

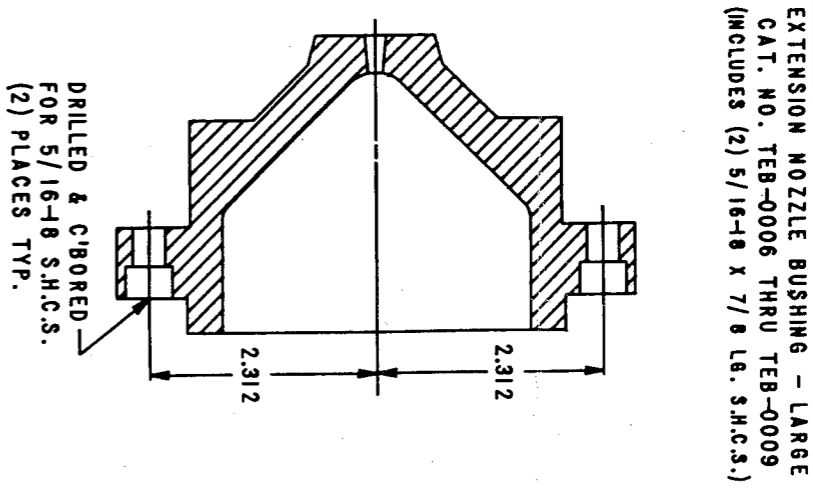
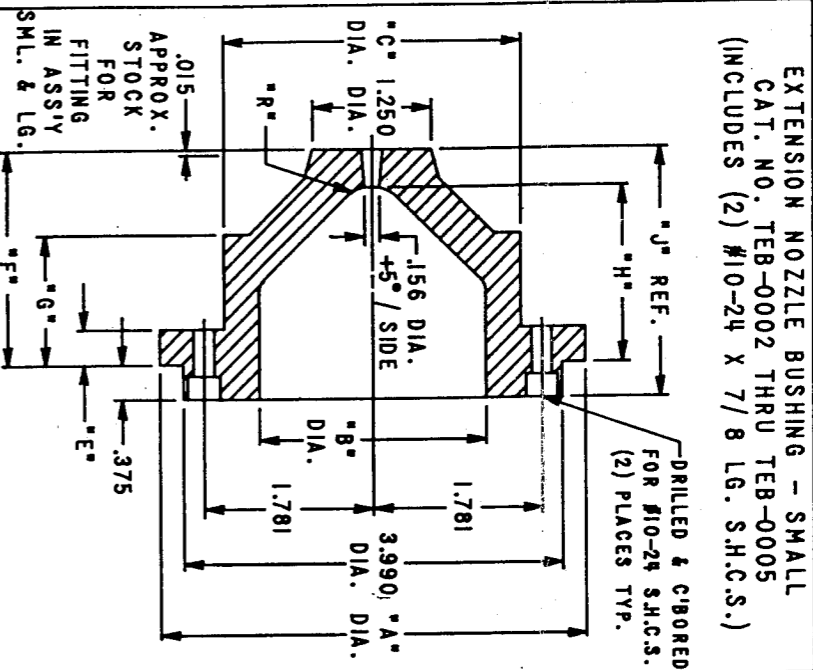
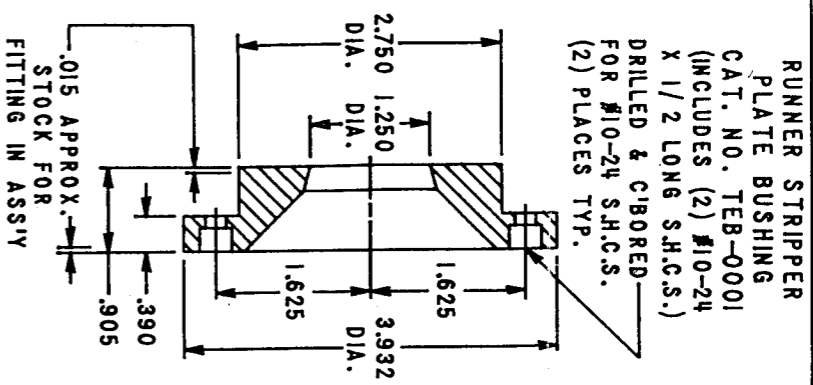
D-M-E

