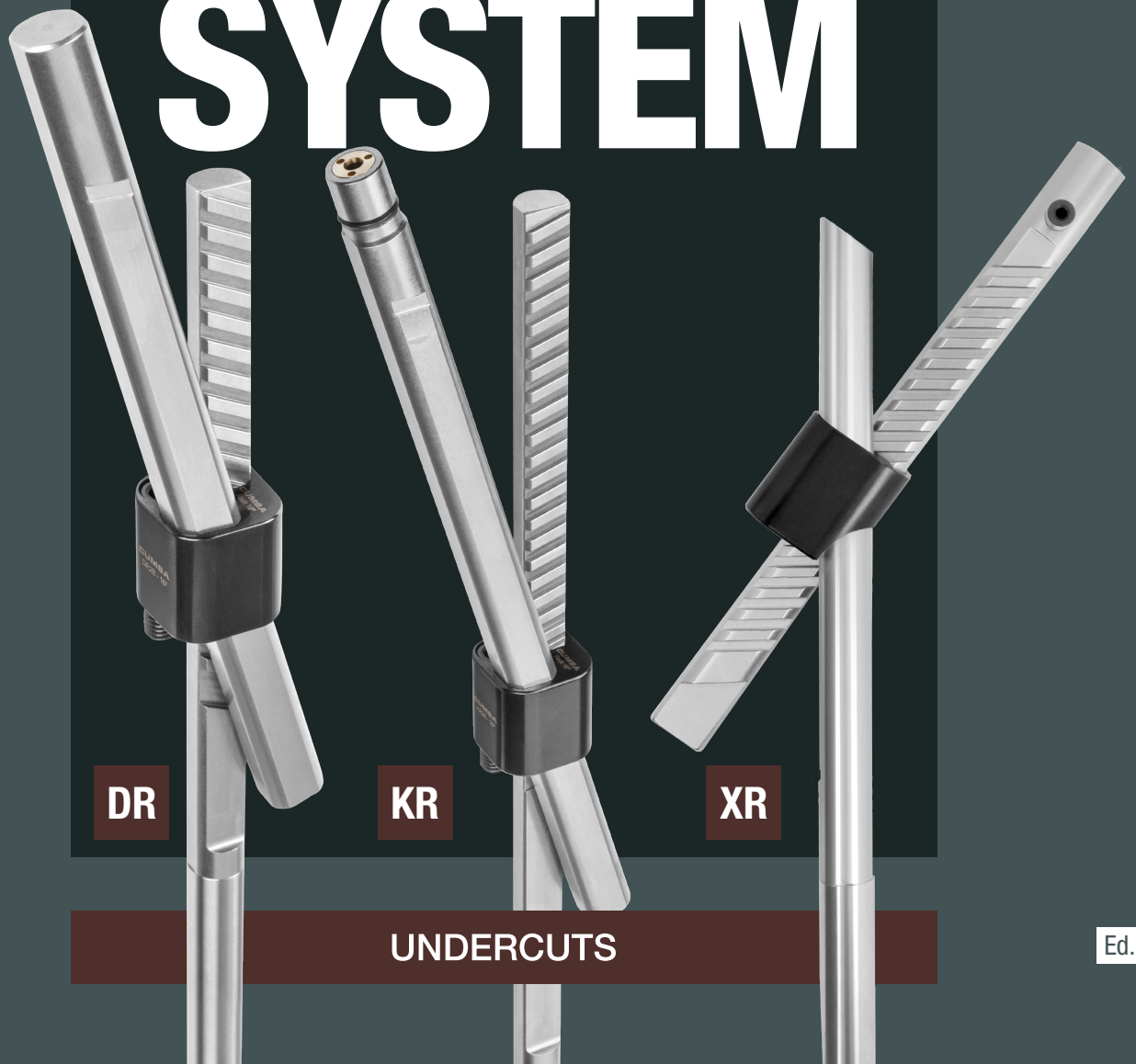


CUMSA

INNOVATIVE SOLUTIONS
FOR YOUR MOLDS

DOUBLE RACK SYSTEM



DR

KR

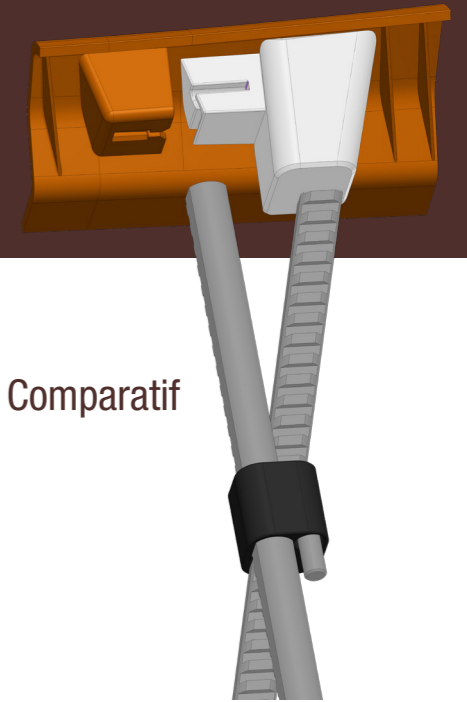
XR

UNDERCUTS

Ed. 2022-09

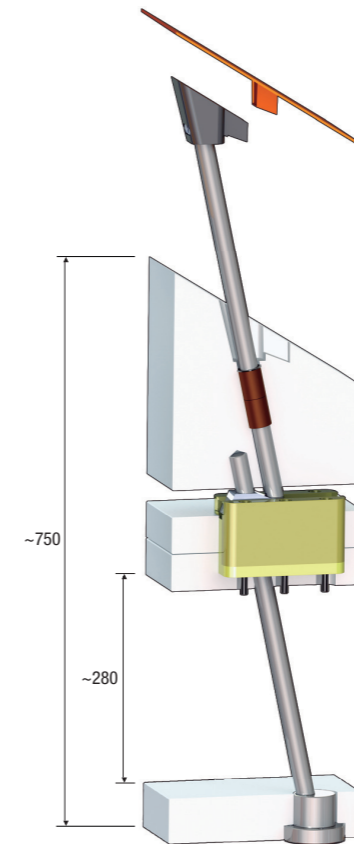
DOUBLE RACK SYSTEM

by **CUMSA**

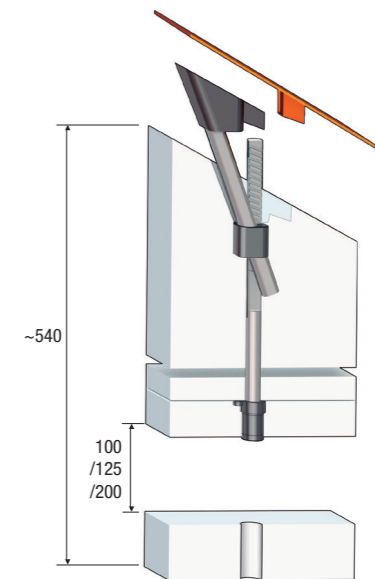


COMPARE

Comparativa · Vergleich · Confronto · Comparativo · Comparatif



CONVENTIONAL SYSTEM



DOUBLE RACK SYSTEM

**EN Vertical function maximizing strength.
Smaller and less expensive injection machine required.
Eliminates the need for high-precision angled housings in the core plates.**

ES Funcionamiento vertical que minimiza el esfuerzo del conjunto.
Permite usar una máquina de inyección más pequeña y económica.
Elimina los complicados taladros inclinados de alta precisión.

DE Vertikale Funktion mit maximaler Kraft.
Ein kleineres Werkzeug kann eventuell eine kleinere und günstigere Spritzgießmaschine benötigen.
Es wird keine hochpräzise Schrägbohrung in der Formplatte benötigt.

IT Funzionamento verticale che minimizza lo sforzo.
Permette di usare una macchina d'iniezione più piccola ed economica.
Elimina le complicate lavorazioni inclinate ad alta precisione.

PT Funcionamento na vertical minimizando o esforço.
Permite o uso de máquinas de injeção de menores dimensões e mais económicas.
Elimina a necessidade de furos inclinados com precisão.

FR Fonctionnement vertical réduisant les efforts.
Permet de réduire la dimension de la presse d'injection et ainsi de réaliser des économies.
Terminé les logements inclinés de haute précision.

