noyau éclipable est supposée.

Pos.	Mat.
1	1.2343
2 / 3	1.2379
4 / 5 / 6 / 7	1.7225
8	8.8
9	Viton

**Einfallkerne**

**Collapsible cores**

**Noyaux éclipables**



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FALTEINHEITEN  
FOLDING UNITS  
UNITES DE PLIAGE



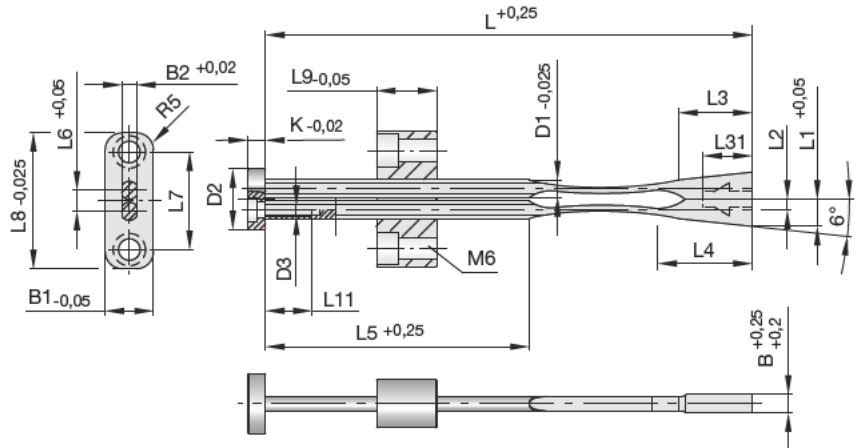




**Flexible Auswerfer**

**Flexible ejectors**

**Ejecteurs flexible**



**Z 4264-**

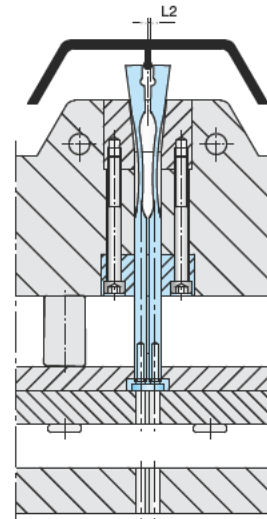
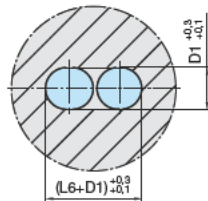
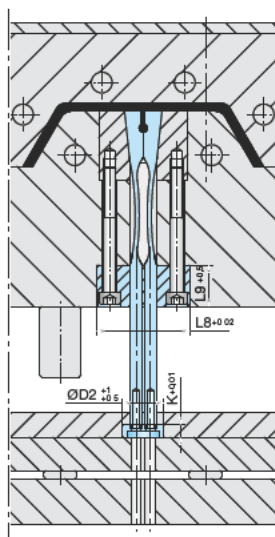
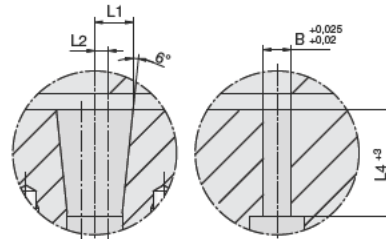
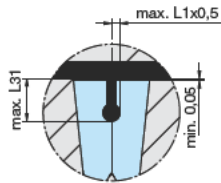
Mat.: 1.6565/  
Bronze

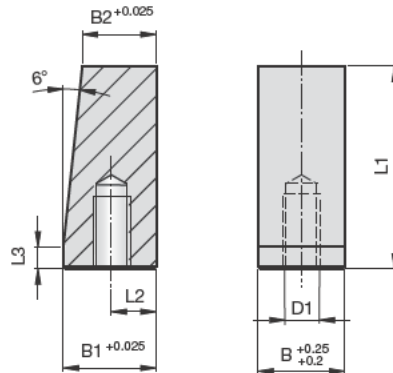
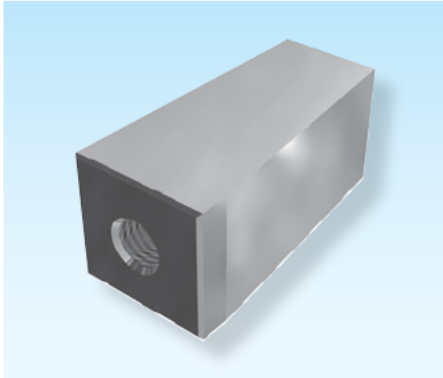
**Z 4264-B**



