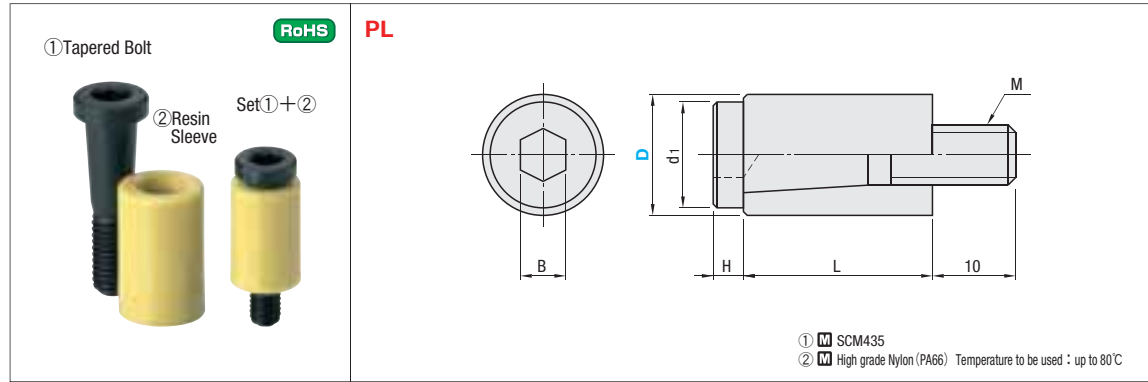


The volume discount rate is also applicable to alteration cost.
All price & lead time are to be quoted.

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d1	M	B	L	H	Catalog No.		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)

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

Resin Sleeves for PL Parting Lock (Component)

Catalog No.	U/Price	
Type	D	1~19
PLP (2) Resin sleeve only	10	Quotation
	13	
	16	
	20	

Order

Catalog No.

①+②Set PL13
①Tapered bolt only PLB13
②Resin sleeve only PLP13

Delivery

PL (PLB · PLP)
SGP Stock
For area out of Singapore please refer to P.i.

Quantity discount rate

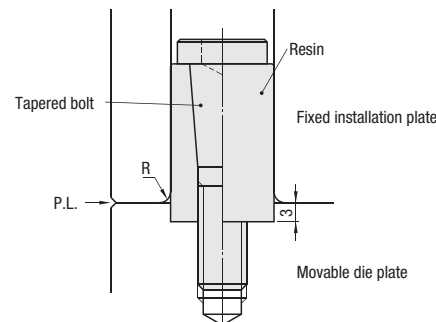
Quantity	1~19	20~29	30~49	50~100
Rate	—	5%	10%	15%

- ### 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 $\sqrt{1.6} \sim \sqrt{0.2}$.

- 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.

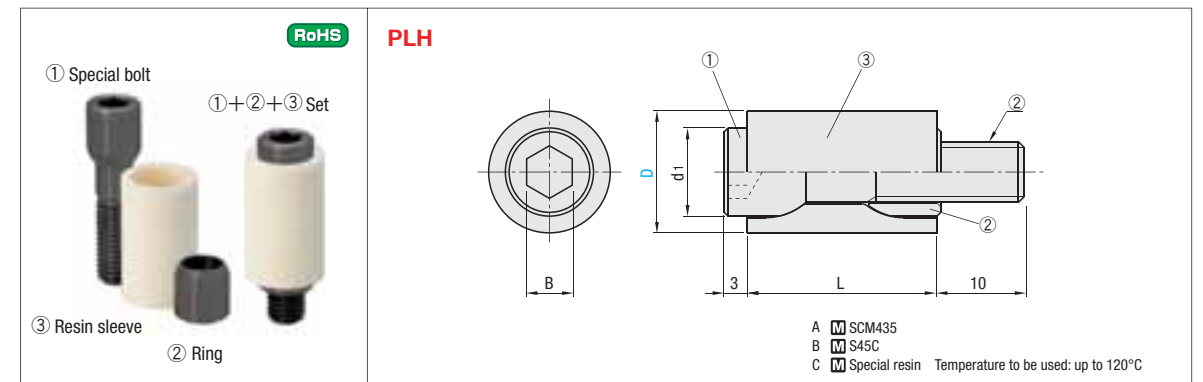
Do not lubricate this parting lock. Lubrication reduces its friction force and nullifies its function.



Typical usage of parting locks

Catalog No.	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.



d1	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	

(1) Special Bolt + (2) Ring 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 sleeve only	10	Quotation
	13	
	16	
	20	

Order Example

Part Number

①+②+③ Set PLH13
①+② Special bolt + Ring PLHB13
③ Resin sleeve only PLHP13

SGP Stock
3 Days

Quantity discount rate

Quantity	1~19	20~29	30~49	50~100
Rate	—	5%	10%	15%

- ### 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.
- ### 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.

