

ULB-ULC-ULG

Unilifter



Unilifter - Undercut releasing system

- Standard components simplify mold design and construction for release of molded undercuts.
- Radiused dovetail design lets core blade seat automatically at the required angle.
- Smooth travel of U-Coupling in T-Gib eliminates heel binding often encountered in other fixed angle designs.
- Wide size selection covers more applications than similar standardized systems.
- **DME steel 5 (1.2344)** Core blades for easy conventional machining.
- Each Unilifter assembly is comprised of a Core blade, U-Coupling and T-Gib.

Core Blades are available in a wide range of standard sizes, with specials also available.

U-Coupling permits core blade to seat at any angle.



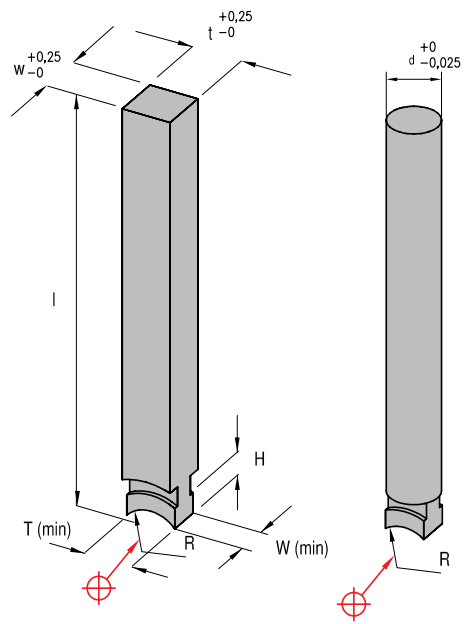
T-Gibs are available in several sizes to accommodate various travels required.

The UniLifter undercut releasing system incorporates a three piece set: Core Blade, U-Coupling, and T-Gib.

**Core blades** Mat.: 1.2344, 38-42 HRC

**ULB**

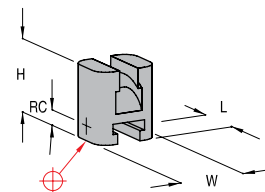
REF	Old REF	W min	R	H	T min	t	w	l	d
<b>ULBMM10x10L250</b>	<b>ULB-1001</b>	10	10	5	10	10	10	250	-
<b>ULBMM15x15L250</b>	<b>ULB-1002</b>				15	15	15	250	-
<b>ULBMM10x20L250</b>	-				10	20	10	250	-
<b>ULBMM20x10L250</b>	-				15	10	20	250	-
<b>ULBMM15x30L400</b>	-				15	30	15	400	-
<b>ULBMM30x15L400</b>	-				15	15	30	400	-
<b>ULBMM20x20L400</b>	<b>ULB-1003</b>				15	20	20	400	-
<b>ULBMM15DL250</b>	<b>ULB-1101</b>				10	-	-	250	15
<b>ULBMM10DL250</b>	-				10	-	-	250	10



