

# PARTING LOCK SETS

—MOLD OPENING • MOLD CLOSING CONTROL TYPE—

# HOW TO START / MOUNT PARTING LOCK SET

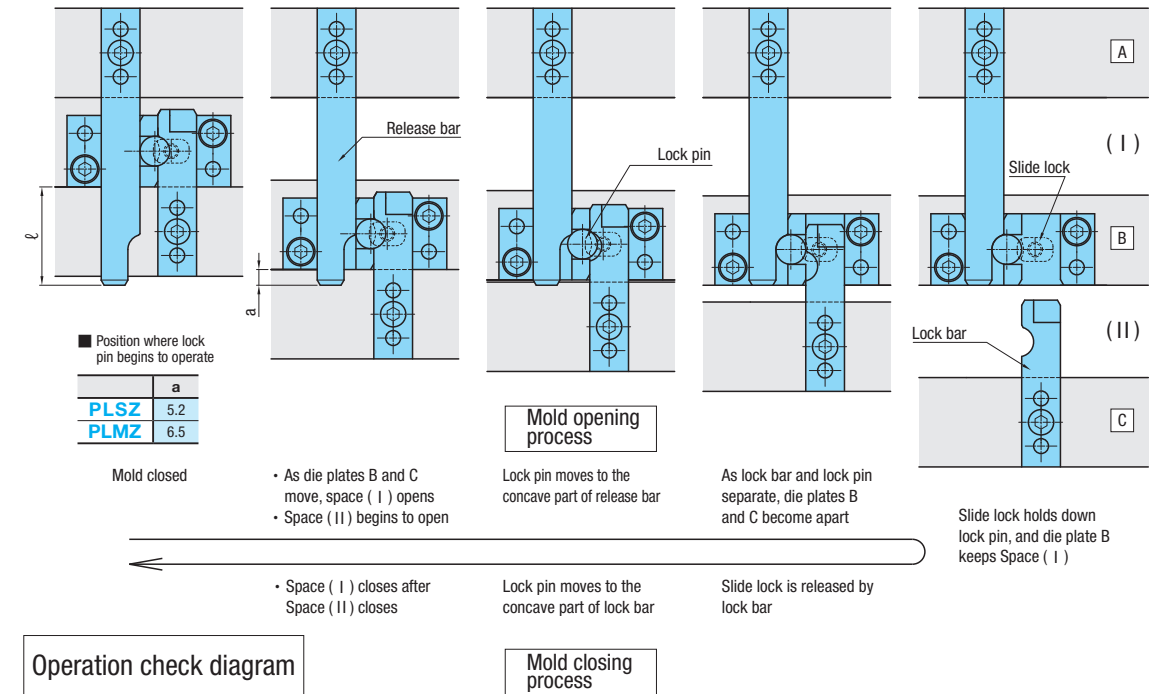
Ⓜ Non JIS material definition is listed on P.1351 - 1352

**PLSZ**  
**PLMZ**

| No. | Name                  | M                | H        |
|-----|-----------------------|------------------|----------|
| ①   | Cam holder            |                  | 50~55HRC |
| ②   | Lock bar              | Alloy tool steel | 58HRC~   |
| ③   | Lock pin              |                  | 58~60HRC |
| ④   | Slide Lock            |                  | 58~60HRC |
| ⑤   | Spring                | SUS631           |          |
| ⑥   | Release bar           | Alloy tool steel | 58HRC~   |
| ⑦   | Spacer                | S45C             |          |
| ⑧   | Backing plate         | Alloy tool steel | 50HRC~   |
| ⑨   | Socket head cap screw | SCM435           | 38~43HRC |
| ⑩   | Dowel pin             | SUJ2             | 45~50HRC |

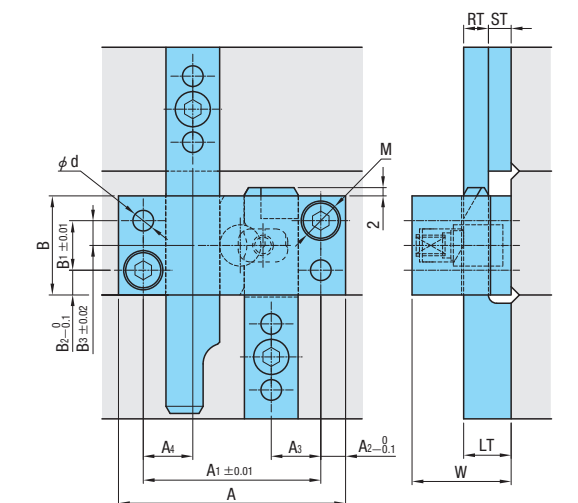
## Characteristics

- Mold closing control (closing PL surface after closing the stripper plate, etc.), which was not possible with the conventional parting lock set (PLS and PLSW), is now possible.
- The lock bar is long, so it can also be used for thrusting out the stripper plate.
- Enables accurate mold opening and closing movement with no reaction.



