

DMS - Diemould  
Section 7 - Mechanisms

SRT  
Slide Retainers



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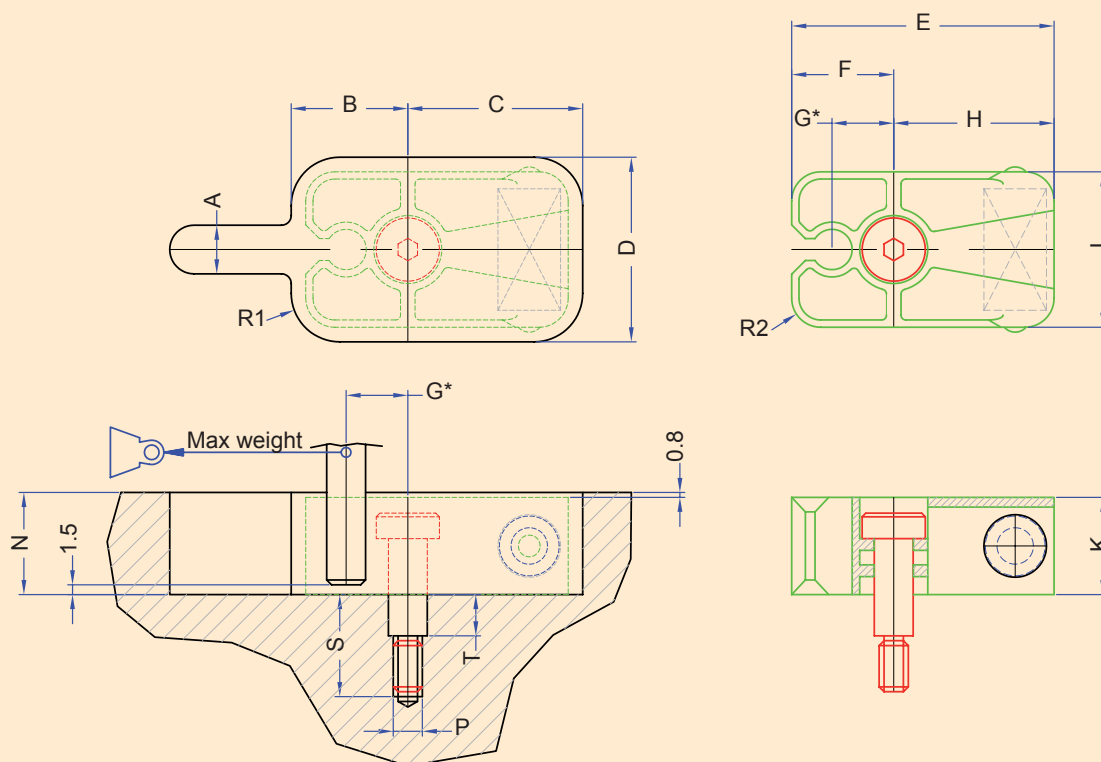
DMS Diemould's range of case hardened slide retainers are compact, have a positive action, and can be installed in new moulds or retro fitted in to existing moulds.

They are available in 3 sizes and can be used in multiples.  
SRT units can also be used for holding or pulling floating plates.

Download CAD data at  
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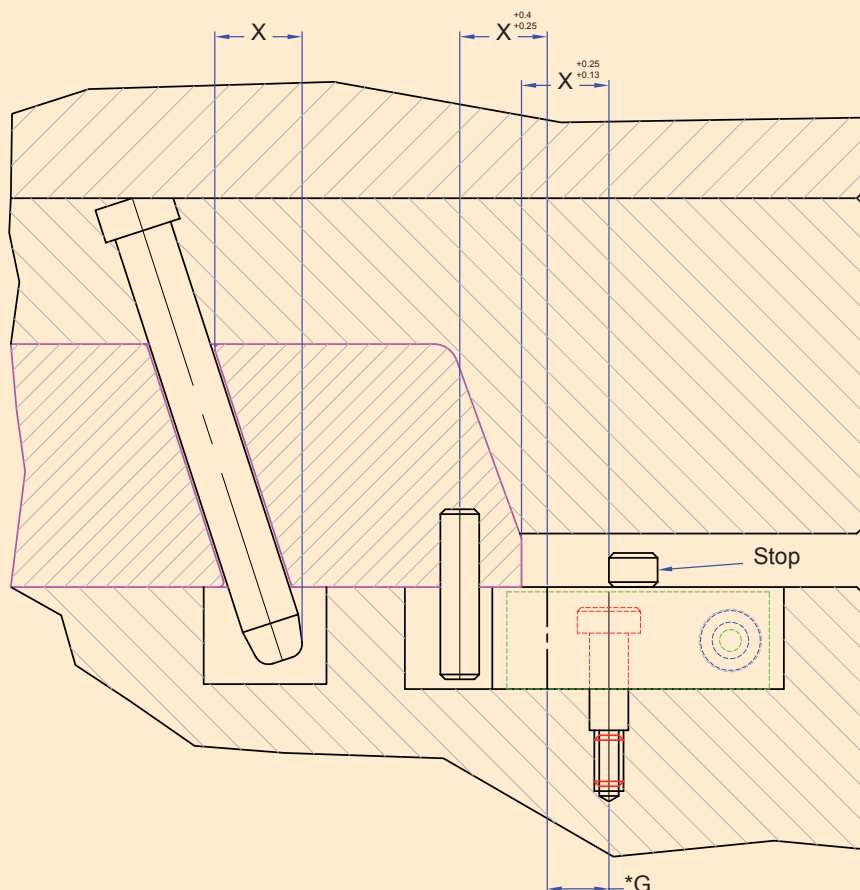
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	Max Slide Weight		SS			MD
	Kg	( Newtons )	Size	Max Torque Nm	P	
SRT - 10	10	( 100 )	6 x 16	10	M5	Ø6 x 30
SRT - 20	20	( 200 )	8 x 20	15	M6	Ø8 x 40
SRT - 40	40	( 400 )	10 x 30	20	M8	Ø10 x 60



	A	B	C	D	E	F	G*	H	J	K	N	P	R1	R2	S	T
SRT - 10	8	19	26	25	38	16	9.15	22	19	16	17	M5	8	5	10	6
SRT - 20	10	24	36	38	54	21	12.7	33	32	20	21	M6	10	6	12	8.5
SRT - 40	12	36	56	51	86	33	20.3	53	45	30	31	M8	13	10	15	10

**\* Please read fitting and design notes. This dimension is critical.**



#### Fitting & Design Notes

- 1, The bottom of the machined pocket must be flat to allow free movement of the SRT.
- 2, Dimension 'X' is the slide travel caused by the angle pin. Please pay attention to the tolerances.
- 3, A positive stop must be fitted.
- 4, When more than one slide is used they must -  
Act uniformly and symmetrically.  
Be the same size.  
Note : Add Wt together for total force
- 5, It is important when installing the unit that dimension 'G' ( the distance from the shoulder screw to the dowel pin ) is maintained.
- 6, The tapped hole for the shoulder screw must not be countersunk.
- 7, Do not operate above 110°C.

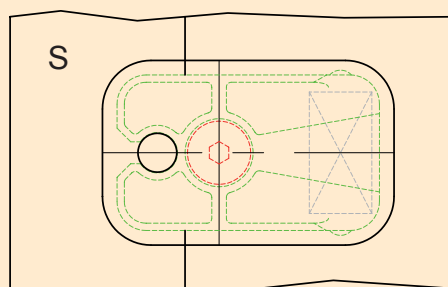
#### WARNING

Regularly check for signs of wear or fatigue.