B	L	L1	L2	L3	L31	L4	L5	B2	D1	L8	B1	L9	L6	L7	D2	K	L11	D3
6	162,5	9,0	3,5	24,3	12,5	24,3	88	4,84	5,94	45	16	20	6,90	32,3	20	6	19	M4
12	200,0	11,5	4,5	26,0	16,5	30,0	111	7,37	7,92	48	16	20	8,94	34,4	20	6	19	M5
14	200,0	12,5	4,5	28,5	16,5	33,1	107	7,37	7,92	48	16	20	8,94	34,4	22	6	19	M5
16	200,0	12,5	4,5	28,5	16,5	33,1	107	7,37	7,92	48	16	20	8,94	34,4	22	6	19	M5

5



**Verschleißblock für flexible Auswerfereinheit**
**Wear block for flexible ejector unit**
**Bloc d'usure pour l'unité d'éjecteur flexible**

**Z 4266-**

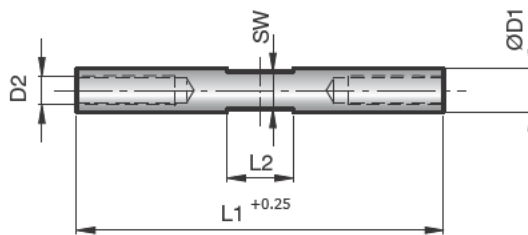
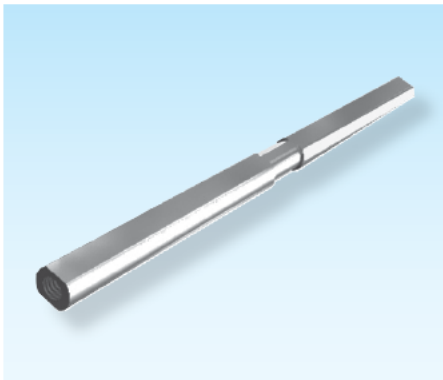
 Mat.: 1.2311 nitriert  
 ~ 68HRC

B	L1	L2	L3	B1	B2	D1
6	25,4	7,2	2,9	15,90	13,55	M5
8	25,4	7,2	2,9	15,90	13,55	M6
10	25,4	7,2	2,9	14,40	12,05	M6
12	25,4	7,2	2,9	14,40	12,05	M6
14	33,3	8,0	2,9	15,24	12,12	M6
16	33,3	8,0	2,9	15,24	12,12	M6

Z 4266-B



5

**Verlängerung für flexible Auswerfereinheit**
**Extension for flexible ejector unit**
**Allongement pour l'unité d'éjecteur flexible**

