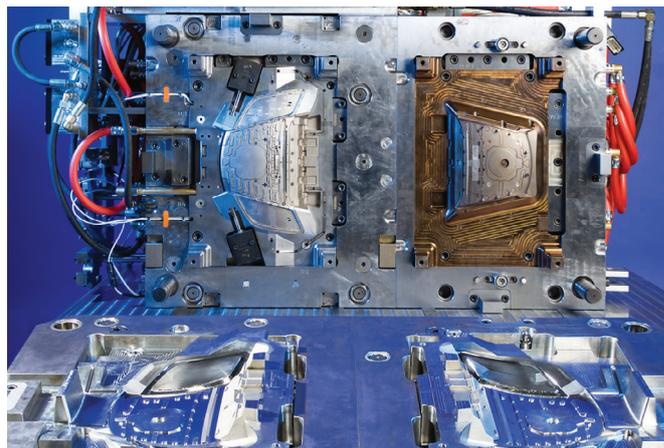


# KH shows 4,000 man hour IMD tool

The injection moulding tool manufactured by German moulder Kunststoff Helmbrechts for producing the two-component IML decorated radio/CD panel on the latest Ford C-Max, represented more than 4,000 man-hours of development and manufacturing time.

The FN 5128 rotating mould used to produce the 380mm by 250mm by 50mm C-Max panel weighs 4.5 tonnes and was the

largest KH had produced at the time. The company has since broken that record with a tool for a similar part on the latest Ford Fiesta. The mould tool comprises two mould quarters assembled together on a 66mm thick adaptor plate measuring 1,092mm by 696mm by 744mm. It incorporates two straight slide valves, 22 diagonal slide valves with 10 control wedges, and eight buried slide valves. Defor-



Kunststoff Helmbrechts broke its size, weight and complexity records producing this tool for the radio/CD panel tools for the new Ford C-Max

mation is controlled by forming four core forms from the panel screw domes.

According to KH, tool design took up to 500 man-hours, while its engineers put in 4,080 hours.

Wire cutting and EDM took up 1,706 hours of machine time; the company's Agietron EDM centre was occupied for three weeks and used up 400 graphite electrodes.



## Kistler simplifies sensor installation

Kistler has developed multi-channel cable technology to simplify the installation of cavity pressure sensors in complex multi-cavity moulds.

Previously, each cavity pressure sensor required a separate cable to the charge amplifier, making installation time consuming and presenting a potential risk of incorrect connection. The new multi-channel cable system uses single wire technol-

ogy to replace multiple connections with one or more eight-pin plug-in connectors.

In the new system, cables from up to eight sensors are brought to a single mould-mounted connector from which a multi-core cable carries signals to the charge amplifier. The specially designed multi-channel charge amplifier is suitable for use with all Kistler Unisens single wire sensors

## DME improves core pulling

DME has developed a new hydraulic locking cylinder for actuating core pulls and mould slides in plastics injection moulds. It is designed to simplify design, fitting and maintenance compared to traditional alternatives.

The cylinder features a mechanical locking system, incorporating a segmented ring that is pushed outward and held by a tapered piston in a cylinder groove. This is claimed to provide quicker and more efficient

operation than traditional cylinders, which require heel blocks to withstand the loads that result from high injection cavity pressures.

The cylinder has proximity switches to sense full extension or retraction, and the piston has a built-in cushion at the fully-retracted stroke end.

The new locking cylinder is more compact and can be operated independently from the mould opening stroke.

## BBG stretches PU carrier line

Germany-based BBG has developed two new mould carrier systems for customers involved in PU-RIM processing.

The BFT-U 26x20 system is hydraulically activated. It was developed for a producer of PU composite spray moulded automotive components and is designed to handle moulds with mounting bases measuring up to 2,600mm by 2,000mm and weighing up to 20 tonnes. It provides a mould stroke of 1,900mm and maximum

closing force of three tonnes.

The BFT-P V4 16x11 is an all-electric system and was delivered to Hennecke's pilot production plant at Sankt Augustin. Designed for maximum production versatility, the carrier provides four independently controlled axes, a swiveling turret, and independently adjustable mould mounting plates.

The BFT-P V4 incorporates mounting plates measuring 1,600mm by 1,100mm and can handle moulds up to 2.5 tonnes.