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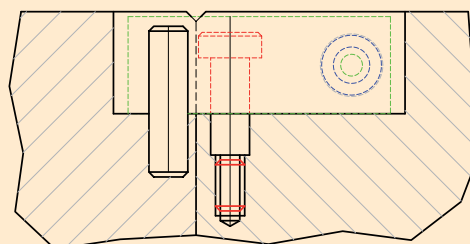
#### Operation A

- 1, As the mould opens, the angle pin moves the slide.
- 2, The dowel in the slide opens the SRT and locks in to place. At the same time the angle pin leaves the slide and the slide is limited from overtravel by the stop.
- 3, Slide held in position by the SRT.
- 4, Mould closes, angle pin draws slide back to closed position.



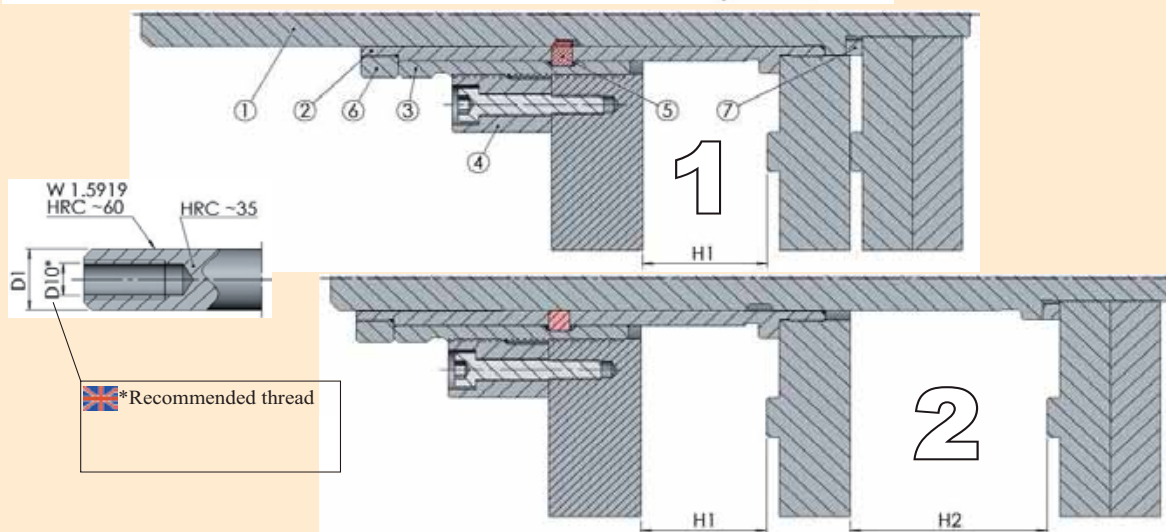
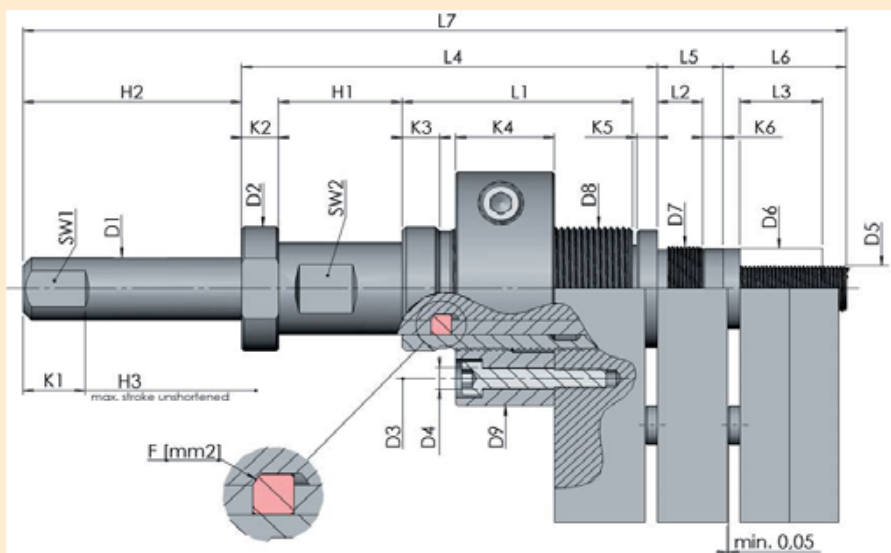
#### Operation B

- 1, As the tool opens, plate 'S' is held in position until being pulled apart. Note the force required ( Wt ) to overcome the spring in the SRT.
- 2, Always fit SRT's symmetrically in the tool.



### Design Notes

1. This unit should only be used on machines with hydraulic Ejection.
2. A mould safety device should be fitted to the moulding machine.
3. Internal and external threads on item 1, D1 & D5 must be machined accurately.
4. Item 1 must not be shortened by more than K1, if H3 is to be maintained.
5. All bores must be in line and have a flat bottom.

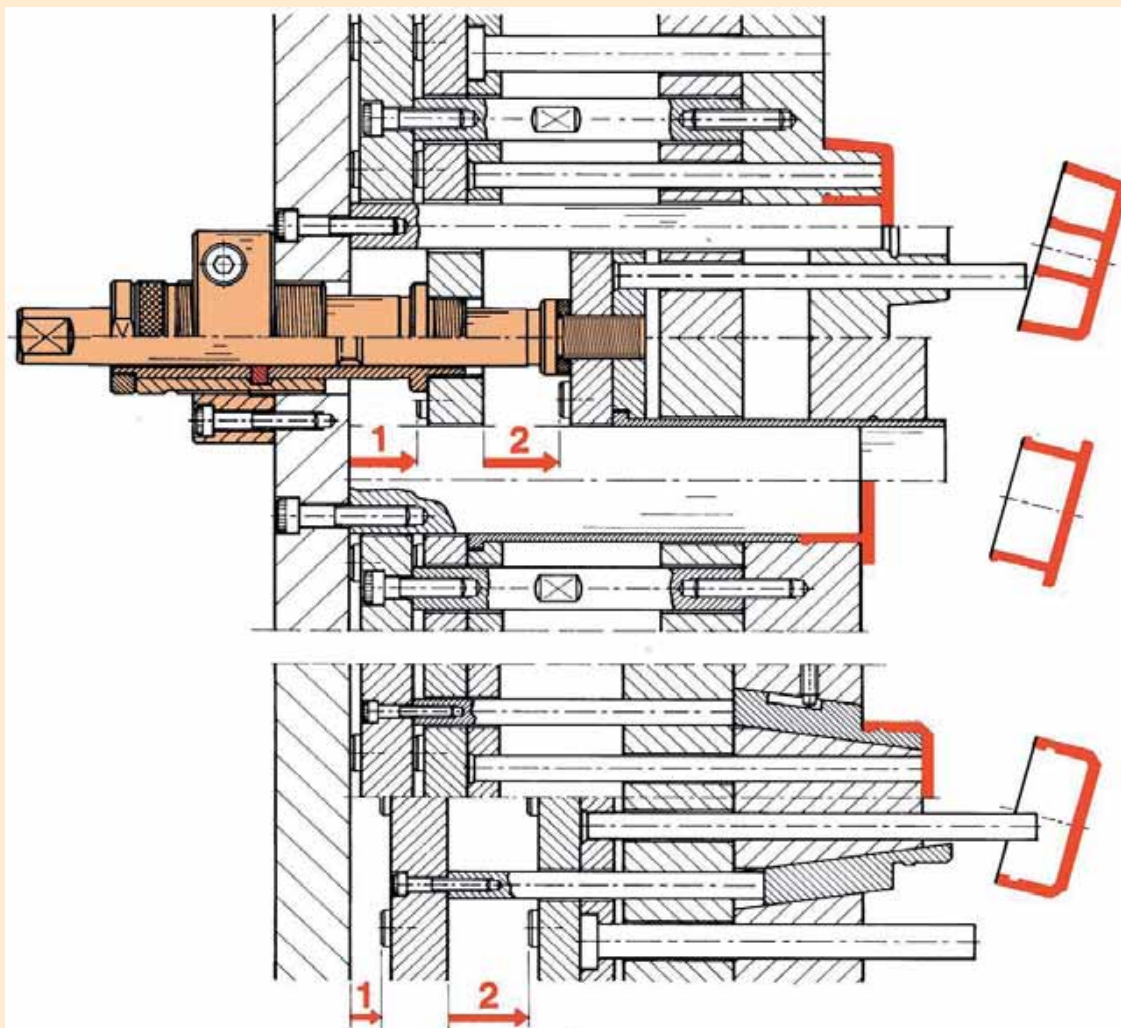


### Parts List

- 1 - Ejector Rod
- 2 - Ejector Sleeve
- 3 - Adjustable Bush
- 4 - Assembly Flange
- 5 - Segment
- 6 - Lock Ring
- 7 - Spacer

