

EXΔflow®



The Threadformer™

*Unscrewing
Devices for Molds*

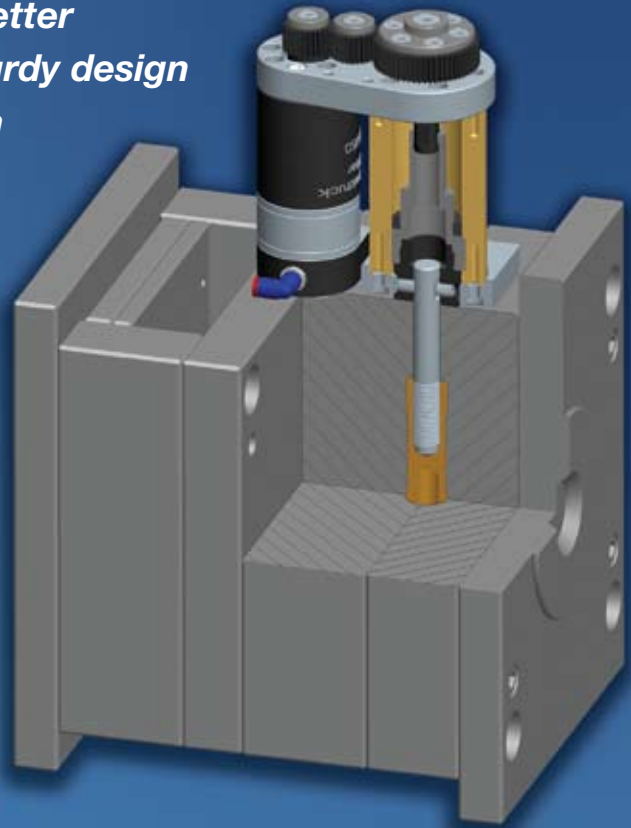
 **SUPERIOR**
DIE SET CORPORATION

Single and Twin Units

The Threadformer™

Features and Specifications

- **Powerful Hydraulic Motor**
- **Precision Core stopping within .003" or better**
- **Compact and sturdy design**
- **Unscrews 70 mm**



Complete single unit Threadformer installation.

Features

The Threadformer™ Unscrewing devices are precise, sturdy and cost-efficient

- Powerful hydraulic motor for rapid and unscrewing action
- Repeatable precise core stopping ability within .003" or better
- Compact single and twin drive unit designs
- Supports long thread depths, pitches, and types
- Requires minimal maintenance for high production use
- Retrofittable for new or existing injection molds
- Demolds both right and left-hand threads
- Can be mounted at any angle or within the mold

Our unscrewing devices provide time and cost gains in moldmaking while reducing production costs for the injection molder by giving reliable, trouble-free service.

Specifications

The EXAflow Threadformer is supplied ready for operation. The fixed thread guide nut comes with factory-machined internal threads matching the pitch of the thread to be molded. Three powerful hydraulic motors to choose from, which can deliver up to 2,450 rpm. Single-drive unit mounts to mold using two M10 SHCS. For twin-drive units, two M10 mounting screws are required. 24 volt DC high precision proximity switches are included for hydraulic control. All steel parts are hardened and ground with the core holder nitrided for extra wear-resistance.



Thread Core Mounting



Core Nut



Core Holder



Unscrews 70 mm
(Standard version)



Simply install core in core nut and secure with two set screws. The thread core mounts in the core holder via a common 16 mm dia. shank system. Moldmakers need to fabricate their own thread core defining the geometry of the mold-in thread. Pitch should include shrinkage.

