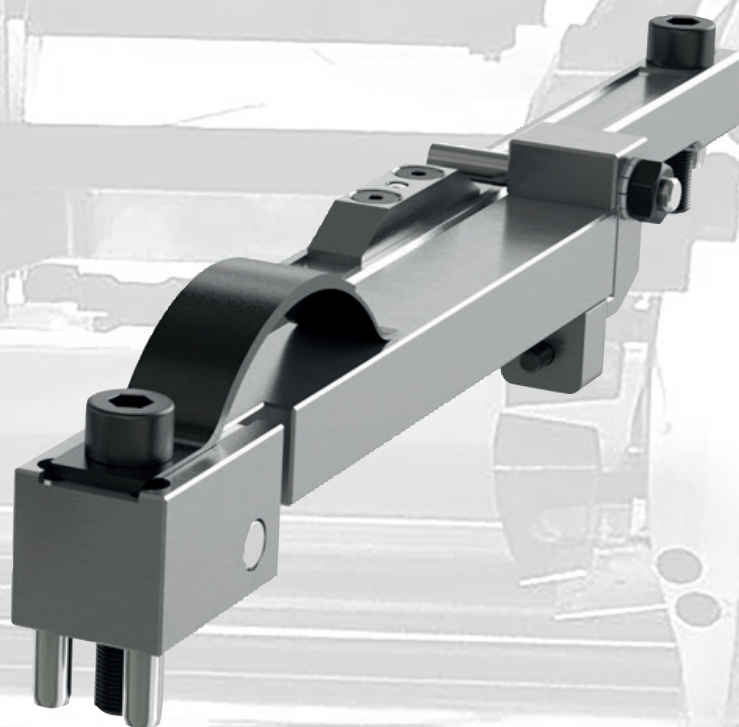


Z5 LATCH LOCKS OPERATING INSTRUCTION



STRACK®

NORMALIEN

Operating instruction english – Latch locks Z5-0, Z5-1 and Z5-2

1. Selection

The determining factors for the selection of the latch locks are not only the mould size but also the anticipated stripping forces, the weight of the stripper plate and the opening and closing speeds.

Recommended sizes, not binding

| Type | Stroke min. (mm) | Tensile force max. |
|------|------------------|--------------------|
| Z5-0 | 7 | 6 kN |
| Z5-1 | 10 | 10 kN |
| Z5-2 | 14 | 20 kN |

2. Principle of operation

The latch locks the mould plate in the selected mould half and, when the desired opening stroke (S1) is reached, is released by the cam plate. The cam plate is adjustable within the housing and determines the point at which the mould is unlocked. The mould moves onwards in the parting plane (S2). When the injection mould has closed again, the leaf springs press the latch lever back into its original position.

Notes on mounting and assembling

The length of the latch lever and the side track is a predetermined dimension. If this dimension does not correspond to the intended design, it must be shortened accordingly (see fig. 3):

Z5-0 = limit dimension for X1 – 75 mm, X2 – 80 mm

Z5-1 = limit dimension for X1 – 90 mm, X2 – 80 mm

Z5-2 = limit dimension for X1 – 150 mm, X2 – 130 mm

The bearing support (2) and wear plate (15) and, only for Z5-0, the side track (3) are to be incorporated into the mould plates by the dimensions shown in the catalogue. Ensure adequate clearance for the latch lever.