	**	D1	D2	D3	D4	D5	D6	D7	D8	D9	D10	H1	H2	H3	K1	K2	K3	K4	K5	K6	L1	L2	L3	L4	L5	L6	L7	SW1	SW2	Fmm2
FW1800 M32x1,5	150	16	32	46	5,6	M12x1	20,6	M22x1	M32x1,5	60	M10	5-30	50	80	16	9	8	24	5	5	56	11	20	101	16	30	200	13	20	56
M42x1,5	200	22	42	62	6,6	M16x1,5	28	M30x1,5	M42x1,5	80	M14	10-40	70	110	20	9	10	30	6	6	75	16	30	132	22	40	266	17	27	100
M52x1,5	350	28	53	72	9	M20x1,5	36	M38x1,5	M52x1,5	90	M16	10-40	80	120	22	10,5	12	30	8	6	75	16	35	134	22	45	285	22	35	152
M62x1,5	500	37	63	80	9	M24x1,5	44	M48x1,5	M62x1,5	102	M20	10-40	80	120	22	10,5	12	30	8	6	80	16	40	140	22	50	300	30	44	215

\*\*Recommended measure for the ejector plates length



#### Fitting Notes

1, Fit ejector rod item 1 in to the ejector plate, secure with Loctite 242e.

2, Position items 2, 3 and 4.

- a) rotating item 3 adjusts stroke H3.
- b) H1 moves both ejector sets together.
- c) H2 moves ejector set 2 only.

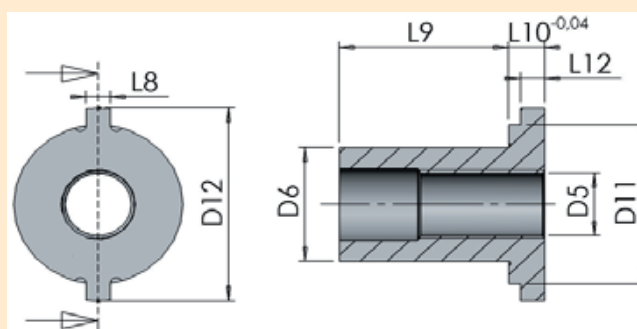
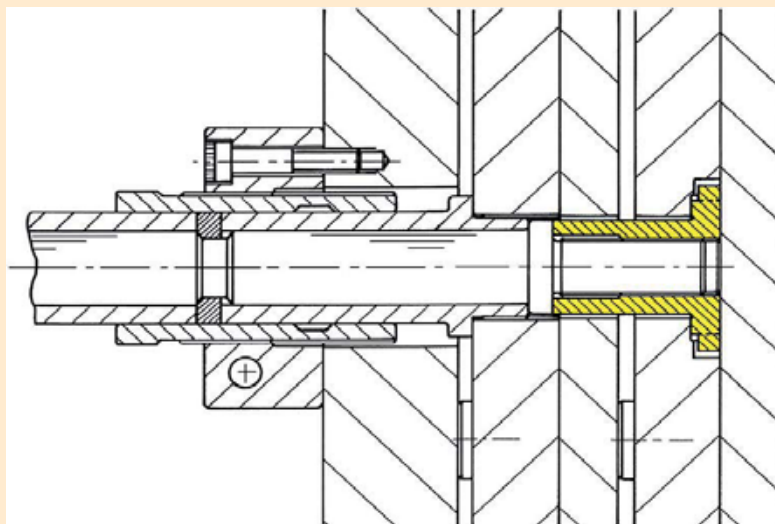
3, Item 7 spacer ring should be machined so that there is 0.05mm clearance between ejector sets.

4, Tighten item 3 after adjustment.

5, Secure item 3 with item 4 location flange.

6, Check function manually.





	D5	D6	D11	D12	L8	L9	L10	L11	L12
FW 180-32-150	M12x1,0	20	28	34	4	28	6	13	4
FW 180-42-200	M16x1,5	28	37	44	5	36	7	18	5
FW 180-52-350	M20x1,5	36	46	55	6	51	8	22	6
FW 180-62-500	M24x1,5	44	56	66	7	81	10	26	7

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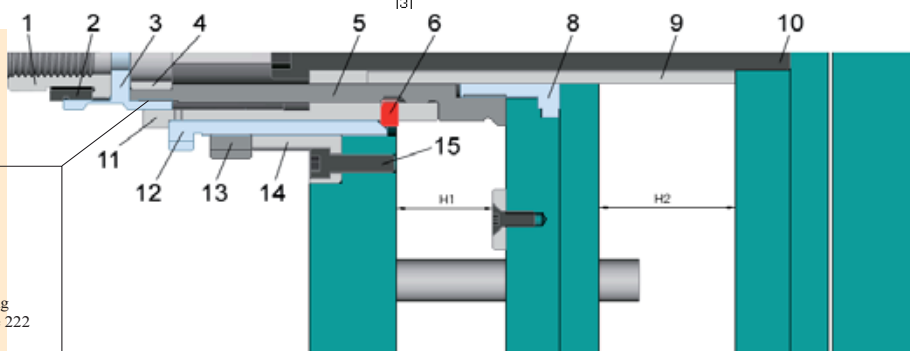
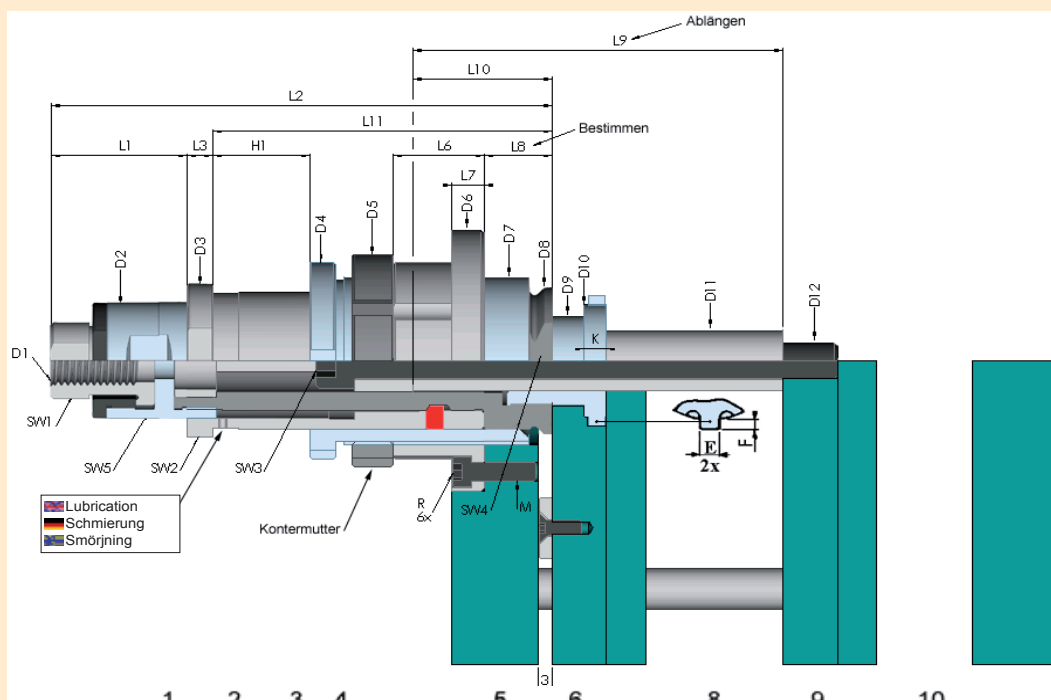
Two Stage Ejector  
FW ( AET )  
Notes