**U-Couplings** Mat.: 1.2344, Surface 60-70 HRC, Core 38-42 HRC

**ULC**

REF	Old REF	W	L	H	RC	R
<b>ULCMM22</b>	<b>ULC-1001</b>	22	18	25	6	10



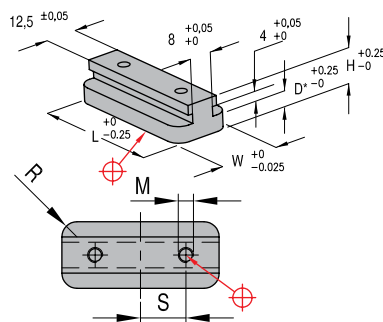
RC: Radius center for radius R

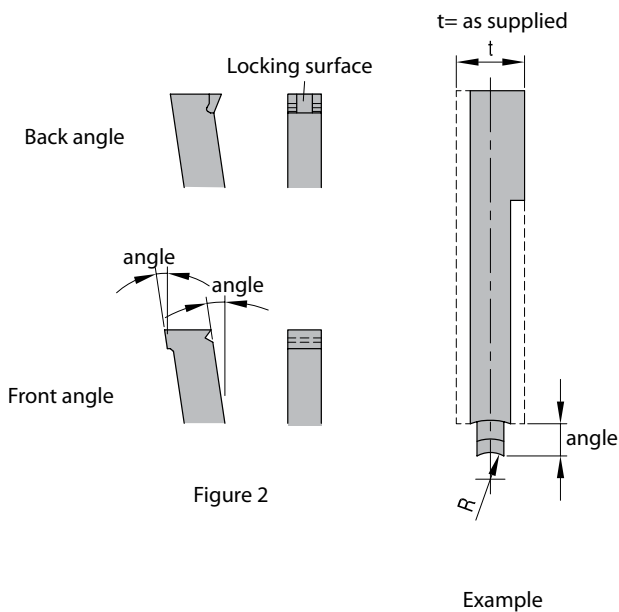
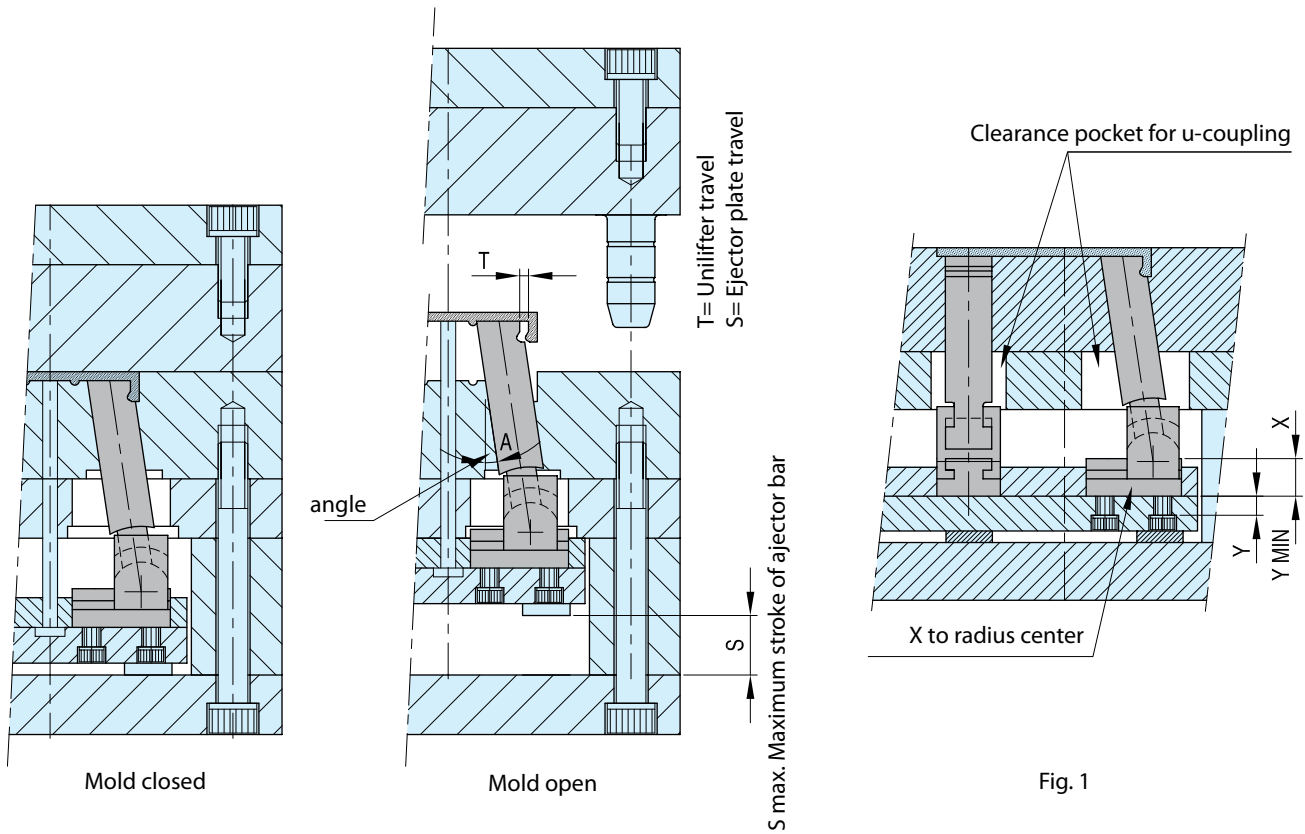
**T-Gibs** Mat.: 1.2344, Surface 60-70 HRC, Core 38-42 HRC

**ULG**

REF	Old REF	W	D*	H	R	M	S	L	Travel allowed
<b>ULGMM10</b>	<b>ULG-1001</b>	22	6	13	5	M5x20	10	33	10
<b>ULGMM30</b>	<b>ULG-1002</b>	22	6	13	5	M5x20	15	52	30

\*0,25mm oversize





1. General installation

It is recommended that lifters be installed as shown in Fig. 1, with T-Gib mounted to top of ejector plate. The appropriate X and Y dimensions are as follows: X = 12 mm, Y = min 11 mm (min Y dimension prevents mounting screws from interfering with U-Coupling travel).

2. Angles

Designs using angles from 5 to 10° will typically yield the best results. Angles up to 15° are permissible by using lifter guides in the bottom of the support plate. (Lifter guides to be made by moldmaker).

3. Lifter guides

Lifter guides are recommended for designs with angles of 15° (see 2 above) or whenever less than half of the Core blade is bearing in the core insert.

4. Guided ejection

It is recommended that guided ejection be used in all designs.

5. Fit

Recommended clearance for Core blade is 0,025/0,040 mm where permissible.

6. Locking angles

Locking angles (see Fig. 2) may be designed in if required to provide a locking surface to counter against molding pressure.

7. Other dimensions upon request.