**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.

2) **In gate cutting**
- The PL surface (I) is opened by opening of the moving side and coil spring.
- By rotating (θ), the gate pin with steel ball in the fixed ring and pin’s spiral groove using mold opening (ST) of the PL surface (II) is opened.

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

4) **When product is ejected**
Ejector plate is ejected and the product, runner and sprue are removed.

**Notes**
- Do not use Z pin. Otherwise operation of rotation gate cut pin is interrupted.
- It is necessary to stabilize the rotation gate cut unit operations.

**Characteristics**

- Resin flows through runner and side gate engraved on the rotation gate pin, and then runs to the gate section. When the rotation gate pin is rotated, the gate section is cut and the product is ejected.
- Non-JIS material definition is listed on P.1351 - 1352.