## Two Stage Ejector G (AET-G)



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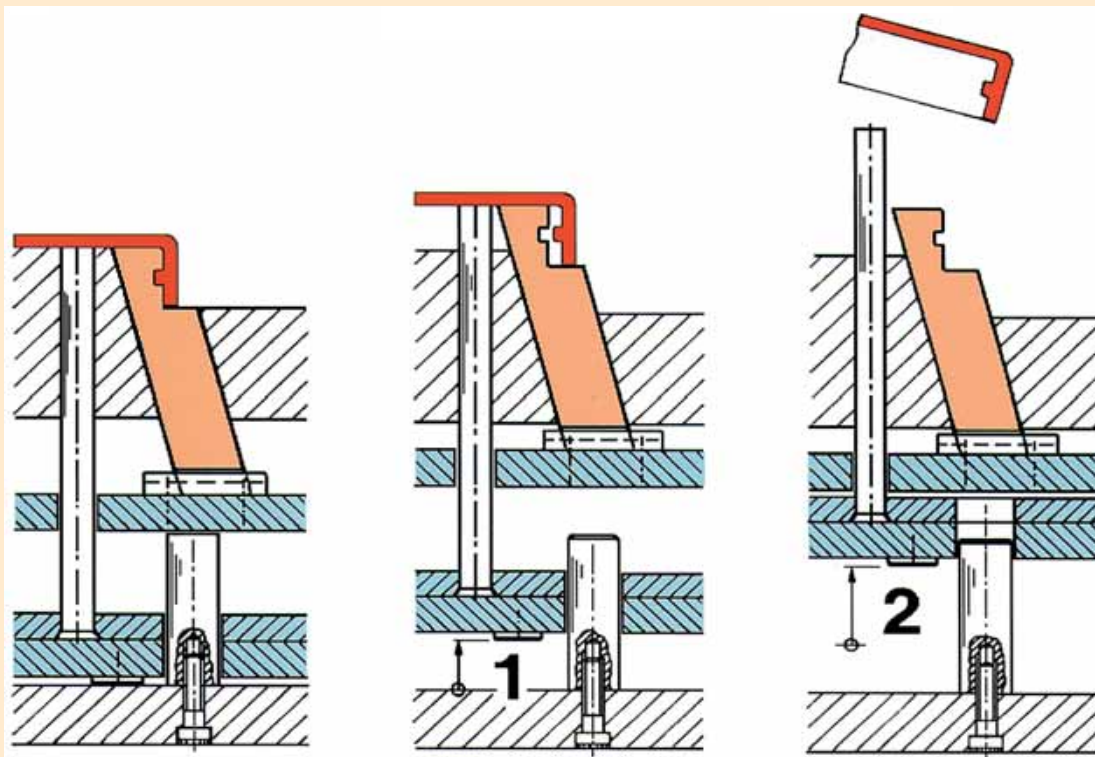
	*[Nm]	**[Nm]
G-42	130	140
G-48	140	150
G-46/58	140	160
G-68/82	150	180

\* Max. torque at assembling  
(Use 2-3 drops of Loctite 222  
or similar only on part 3)  
\*\* Torque at disassembling

TYP	D1	D2	D3	D4	D5	D6	D7	D8	D9	D10	D11	D12	H1	H2	R	L1	L2	L3	L4	L5	L6	L7	L8	L9	L10	L11	E	F	K	M	SW1	SW2	SW3	SW4	SW5
G-42	M16	38	55	65	71	86	M55x1,5	48	M29x1,25	37	20	M12	6-36	8-42	36,5	42	155	8	8	13	28	10	20	130	43	105	5	3	7	6	22	50	10	41	34
G-48	M16	44	61	71	81	96	M62x1,5	54	M29x1,25	37	20	M12	6-36	10-48	41,5	49	170	10	10	14	32	12	18	130	44	111	5	3	7	6	24	55	10	46	41
G-46	M16	50	71	86	94	110	M74x1,5	61	M32x1,5	40	22	M12	10-38	10-46	48,5	47	169	12	11	14	30	12	18	132	48	110	5	3	7	6	24	65	10	50	*
G-58	M16	50	71	86	94	110	M74x1,5	51	M32x1,5	40	22	M12	15-48	15-58	48,5	47	191	12	12	14	37	12	18	155	58	132	5	3	7	6	24	65	10	50	*
G-68	M20	57	81	98	104	126	M82x1,5	69	M40x1,5	48	28	M16	15-50	20-68	55	57	216	14	16	15	40	15	24	175	60	144	6	3,5	8	8	27	75	14	60	*
G-82	M20	57	81	98	104	126	M82x1,5	69	M40x1,5	48	28	M16	20-55	25-82	55	57	235	14	16	15	45	15	24	195	65	163	6	3,5	8	8	27	75	14	60	*

\*Hook wrench





#### Functioning Sequence

##### Advance

1, Both ejector assemblies are moved forwards simultaneously H1.

2, The lower ejector plates run further H2.

##### Retract

3, The lower plates run back by the distance H2.

4, Both ejector assemblies run back simultaneously.



#### Installation Notes

1, Determine stroke H1 & H2.

2, Drill hole D6 and thread D12, machining in clearance holes D7, D9 and D10. Then machine areas E & F to specified dimensions ( tolerance +1 / +0.5 ).

3, Machine parts 9 and part 10 to the length of H2.

4, Mount part 8 so that it can move.

5, Screw in the two stage ejector by means of SW2 and screw 15.

6, Tighten screw 10 with SW3 and locking.

#### WARNING

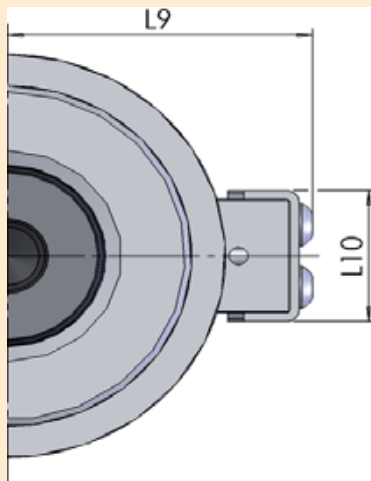
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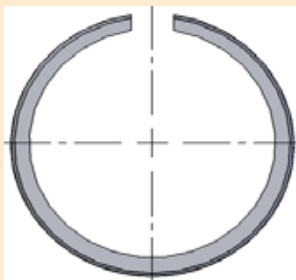
# Self Locking Cylinder BZ



