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Informações Gerais

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Série
A SÉRIE do porta-molde é determinada inicialmente de acordo com a área útil para a usinagem das cavidades, que é calculada a partir das dimensões do produto a ser injetado e das considerações técnicas de funcionamento do molde. Na página de "Séries e Dimensões" encontram-se as cotas que permitem definir a SÉRIE de acordo com a área útil (cotas X e Y).

Tipo
O tipo do molde especifica a largura das placas PB´s (Placa Base Superior e Inferior)
MOLDE TIPO 3: Porta-molde fornecido com rasgo de fixação
MOLDE TIPO 6: Porta-molde fornecido com ABA.

Sub-Série
A SUB-SÉRIE será determinada pela espessura das placas cavidades que estão associadas a altura do produto, detalhes de refrigeração, inserção de gavetas entre outras características funcionais. A SUB-SÉRIE é a identificação das espessuras das placas P1 e P2 e seus valores estão descritos na tabela "SUB-SÉRIES".

Aço
Os aços de construção dos Polimolds foram desenvolvidos para aplicações diferenciadas. As placas que compõem a estrutura de um Polimold, são fornecidas em aço SAE 1045 e as placas cavidades podem ser fornecidas nos seguintes aços:

***Aço 1*: Corresponde ao aço SAE1045 (DIN 1.1730), de fácil usinabilidade e é indicado para moldes com alojamento de postiços.**

***Aço 3*: Corresponde ao aço P20, recomendado para usinagem de cavidade diretamente nas placas. Fornecido com dureza de 28 a 34 HRC, é de excelente usinabilidade e possibilita excelente polimento além de contribuir para a vida útil do molde.**

**Os Polimolds podem ainda serem fornecidos com outros tipos de aços mediante prévia consulta.*

Curso
Os Polimolds possuem 3 cursos de extração padronizados para cada SÉRIE de molde, este curso deve ser determinado em função da altura necessária para extrair o produto (veja tabela de CURSOS)

Montagem
Existem 6 opções diferentes de montagens, elas determinam a inclusão ou posição das guias das extratoras e dos pinos de retorno.

Colunamento
A Polimold padronizou 3 modelos de colunamento, escolha o mais adequado ao seu projeto.

- Colunamento "A": Guia nas placas cavidades P1, PF e P2.
- Colunamento "B": Guia parcial do molde com alinhamento preciso entre as placas cavidades P1, PF e P2 e nas placas Superior e Suporte.
- Colunamento "C": Guia completo com alinhamento preciso e seguro em todas as placas do Polimold.

Condições Gerais

Os Polimolds com tamanho entre 15.15 e 20.20 podem ser fornecidos opcionalmente com 4 colunas no conjunto extrator, para isso as coordenadas devem ser fornecidas pelo cliente.	Nos Polimolds acima de 50.50 o conjunto extrator pode ser fornecido opcionalmente com seis colunas guias e seis EP's, desde que as coordenadas sejam informadas.	As placas cavidades com espessura igual ou superior a 156mm possuem alivio no ajuste dos furos e componentes.	Nas montagens 4, 5 e 6 os pinos de retorno seguem avulsos na embalagem.	Os moldes de série acima de 50-80 podem ser fornecidos com coluna de diâmetro (D2) 60,00mm ou 70,00 mm desde que sejam informadas as coordenadas de montagem.