DR

UNDERCUTS

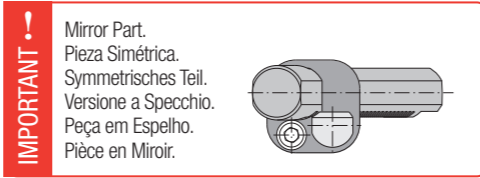
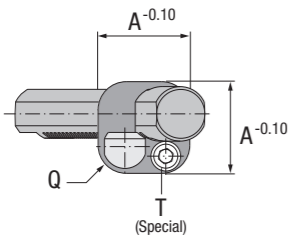
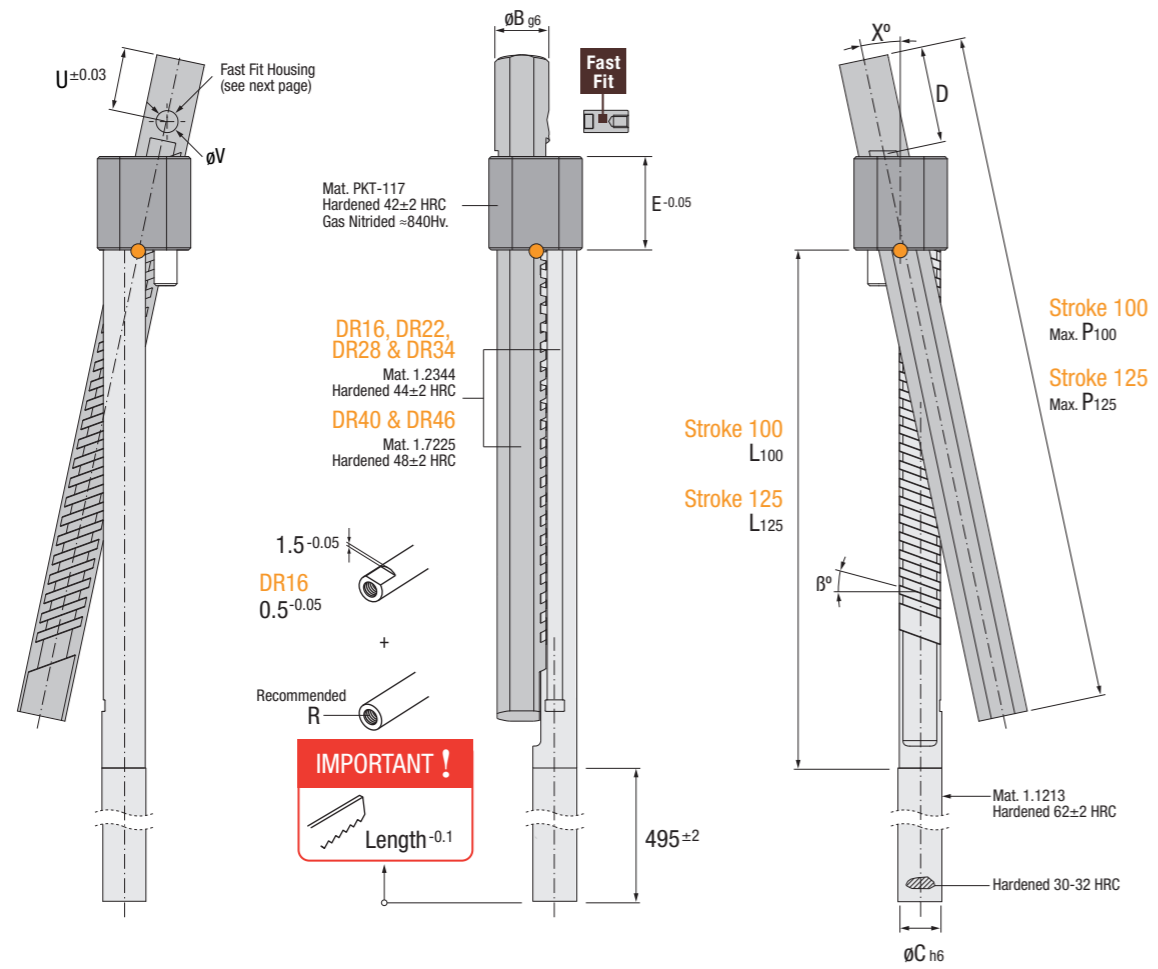


Patented

DOUBLE RACK LIFTER

ES Doble Cremallera DE Zweifach Zahnstangen-System
IT Doppia Cremagliera PT Duplo Rack FR Double Cremaillere

● Cad Insertion Point



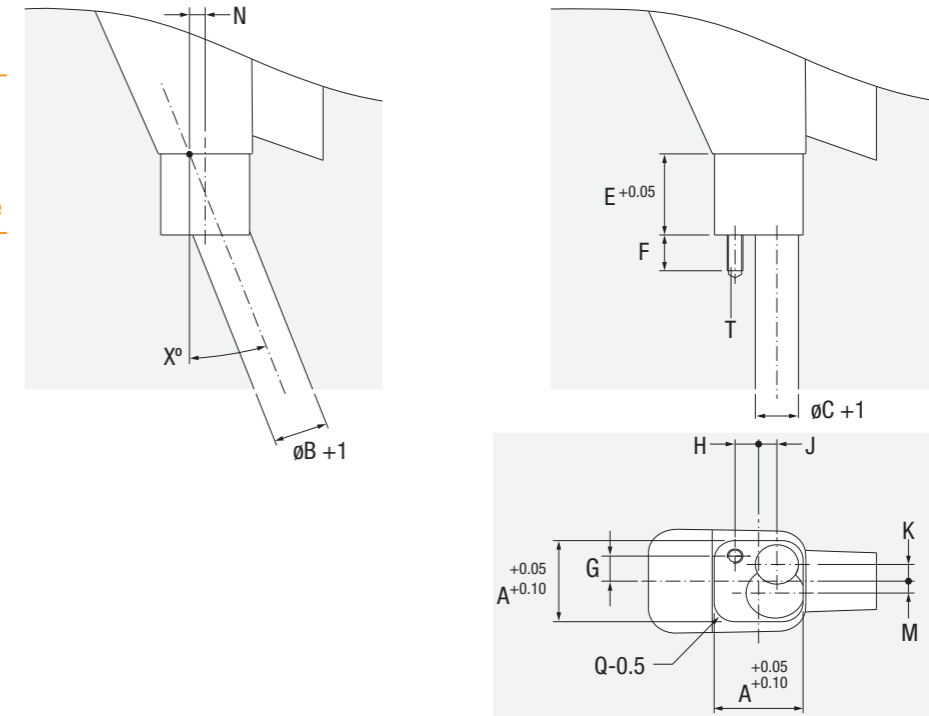
Stroke 100	Stroke 125	X°	A	B	C	D	E	L100	P100	L125	P125	Q	R	T	U	V	Stroke 100-S	Stroke 125-S
DR.16100L-x	-	8 12 16	- 16	9 8	20 20	142	178	-	-	4	M5	M5	10	6			DR.16100L-x-S	-
DR.22100L-x	DR.22125L-x	8 12 16 20	22 12	12 30	22 30	148	202	202	261	6.5	M6	M6	17	8			DR.22100L-x-S	DR.22125L-x-S
DR.28100L-x	DR.28125L-x	8 12 16 20	28 16	14 36	28 36	152.5	214	194.5	266	8.5	M8	M8	23	8			DR.28100L-x-S	DR.28125L-x-S
DR.34100L-x	DR.34125L-x	8 12 16 20	34 20	16 36	34 36	160.5	227	188.5	264	10.5	M8	M8	23	8			DR.34100L-x-S	DR.34125L-x-S
DR.40100L-x	DR.40125L-x	8 12 16 20	40 22	20 36	40 40	170	244	204	284	10.5	M10	M10	20	10			DR.40100L-x-S	DR.40125L-x-S
DR.46100L-x	DR.46125L-x	8 12 16 20	46 24	24 42	46 46	175	258	201	289	10.5	M10	M12	26	10			DR.46100L-x-S	DR.46125L-x-S

IMPORTANT!
Replace the **X** in the reference with the required X° dimension (24°, 28°, 32° or 36°) and indicate the required β°.
Sustituir la **X** de la referencia por la cota X° deseada (24°, 28°, 32° or 36°), e indique el ángulo β° requerido.
Ersetzen Sie das **X** der Referenz durch den gewünschten X° Winkel (24°, 28°, 32° or 36°). Geben Sie den benötigten β° Winkel an.
Sostituite la **X** del codice con l'angolo X° desiderato (24°, 28°, 32° or 36°) e indiate la β° richiesta.
Substituir o **X** da referencia pela cota X° desejada (24°, 28°, 32° or 36°), e indique o angulo β° pretendido.
Remplacez la valeur **X** par la valeur angulaire X désirée (24°, 28°, 32° or 36°). Ensuite indiquez l'angle β° correspondant.