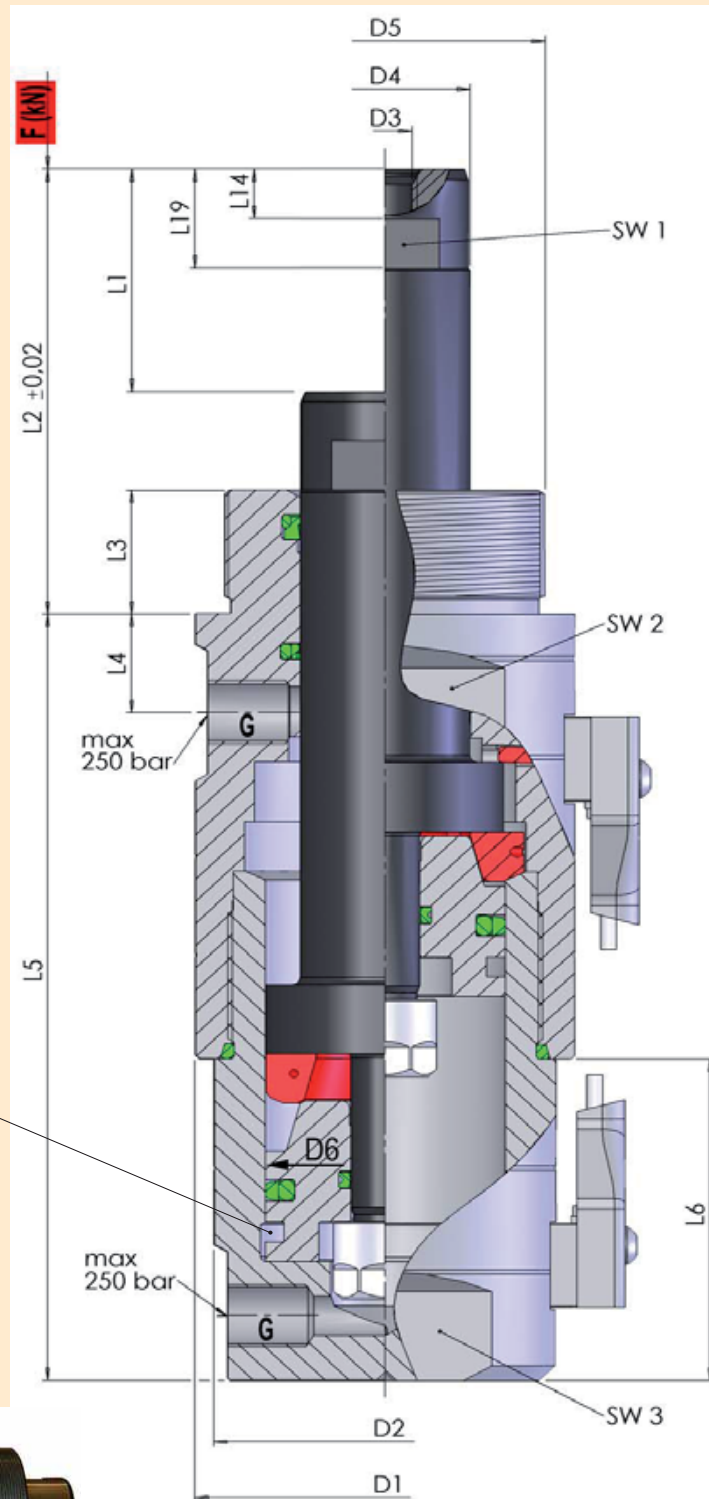
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Vertically mounted cylinder (rod pointing downwards) could be assembled with a self redeeming stop.



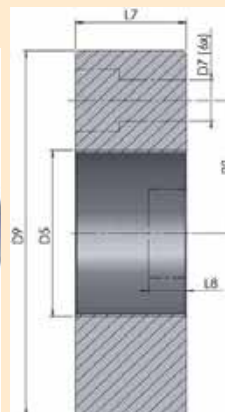
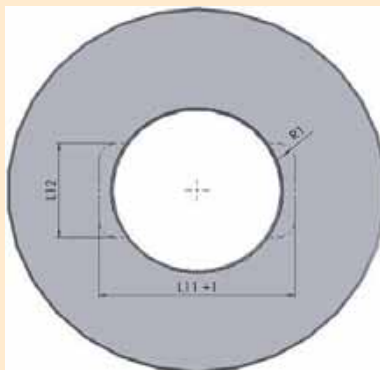
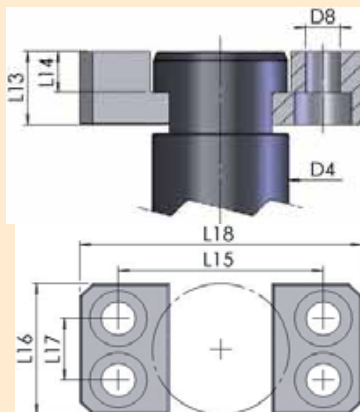
**Note!**  
Using key grip SW3 is NOT allowed when assembling or disassembling the the cylinder.



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## Self Locking Cylinder BZ



### Note

BZ-16 cannot be supplied with anti torque clamps. To avoid burring, the locking cylinder can be mounted with a pre-load. In this case the distance L2 shall be adjusted shorter in the tool according to table V.

Anti torque clamps, mounting plates and self redeeming stops are all available on request.

Sensors are also available to order and are supplied in pairs. Please use code DW-AD-403-M5x0.5

Art. Nr	D1	D2	D3	D4	D5	D6	D7	D8	D9	L7	L8	L9	L10	L11	L12	L13	L14	L15	L16	L17	L18	L19	R1	R2	G
BZ-16	38	36	M8	16	M30x1,5	24	8,5	-	82	22	-	34	12		-	-	5	-	-	-	-	11	-	28	1/8
-20	48	46	M8	20	M40x1,5	30	11	5,1	102	28	11	39	20	48	23	11	6	32	21	10	46	13	4	35	1/4
-25	57	53	M10	25	M48x1,5	36	13	6,1	112	32	13	43	20	54	28	14	8	38	26	12	52	15,5	5	40	1/4
-32	71	64	M12	32	M60x1,5	45	15	8,1	132	38	13	48	20	68	34	18	10	48	32	15	66	20	6	48	1/4
-42	87	79	M16	42	M75x1,5	56	17	8,1	160	46	15	57	20	80	38	22	12	58	36	18	78	24	7	58	3/8
-50	110	98	M16	50	M95x2	71	21	10	200	54	13	67	20	95	46	27	14	67	42	20	91	29	7	74	3/8
-60	129	114	M20	60	M110x2	84	25	10	238	64	-	75	20	-	-	27	14	76	42	20	100	32	-	86	1/2
-75	162	148	M24	75	M135x2,5	105					-		20	-	-		20					41	-		1/2

Art. Nr.	L1	L2	L3	L4	L5	L6	V	V	SW1	SW2	SW3	F(KN)	F(KN)	F(KN)	F(KN)
BZ-16-20	20	45	15	12	90	30	0,12	0,18	12	30	30	35	40	60	4
-40	40	65	-	-	110	50	0,20	0,27	-	-	-	-	-	-	-
BZ-20-30	30	60	18	14	115	47	0,12	0,18	14	38	41	50	70	100	6
-60	60	90	-	-	145	77	0,20	0,27	-	-	-	-	-	-	-
BZ-25-35	35	70	20	15	125	51	0,08	0,12	18	46	41	65	90	130	8
-70	70	105	-	-	160	86	0,10	0,15	-	-	-	-	-	-	-
BZ-32-45	45	90	25	20	155	65	0,12	0,17	24	55	50	110	150	200	12
-90	90	135	-	-	200	110	0,15	0,20	-	-	-	-	-	-	-
BZ-42-50	50	105	32	24	185	71	0,10	0,15	32	75	65	160	220	280	17
-100	100	155	-	-	235	121	0,15	0,20	-	-	-	-	-	-	-
BZ-50-60	60	130	42	26	216	78	0,20	0,25	41	90	80	300	400	500	32
-120	120	190	-	-	276	138	0,25	0,35	-	-	-	-	-	-	-
BZ-60-75	75	155	50	36	260	100	0,20	0,25	50	110	95	400	600	700	43
-150	150	230	-	-	335	175	0,25	0,35	-	-	-	-	-	-	-
BZ-75-100	100	200	60	55	335	120	0,30	0,35	65	130	120	550	850	1000	67

### Note

Secondary locking pressure minimum 60 bar.



160 bar  
240 bar  
120-250 bar  
Maximum load for installation without pre-load  
160 bar  
Returning power

## Self Locking Cylinder BZ



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### Installation Notes

Mounting plate thickness should be reduced on the back face until the hydraulic inlet / outlet fittings are in the correct position.