**Z 4268-**

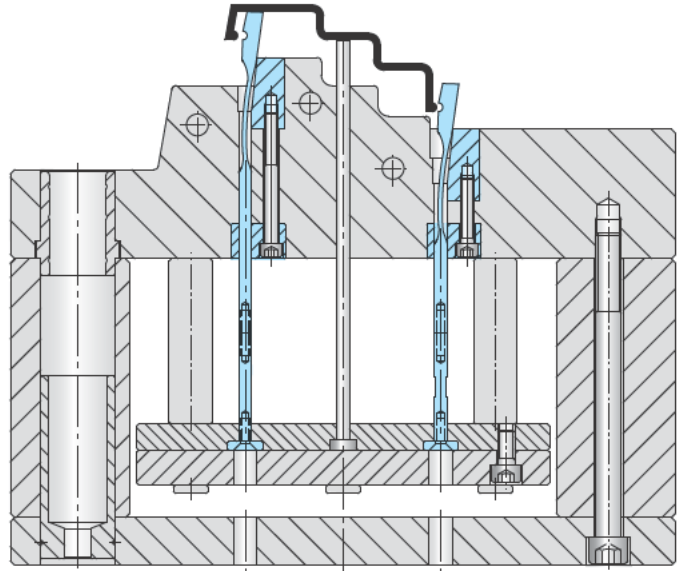
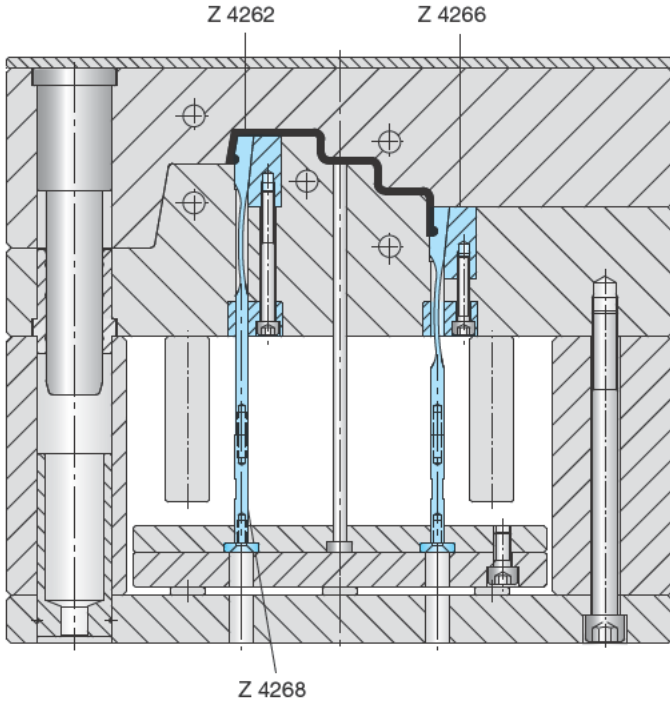
 Mat.: 1.7225  
 ~ 30HRC

D1	L1	L2	SW	D2
6	50	9	3/16"	M4
6	100	9	3/16"	M4
8	50	9	1/4"	M5
8	100	9	1/4"	M5

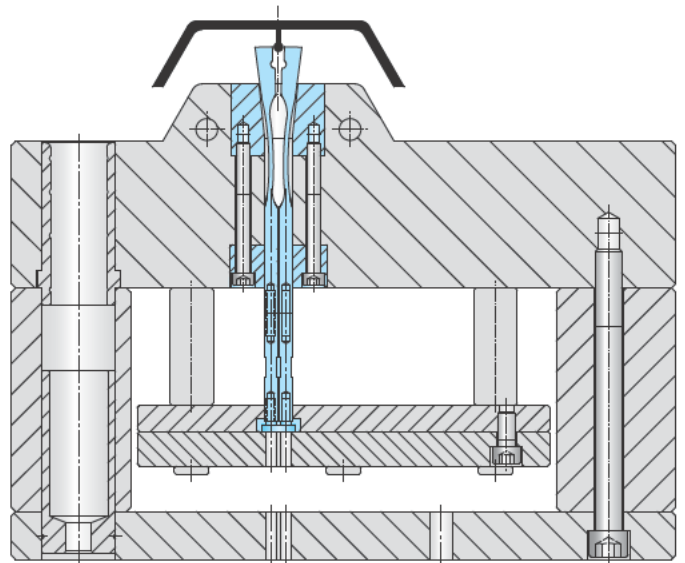
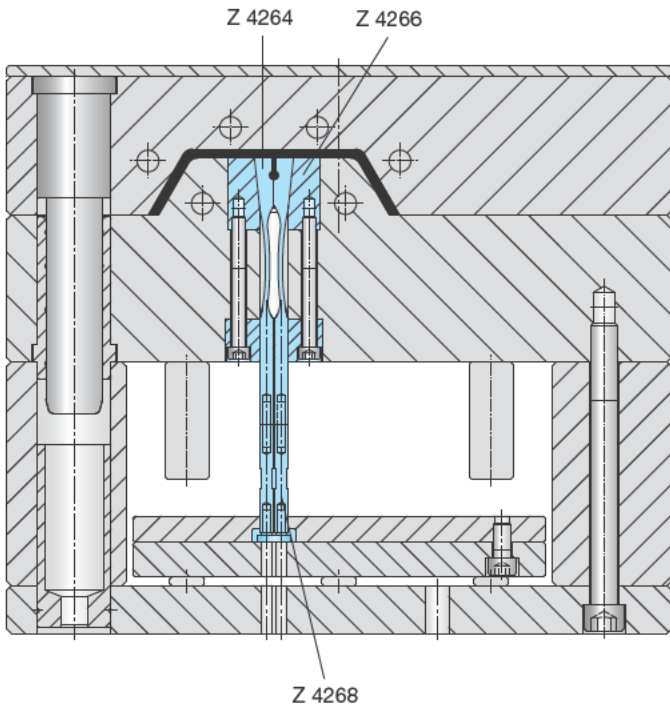
Z 4268-D1-L1



