QMC122 Series

MILACRON clamping units are designed for industrial applications, where a reduction in machine downtime is necessary.

Features- At a Glance

- Flexibility – Any mold shape and size can be clamped without modification.
- Limited Maintenance – No moving parts, no threads to strip.
- Control Display – Operator pendant is capable of displaying system holding force and temperature.

MILACRON clamping units feature a rugged honeycomb construction, which incorporates a patented circular pole design. The system comes with a standard SPI interface. New system control features allow for data logging, pin code access and safety warnings.

Available Voltage
208-240V / 380-480V

Available Machine Types
SPI, Euromap and JIS

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Standard Equipment

System Operation
With a Double-Magnet System, the lower magnet's polarity is reversed to direct the flow of the magnetic field either into the mold base or into the magnetic chuck.

Specifications

- Pole size: 2.36"
- Plate Thickness: 2"
- Maximum Working Temperature: 212°F
- Maximum depth of magnetic field: 11mm
- Air gap sensitivity: 0.004"

System Parameters

- **Contact area**: Mold to plate contact area is proportional to holding force. Deep draw parts with a small footprint must be reviewed.
- **Material composition**: As alloy content is increased, the material’s magnetic conductivity worsens. Acceptable mold base materials are 1020, 420, 4130 and DME#7.
- **Base plate thickness**: All magnetic flux generated must be adsorbed by the base plate steel. All mold bases must be a minimum of 11mm thick.
- **Surface quality**: It is important to ensure that the magnet and base plate are free from dirt, debris, and rust. These can create air gaps which reduce holding force.
- **Temperature**: (@ 212°F) High temperature can do irreparable damage to the system.

Standard Features

- **Patented Circular Pole Design**
  - More power at center of mold
  - Symmetrical lines of flux
  - Low field height
  - Predictable clamp force
- **Rugged Construction**
  - Honeycomb design means stability
  - Brass inter-poles
  - Totally sealed assembly
- **Advanced Control System**
  - Mold data entry
  - Calculation and display of clamping force
  - Temperature display
  - SPI interface
  - Data logging
  - Three levels of access
  - Alarm and message display