

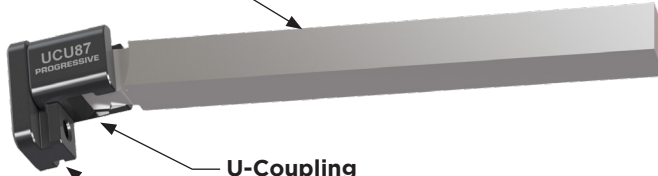


UNILIFTER® UNDERCUT RELEASE LIFTER

UNILIFTER: UL-SERIES

Core Blade

H-13, 38-42 HRC

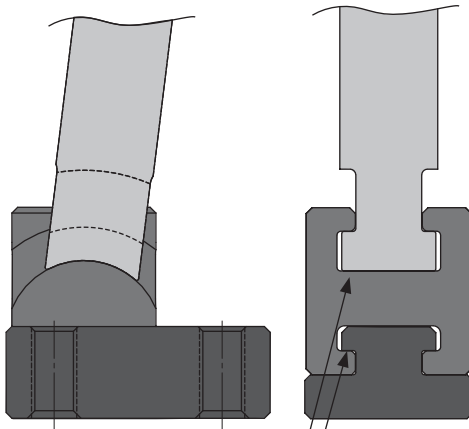


U-Coupling

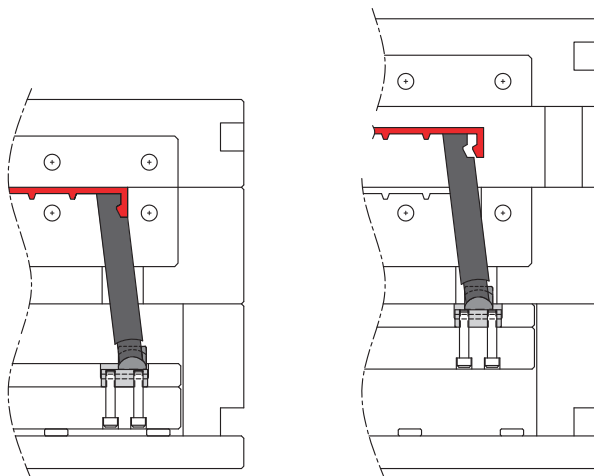
H-13, 70 HRC

T-Gib

H-13, 70 HRC



The T-slot's large surface contact is designed to withstand extreme force and run smoothly without binding.



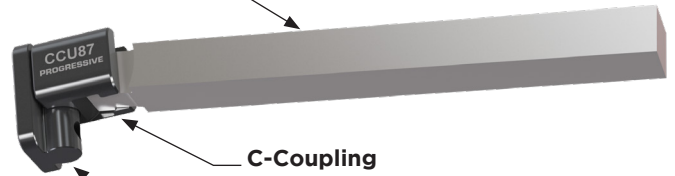
Mold Closed

Mold Open

UNILIFTER: C-SERIES

Core Blade

S-7, 54-56 HRC

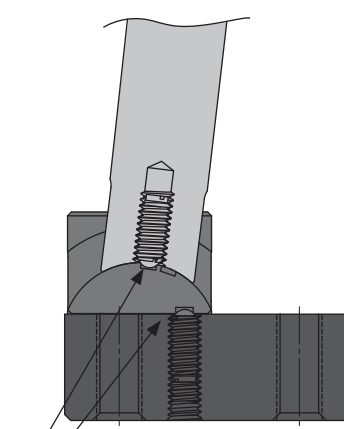


C-Coupling

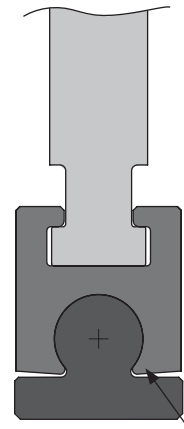
H-13, 70 HRC

C-Gib

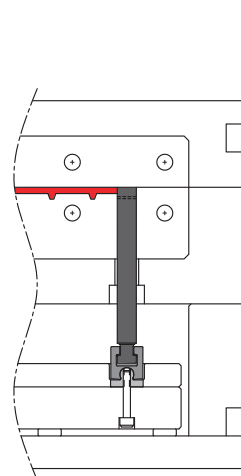
H-13, 70 HRC



Click-in-place assembly feature sets the components to the required operating position, allowing for simplified insertion into the mold plate pockets.



