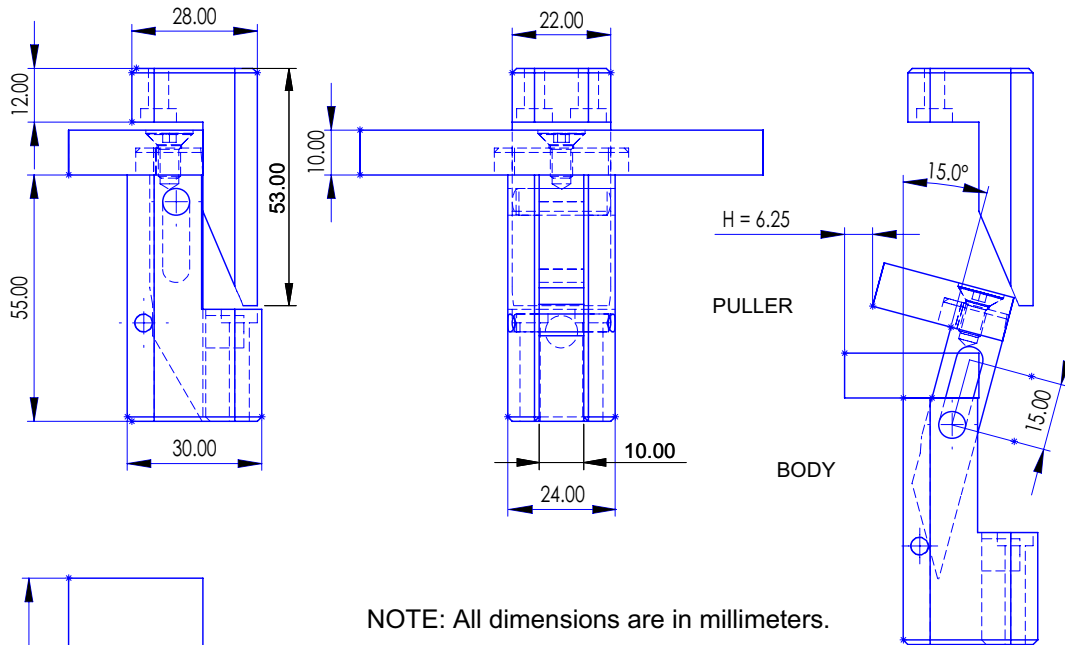


QUICK STRIP QS2430015
UNIT 24 X 30 X 15 mm STROKE
INSTALLATION INSTRUCTIONS



SHCS M4x0.7x16Lg
 Recommended torque:8 Nm
 (70 in lbs)

FINGER

SCS M5x0.8x10Lg
 Recommended
 torque :16 Nm
 (140 in lbs)

SPOON

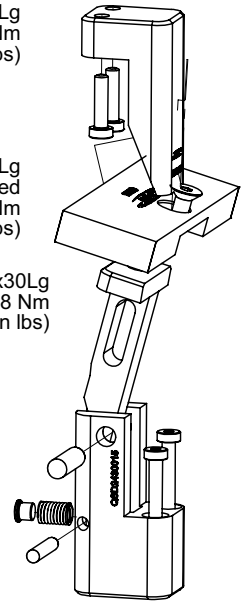
SHCS M4x0.7x30Lg
 Recommended torque:8 Nm
 (70 in lbs)

Dowel Pin
 6.00 DIA 22 mm Lg

Wear Stop
 Catalog #QSE24

Spring
 Catalog #QSF24

Dowel Pin
 4.00 DIA 22 mm Lg



NOTE: All dimensions are in millimeters.

GENERAL MOUNTING RECOMMENDATIONS

The Quick Strip Body, Puller and Spoon are mounted either on the stationary half of the mold (Fig 1) or on the moving half (Fig 2).

The Finger will be mounted on the side of the mold opposing the Puller and Spoon assembly.

The Quick Strip assemblies are installed on the extremities of the molded part cavity and the spoons form part of the molded part surface. Spoons are to be machined in accordance with the molded part features.

MACHINING RECOMMENDATIONS

Final spoon dimensions (and spoon pocket work) shown assuming minimal alterations made to the spoon. Customer is expected to modify the Spoon to meet the molded part requirements.

Customer is responsible to modify the Spoon and Spoon Pocket dimensions to suit.

Final spoon dimensions : "X", "Y", "R" and angle "α".

Recommended tolerances are +0/-0.01mm and +0/-0.1° (6').

Final pocket dimensions will be nominal values corresponding to "X", "Y", "R pocket" and "α" +0.01/-0 mm and +0.1°/-0 (6').

Recommended minimum "α" angle is 5°. Recommended minimum Spoon Radius "R" 2.00 mm.

Pocket radius ("R pocket") should be 1.00 mm smaller than spoon radius ("R").

Recommended surface finishing for Spoon : 3.2µm (125µin).

Recommended surface finishing for Mounting Pockets: 3.2µm (125µin).

WARNING

FAILURE TO COMPLY COULD RESULT IN SERIOUS INJURY

The Quick Strip is intended to be used to be used with molding plastic, and in minimum sets of two assemblies per molded part. The assemblies called on this installation instruction are not to be used with Die Casting. The Quick Strip assembly is intended to cross the parting line and molding surface of the mold, and is intended to be actuated by the opening and closing motion of the mold and molding machine platens. Machine guard doors must be present and interlocked with the motion of the molding machine platens. Failure to comply could cause serious injury to personnel.

Care must be taken when installing, adjusting or servicing the Quick Strip assembly, as improper handling or use may result in equipment damage and possible injury to personnel.