Medidas do Molde

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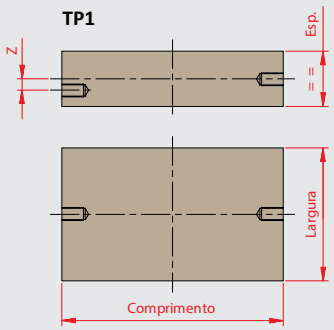
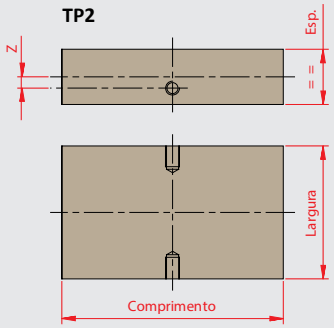
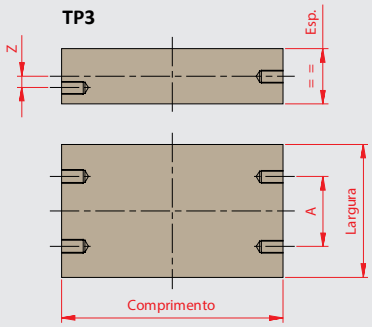
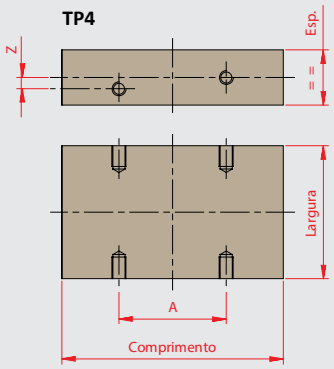
Roscas para Transporte

Os ganchos são necessários para placas acima de 120kg /ou área acima de 500 x 500mm, os mesmos seguem centralizados na espessura da placa, exceto quando informado a dimensão "Z". Nos tipos 3 e 4 é necessário informar a medida "A".