Z 4262- ... Z 4268-



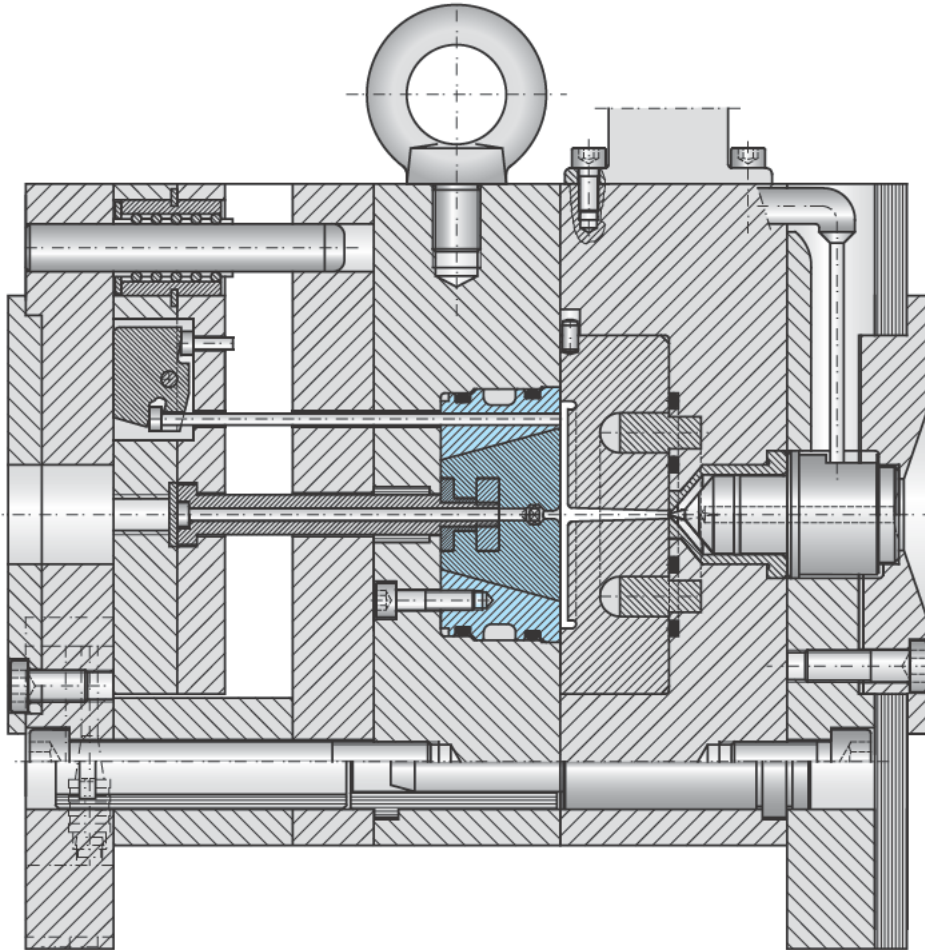
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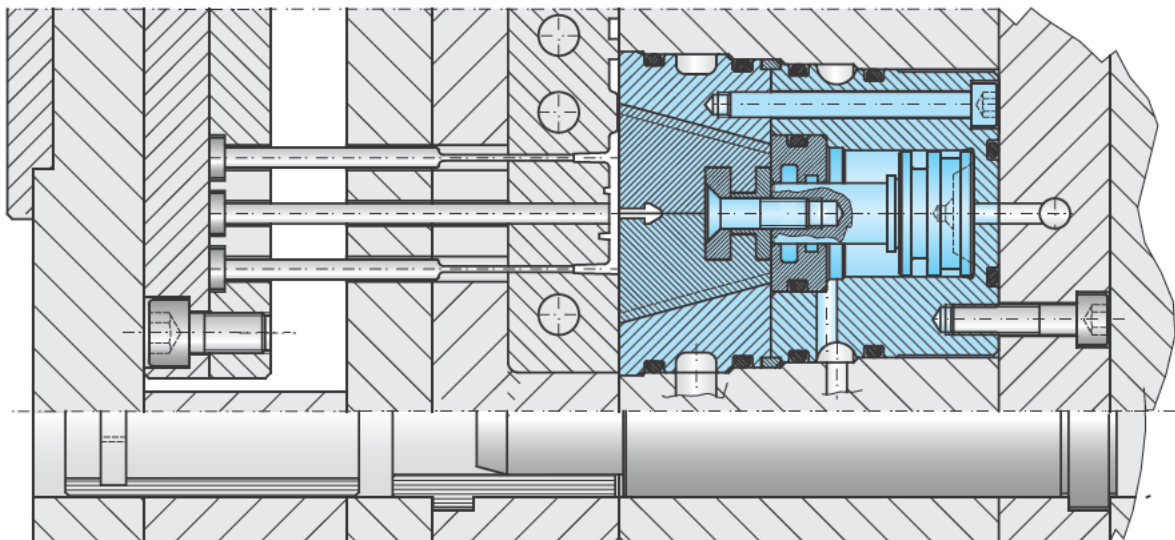
Falteinheiten

