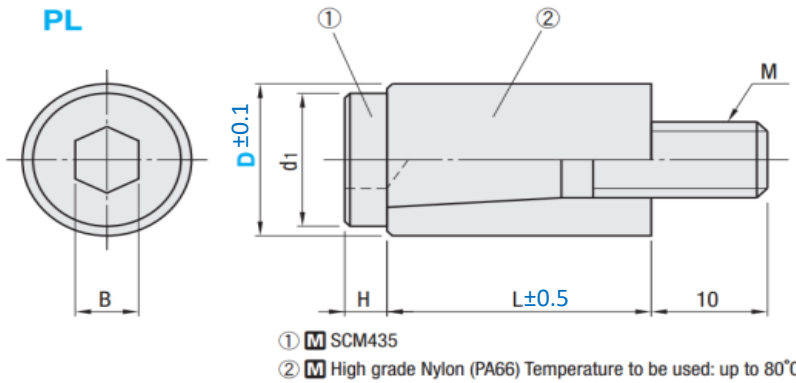




d ₁	M	B	L	H	Part Number	
					Type	D
8.5	5	4	18	3	PL (Set ①+②)	10
11.5	6	5	20	3.2		13
14	8	6	25	4		16
18	10	6	30	4		20

■ Tapered Bolts for PL Parting Lock (Component)

Part Number	
Type	No.
PLB (① Tapered bolt only)	10
	13
	16
	20



Chu kỳ thay thế tốt nhất
sau: 250,000ea

Tapered bolt only P0
 Quy cách mua lẻ ốc lục giác
 → Mã Order : PLB16



Resin sleeve only P0
 Quy cách mua lẻ vỏ nhựa
 → Mã Order : PLP16

■ Resin Sleeves for PL Parting Lock (Component)

Part Number	
Type	D
PLP (② Resin sleeve only)	10
	13
	16
	20



Chu kỳ thay thế tốt nhất
sau: 50,000ea

■ 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.



Part Number

1+2 Set

1 Tapered bolt only

2 Resin sleeve only

PL13

PLB13

PLP13

