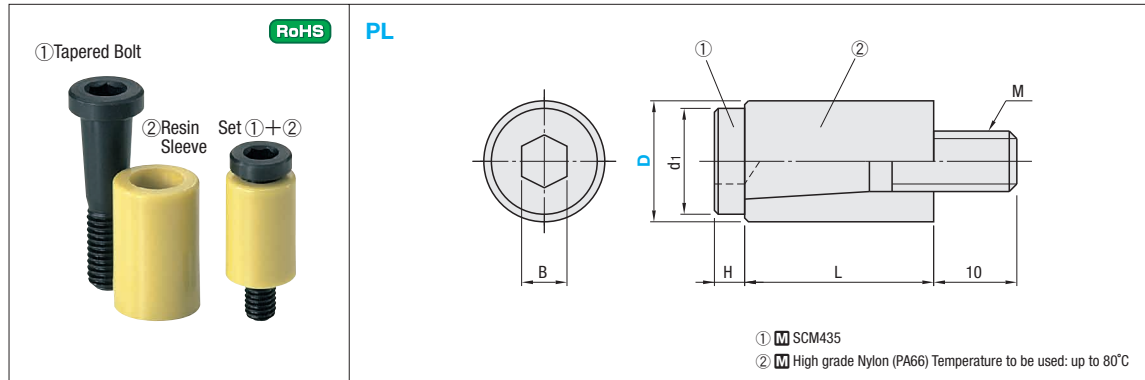


PARTING LOCKS

PARTING LOCKS

—Heat-Resistant120°C · ANTI-WEAR TYPE—

Ⓜ Non JIS material definition is listed on P.1351 - 1352



d ₁	M	B	L	H	Part Number		U/Price
					Type	D	1~19
8.5	5	4	18	3	PL (Set ①+②)	10	Quotation
11.5	6	5	20	3.2		13	
14	8	6	25	4		16	
18	10	6	30	4		20	

■ Tapered Bolts for PL Parting Lock (Component)

Part Number	U/Price	
Type	No.	1~19
PLB ① (Tapered bolt only)	10	Quotation
	13	
	16	
	20	

■ Resin Sleeves for PL Parting Lock (Component)

Part Number	U/Price	
Type	D	1~19
PLP ② (Resin sleeve only)	10	Quotation
	13	
	16	
	20	

Order

Part Number	Days to Ship	Price
①+②Set	Quotation	PL13
①Tapered bolt only		PLB13
②Resin sleeve only		PLP13

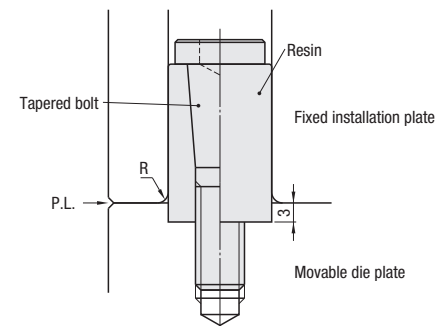
Price

■ Features

- Allows adjustment of friction between the base plate and resin sleeve by tightening/loosening the tapered bolt.
- Made of a high grade nylon (PA66), this parting lock features excellent corrosion and heat resistance properties. The resin sleeve by itself has heat resistant temperature of 150°C. But use it at 80°C or less because the durability will reduce due to tightening stress by the tapered bolt in the practically continuous use.