INSTALLATION GUIDELINES

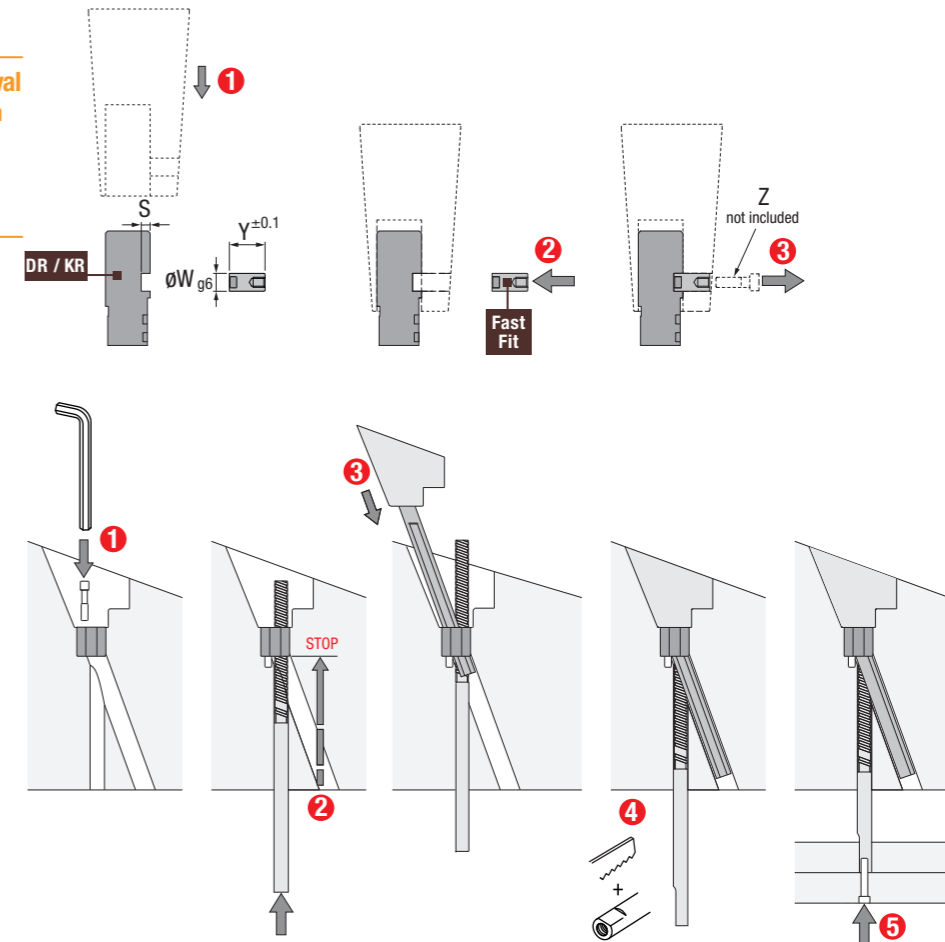
ES Consejos de Instalación DE Richtlinien zur Installation
IT Consigli di Installazione PT Instruções de Instalação FR Mode d'Installation

Core Housing
Alojamiento Placa Punzón
Einbaumaße DR Führung
Sede nel Punzone
Alojamento Bucha
Logement dans l'empreinte



Stroke 100	Stroke 125	Stroke 200	F	G	H	J	K	M	N	S	T	W	Y	Z
DR.16100L-..	-	-	10	4.6	4.6	3	2.35	3	2.8	2.5	M5	6	9	M4
DR.22100L-..	DR.22125L-.. / KR.22125L-..	-	13	5.6	5.6	4.2	3.7	4.2	3.5	2.5	M6	8	12	M4
DR.28100L-..	DR.28125L-.. / KR.28125L-..	-	16	7.5	7.5	5	5.4	4.8	4.8	2.5	M8	8	13.5	M4
DR.34100L-..	DR.34125L-.. / KR.34125L-..	-	16	10.5	8	7	7	5	6	4	M8	8	16	M4
DR.40100L-..	DR.40125L-..	-	20	11	11	7	8	7	7	4	M10	10	20	M6
DR.46100L-..	DR.46125L-..	-	25	13	13	8	8	9	9	5	M12	10	24	M6
-	-	KR.58200L-..	28	15.5	15.5	10	12.2	11.2	10	5	M14	12	30	M6
-	-	KR.76200L-..	36	21	21	13	15.2	15.2	12	6	M18	12	36	M6

FAST FIT:
Installation and Removal
Instalación y Desinstalación
Montage und Demontage
Montaggio e Smontaggio
Instalação e Desinstalação
Montage et Démontage



DR

UNDERCUTS



DK

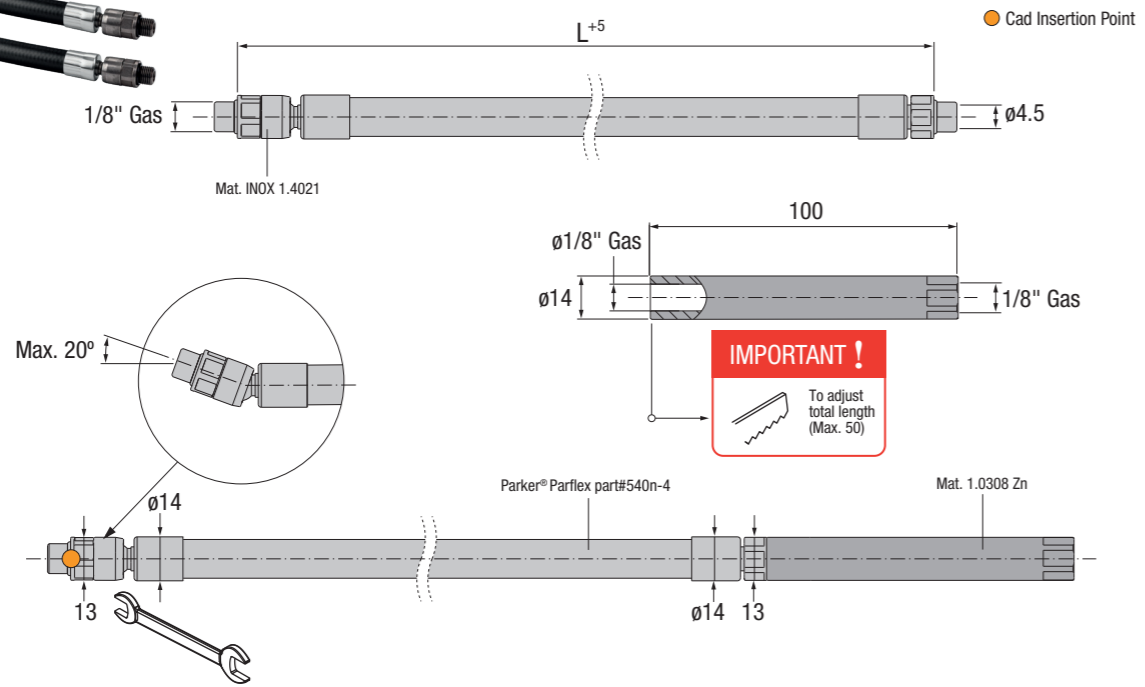
DR COOLING HOSE

ES Refrigeración DR DE Kühlungsschlauch für DR
IT Refrigerazione DR PT Refrigeração DR FR Refroidissement DR