Self-adjusting cylindrical design to compensate for severe ejector plate misalignment or warpage.

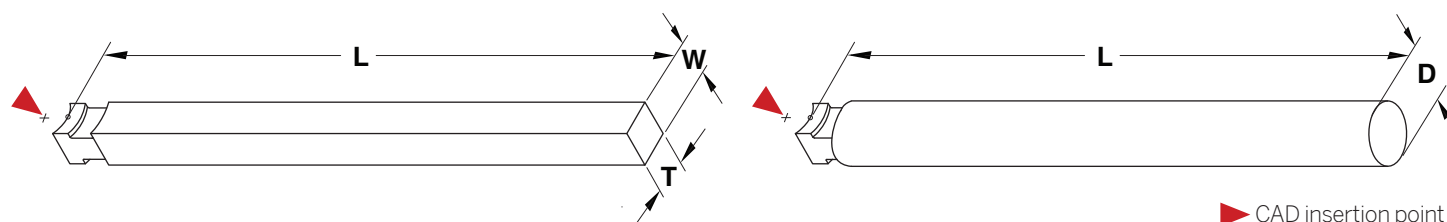


Mold Closed

Mold Open

CORE BLADES

INCH STANDARD



Flat Core Blades			H-13 38-42 HRC		S-7 54-56 HRC		COUPLINGS
T +.000 -.001	W +.000 -.001	SERIES	L=8" +.06 -.00	L=18" +.06 -.00	L=8" +.06 -.00	L=18" +.06 -.00	
.385	.260	Mini	CBS37X25L8	CBS37X25L18	CBS7X37X25L8	CBS7X37X25L18	UL-Series: UCM50 C-Series: CCM50
.510	.260		CBS50X25L8	CBS50X25L18	CBS7X50X25L8	CBS7X50X25L18	
.760	.385		CBS75X37L8	CBS75X37L18	CBS7X75X37L8	CBS7X75X37L18	

Note: S-7 Core Blades come with the assembly detent installed.

Flat Core Blades			H-13 38-42 HRC			S-7 54-56 HRC			COUPLINGS
T +.000 -.001	W +.000 -.001	SERIES	L=8" +.06 -.00	L=14" +.06 -.00	L=20" +.06 -.00	L=8" +.06 -.00	L=14" +.06 -.00	L=20" +.06 -.000	
.510	.510	UL	CBS50X50L8	CBS50X50L14	CBS50X50L20	CBS7X50X50L8	CBS7X50X50L14	CBS7X50X50L20	UL-Series: UCU87 C-Series: CCU87
.510	.760		CBS50X75L8	CBS50X75L14	CBS50X75L20	CBS7X50X75L8	CBS7X50X75L14	CBS7X50X75L20	
.510	1.010		CBS50X100L8	CBS50X100L14	CBS50X100L20	CBS7X50X100L8	CBS7X50X100L14	CBS7X50X100L20	
.510	1.510		—	CBS50X150L14	CBS50X150L20	—	—	—	
.760	.510		—	CBS75X50L14	CBS75X50L20	—	—	—	
.760	1.510		CBS75X150L8	CBS75X150L14	CBS75X150L20	—	CBS7X75X150L14	CBS7X75X150L20	
1.010	.510		CBS100X50L8	CBS100X50L14	CBS100X50L20	—	CBS7X100X50L14	CBS7X100X50L20	
1.510	.510		CBS150X50L8	CBS150X50L14	CBS150X50L20	—	—	—	
1.510	.760		CBS150X75L8	CBS150X75L14	CBS150X75L20	—	CBS7X150X75L14	CBS7X150X75L20	

Note: S-7 Core Blades come with the assembly detent installed.