Folding units

Unités de pliage



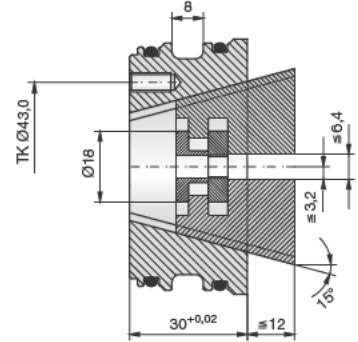
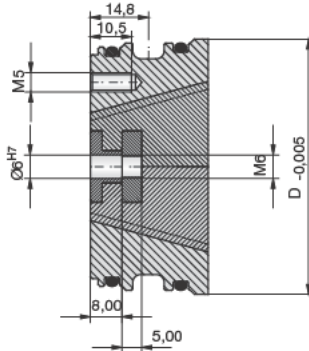
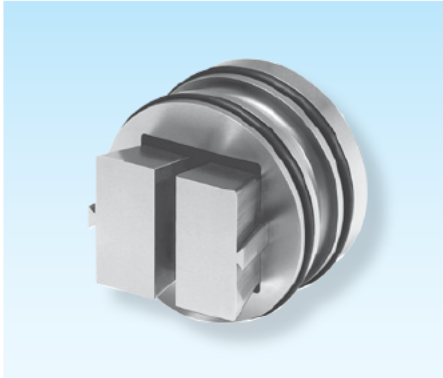
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Falteinheiten