UNDERCUTS



Max. Cooling Fluid 50°C

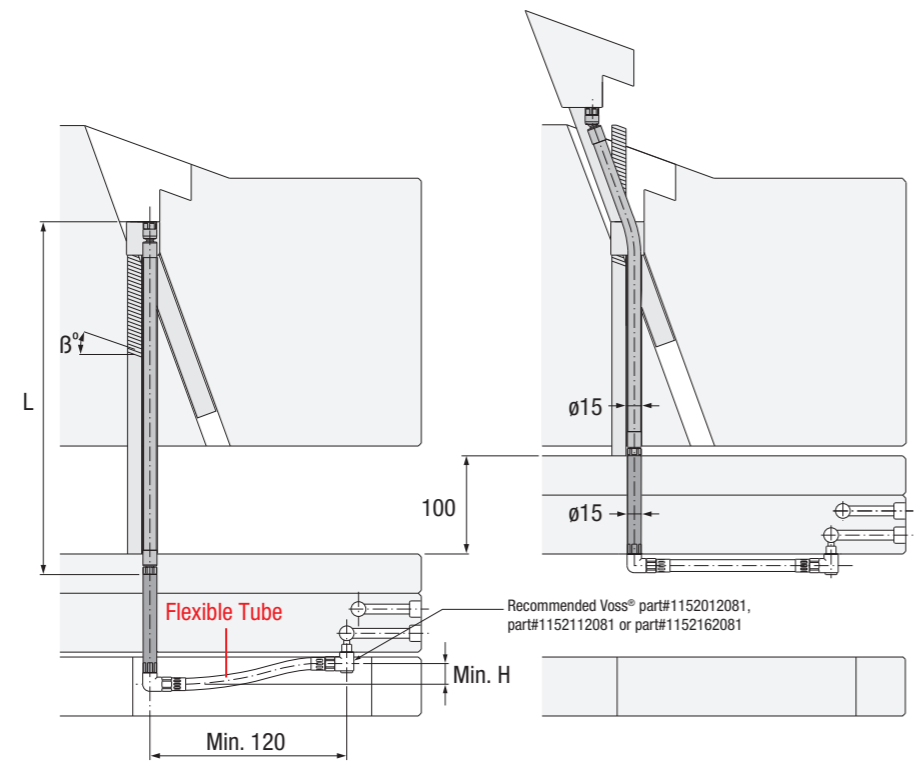


Ref.	β°	H			
		DR.xxxxx-8	DR.xxxxx-12	DR.xxxxx-16	DR.xxxxx-20
DK.141818-...	Negative to 0°	10	10	10	10
	+1° to +9°	10	10	10	15
	+10° to +20°	10	15	20	25
	>+20°	15	20	25	30

IMPORTANT! Indicate the required **L** dimension; the length will be rounded up to the next multiple of 25mm. Indicar la cota **L** deseada. Se suministrará redondeada al múltiplo superior de 25mm. Gewünschte Länge **L** angeben. Die Länge wird auf die nächste Vielfachen von 25 mm abgerundet. Indicare la lunghezza **L** desiderata; la quota richiesta sarà arrotondata al multiplo di 25mm superiore. Indicar a cota **L** desejada. Será fornecido com a dimensão múltipla de 25mm seguinte. Indiquer la cote **L** désirée. Celle-ci sera arrondie à un multiple supérieur de 25 mm.

Installation Guidelines

Consejos de Instalación · Richtlinien zur Installation · Consigli di Installazione · Instruções de Instalação · Mode d'Installation



ADJUSTABLE FIXING

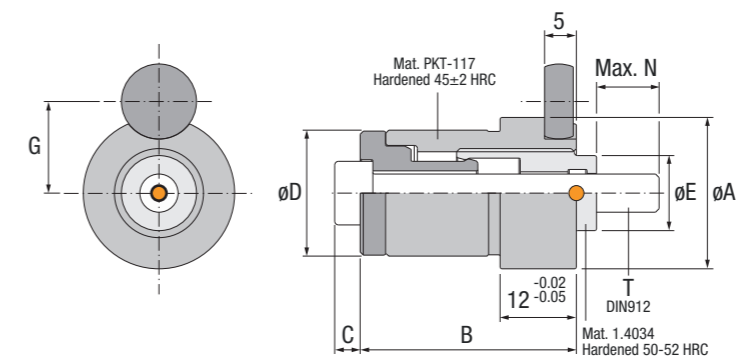
ES Fijación Regulable DE Einstellbare Befestigung
IT Fissaggio Regolabile PT Fixação Regulável FR Fixation Reglable

RF

UNDERCUTS



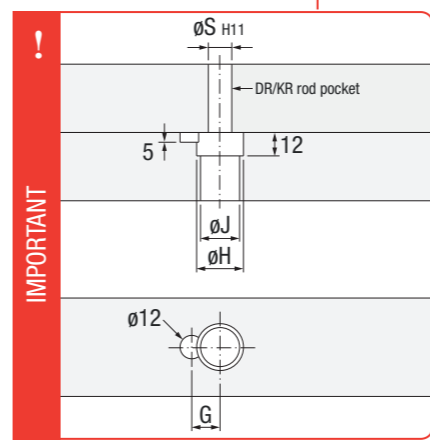
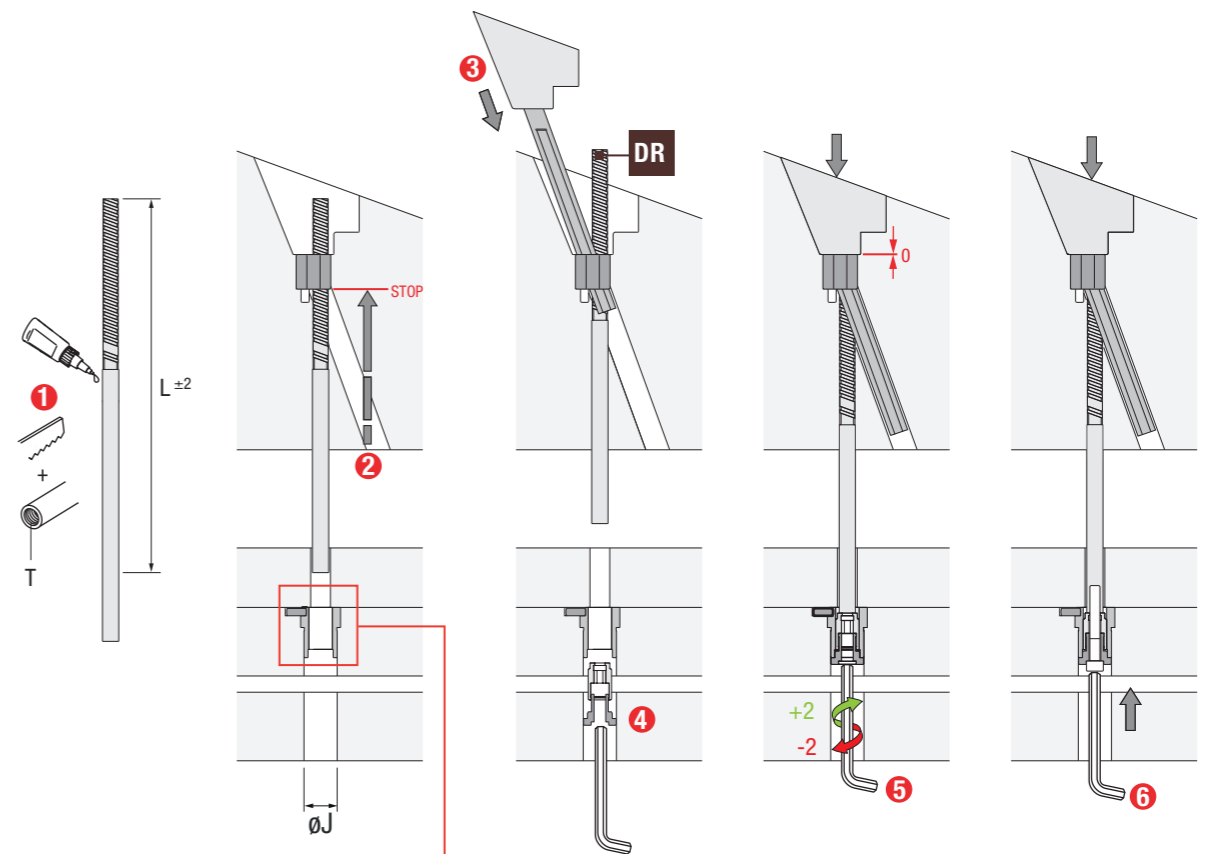
● Cad Insertion Point