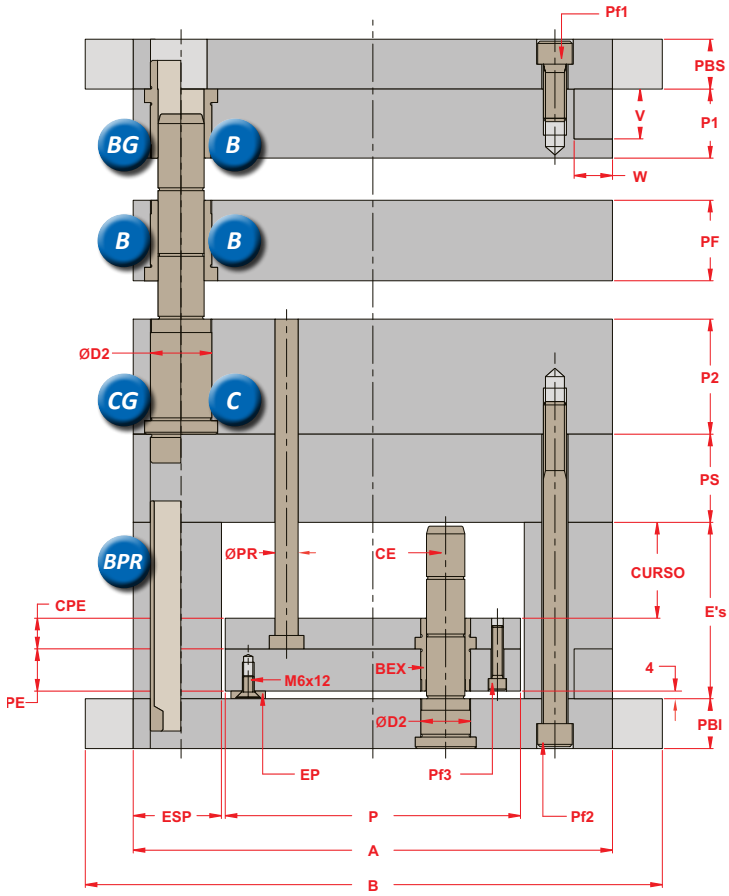


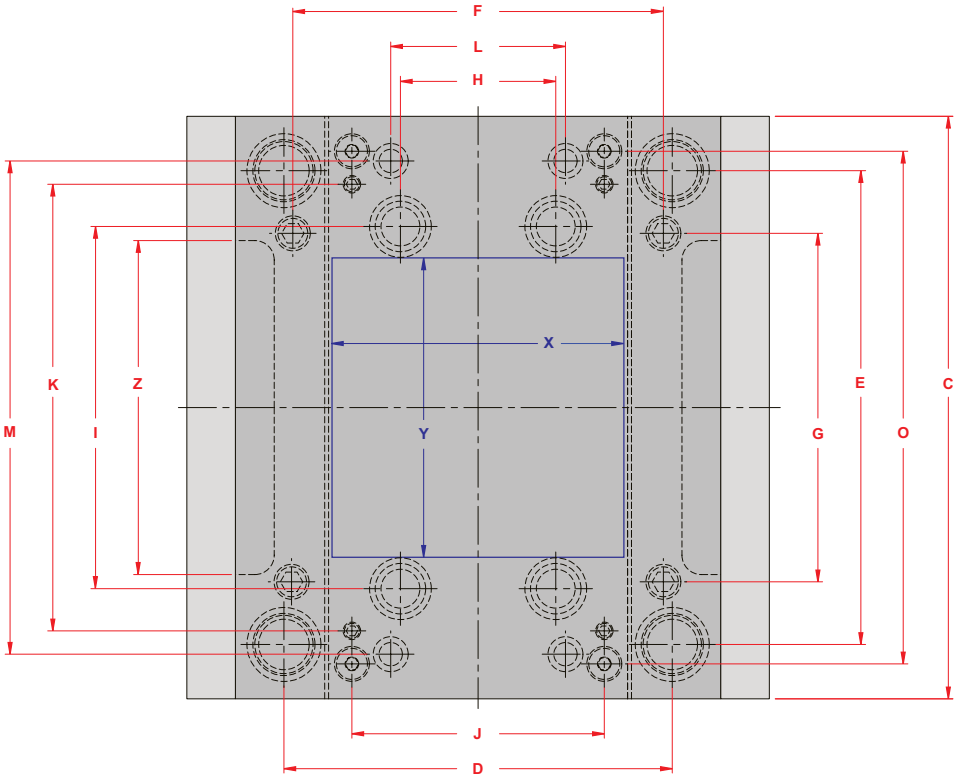




Legenda:
Esp. = Espessura da Placa
A = Distância entre Centros dos Ganchos
Z = Distância Deslocada do Centro da Esp.

Vistas Com Dimensões





Os novos Polimolds são fornecidos com uma coluna de diâmetro menor na ponta em substituição ao furo deslocado

Montagens e Forma de Pedido

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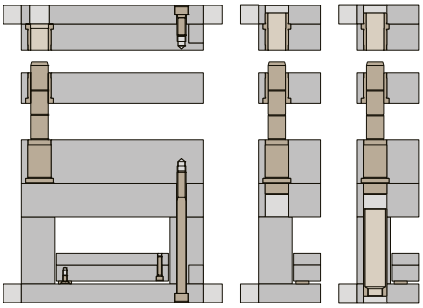
Tipos de Montagens

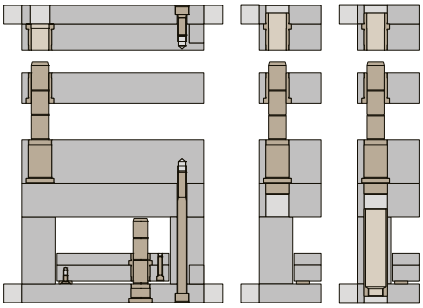
Os Polimolds possuem 18 tipos diferentes de montagem com variações de “colunamento”, escolha a que melhor se encaixa em sua necessidade.