INSTALLATION DATA

FOR: THREE PLATE EXTENSION BUSHINGS

Please read carefully before installing components

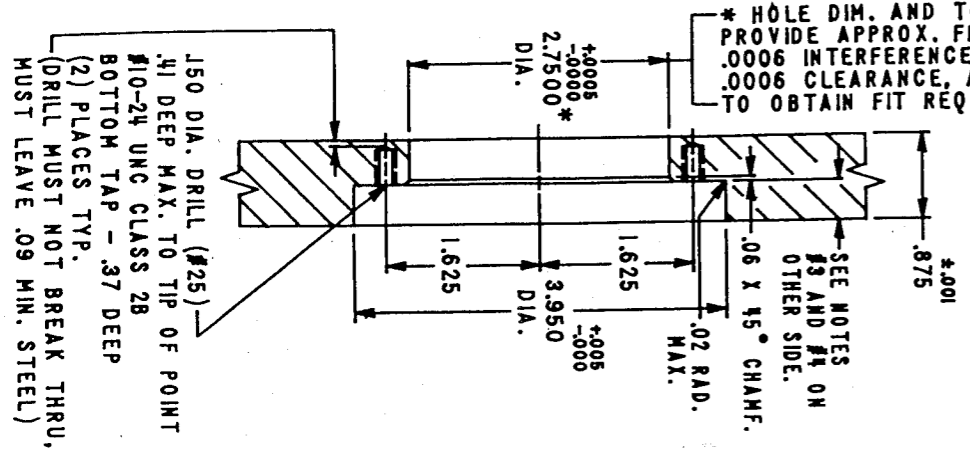
THE RUNNER STRIPPER PLATE BUSHING CATALOG NUMBER TEB-0001 IS USED WITH ALL SIZES OF BOTH LARGE AND SMALL EXTENSION NOZZLE BUSHINGS. THE LARGE OR SMALL EXTENSION NOZZLE BUSHING IS TYPICALLY SELECTED BASED ON THE THICKNESS OF THE "A" CLAMPING PLATE (A.C.P.) AND THE I.D. CLEARANCE REQUIRED FOR THE NOZZLE OF THE MOLDING MACHINE.



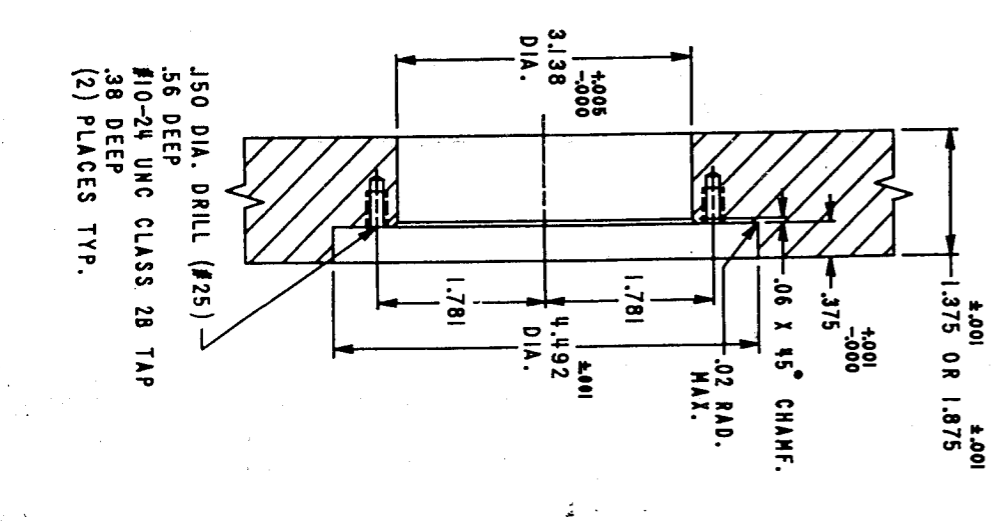
CATALOG NUMBER	"R" SPH. RAD.	"A" DIA.	"B" DIA.	"C" DIA.	"E"	"F"	"G"	"H"	"J"
TEB-0002	1/2					2.265	1.377	1.875	2.640
TEB-0003	3/4	4.490	2.375	3.120	.375	2.265	1.812	1.812	2.640
TEB-0004	1/2					2.765	1.877	2.375	3.140
TEB-0005	3/4					2.765	1.877	2.312	3.140
TEB-0006	1/2					2.765	1.877	2.375	3.140
TEB-0007	3/4	5.490	3.250	3.932	.750	3.265	2.377	2.875	3.440
TEB-0008	1/2					3.265	2.377	2.812	3.440
TEB-0009	3/4					3.265	2.377	2.812	3.440

