GUIDE FOR ROLLING GATE CUT UNITS

ROLLING GATE CUT UNITS

RoHS

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

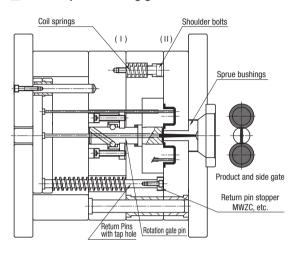
■What is rolling gate cut unit?

This unit is designed to rotate the rotary gate pin to cut the side gate by using the mold opening movement.

■Characteristics

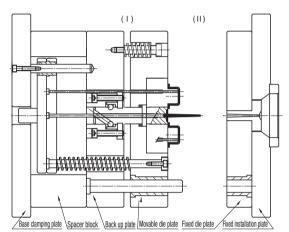
- · Since gate section of the side gate is larger than that of pin gate and oblique gate, it can effectively apply holding pressure. Therefore, traction prevention, dimensional stability and appearance transcription are improved.
- · Labor cost can be significantly reduced by automation of gate cut operation.
- · Gate cut sections are uniform to avoid unstable hand cutting. In addition, generation of dust during gate cutting can be repressed.

■How to operate rolling gate cut unit



1) In forming

Resin flows through runner and side gate engraved on the rotation gate from sprue to form the product.



3) Mold opened

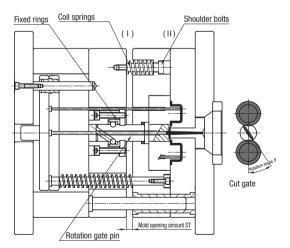
Ejector leader P&B

RA

Operation of PL surface (I) is limited by the shoulder bolts and the PL surface (II) is opened.

(11)

(1)

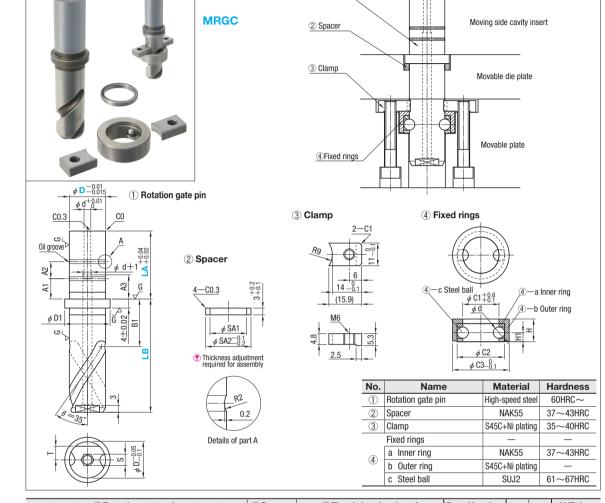


2) In gate cutting

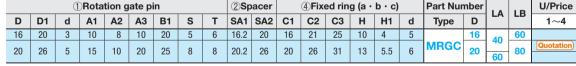
- The PL surface (|) is opened by opening of the moving side and coil spring. • By rotating (θ degree) the gate pin with steel ball in the fixed ring and pin's spiral groove using mold opening (ST) of the PL surface (1), it cuts the side
- 4) When product is ejected Ejector plate is ejected and the product, runner and sprue are

■ Notes

- 1) This is a unit to cut the gate by rotating gate pins by means of mold opening of (|) before the product PL surface (||). Since this is a special structure, be sure to use the following parts:
- Coil spring • • • Use coil springs and parting lock to ensure that the PL surface (I) is opened first. • Shoulder bolt • • • • • Used for the product PL surface (II) to open.
- Return pin stopper • Interlocks and operates the moving side plate and ejector plate when the PL(|) is opened. Without interlocking, the product and ejector pin tip are separated by the opening
 - The product may be whitened when the ejector rod contacts with the product again.
- · Ejector leader pin · bushing · · · · Necessary to stabilize the rotation gate cut unit operations



1 Rotation gate pin





LA









Alteration	Code	Spec.	1Code
LAC	LAC	$ \begin{array}{ c c c c } LA \ dimension \ alteration \\ \hline D \ LA \ 0.01mm \ increments \\ \hline 16 \ 40 \ \ 25 \leq LAC < 40 \\ \hline 20 \ \ 40 \ \ 35 \leq LAC < 40 \\ \hline 60 \ \ 40 < LAC < 60 \\ \hline There is not change to A1, A2, and A3. \\ \end{array} $	Quotation