Flat Core Blades			H-13 38-42 HRC		COUPLINGS
T +.000 -.001	W +.000 -.001	SERIES	L=10" +.06 -.00	L=18" +.06 -.00	
1.010	1.010	XL	CBS100X100L10	CBS100X100L18	UL-Series: UCX175
1.010	1.510		CBS100X150L10	CBS100X150L18	
1.510	1.010		CBS150X100L10	CBS150X100L18	

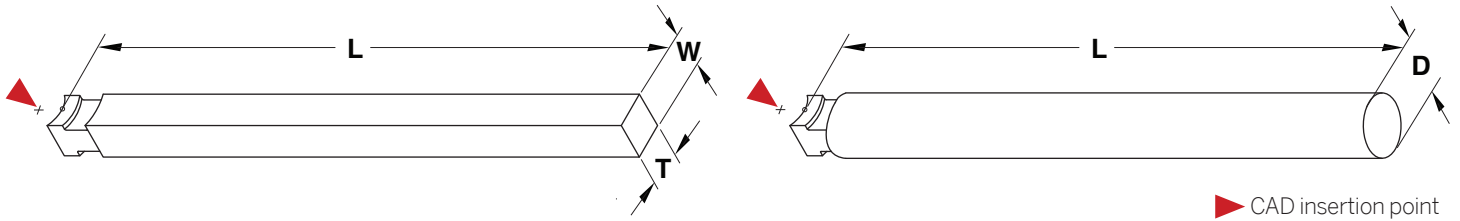
Round Core Blades		H-13 38-42 HRC					COUPLINGS
D +.000 -.001	SERIES	L=8" +.06 -.00	L=10" +.06 -.00	L=14" +.06 -.00	L=18" +.06 -.00	L=24" +.06 -.00	
.437	Mini	CBS43DL8	—	—	CBS43DL18	—	UL-Series: UCM50 C-Series: CCM50
.500		CBS50DL8	—	—	CBS50DL18	—	
.750	UL	CBS75DL8	—	CBS75DL14	CBS75DL18	CBS75DL24	UL-Series: UCU87 C-Series: CCU87
1.250	XL	—	CBS125DL10	—	CBS125DL18	—	UL-Series: UCX175

For Core Blades in different materials or sizes, refer to the templates at procomps.com.



CORE BLADES

METRIC STANDARD



► CAD insertion point

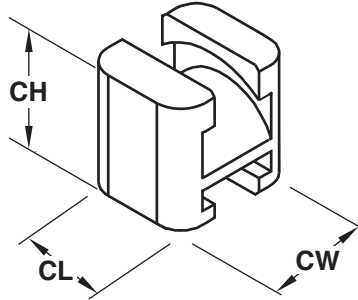
Flat Core Blades			H-13 48-50 HRC	DC53 58-60 HRC	H-13 38-42 HRC		S-7 54-56 HRC	COUPLINGS
T -.005 -.015	W -.005 -.015	SERIES	L=200MM +2 +0				L=250MM +2 +0	
6.00	6.00	Metric Mini	CBMMH6X6L200	CBMMP6X6L200	—	—	—	UL-Series: UCMM16
6.00	10.00		CBMMH6X10L200	CBMMP6X10L200	—	—	—	
8.00	6.00		CBMMH8X6L200	CBMMP8X6L200	—	—	—	
8.00	8.00		CBMMH8X8L200	CBMMP8X8L200	—	—	—	
10.00	8.00		CBMMH10X8L200	CBMMP10X8L200	—	—	—	
10.00	10.00	Metric	—	—	—	—	CBMMS7X10X10L250	C-Series: CCMM22
15.00	15.00		—	—	—	—	CBMMS7X15X15L250	
T +.000 -.025	W +.000 -.025	SERIES			L=250MM +2 +0	L=400MM +2 +0		COUPLINGS
10.25	10.25	Metric	—	—	CBMM10X10L250	—	—	UL-Series: UCMM22
10.25	20.25		—	—	CBMM10X20L250	—	—	
15.25	15.25		—	—	CBMM15X15L250	—	—	
15.25	30.25		—	—	—	CBMM15X30L400	—	C-Series: CCMM22
20.25	10.25		—	—	CBMM20X10L250	—	—	
20.25	20.25		—	—	—	CBMM20X20L400	—	
30.25	15.25		—	—	—	CBMM30X15L400	—	

Note: S-7 Core Blades come with the assembly detent installed.