Folding units

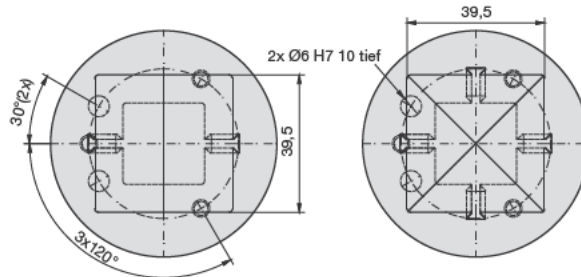
Unités de pliage



**Z 4280-**

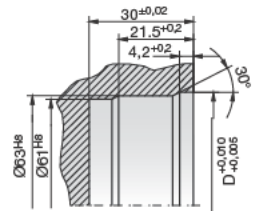
Mat.: 1.2343/  
~ 54HRC

Z 4280-Type

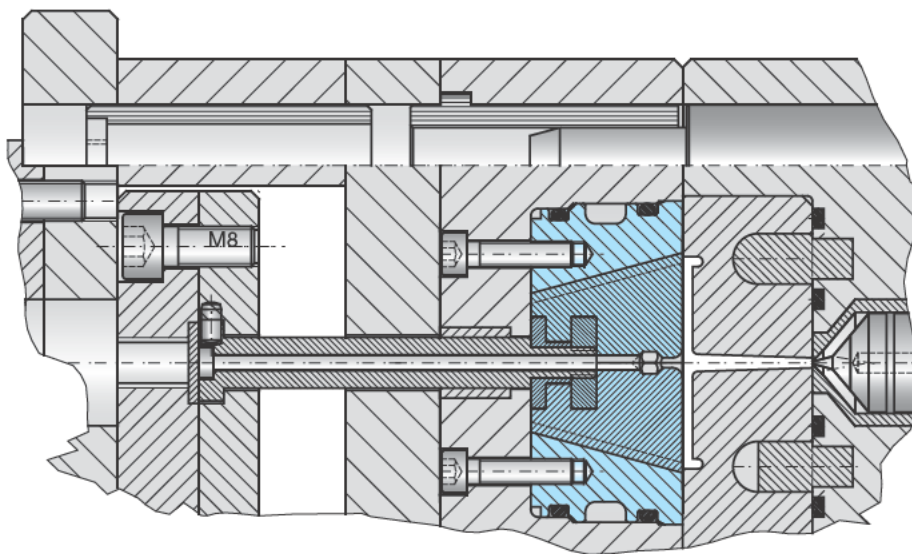


**Type 1**

**Type 2**



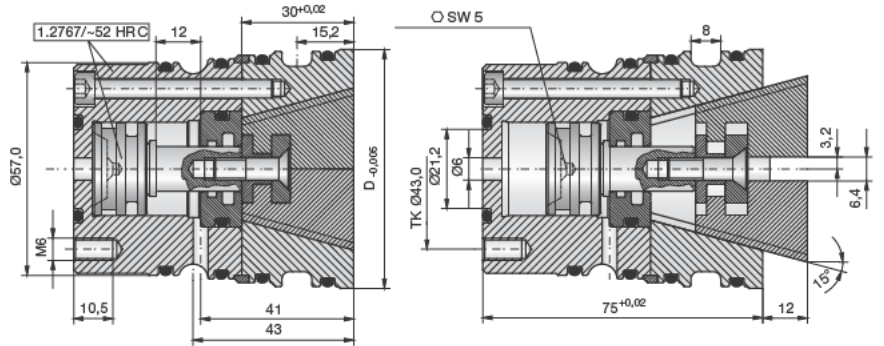
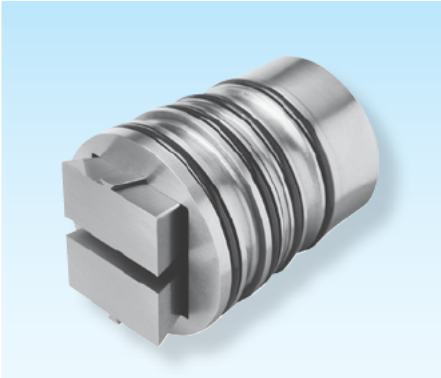
Type	D
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2	64