Ref.	A	B	C	D	E	G	H	J	N	T	S	Compatible with
RF.161605	19.8	34	3	15.8	7.8	12.5	20	16	18	M5x45	8	DR16
RF.222006	23.8	34	4	19.8	11.8	14.5	24	20	18	M6x45	12	DR22/KR22
RF.282408	27.8	42	0	23.8	13.8	16.5	28	24	20	M8x50	14-16	DR28/DR34/KR28/KR34
RF.403210	35.8	42	0	31.8	19.8	20.5	36	32	24	M10x50	20-24	DR40/DR46

Installation Guidelines

Consejos de Instalación · Richtlinien zur Installation · Consigli di Installazione · Instruções de Instalação · Mode d'Installation



KR

UNDERCUTS

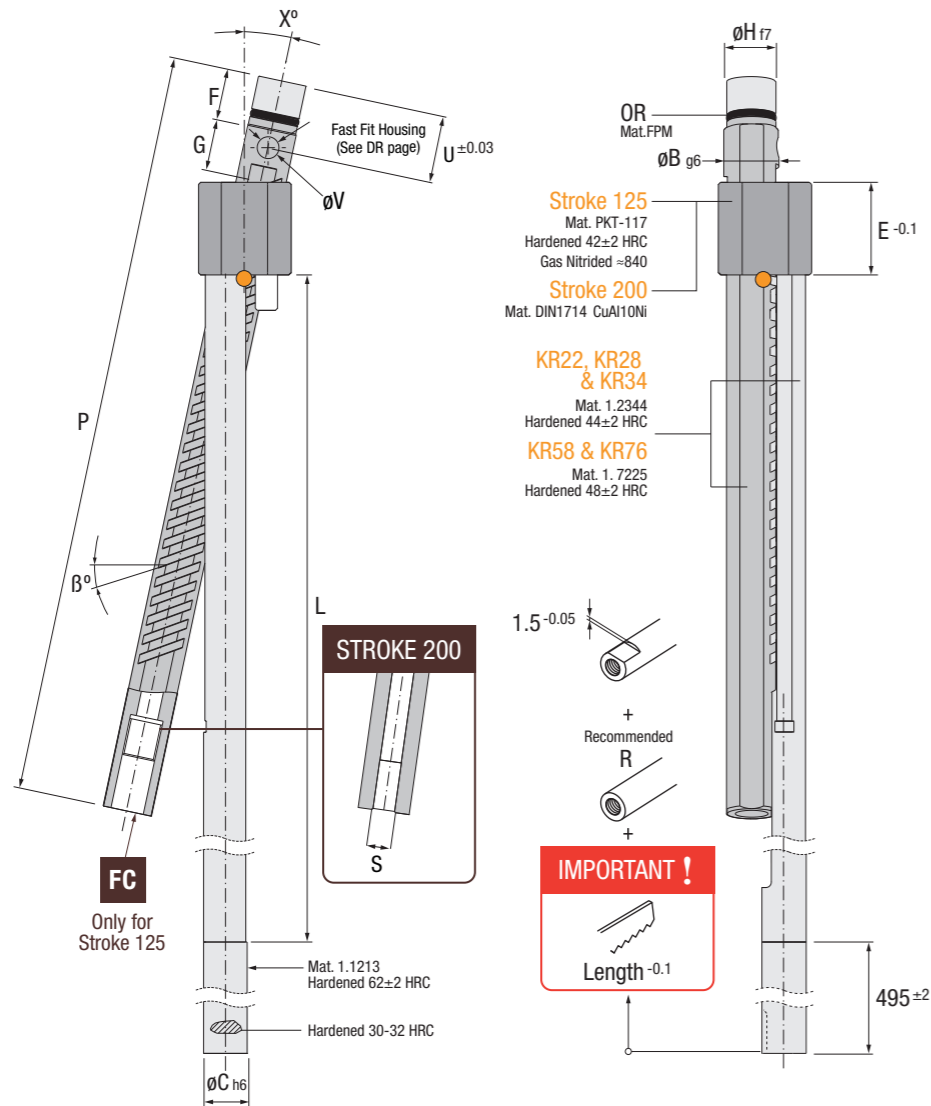


Patented

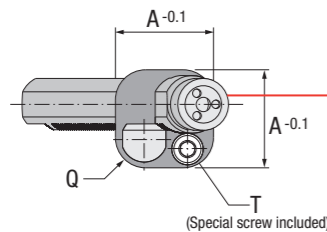
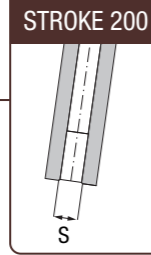
COOLED RACK LIFTER

ES Doble Cremallera Refrigerada DE Gekühltes Zweifach Zahnstangen System
IT Doppia Cremagliera con Refrigerazione PT Duplo Rack Refrigerado FR Double Rack Réfrigéré

● Cad Insertion Point



FC
Only for Stroke 125



IMPORTANT !
Length -0.1

IMPORTANT !
COOLING CONNECTION OPTIONS
Only for Stroke 125
Option A Option B

IMPORTANT !
Mirror part.
Pieza simétrica.
Symmetrisches Teil.
Versione a specchio.
Peça em espelho.
Pièce en miroir.

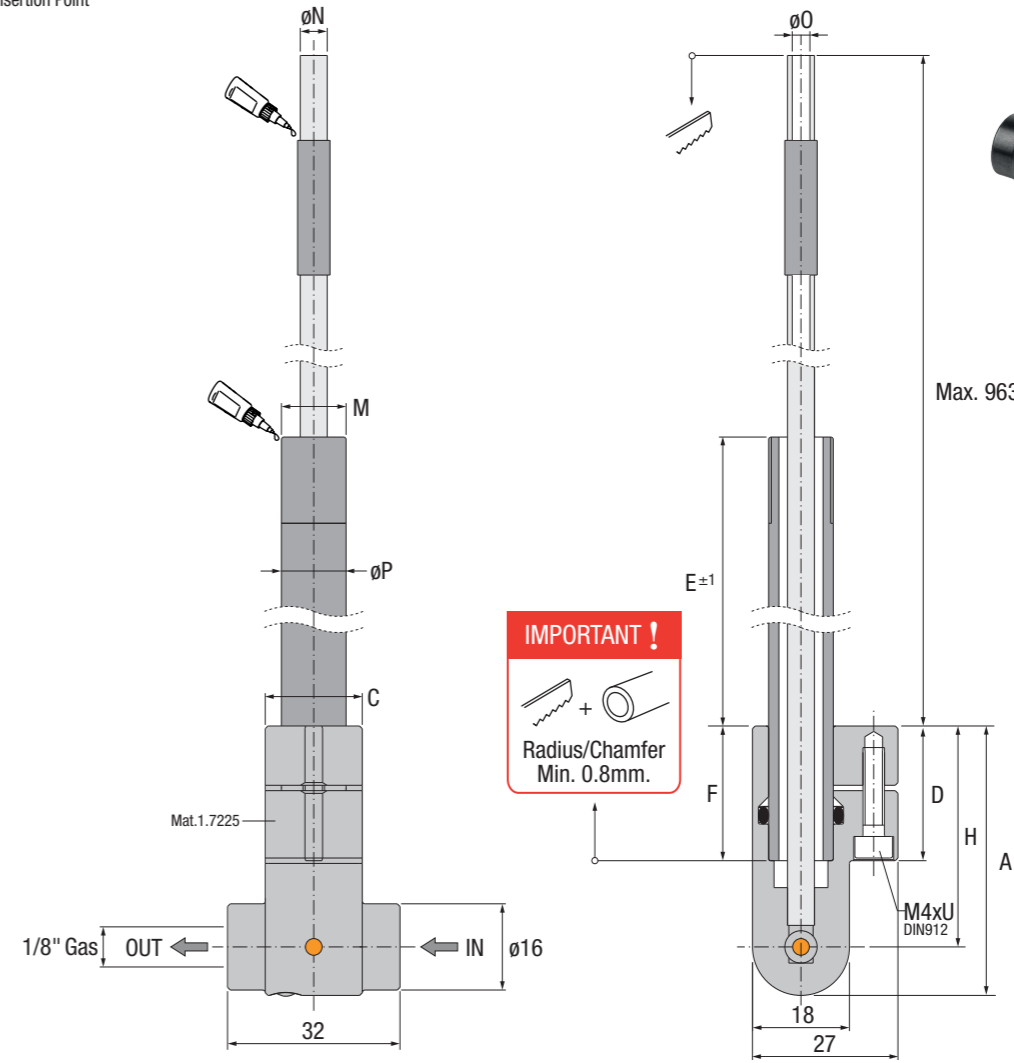
	Ref.	X°	A	B	C	E	F	G	H	L	P	Q	R	S	T	U	V	OR	Mirror Ref. -S
Stroke 125	KR.22125L-x	8 12 16 20	22	12	12	22	16	20	10.8	282	260	6.5	M6	-	M6	23	8	8x1.25	KR.22125L-x-S
	KR.28125L-x	8 12 16 20	28	16	14	28	16	20	13.8	294.5	272	8.5	M8	-	M8	23	8	11x1.3	KR.28125L-x-S
	KR.34125L-x	8 12 16 20	34	20	16	34	18	20	17.8	311.5	275	10.5	M8	-	M8	25	8	14x1.78	KR.34125L-x-S
	KR.40125L-x	8 12 16 20	40	22	20	40	20	25	19.8	342	350	10.5	M10	-	M10	28	10	15x1.8	KR.40125L-x-S
	KR.46125L-x	8 12 16 20	46	24	24	46	22	25	21.8	361	350	10.5	M12	-	M12	30	10	18x1.8	KR.46125L-x-S
Stroke 200	KR.58200L-x	8 12 16 -	58	30	30	66	25	55	26	362	430	13.5	M20	1/4" Gas	M14	60	12	21x2.5	KR.58200L-x-S
	KR.76200L-x	8 12 16 -	76	40	40	80	30	60	34	392	470	17	M24	3/8" Gas	M18	70	12	28x3	KR.76200L-x-S

