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(54) **VACUUM FORM TOOLING**

(57) The present invention relates to a vacuum form tooling for a press lamination system or a for a vacuum lamination system, to a respective press lamination system, to a clamping frame being part of the vacuum form tooling and to a vacuum lamination method. The vacuum form tooling 10 comprising a lower mold 110, being adapted to support at least one substrate element 20 to be laminated or to provide at least one molding tool to be molded and being adapted to be negatively pressurized. The vacuum form tooling 10 further comprising an upper mold 130, being adapted to be negatively pressurized. Further, the vacuum form tooling includes a clamping frame 200, the clamping frame 200 being adapted to clamp a film portion 30 to be laminated on the at least one substrate element 20 or to be molded onto the at least one molding tool. Said clamping frame 200 being moveable from a first position to a second position, wherein in the first position, the clamping frame 200 is positioned relative to the upper mold 130 in a way that the clamped film portion 30 can be sucked at least partially into the negatively pressurized upper mold, and wherein in the second position, the clamping frame 200 is positioned relative to the lower mold 130 in a way that the clamped film portion 30 can be sucked for lamination on the at least one substrate element 20 supported by

the negatively pressurized lower mold 110, or for molding onto the at least one molding tool of the lower mold 110.

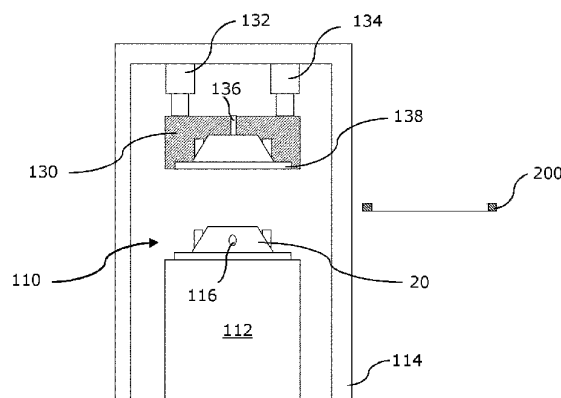


Fig. 1A