Round Core Blades		H-13 48-50 HRC	DC53 58-60 HRC	H-13 38-42 HRC	
D -.005 -.014	SERIES	L=200MM +2 +0			COUPLINGS
8.00	Metric Mini	CBMMH8DL200	CBMMP8DL200	—	UL-Series: UCMM16
D +.000 -.025	SERIES			L=250MM +2 +0	COUPLINGS
10.00	Metric	—	—	CBMM10DL250	UL-Series: UCMM22 C-Series: CCMM22
15.00		—	—	CBMM15DL250	

UNILIFTER: UL-SERIES COMPONENTS

U-COUPPLINGS



Inch Standard

M H-13 **H** Core: 40-44 HRC Surface: 70 HRC
S Black Nitride

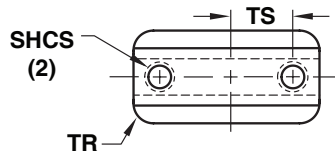
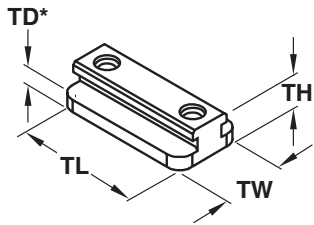
SERIES	CATALOG NUMBER	CW	CL	CH
Mini	UCM50	.50	.44	.62
UL	UCU87	.87	.75	.87
XL	UCX175	1.75	1.50	1.65

Metric Standard

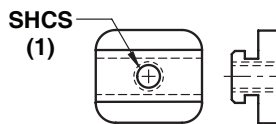
M H-13 **H** Core: 40-44 HRC Surface: 70 HRC
S Black Nitride

SERIES	CATALOG NUMBER	CW	CL	CH
Metric Mini	UCMM16	16	14	21
Metric UL	UCMM22	22	18	25

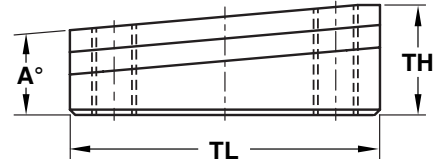
T-GIBS



TGM31 & TGU25



TGU100-5 & TGU100-10



*TD Includes fitting stock for final adjustments.

Inch Standard

M H-13 **H** Core: 40-44 HRC Surface: 70 HRC **S** Black Nitride

SERIES	CATALOG NUMBER	TRAVEL ALLOWED	TW +.000 -.001	TH +.010 -.000	TD* +.010 -.000	TR	TS ±.01	TL +.000 -.010	A ANGLE	SHCS (INCLUDED)
Mini	TGM31	.312	.500	.500	.344	.093	—	.750	—	#10-32 x 1
	TGM100	1.000					.50	1.50	—	
UL	TGU25	.250	.875	.468	.219	.187	—	1.00	—	1/4-20 x 3/4
	TGU50	.500					.37	1.25	—	
	TGU100	1.000		.62 1.75			—			
	TGU100-5	1.000					5°			
	TGU100-10	1.000					10°			
	TGU150	1.500					.468	.75	2.25	
XL	TGX50	.500	1.750	.615	.250	.312	.62	2.00	—	3/8-16 x 1-1/4
	TGX100	1.000					.87	2.50	—	
	TGX250	2.500					1.37	4.00	—	

Metric Standard

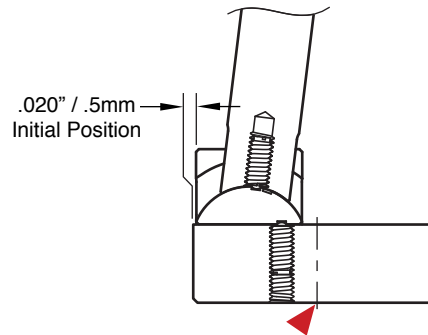
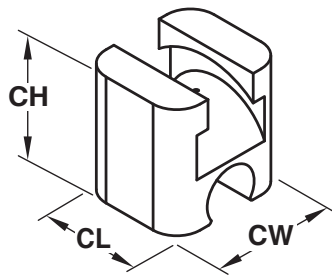
M H-13 **H** Core: 40-44 HRC Surface: 70 HRC **S** Black Nitride

SERIES	CATALOG NUMBER	TRAVEL ALLOWED	TW +.000 -.025	TH +.25 -.00	TD* +.25 -.00	TR	TS ±.25	TL +.00 -.25	SHCS (INCLUDED)
Metric Mini	TGMM16	18	16	13	6	2.5	10	33	M4-.7x20
Metric UL	TGMM10	15	22	13	6	5	10	33	M5-0.8 x 20
	TGMM30	34					15	52	