Opções na Montagem 1



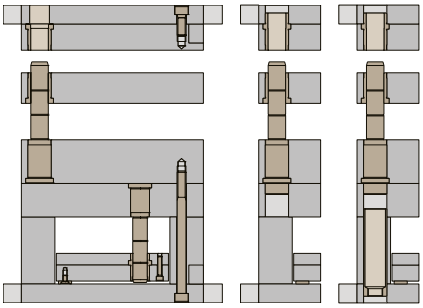
1A 1B 1C

Opções na Montagem 2



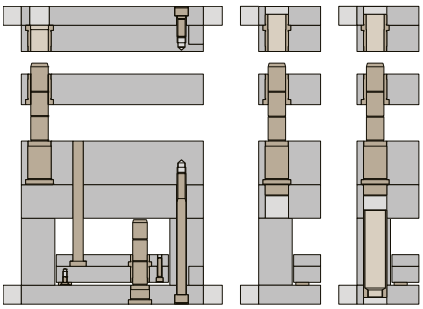
2A 2B 2C

Opções na Montagem 3



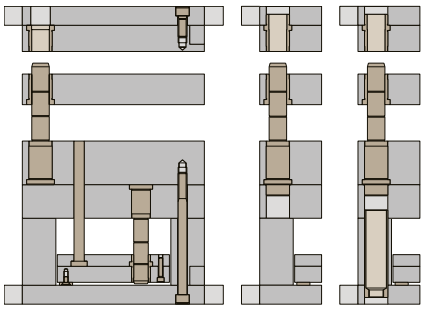
3A 3B 3C

Opções na Montagem 4



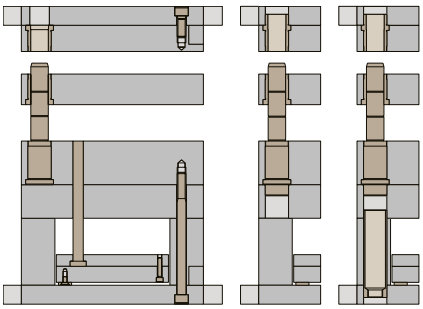
4A 4B 4C

Opções na Montagem 5



5A 5B 5C

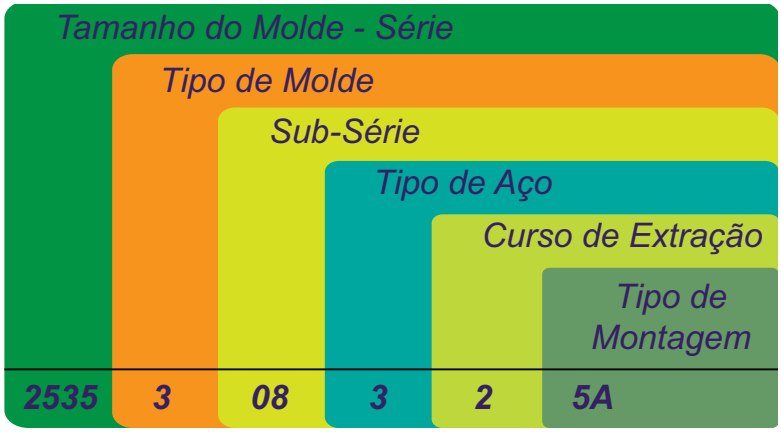
Opções na Montagem 6

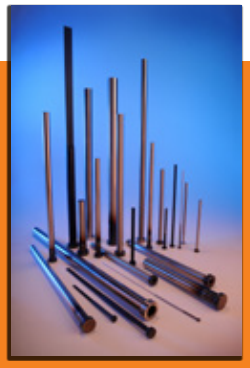


6A 6B 6C

Solicitando seu Polimold

Para efetuar o pedido de seu Polimold foi criada uma sequência de informações que facilitará e agilizará este processo, observe o exemplo ao lado:





Conheça também toda a Linha de Extratores

A linha de Extratores Polimold possui diversas opções de tamanhos facilitando seu projeto. Fabricada com aço H13 e excelente nível de acabamento, proporcionando maior durabilidade.

