



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

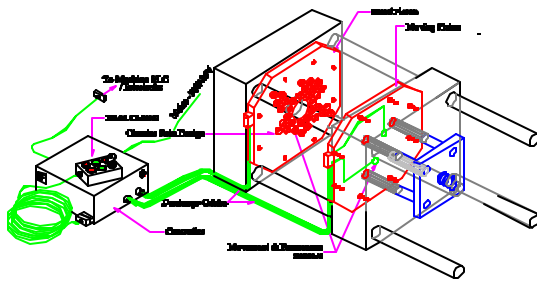
Available Machine Types

SPI, Euromap and JIS

Milacron Process Support Business

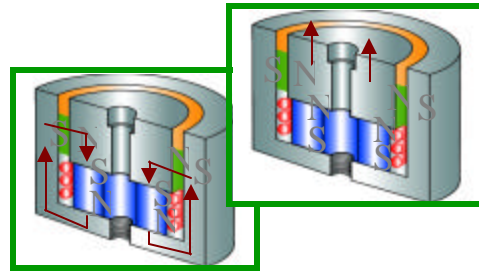
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Standard Equipment



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.....	.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