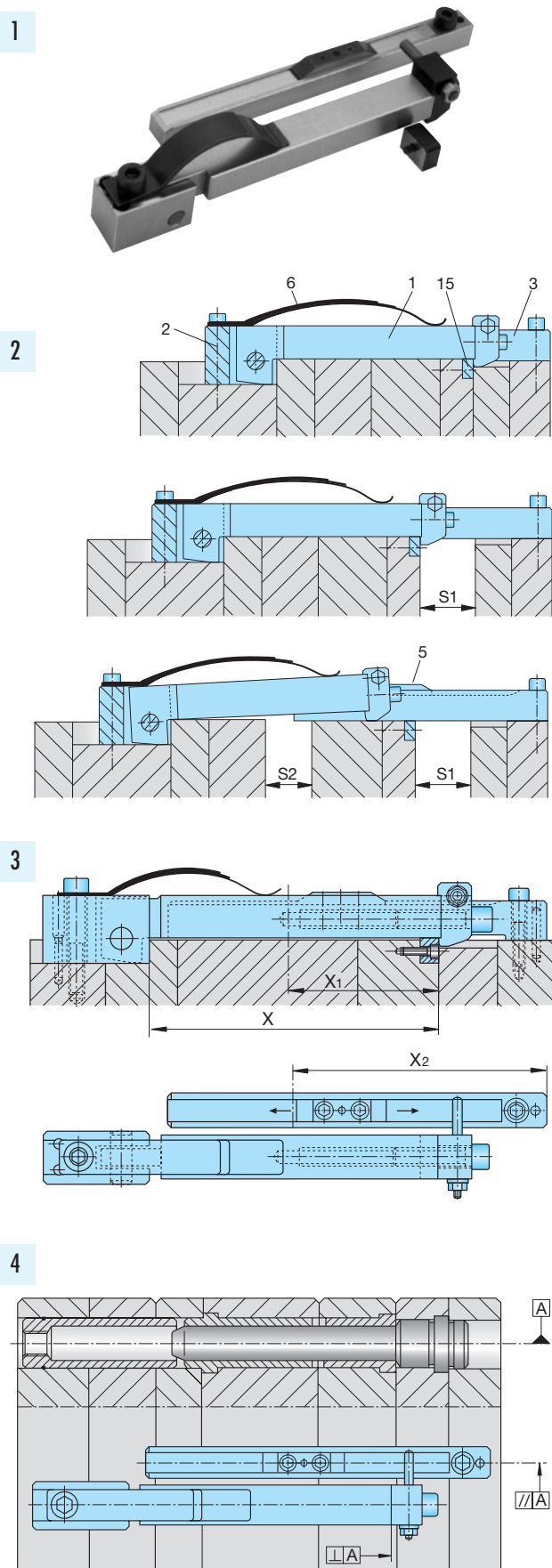
After determining the desired mould opening stroke (S1), bolt down the cam plate (5) and, after fine adjustment of all the latch locks, secure with pins (see fig. 2+3).



- If the latch lever (1) is shortened by more than $X/2$, one of the shorter leaf springs (6) should be removed.
- Mount the latch locks symmetrically, parallel and at right angles to the mould guide (see fig. 4).
- Take care to ensure uniform adjustment of all the latch locks and uniform drawing of the moving plate.
- Perform mounting and adjustment on the assembled mould.
- Use spring washers to secure the mounting bolts.

3. Maintenance

All working parts of the latch locks must be greased at regular intervals and the springs checked for correct function. Check the tightness of the mounting bolts at regular intervals.



Operating instruction english – Latch locks Z5-31 and Z5-32

Recommended sizes, not binding

| Type | Stroke min. (mm) | Tensile force max. |
|-------|------------------|--------------------|
| Z5-31 | 9 | 6 kN |
| Z5-32 | 9 | 6 kN |

Principle of operation

The latch locks the mould plate in the selected mould half and, when the desired opening stroke (S1) is reached, is released by the cam plate. The cam plate is adjustable within the housing and determines the point at which the mould is unlocked. The mould moves onwards in the parting plane. When the injection mould has closed, the pressure spring is pressing the latch lever back into its original position.

Notes on mounting and assembling

The length of the latch lever and the side track is a predetermined dimension. If this dimension does not correspond to the intended design, it must be shortened accordingly (see fig. 3):

Z5-31 (-32) = limit dimension for X1 – 52 mm, X2 – 90 mm

The bearing support (2) and wear plate (15) and the side track (3) are to be incorporated into the mould plates by the dimensions shown in the catalogue (see fig. 2). Ensure adequate clearance for the latch lever.