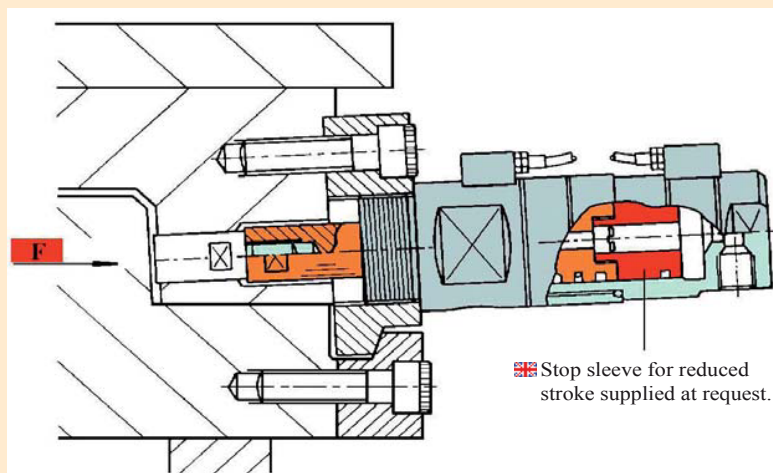
Reduce the front face of the mounting plate down until L2 is achieved.

Use large screws and fit as close to the cylinder as possible.

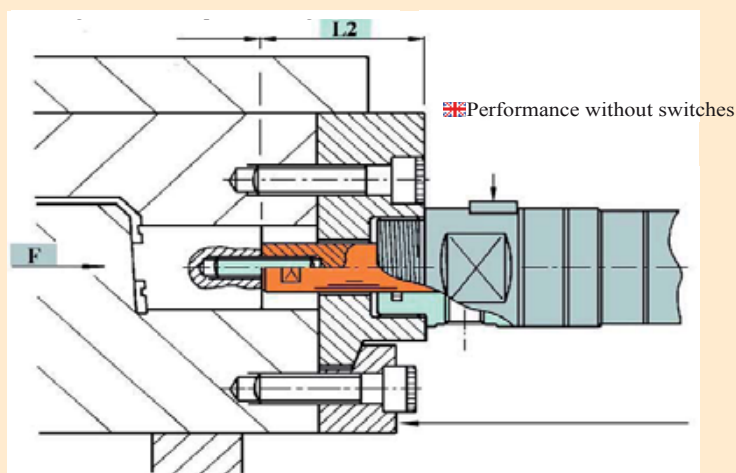
The largest possible cylinder should be selected when using in reverse.

Secondary locking pressure = 60 bar.

The unit can withstand temperatures up to 100°C.



Length L2 can be pre-loaded, see table V



### Inductive Switches. 3 lead solid state.

Brown = +24v  
 Blue = 0v  
 Black = contact A  
 Output type = PNP ( *NPN option* )  
 Contact = N.A. ( *N.C. option* )  
 Maximum switching current = 2mA  
 Supplied with 2 metres of cable

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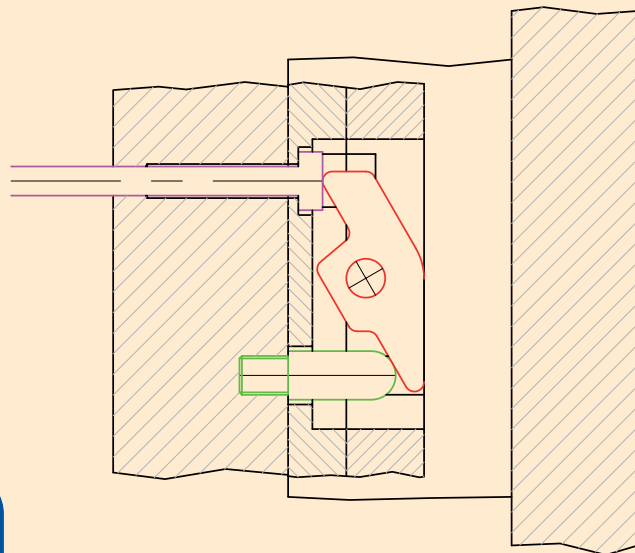
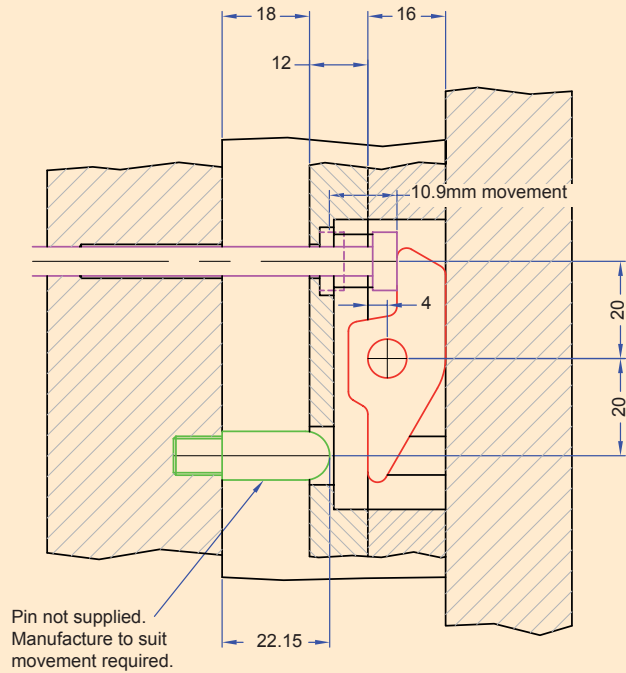
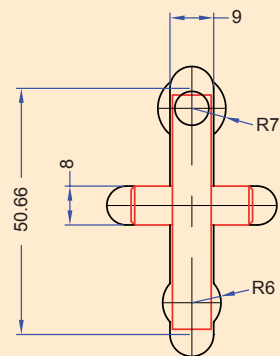
Self Locking Cylinder  
BZ  
Notes

#### Design Notes

Manufactured from 8mm thick gauge plate.

Pin has to be returned from forward position.

Example shown utilising a 6mm ejector pin.



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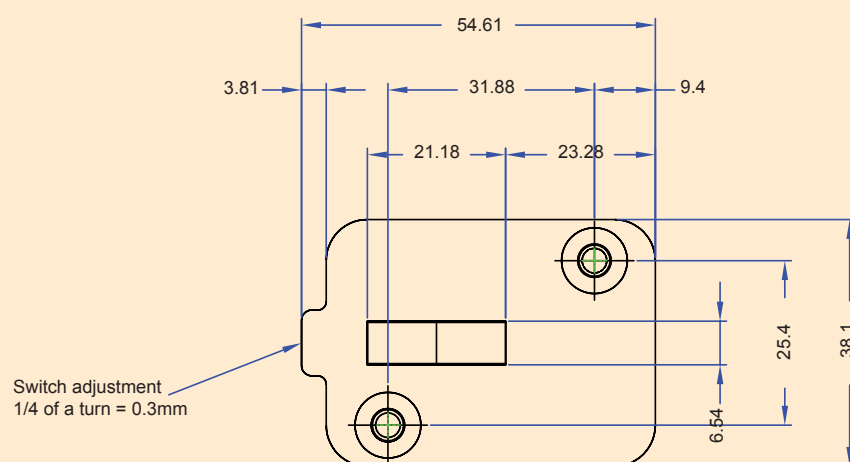
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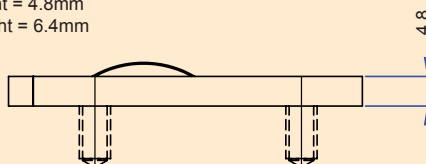
Designed to verify that the ejector plates are back.

For use with very low power mould protection control circuits.