IMPORTANT !
Replace the **x** in the reference with the required X° dimension (8°, 12°, 16° or 20°) and indicate the required β°.
Sustituir la **x** de la referencia por la cota X° deseada (8°, 12°, 16° o 20°), e indique el ángulo β° requerido.
Ersetzen Sie das **x** der Referenz durch den gewünschten X° Winkel (8°, 12°, 16° oder 20°). Geben Sie den benötigten β° Winkel an.
Sostituire la **x** del codice con l'angolo X° desiderato (8°, 12°, 16° o 20°) e indichiate la β° richiesta.
Substituir o **x** da referencia pela cota X° desejada (8°, 12°, 16° o 20°), e indique o angulo β° pretendido.
Remplacez la valeur **x** par la valeur angulaire X désirée (8, 12, 16 ou 20). Ensuite indiquez l'angle β° correspondant.

KR COOLING HOSE

ES Tubo Refrigeración KR DE KR Kühlungsschlauch
IT Sistema Refrigerazione KR PT Tubo de Refrigeração KR FR Tube de Refroidissement KR

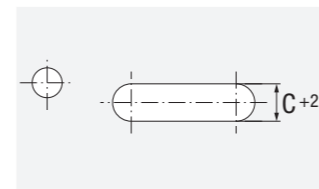
● Cad Insertion Point



Ref.	A	C	D	E	F	H	M	N	O	P	U	Compatible With
FC.220500	40	15	18	483.5	16.5	31	M8x1	3.5	3	8	10	KR.22125L
FC.280500	50	18	25	475	25	41	M10x1	4.5	4	10	16	KR.28125L
FC.340500	50	18	25	475	25	41	M12x1	5	4.5	12	16	KR.34125L
FC.400500	54	20	25	475	25	44	M14x1	7	6.5	14	16	KR.40125L / KR.46125L

Installation Guidelines

Consejos de Instalación · Richtlinien zur Installation · Consigli di Installazione · Instruções de Instalação · Mode d'Installation



IMPORTANT !

R ef.	Q					
	β ≤ 0°	0° < β ≤ 10°	10° < β ≤ 20°	20° < β ≤ 25°	25° < β ≤ 30°	30° < β ≤ 35°
KR.xx125L-8	10	15	18	20	23	25
KR.xx125L-12	10	16	22	25	29	-
KR.xx125L-16	10	18	26	31	-	-
KR.xx125L-20	10	20	31	-	-	-

FC

UNDERCUTS



Max. 80°C

XR

UNDERCUTS



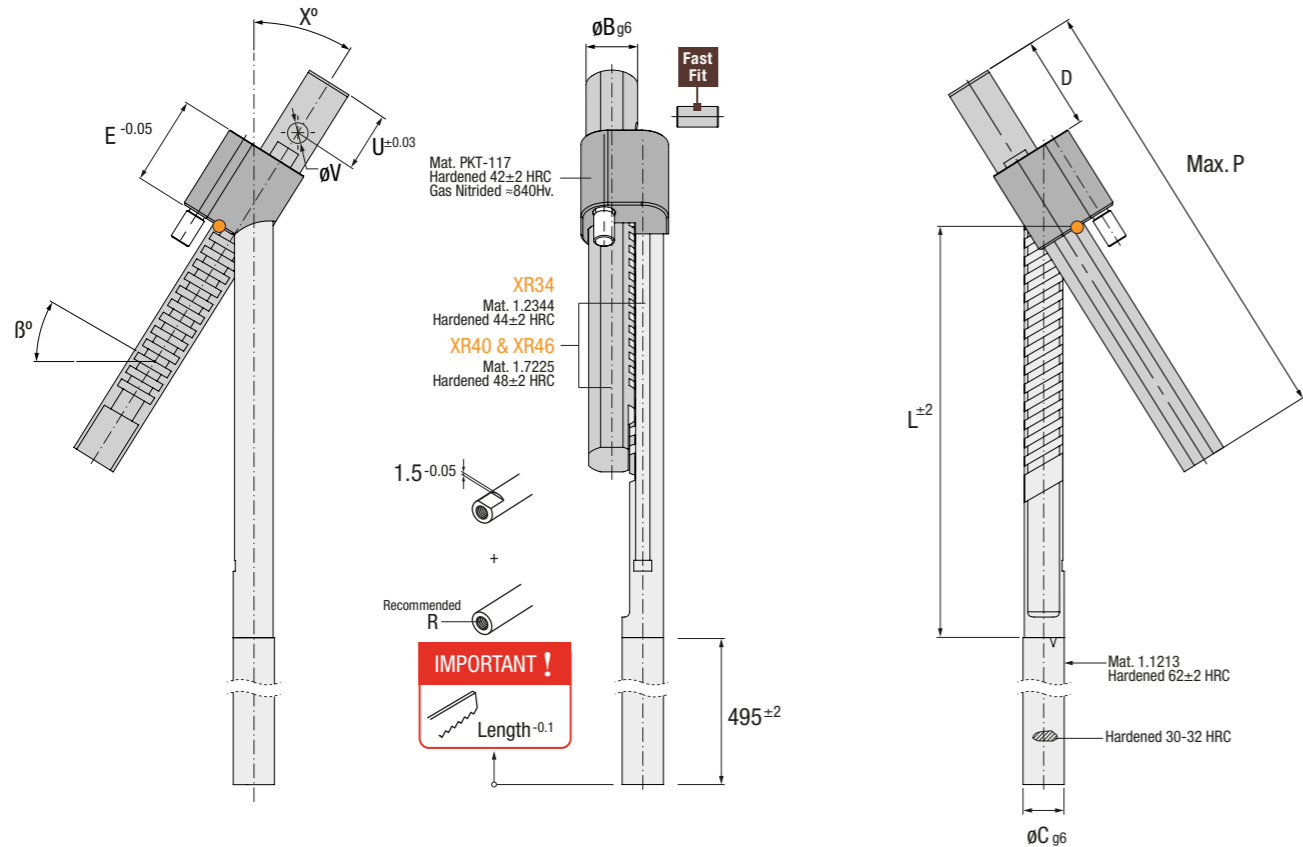
Patented

Max. 120°C

XTREME DOUBLE RACK

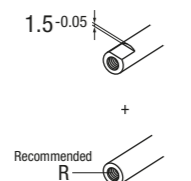
ES Doble Cremallera Xtreme DE Xtreme Double Rack
IT Doppia cremagliera Xtreme PT Xtreme Double Rack FR Double Cremaillere Xtreme

● Cad Insertion Point

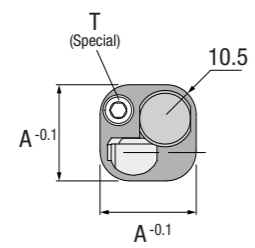


XR34
Mat. 1.2344
Hardened 44±2 HRC

XR40 & XR46
Mat. 1.7225
Hardened 48±2 HRC



IMPORTANT!
Length-0.1



IMPORTANT!
Mirror Part.
Pieza Simétrica.
Symmetrisches Teil.
Versione specchiata.
Peça em Espelho.
Pièce en Miroir.