## Mounting

- Mount 2 or more parting lock sets at symmetrical positions of the mold.  
 PLSZ : 10KN or less for 1 mold/when mounting 2 sets  
 PLMZ : 20KN or less for 1 mold/when mounting 2 sets
- Form bolt holes and reamer holes using NC machining, and install the cam holder parallel to the PL face.
- Cut the lock bar to the necessary length, form the bolt holes and reamer pilot holes, tighten the cam lock with the bolts while pulling it, carry out position adjustment by **matching with the actual part**, form the dowel holes, and fix the cam lock.
- Cut the release bar to the necessary length, and install it perpendicularly to the mold. Make the overhang length  $\ell$  of each release bar the same in order to equalize the release points. (Maintain proper alignment of the release points to avoid uneven contact and resultant breakage.)



| Part Number | A  | A1 | A2 | A3 | A4 | B  | B1 | B2 | B3 | W    | LT   | RT | ST  | d | M |
|-------------|----|----|----|----|----|----|----|----|----|------|------|----|-----|---|---|
| PLSZ        | 55 | 43 | 6  | 12 | 12 | 24 | 12 | 6  | 6  | 24   | 11.5 | 6  | 5.5 | 5 | 5 |
| PLMZ        | 67 | 53 | 7  | 15 | 14 | 32 | 16 | 8  | 8  | 32.5 | 16.5 | 10 | 6.5 | 6 | 6 |

| Part number | ① Cam holder ⑧ Backing plate |    |    |    |    |    |   |   |      |   | ② Lock bar |     |    |     |     |     |      |     |
|-------------|------------------------------|----|----|----|----|----|---|---|------|---|------------|-----|----|-----|-----|-----|------|-----|
|             | A                            | A1 | A2 | B  | B1 | B2 | d | M | W    | T | LW         | LW1 | LR | LL  | LL1 | LL2 | LT   | LT1 |
| PLSZ        | 55                           | 43 | 6  | 24 | 12 | 6  | 5 | 5 | 24   | 5 | 13         | 4   | 5  | 100 | 14  | 28  | 11.5 | 6   |
| PLMZ        | 67                           | 53 | 7  | 32 | 16 | 8  | 6 | 6 | 32.5 | 6 | 18         | 5   | 6  | 150 | 18  | 36  | 16.5 | 10  |

| ③ Lock pin |    | ④ Slide lock |    | ⑤ Spring |         | ⑥ Release bar |     |    |     | ⑦ Spacer |    |    | Accessories |     |        |             |
|------------|----|--------------|----|----------|---------|---------------|-----|----|-----|----------|----|----|-------------|-----|--------|-------------|
| P          | PL | SA           | SB | SW       |         | RW            | RW1 | RR | RL  | RL1      | RT | SW | SL          | ST  | ⑨ Bolt | ⑩ Dowel pin |
| 10         | 12 | 12           | 8  | 10       | WLH5-15 | 13            | 4   | 5  | 150 | 12       | 6  | 13 | 40          | 5.5 | CB5-25 | MSTM5-30    |
| 12         | 17 | 16           | 10 | 13       | WLH6-20 | 16            | 5   | 6  | 200 | 16       | 10 | 16 | 50          | 6.6 | CB6-35 | MSTM6-35    |

## Set

| Components | Part number  | U/Price 1~9 Set |
|------------|--------------|-----------------|
| ①~⑩ Set    | PLSZ<br>PLMZ | Quotation       |

## Components (Single Items)

| Components    | Part Number   | U/Price 1~9 |
|---------------|---------------|-------------|
| ② Lock bar    | PRKZ<br>PRKZM | Quotation   |
| ④ Slide lock  | PRSZ<br>PRSZM |             |
| ⑥ Release bar | PRLZ<br>PRLZM |             |



Order

Part Number  
PLSZ



Days to Ship

Quotation



Price

Quotation

Mold Opening Controllers