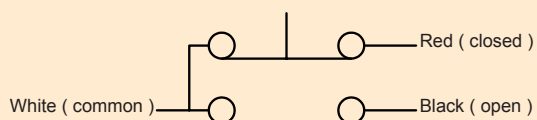
Do not use in wet locations.



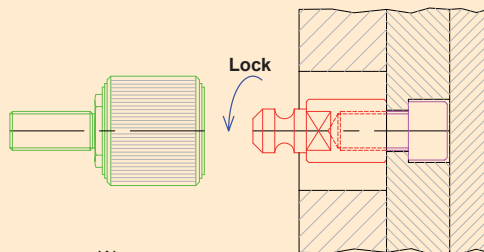
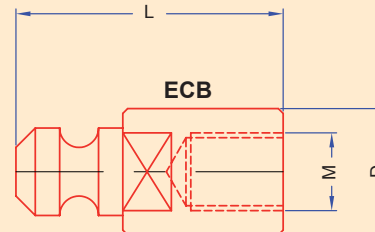
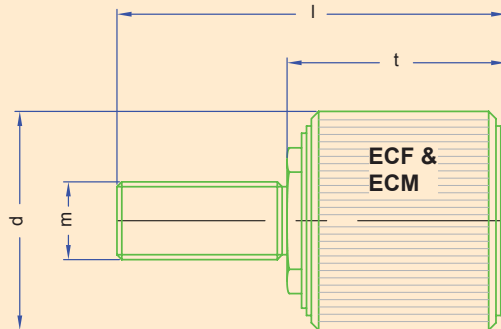
Minimum actuation height = 4.8mm  
 Maximum actuation height = 6.4mm



Switch Schematic







Note

Applies to the ECM only

✉	M	L	D
ECB-45-M08	M08	45	22
ECB-45-M10	M10		
ECB-45-M12	M12		
ECB-45-M16	M16	55	32
ECB-60-M20	M20	70	
ECB-60-M24	M24	85	
ECB-75-M24	M24	85	42
ECB-75-M30	M30	100	

## Operation

### ECF

- 1, Secure bolt in ejector set and secure coupling on to the machine ejector bar.
  - 2, Load tool in to press.
  - 3, Bring ejector bar forwards to engage coupling on to ECB.
  - 4, Twist body of coupling.
- The coupling and bolt are now fixed together.
- 5, Adjust ejection stroke.

### ECM

As ECF except ECM allows for misalignment of ejector bar / tool.

✉	m	KN	l	d	t
ECF-45-M12	M12	95	80	45	45
ECF-45-M16	M16	180		45	45
ECF-45-M20	M20	280		45	45
ECF-60-M20	M20	280	110	60	58
ECF-60-M24	M24	400		60	58
ECF-75-M24	M24	400	150	75	80
ECF-75-M30	M30	640		75	80
ECF-75-M36	M36	940		75	80

✉	m	KN	l	d	t	W
ECM-45-M12	M12	95	95	45	60	2.5
ECM-45-M16	M16	180		45	60	2.5
ECM-45-M20	M20	280		45	60	2.5
ECM-60-M20	M20	280	128	60	78	3
ECM-60-M24	M24	400		60	78	3

## WARNING

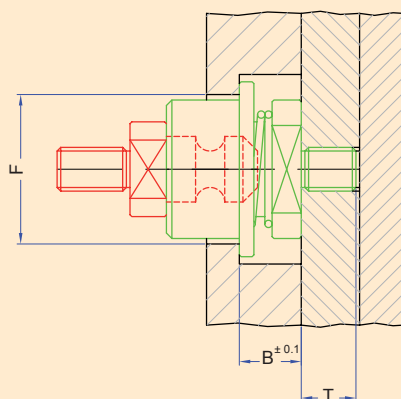
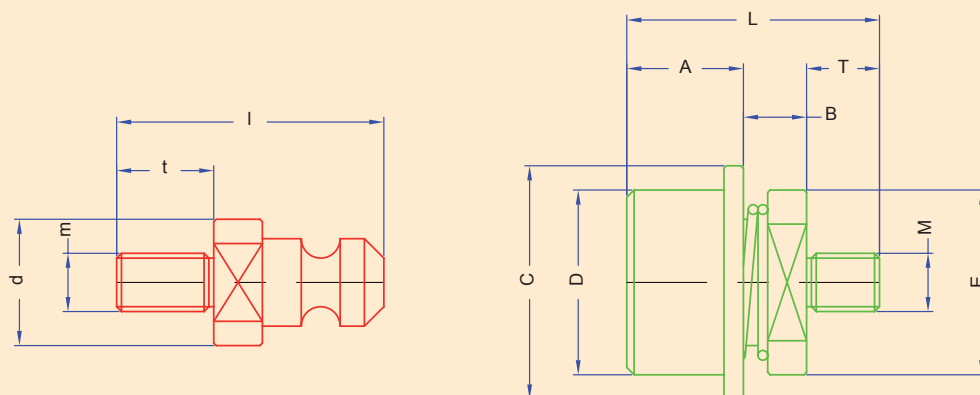
Regularly check for signs of wear or fatigue.

DMS accepts no responsibility for loss or damage caused by incorrect fitting or failure of any ECF, ECM or ECB.

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## Automatic Ejector Return AER



### WARNING

Regularly check for signs of wear or fatigue.

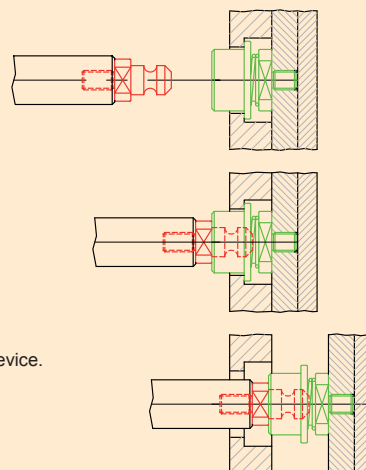
DMS accepts no responsibility for loss or damage caused by incorrect fitting or failure of any AER.

### Operation

- 1, Machine ejector bar moves forward.
- 2, AER bolt snaps in to coupling forming a positive lock.
- 3, Ejector system is pushed forwards.
- 4, Ejector system is pulled back in reverse sequence.

### Fitting and Design Notes

- 1, This unit must be used with machines fitted with hydraulic ejection and mould safety device.
- 2, All bores must be in line and the counterbore must have a flat bottom.
- 3, Max weight to be moved -  
AER-38 = 2400Kg  
AER-56 = 3200Kg



☒	m	t	d	l	M	T	L	A	B	C	D	E	F	G
AER-38-M10	M10	20	26	55	M16 x 1.5	15	52	24	13	48	38	38	40	53
AER-38-M12	M12				M16 x 1.5									
AER-38-M14	M14				M16 x 1.5									
AER-56-M16	M16	25	35	68	M18 x 1.5	18	68	33	17	65	56	52	58	70
AER-56-M18	M18				M18 x 1.5									
AER-56-M20	M20				M20 x 1.5									
AER-56-M24	M24				M20 x 1.5									
AER-56-M27	M27				M20 x 1.5									
AER-56-M30	M30				M20 x 1.5									



## TERMS AND CONDITIONS OF SALE

### 1) CUSTOMER CONDITIONS DO NOT APPLY.

All quotations are made and all orders are accepted subject to the following conditions. All other terms, conditions or warranties whatsoever are excluded from the contract or any variation thereof unless expressly accepted by a Director of the Supplier in writing.

### 2) DELIVERY.

Every effort will be made to keep delivery dates. Time for delivery is given as accurately as possible but it is not guaranteed nor is it the essence of the contract. The customer has no right to damages or to cancel the order for failure for any cause to meet any delivery time stated.