To avoid damage, misuse or personal injury during installation, adjustment or servicing of the Quick Strip assembly:

1. Do not expose the Quick Strip to temperatures in excess of 700°F (371°C) at any time.
2. Lubricant is not recommended with the Quick Strip assembly.
3. Ensure that molded plastic part is removed from both the Quick Strip assembly and the mold prior to attempting to close the mold.
4. When servicing the Quick Strip assembly, wear protective gloves, protective clothing, and wear protective goggles or a protective face shield.
5. Ensure that recommended torque setting is used when fastening the Spoon to the Puller.
6. Do not attempt to close the mold if the Quick Strip assembly appears damaged.

**QUICK STRIP QS2430015
UNIT 24 X 30 X 15 mm STROKE
INSTALATION INSTRUCTIONS**

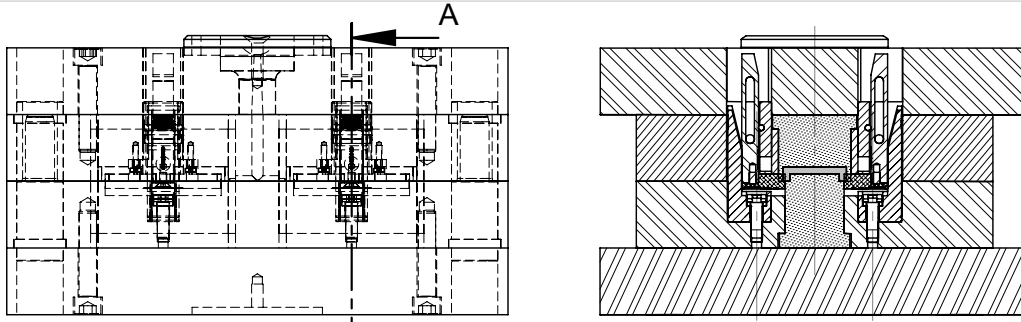


FIG #1
Quick Strip Body, Puller and Spoon are mounted on the stationary ("A") half of the mold
Finger is mounted on "B" half of the mold

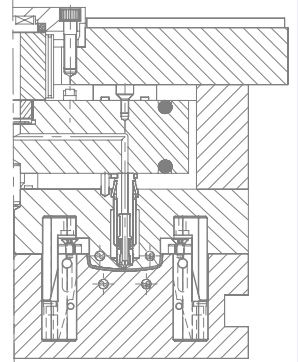
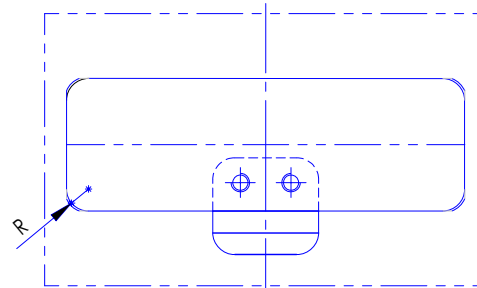
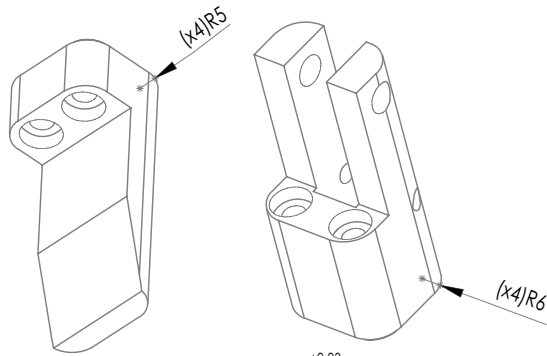
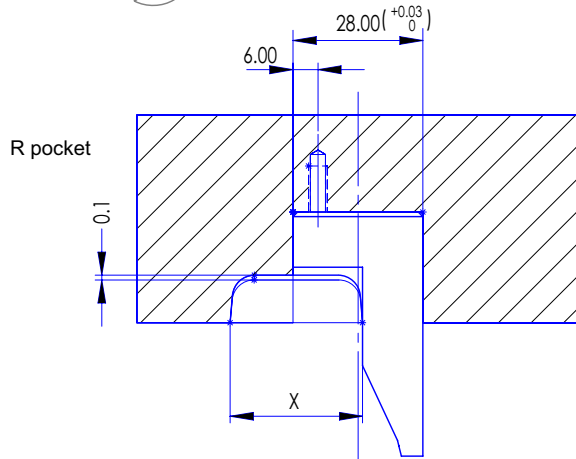


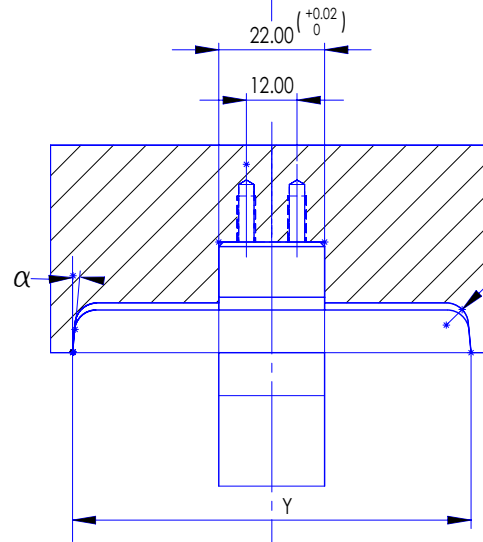
FIG #2
Quick Strip Body, Puller and Spoon are mounted on the moving ("B") half of the mold.
Finger is mounted on "A" side of the mold.



R pocket



R pocket



M10x1.5 x 10 deep
(4 places)

R pocket