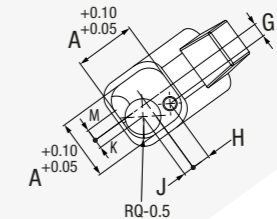
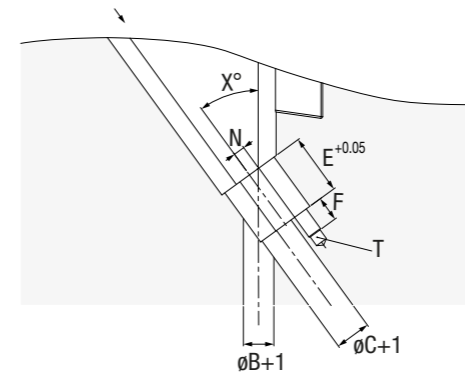
Stroke 100	X°	A	B	C	D	E	L	P	R	T	U	V	Stroke 100-S
XR34100L-x	24 28 32 36	34	20	16	36	34	159	225	M8	M8	23	8	XR34100L-x-S
XR40100L-x	24 28 32 36	40	22	20	36	40	170	240	M10	M10	20	10	XR40100L-x-S
XR46100L-x	24 28 32 36	46	24	24	42	46	174	255	M10	M12	26	10	XR46100L-x-S

IMPORTANT!
Replace the **X** in the reference with the required X° dimension (24°, 28°, 32° or 36°) and indicate the required B°.
Sustituir la **X** de la referencia por la cota X° deseada (24°, 28°, 32° or 36°), e indique el ángulo B° requerido.
Ersetzen Sie das **X** der Referenz durch den gewünschten X° Winkel (24°, 28°, 32° or 36°). Geben Sie den benötigten B° Winkel an.
Sostituite la **X** del codice con l'angolo X° desiderato (24°, 28°, 32° or 36°) e indicite la B° richiesta.
Substituir o **X** da referencia pela cota X° desejada (24°, 28°, 32° or 36°), e indique o angulo B° pretendido.
Remplacez la valeur **X** par la valeur angulaire X désirée (24°, 28°, 32° or 36°). Ensuite indiquez l'angle B° correspondant.

INSTALLATION GUIDELINES

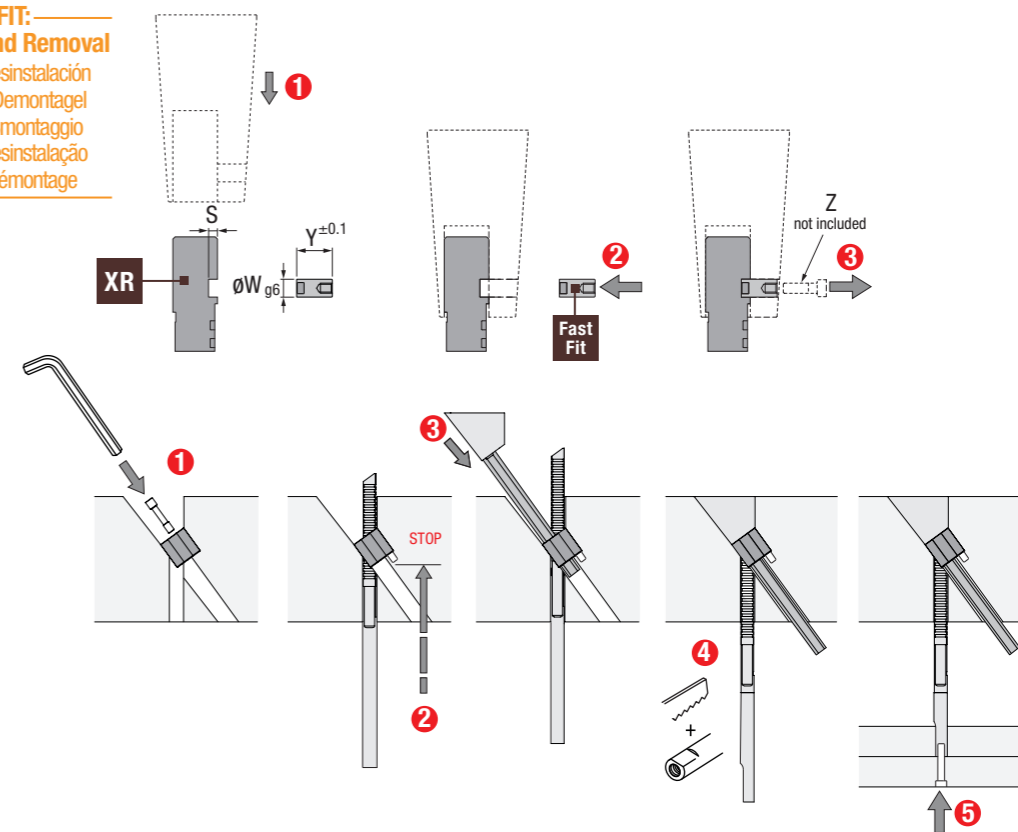
ES Consejos de Instalación DE Richtlinien zur Installation
IT Consigli di Installazione PT Instruções de Instalação FR Mode d'Installation

Core Housing
Alojamiento Placa Punzón
Einbaumaße DR Führung
Sede nel Punzone
Alojamento Bucha
Logement dans l'empreinte



Stroke 100	F	G	H	J	K	M	N	S	T	W	Y	Z
XR34100L-..	16	8	10.5	6	5	7	6	4	M8	8	16	M4
XR40100L-..	20	11	11	7	7	8	7	4	M10	10	20	M6
XR46100L-..	25	13	13	9	9	8	8	5	M12	10	24	M6

FAST FIT:
Installation y Desinstalación
Montage und Demontage
Montaggio e Smontaggio
Instalação e Desinstalação
Montage et Démontage



XR

UNDERCUTS



RD

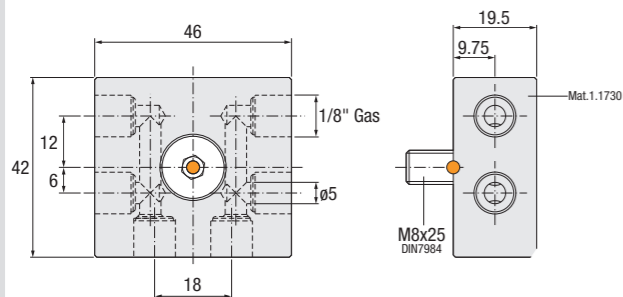
COOLING DISTRIBUTOR
 ES Distribuidor Refrigeración
 DE Verteilerschlauch
 IT Distributore Refrigerazione
 PT Distribuidor de Refrigeração
 FR Distribution de Refroidissement