■ How to Mount

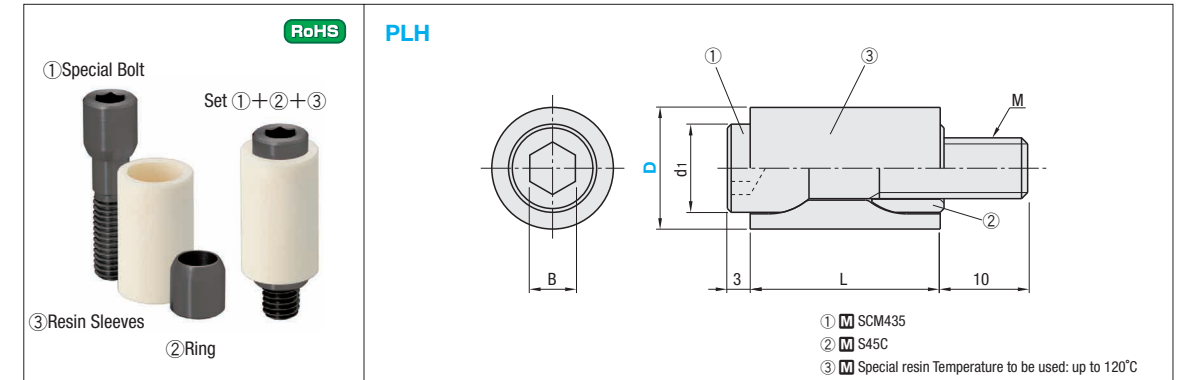
- Embed the resin sleeve about 3mm in the movable side die plate.
- Create a hole on the fixed side die plate and finish it so that its internal surface roughness finishes within the range between $\frac{16}{\sqrt{R}} \sim \frac{0.2}{\sqrt{R}}$.
- Also make sure to R-chamfer the inlet edge-the parting lock's durability becomes lower with a C-chamfered edge.
- As to the hole's dimensional tolerance, aim at creating a H7 reamer hole for PL10, and a H7 reamer hole +0.1 for PL13/16/20.
- These R-chamfering and surface polishing processes can be omitted by using a PLBS bushing that is specially designed for use with this parting lock.
- The required tension can be obtained by adjusting (tightening/loosening)the lock's tapered bolt.
- Do not lubricate this parting lock. Lubrication reduces its friction force and nullifies its function.



● Typical usage of parting locks

Part Number	No. of parting locks	Mold weight
PL10	4 pcs.	100kg or less
PL13	4 pcs.	250kg or less
PL16	4 pcs.	250kg or more
PL20	4 pcs.	300kg or more

Ⓜ Use the above values as reference only. Applicable mold weight and suitable number of parting locks depend on the precision and finishing of a counterpart hole, as well as the level of bolt tightening.



d ₁	M	B	L	Part Number		U/Price
				Type	D	1~19
7.6	5	4	17	PLH (Set ①+②+③)	10	Quotation
9.6	6	5	20		13	
11.6	8	6	25		16	
14.6	10	6	30		20	

■ ①Special Bolt+②Ring for PLH Parting Lock

Part Number	U/Price	
Type	No.	1~19
PLHB ①+② (Special Bolt + Ring)	10	Quotation
	13	
	16	
	20	

■ Resin Sleeves for PLH Parting Lock (Component)

Part Number	U/Price	
Type	D	1~19
PLHP ③ (Resin Sleeves only)	10	Quotation
	13	
	16	
	20	

Order

Part Number	Days to Ship	Price
①+②+③Set	Quotation	PLH13
①+②Special Bolt+Ring		PLHB13
③Resin Sleeves only		PLHP13

Price

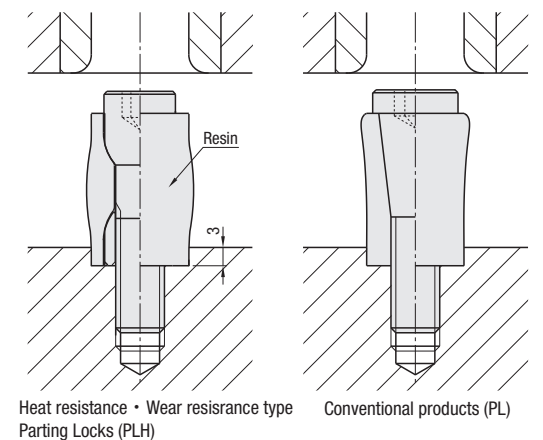
■ Features

- Heat resistance** ...Compared with conventional products (PL) whose resin sleeves have heatproof temperature of 80°C, PLH can be used under temperature up to 120°C.
- Wear resistance** ...Because even force is applied in vertical direction through special bolt and ring, the center of resin sleeve is smoothly expanded, thus reducing the generation of abrasion powder.
- Interchangeability**...PLH can be replaced with molds for which conventional products are used.
- Typical usage** ...The number of parting locks and mold weight for each size are equal to those of conventional products.

■ How to mount Same as conventional products. (Refer to P.1017 for detail.)

■ Notes

- PLH is of 3-piece structure. Mount PLH so that the special bolt protrudes from the resin sleeve as shown in the figure. (Pin gate mark is on the bottom surface.)
- In terms of shape characteristics, the bolt tightening torque is lower than that of conventional products, so keep the once tightening amount within 1/4 turn during operation.



Heat resistance · Wear resistance type Parting Locks (PLH) Conventional products (PL)