SUGGESTED MOLD BASE MACHINING DIMENSIONS FOR INSTALLING THREE PLATE EXTENSION BUSHINGS:

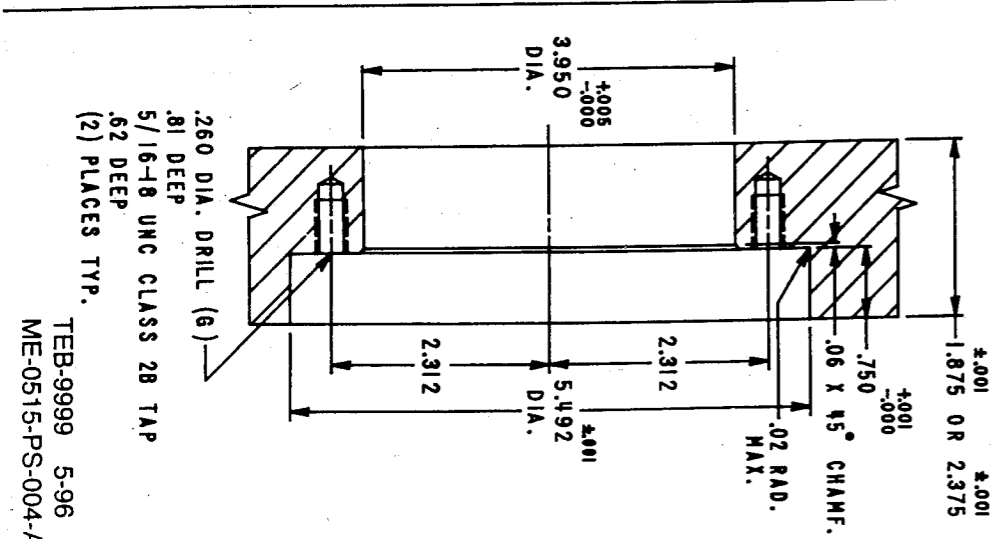
MACHINING DIMENSIONS IN X-1 STRIPPER PLATE FOR RUNNER STRIPPER PLATE BUSHING CAT. NO. TEB-0001