Saiba mais em http://www.polimold.com.br

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Séries e Dimensões

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Série	Molde	Dimensões de Placas											
		Comprimento - Largura				Área Útil		Espessura das Placas					
		A	B	C	P	X	Y	PBS	PS	ESP	CPE	PE	PBI
15.15	156 156	156,0	206,0	156,0	90,0	88,0	42,0	22,0	27,0	32,0	9,0	17,0	22,0
15.20	156 196	156,0	206,0	196,0	90,0	88,0	82,0	22,0	27,0	32,0	9,0	17,0	22,0
15.25	156 246	156,0	196,0	246,0	90,0	88,0	132,0	22,0	27,0	32,0	9,0	17,0	22,0
20.20	196 196	196,0	246,0	196,0	118,0	116,0	72,0	22,0	27,0	38,0	12,0	17,0	22,0
20.25	196 246	196,0	246,0	246,0	108,0	106,0	122,0	27,0	36,0	43,0	12,0	17,0	27,0
20.30	196 296	196,0	246,0	296,0	108,0	106,0	160,0	27,0	36,0	43,0	12,0	17,0	27,0
20.35	196 346	196,0	246,0	346,0	108,0	106,0	210,0	27,0	36,0	43,0	12,0	17,0	27,0
20.40	196 396	196,0	246,0	396,0	108,0	106,0	260,0	36,0	36,0	43,0	17,0	22,0	36,0
25.25	246 246	246,0	296,0	246,0	158,0	156,0	96,0	27,0	36,0	43,0	12,0	17,0	27,0
25.30	246 296	246,0	296,0	296,0	158,0	156,0	146,0	27,0	36,0	43,0	12,0	17,0	27,0
25.35	246 346	246,0	296,0	346,0	158,0	156,0	196,0	27,0	46,0	43,0	17,0	22,0	27,0
25.40	246 396	246,0	296,0	396,0	150,0	148,0	246,0	36,0	46,0	47,0	17,0	22,0	36,0
25.45	246 446	246,0	296,0	446,0	158,0	156,0	296,0	36,0	46,0	43,0	17,0	22,0	36,0
25.50	246 496	246,0	296,0	496,0	158,0	156,0	346,0	36,0	46,0	43,0	17,0	22,0	36,0
30.30	296 296	296,0	346,0	296,0	208,0	206,0	146,0	27,0	46,0	43,0	12,0	17,0	27,0
30.35	296 346	296,0	346,0	346,0	208,0	206,0	196,0	36,0	46,0	43,0	17,0	22,0	36,0
30.40	296 396	296,0	346,0	396,0	200,0	198,0	246,0	36,0	46,0	47,0	17,0	22,0	36,0
30.45	296 446	296,0	346,0	446,0	208,0	206,0	296,0	36,0	46,0	43,0	17,0	22,0	36,0
30.50	296 496	296,0	346,0	496,0	208,0	206,0	346,0	36,0	46,0	43,0	17,0	22,0	36,0
35.35	346 346	346,0	396,0	346,0	258,0	256,0	196,0	36,0	46,0	43,0	17,0	22,0	36,0
35.40	346 396	346,0	396,0	396,0	218,0	216,0	238,0	36,0	46,0	62,0	17,0	22,0	36,0
35.45	346 446	346,0	396,0	446,0	218,0	216,0	288,0	36,0	46,0	62,0	17,0	22,0	36,0
35.50	346 496	346,0	396,0	496,0	218,0	216,0	338,0	36,0	46,0	62,0	17,0	22,0	36,0
35.55	346 546	346,0	396,0	546,0	218,0	216,0	388,0	36,0	46,0	62,0	22,0	27,0	36,0
35.60	346 596	346,0	396,0	596,0	218,0	216,0	438,0	36,0	46,0	62,0	22,0	27,0	36,0
40.40	396 396	396,0	446,0	396,0	268,0	266,0	238,0	36,0	46,0	62,0	17,0	22,0	36,0
40.45	396 446	396,0	446,0	446,0	268,0	266,0	288,0	36,0	46,0	62,0	17,0	22,0	36,0
40.50	396 496	396,0	446,0	496,0	268,0	266,0	338,0	36,0	46,0	62,0	22,0	27,0	36,0
40.55	396 546	396,0	496,0	546,0	268,0	266,0	388,0	36,0	46,0	62,0	17,0	27,0	36,0
40.60	396 596	396,0	496,0	596,0	268,0	266,0	438,0	36,0	46,0	62,0	22,0	27,0	36,0