TECHNICAL INFORMATION	MOTOR SELECTIONS
<p>Machine Core hold clearance in mold $+0,01/+0,02$mm Single-drive dimensions: 110 x 142 x 181 mm Weight approximately 7.5 kg (16.5 lbs.) Twin-drive dimensions: 190 x 147 x 181 mm Custom axis spacings can be provided upon request. DO NOT DOWEL MOUNT THREADFORMER TO MOLD BASE</p>	<p>Size 8, 32, or 50 cm³ EXAFlow® will select the motor best suited to your application. Pitches are from 0.5 mm up to 20 mm. Thread lengths up to 100 mm and thread diameters of minimum 50 mm (depends on thread type).</p>

Positioning Accuracy – Brief Instruction

To guarantee a precise thread start position, the core holder must run against a fixed stop with its entire front surface area at a pressure not exceeding 40 bar.

The flow of hydraulic fluid must be shut off by use of a proximity switch slightly before the core holder touches the fixed stop.

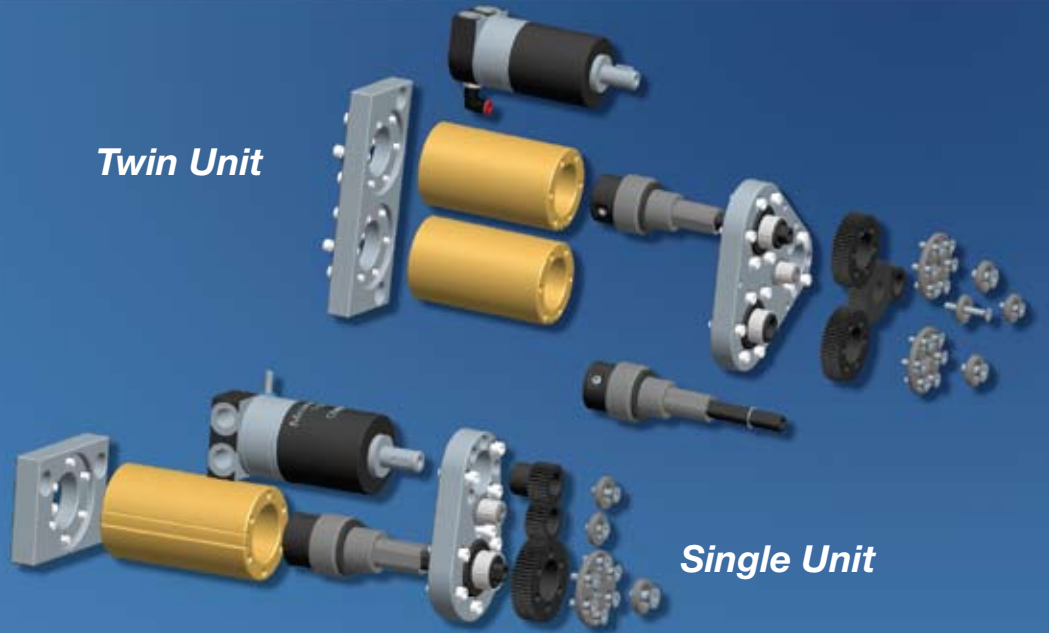
For the core holder retraction movement, the unscrewing pressure must be higher than the screw-in pressure. However, the unscrewing pressure should not be higher than 100 bar.

The retraction of the core holder must again be stopped by a proximity switch. This will involve some after running. Care should be taken to ensure that the core holder does not run up against a fixed stop at this point. In case this has happened, the core holder must be released manually. With through-thread, note that the core holder must not touch but should have up to 0,02 mm clearance upon reaching the thread start position. This amount of play will not result in melt film formation.

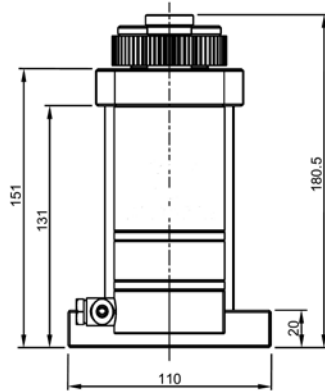




Twin Unit



Single Unit



**2D & 3D
CAD Models
Available**



Twin Threadformer Unit



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For complete technical specifications and further information visit

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