**Falteinheiten**

**Folding units**

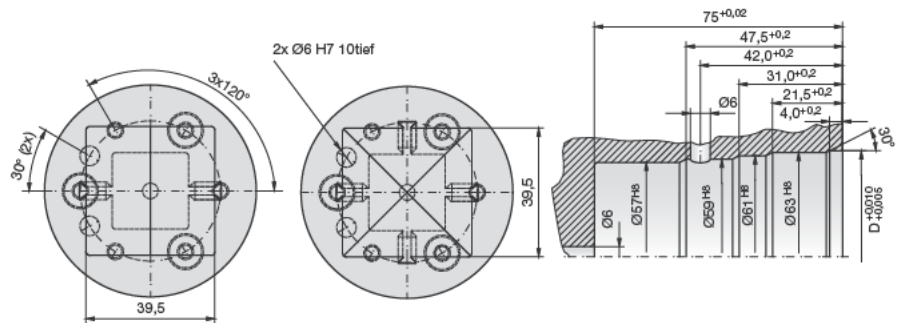
**Unités de pliage**



**Z 4282-**

Mat.: 1.2343/  
~ 54HRC

Z 4282-Type

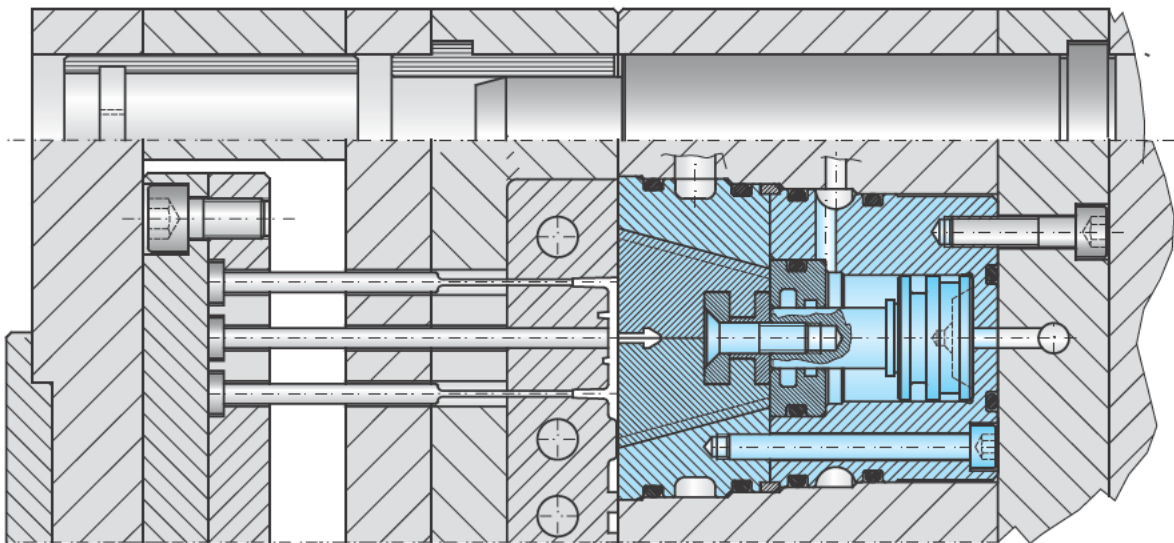


**Type 1**

**Type 2**

Type	D
1	64
2	64

5





INGENIERIA DE MOLDES Y TROQUELES, S. A.

**STRACK®**  
NORMALIEN

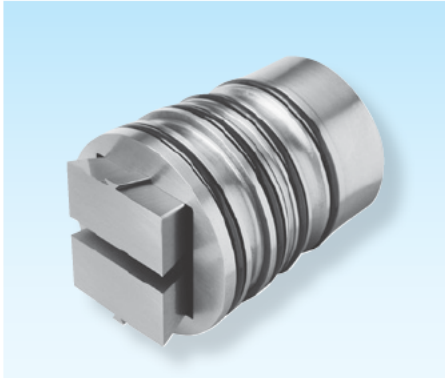
Entformungselemente - direkt / Demoulding elements - direct / Éléments de démoulage - directs

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**Falteinheiten**

**Folding units**

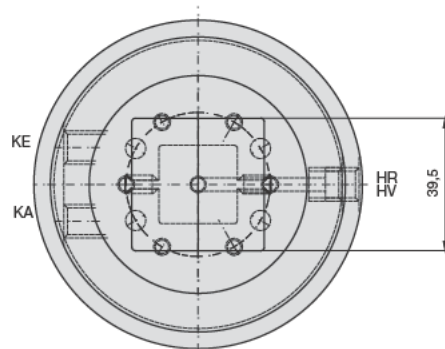
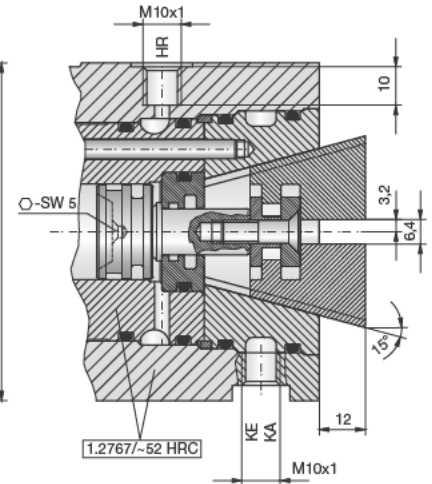
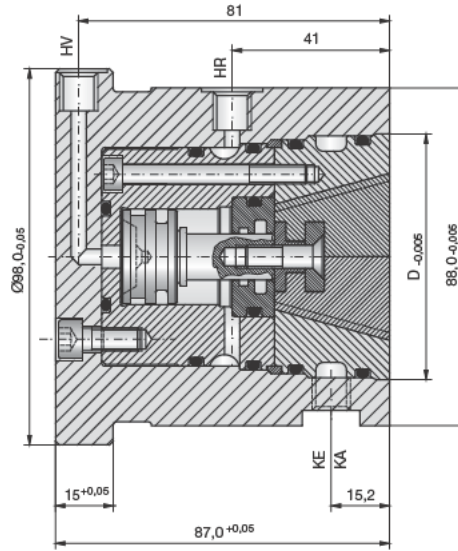
**Unités de pliage**