Coordenadas Gerais

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Série	Molde	Coordendas de Bucha e Coluna			Coordenada de Fixação do Molde			Coordenada das Guias da Extratora			Coord de Fixação da Extratora			Coordenada do Pino de Retorno			Coordenada de Encosto Padrão			Dimensões de Rasgo de Fixação		
		D	E	D2	F	G	Pf1/2	H	I	D2	J	K	Pf3	L	M	DIA	J	O	DIA	W	V	Z
15.15	156 156	122	122	20	122	72	M10	0*	70	20	68	100	M8	40	126	10	68	136	18	15	27	66
15.20	156 196	120	156	20	126	114	M10	0*	110	20	68	140	M8	40	166	10	68	172	18	15	27	102
15.25	156 246	122	212	20	122	162	M10	0*	160	20	68	186	M8	40	216	10	68	224	18	15	27	150
20.20	196 196	154	152	26	154	100	M10	0*	100	20	96	132	M8	62	160	10	96	166	18	20	27	88
20.25	196 246	150	202	26	148	150	M10	46	150	20	90	182	M8	56	210	10	90	216	18	20	27	138
20.30	196 296	150	244	30	150	186	M12	40	194	26	90	230	M8	56	260	10	90	266	18	20	27	172
20.35	196 346	150	294	30	150	236	M12	40	244	26	90	280	M8	56	310	10	90	314	18	20	27	222
20.40	196 396	144	344	30	144	274	M12	40	294	26	90	330	M8	56	360	10	90	364	18	20	27	260
25.25	246 246	200	200	30	200	130	M12	80	130	26	130	180	M8	90	204	12	130	214	18	20	27	116
25.30	246 296	200	244	30	200	186	M12	80	180	26	130	230	M8	90	254	12	130	264	18	20	27	172
25.35	246 346	194	294	30	194	224	M12	86	230	26	136	286	M8	96	304	12	136	324	18	20	27	210
25.40	246 396	198	340	30	198	284	M12	72	280	26	122	330	M8	82	354	12	122	364	18	20	27	270
25.45	246 446	194	394	30	194	324	M12	80	330	26	130	380	M8	90	404	12	130	414	18	20	27	310
25.50	246 496	194	444	30	194	374	M12	80	380	26	130	430	M8	90	454	12	130	464	18	20	27	360
30.30	296 296	250	244	30	250	186	M12	130	180	26	180	230	M8	140	254	14	180	266	18	20	27	172
30.35	296 346	244	294	30	244	224	M12	136	230	26	186	286	M8	146	304	14	186	324	18	20	27	210
30.40	296 396	248	340	30	248	284	M12	126	280	26	176	330	M8	136	354	14	176	364	18	20	27	270
30.45	296 446	244	394	30	244	324	M12	134	330	26	184	380	M8	144	404	14	184	414	18	20	27	310
30.50	296 496	244	444	30	244	374	M12	128	380	26	180	418	M10	140	454	14	180	464	18	20	27	360
35.35	346 346	294	294	30	294	224	M12	186	230	26	236	286	M8	196	304	14	236	324	18	22	27	210
35.40	346 396	274	316	42	274	230	M16	134	276	30	190	320	M10	148	354	14	190	366	18	22	30	212
35.45	346 446	274	374	42	274	280	M16	130	326	30	186	364	M10	144	404	14	186	414	18	22	30	262
35.50	346 496	274	416	42	274	330	M16	134	376	30	190	420	M10	148	454	14	190	466	18	22	30	312
35.55	346 546	274	474	42	274	380	M16	134	426	30	190	470	M10	148	504	14	190	516	18	22	30	362
35.60	346 596	274	524	42	274	430	M16	134	476	30	190	520	M10	148	554	14	190	566	18	22	30	412
40.40	396 396	324	324	42	324	230	M16	180	276	30	236	314	M10	194	354	16	236	364	24	22	30	212
40.45	396 446	324	374	42	324	280	M16	184	326	30	240	364	M10	198	404	16	240	414	24	22	30	262
40.50	396 496	324	424	42	324	330	M16	184	376	30	240	414	M10	198	454	16	240	460	24	22	30	312
40.55	396 546	324	466	42	324	380	M16	184	426	30	240	464	M10	198	504	16	240	510	24	22	30	362
40.60	396 596	324	524	42	324	430	M16	184	476	30	240	514	M10	198	554	16	240	560	24	22	30	412