UNILIFTER: C-SERIES COMPONENTS

C-COUPPLINGS



Inch Standard

M H-13 **H** Core: 40-44 HRC Surface: 70 HRC

S Black Nitride

SERIES	CATALOG NUMBER	CW	CL	CH
Mini	CCM50	.50	.44	.70
UL	CCU87	.87	.75	.87

Metric Standard

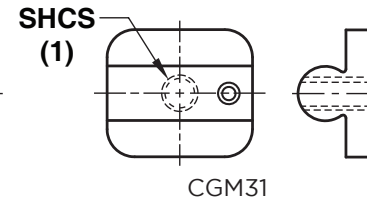
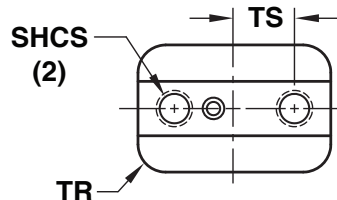
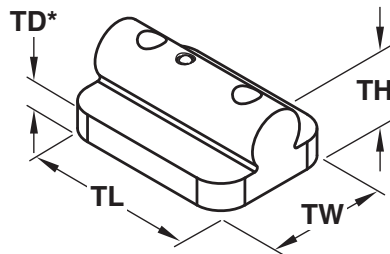
M H-13 **H** Core: 40-44 HRC Surface: 70 HRC

S Black Nitride

SIZE	CATALOG NUMBER	CW	CL	CH
Metric	CCMM22	22	18	24

► CAD insertion point

C-GIBS



*TD Includes fitting stock for final adjustments.

Inch Standard

M H-13 **H** Core: 40-44 HRC Surface: 70 HRC **S** Black Nitride

SERIES	CATALOG NUMBER	TRAVEL ALLOWED	TW +.000 -.001	TH +.010 -.000	TD* +.010 -.000	TR	TS ±.01	TL +.000 -.010	SHCS (INCLUDED)
Mini	CGM31	.312	.500	.550	.250	.093	—	.750	#10-32 x 1
	CGM100	1.000					.50	1.50	
UL	CGU50	.500	.875	.540	.187	.187	.37	1.25	1/4-20 x 3/4
	CGU100	1.000					.62	1.75	