### 3) LIABILITY.

No liability can be accepted for loss caused through delay for reasons beyond our control or by an industrial dispute of any kind (whether involving our employees or not) or by any failure to obtain materials, goods or equipment from a supplier through no fault of our own in due time to observe delivery dates. The supplier's right is reserved to repudiate the contract and/or suspend delivery as long as any payment for goods previously invoiced is in arrears without liability for damage or consequential loss and without prejudice to the Suppliers right to recover all sums owing to it.

### 4) PRICES.

The prices quoted are subject to fluctuation without prior notice. Goods will be invoiced at prices ruling at the date of despatch notwithstanding any quotation or prior acceptance of order. All prices are unless otherwise stated net exclusive VAT and carriage charges. Post or Carriage and packing will be payable by the Customer in addition to the price of the goods.

### 5) EXPORT.

These goods are offered on the understanding that they will not be exported from the United Kingdom for resale.

### 6) PAYMENT.

Payment is due 30 days after the date of the invoice. No disputes arising under the contract nor delays beyond the reasonable control of the Supplier shall interfere with the prompt payment in full by the Customer.

### 7) INTEREST.

The Company reserves the right to charge interest at 2% per month on overdue accounts.

### 8) COLLECTION COSTS.

Should it be necessary for the Company to instruct a third party e.g. Solicitor or Collection Agency to collect any outstanding balance on behalf of the Company, then the following Administration Charges will be payable:

On outstanding balance up to £5,000 – 5% of the debt.

Outstanding balance over £5,000 – 3%.

These charges are in addition to any Court and Solicitors fees which may be payable.

### 9) MINIMUM ORDER VALUE. £15.00.

### 10) RETURN OF GOODS.

Goods must not be returned to us for credit without obtaining our authorisation in writing. A handling charge of 10% of the purchase price will be made and we reserve the right to charge the Customer additionally for all reasonable costs and expenses incurred by the Supplier in respect of returns.

### 11) PACKING.

Unless stated otherwise, the Customer shall be charged for packing cases, these being non-returnable. Packing shall provide adequate protection throughout normal conditions of transit of normal duration. Packing is not suitable for long-term storage. Special requirements for packing must be stated on the order and will be chargeable.

### 12) LAW.

The contract shall be governed and interpreted exclusively according to the law of England and shall be subject to the jurisdiction of the English courts only.

### 13) TITLE AND RISK.

Title to the goods shall only pass to the Customer when the Customer has paid to the Supplier all the sums due and payable by the Customer under the contract and all other prior agreements between the supplier and the Customer. If the Customer fails to pay such sums the Supplier shall be entitled to repossess the goods of which title has not passed to the Customer. The Customer hereby licenses the Supplier, its officers, employees and agents to enter the premises of the Customer for the purpose of either satisfying itself that the goods are kept separately from other goods or to repossess the goods. Until title of the goods has passed to the Customer pursuant to the terms hereof, it shall possess the goods as a bailee of the supplier on the terms of this contract. Risk shall pass to the Customer so that the Customer is responsible for all loss, damage or deterioration to the goods at the time the goods arrive at the place of delivery if the Supplier delivers the goods by its own transport or if the Supplier arranges transport of the goods. In all other circumstances risk shall pass to the Customer at the time the goods leave the premises of the Supplier.

### 14) CONSUMER PROTECTION ACT.

In circumstances where the Supplier supplies parts or products to the Customer for incorporation with, or use ancillary to, and composite products to be produced, manufactured, processed or supplied by Customers then:- The Customer shall forthwith on demand produce for inspection by the Supplier copies of all written instructions, information and warnings to be supplied by the Customer in relation to the said composite products, provided nevertheless that such inspection or right to inspect shall not in itself constitute acceptance or approval on the part of the Supplier of such instructions, information or warnings. The Customer shall indemnify, reimburse and compensate the Supplier for all losses and damages (including costs, expenses and charges for legal actions in which the Supplier may be involved) that the Supplier may incur in the event that any claim or claims are made against the Company pursuant to the Act relating to the said composite products of the Customer or products in circumstances of which part of the product supplied by the supplier was either (i) not the defective part of the said composite product or (ii) was only rendered the defective part or became a defective product by reason of instructions or warnings given by the Customer or other supplier of the said composite product or products. For the purpose of this condition the word "defective" shall be interpreted in accordance with the definition contained in the Act.

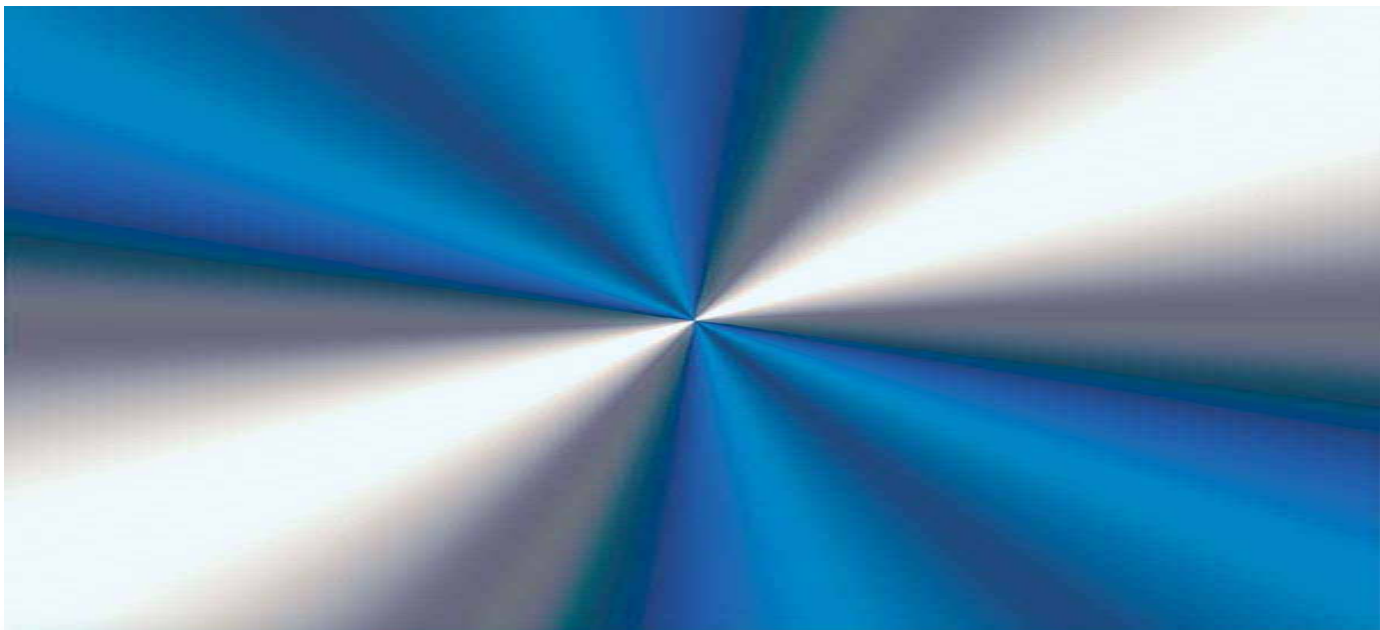
### 15) INDEMNITY FOR PERSONAL INJURY.

Save where the Supplier is shown to have failed to exercise reasonable care in the manufacture and/or supply of the goods and such failure results in the death or personal injury the Supplier shall not be liable in respect of claims arising by reason of death or personal injury. Further, under no circumstances whatsoever shall the Supplier be liable for consequential loss (including the removal or rectification work required in connection with the installation of repaired or substituted goods), loss of profits, damage to property, waste, expenditure or cost of mitigation.

### 16) HEALTH & SAFETY AT WORK.

Whilst every reasonable care is taken to ensure that our products are safe, you are requested to pay particular attention to applying the proper health and safety precautions in the use of our products.

Our complete list of Terms and Conditions are listed at [www.dms-diemould.co.uk](http://www.dms-diemould.co.uk).



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