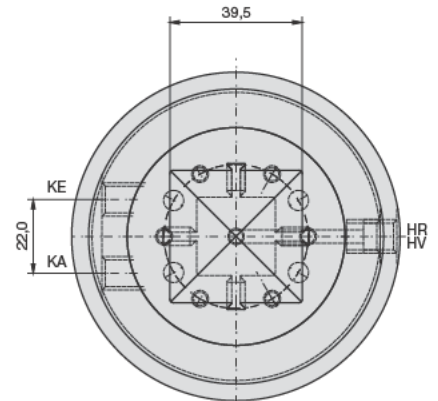
**Z 4284-**

Mat.: 1.2343/  
~ 54HRC

Z 4284-Type



**Type 1**



**Type 2**

Type	D
1	64
2	64

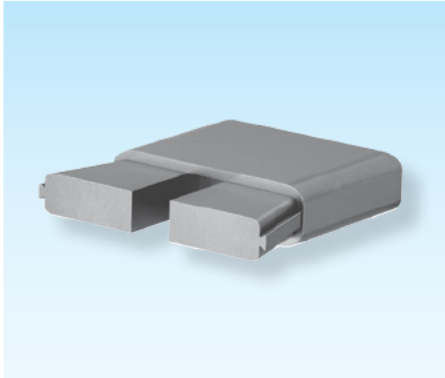
5



**Falteinheiten in Sonderausführung**

**Specially designed folding units**

**Unités de pliage - exécution spéciale**



**Z 4286-**

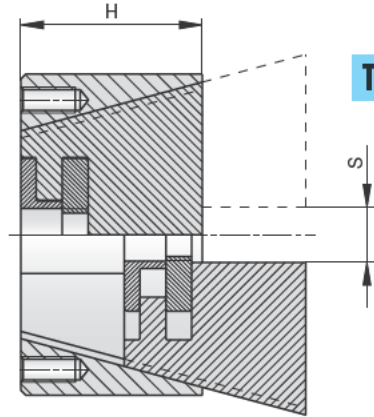
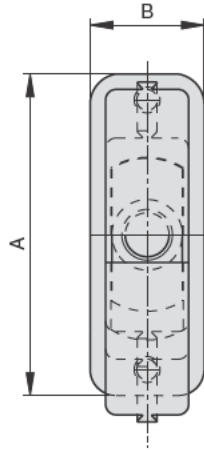
Mat.: 1.2343/  
~ 54HRC



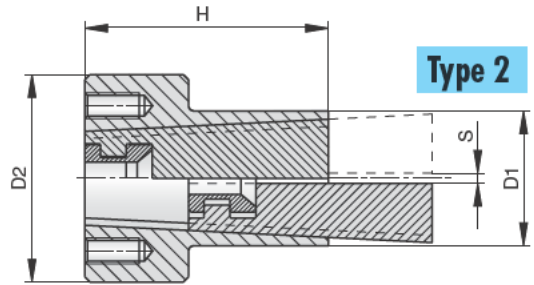
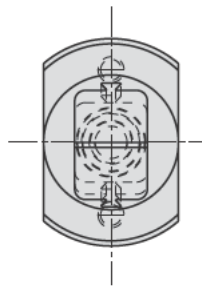
Z 4286-1-S-A-B-H  
Z 4286-2-S-D1-D2-H



5



**Type 1**



**Type 2**

Type

1

2