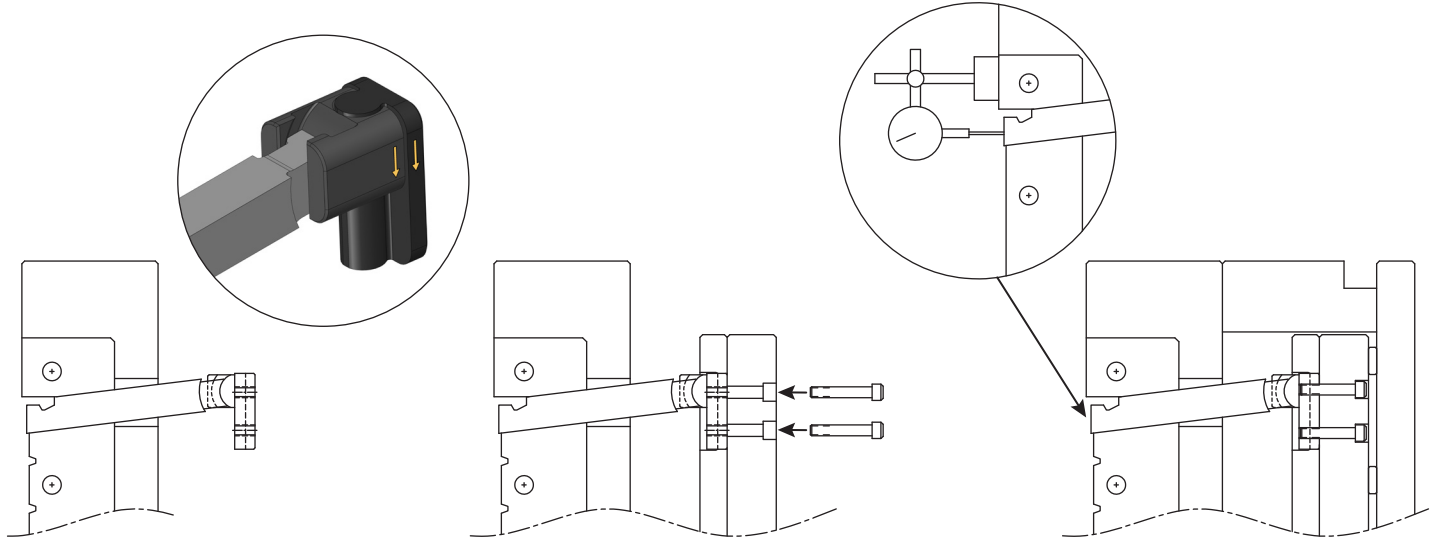
Metric Standard

M H-13 **H** Core: 40-44 HRC Surface: 70 HRC **S** Black Nitride

SIZE	CATALOG NUMBER	TRAVEL ALLOWED	TW +.000 -.025	TH +.25 -.00	TD* +.25 -.00	TR	TS ±.25	TL +.00 -.25	SHCS (INCLUDED)
UL	CGMM10	15	22	15	6	5	10	33	M5-0.8 x 20

APPLICATION GUIDELINES

- C-Series Gibs come with the assembly detent installed.
- Screw thread is not through top of the C-Gib on the Mini sizes.

C-SERIES LIFTER SYSTEMS**INSTALLATION INSTRUCTIONS / APPLICATION GUIDELINES**

1 Install Core Blade, C-Gib and C-Coupling into the mold base. Align arrows to orient with ejection travel.

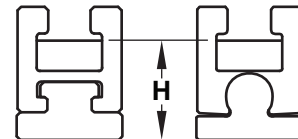
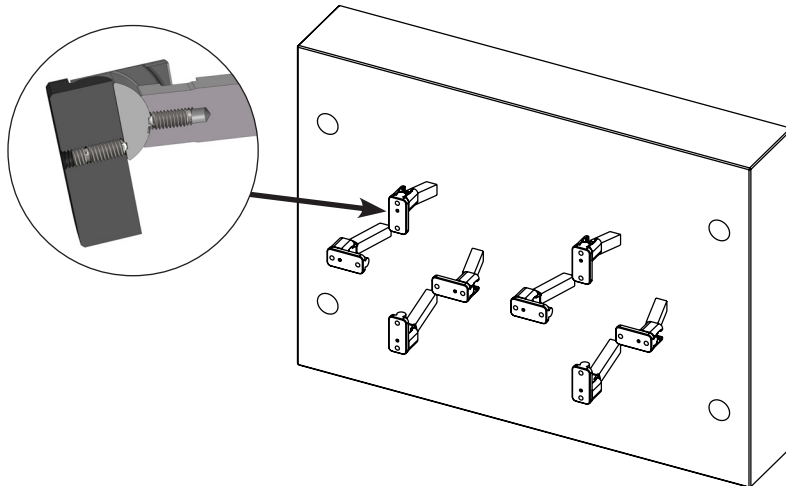
2 Assemble the ejector plates and fasten the C-Gib into the pocket.

3 With the mold assembled, check to verify final position of the lifter. Adjust by grinding the back of the C-Gib as required.

C-Series Lifter Features

Assembly detents allow the toolmaker to set the Core Blade, C-Coupling and C-Gib to the correct angle and position, allowing easy assembly into the mold pocket without parts sliding out of position.

Maintenance Option: Should ejector plates warp over time, the C-Series Gib and Coupling can directly replace the UniLifter Series without altering the Core Blades.



SERIES	H
Mini	.719"
UL	.812"
Metric	22mm

UL-SERIES & C-SERIES APPLICATION GUIDELINES

- Typical Core Blade angle is 5-10°. For greater angles, Lifter Guides are recommended.
- Lifter Guides are also recommended if less than half of the Core Blade is bearing in the insert. Refer to page H-10 for Guides.
- Typical clearance is .001"-.0015" (.02-.04 mm), or a 3° taper on the Core Blade T & W to eliminate contact and friction.
- Core Blades are interchangeable between the UL-Series and C-Series.
- If treating the S-7 Core Blades, the assembly ball plunger should be removed prior to processing.