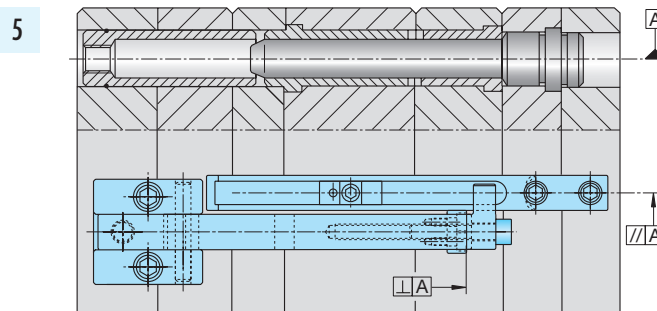
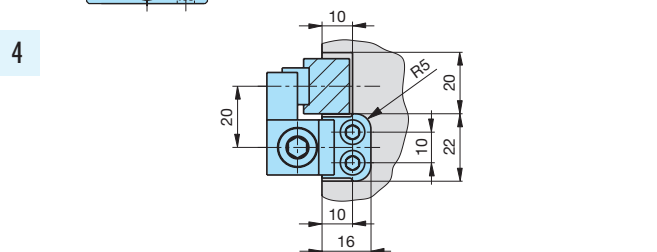
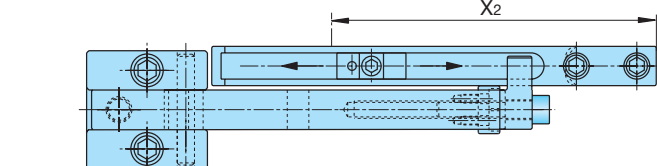
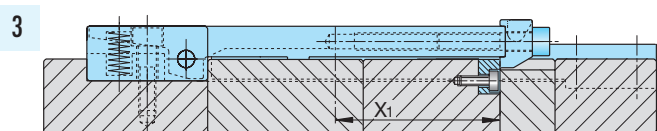
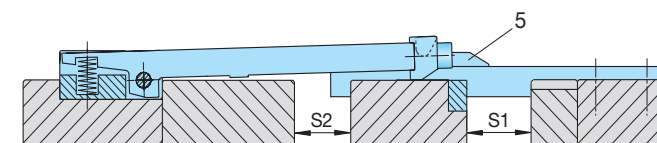
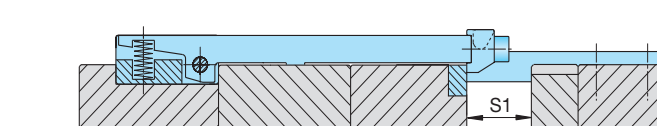
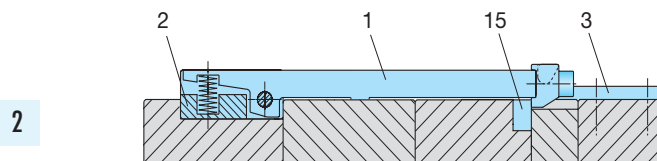
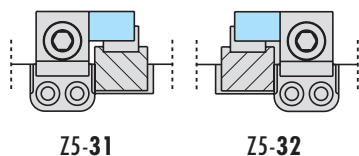
After determining the desired mould opening stroke (S1), bolt down the cam plate (5) and, after fine adjustment of all the latch locks, secure with pins (see figs. 3, 4 + 5).



- Mount the latch locks symmetrically, parallel and at right angles to the mould guide (see fig. 5).
- Take care to ensure uniform adjustment of all the latch locks and uniform drawing of the moving plate.
- Perform mounting and adjustment on the assembled mould.
- Use spring washers to secure the mounting bolts.
- If the latch lever is shortened, the spring force has to be examined.

Maintenance

All working parts of the latch locks must be greased at regular intervals and the springs checked for correct function. Check the tightness of the mounting bolts at regular intervals.



6

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