Cad Insertion Point

UNDERCUTS

Max. 80°C



Ref.
RD.182012

MK

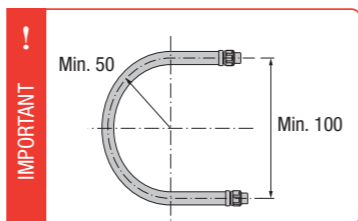
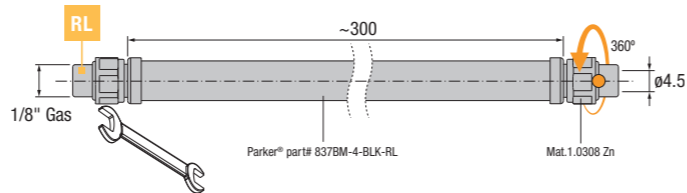
CONNECTION HOSE
 ES Tubo Conexión
 DE Verbindungsschlauch
 IT Tubo Collegamento
 PT Tubo de Ligação
 FR Tube de Liaison



Cad Insertion Point

UNDERCUTS

Max. 80°C



Ref.
MK.120300

RL

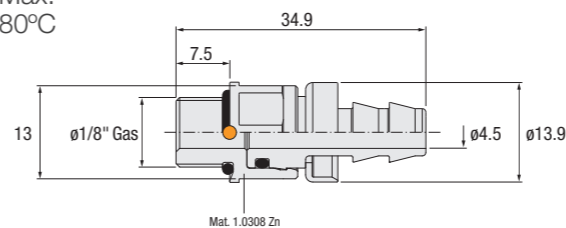
COOLING CONNECTOR
 ES Conector Refrigeración
 DE Kühlung Kupplungsstück
 IT Attacco Refrigerazione
 PT Conector de Refrigeração
 FR Connexion de Refroidissement



Cad Insertion Point

ACCESSORIES

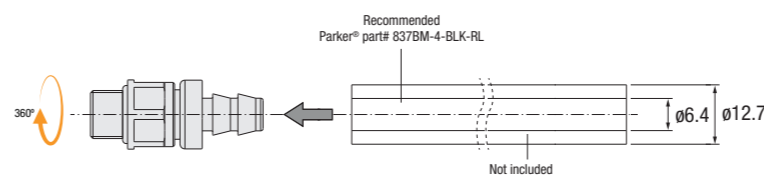
Max. 80°C



Ref.
RL.181235

Installation Guidelines

Consejos de Instalación · Richtlinien zur Installation
 Consigli di Installazione · Instruções de Instalação
 Mode d'Installation



SM

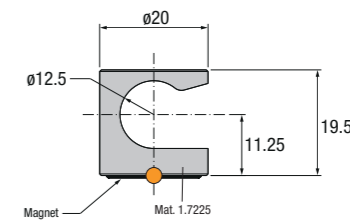
HOSE RETAINER
 ES Sujeta Tubos
 DE Schlauchhalter
 IT Ferma Cavi
 PT Retensor de Mangueira
 FR Retenu de Tuyau



Cad Insertion Point

EJECTION

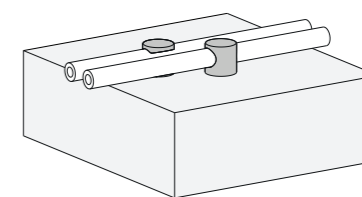
Max. 80°C



Ref.
SM.122020

Installation Guidelines

Consejos de Instalación · Richtlinien zur Installation
 Consigli di Installazione · Instruções de Instalação
 Mode d'Installation



CK

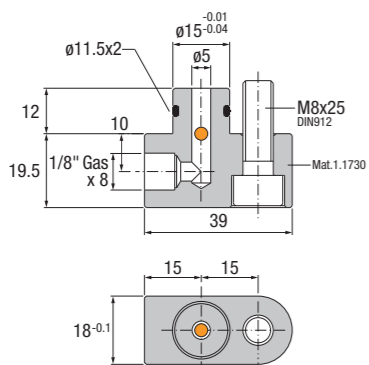
90° PLATE CONNECTOR
 ES Conector Placa a 90°
 DE 90° Platten-Verbindungsstück
 IT Collegamento Piastra a 90°
 PT Conector de Placa a 90°
 FR Connexion Dans la Plaque de 90°



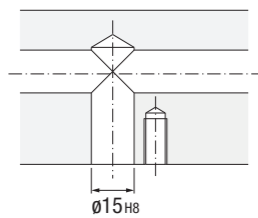
Cad Insertion Point

UNDERCUTS

Max. 80°C



Ref.
CK.181839



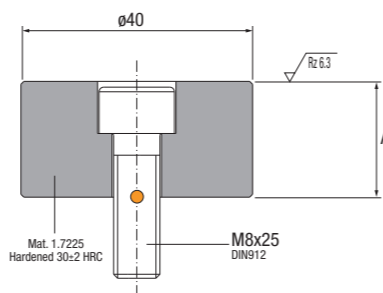
TR

EJECTOR PLATE SPACER
 ES Distanciator Placa
 DE Auswerferplatte Abstandhalter
 IT Distanziale Piastra
 PT Espaçador de Chapas
 FR Entretoise de Passage



Cad Insertion Point

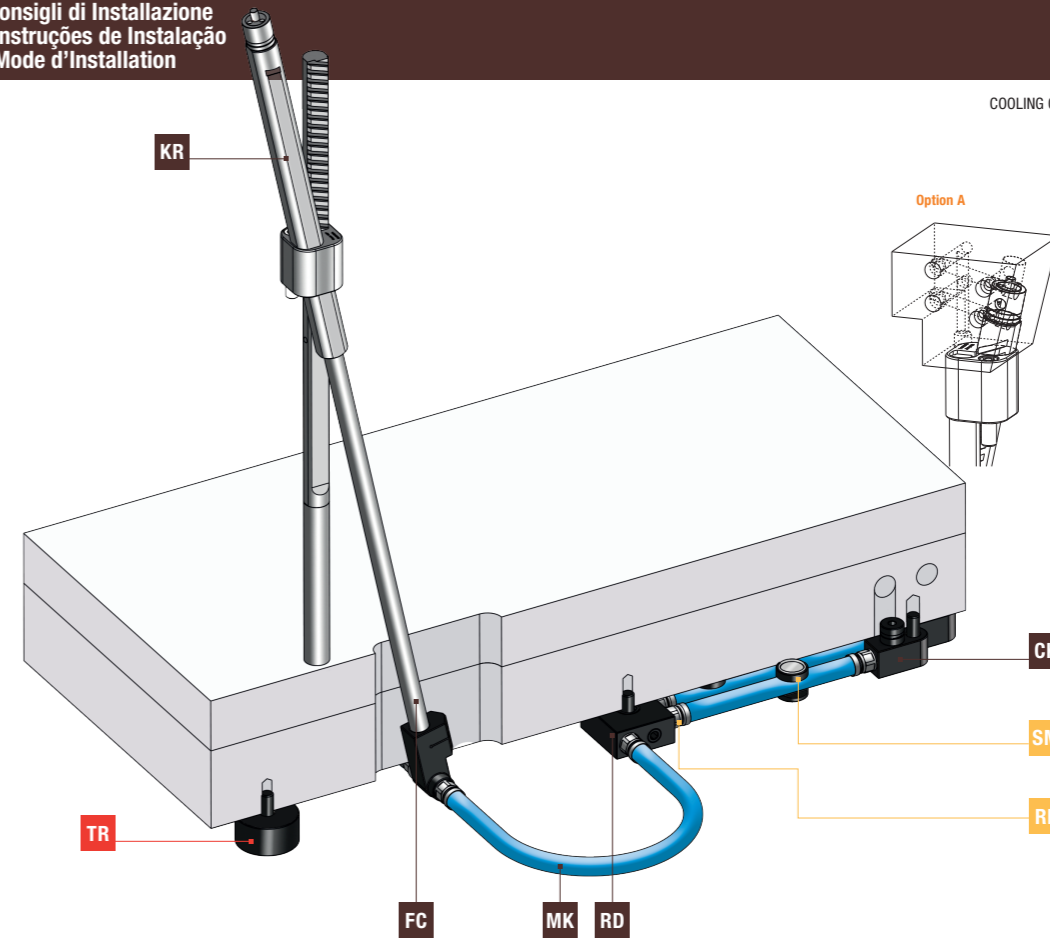
EJECTION



Ref.	A
TR.204008	20
TR.404008	40

INSTALLATION GUIDELINES

ES Consejos de Instalación
 DE Richtlinien zur Installation
 IT Consigli di Installazione
 PT Instruções de Instalação
 FR Mode d'Installation



Max. 80°C

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