Sub-Séries e Cursos de Extração

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Sub-Série	de 156x156 a 156x246			de 196x196 a 346x346			de 346x396 a 396x596		
	P1	PF	P2	P1	PF	P2	P1	PF	P2
1	22	22	27	27	27	36	36	36	46
2	27	22	27	36	27	36	46	36	46
3	36	22	27	46	27	36	56	36	46
4	46	22	27	56	27	36	66	36	46
5	56	22	27	66	27	36	76	36	46
6	66	22	27	76	27	36	96	36	46
7	22	27	36	96	27	36	116	36	46
8	27	27	36	27	36	46	36	46	56
9	36	27	36	36	36	46	46	46	56
10	46	27	36	46	36	46	56	46	56
11	56	27	36	56	36	46	66	46	56
12	66	27	36	66	36	46	76	46	56
13	22	36	46	76	36	46	96	46	56
14	27	36	46	96	36	46	116	46	56
15	36	36	46	27	46	56	36	56	66
16	46	36	46	36	46	56	46	56	66
17	56	36	46	46	46	56	56	56	66
18	66	36	46	56	46	56	66	56	66
19	22	46	56	66	46	56	76	56	66
20	27	46	56	76	46	56	96	56	66
21	36	46	56	96	46	56	116	56	66
22	46	46	56	27	56	66	36	66	76
23	56	46	56	36	56	66	46	66	76
24	66	46	56	46	56	66	56	66	76
25	22	56	66	56	56	66	66	66	76
26	27	56	66	66	56	66	76	66	76
27	36	56	66	76	56	66	96	66	76
28	46	56	66	96	56	66	116	66	76
29	56	56	66	27	66	76	36	76	96
30	66	56	66	36	66	76	46	76	96
31				46	66	76	56	76	96
32				56	66	76	66	76	96
33				66	66	76	76	76	96
34				76	66	76	96	76	96
35				96	66	76	116	76	96
36				27	76	96	36	96	116
37				36	76	96	46	96	116
38				46	76	96	56	96	116
39				56	76	96	66	96	116
40				66	76	96	76	96	116
41				76	76	96	96	96	116
42				96	76	96	116	96	116

Série	Molde	Curso 1		Curso 2		Curso 3	
		Curso	Altura "E's"	Curso	Altura "E's"	Curos	Altura "E's"
15.15	156 156	16	46	26	56	46	76
15.20	156 196	16	46	26	56	46	76
15.25	156 246	16	46	26	56	46	76
20.20	196 196	13	46	23	56	43	76
20.25	196 246	13	46	23	56	43	76
20.30	196 296	23	56	43	76	63	96
20.35	196 346	23	56	43	76	63	96
20.40	196 396	13	56	33	76	53	96
25.25	246 246	23	56	43	76	63	96
25.30	246 296	23	56	43	76	63	96
25.35	246 346	13	56	33	76	53	96
25.40	246 396	13	56	33	76	53	96
25.45	246 446	13	56	33	76	53	96
25.50	246 496	13	56	33	76	53	96
30.30	296 296	23	56	43	76	63	96
30.35	296 346	13	56	33	76	53	96
30.40	296 396	13	56	33	76	53	96
30.45	296 446	13	56	33	76	53	96
30.50	296 496	13	56	33	76	53	96
35.35	346 346	13	56	33	76	53	96
35.40	346 396	33	76	53	96	73	116
35.45	346 446	33	76	53	96	73	116
35.50	346 496	33	76	53	96	73	116
35.55	346 546	33	86	63	116	83	136
35.60	346 596	33	86	63	116	83	136
40.40	396 396	33	76	53	96	73	116
40.45	396 446	33	76	53	96	73	116
40.50	396 496	33	86	63	116	83	136
40.55	396 546	38	86	68	116	88	136
40.60	396 596	33	86	63	116	83	136

Os sistemas Polimold vão deixar marcas em seu produto

(Ainda que sejam imperceptíveis)

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Modelo CATPM3P
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