MACHINING DIMENSIONS IN "A" CLAMPING PLATE (A.C.P.) FOR EXTENSION NOZZLE BUSHING - SMALL CAT. NO. TEB-0002 THRU TEB-0005



MACHINING DIMENSIONS IN "A" CLAMPING PLATE (A.C.P.) FOR EXTENSION NOZZLE BUSHING - LARGE CAT. NO. TEB-0006 THRU TEB-0009



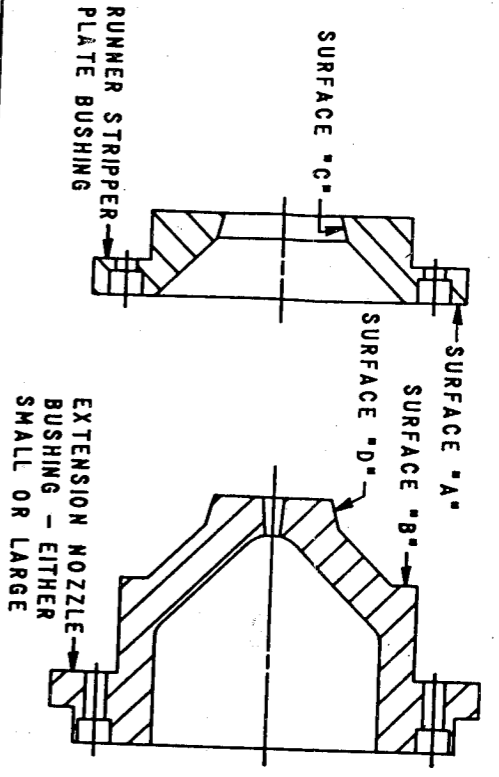
150 DIA. DRILL (#25)
 .41 DEEP MAX. TO TIP OF POINT
 #10-24 UNC CLASS 2B
 BOTTOM TAP - .37 DEEP
 (2) PLACES TYP.
 DRILL MUST NOT BREAK THRU,
 MUST LEAVE .09 MIN. STEEL)

150 DIA. DRILL (#25)
 .56 DEEP
 #10-24 UNC CLASS 2B TAP
 .38 DEEP
 (2) PLACES TYP.

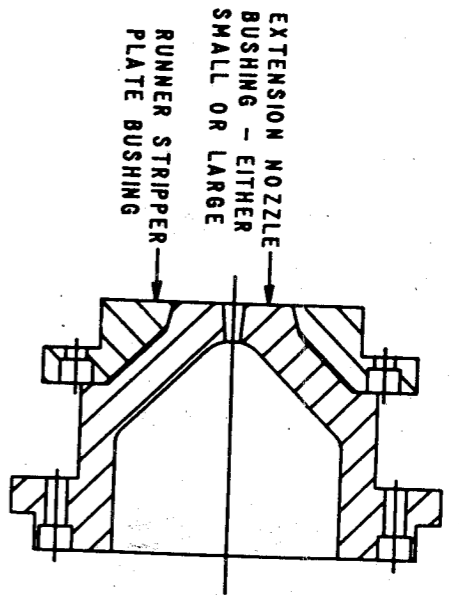
260 DIA. DRILL (6)
 .81 DEEP
 5/16-18 UNC CLASS 2B TAP
 .62 DEEP
 (2) PLACES TYP.
 TEB-9999 5-96
 ME-0515-PS-004-A

INSTALLATION INSTRUCTIONS FOR THREE PLATE EXTENSION BUSHINGS:

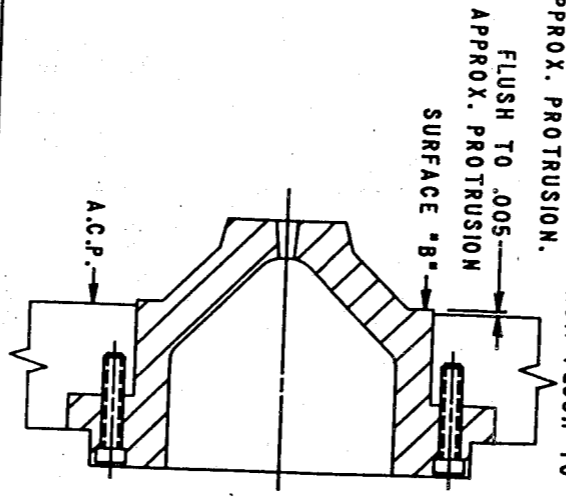
STEP #1:
GRIND SURFACE "A" ON THE RUNNER STRIPPER PLATE BUSHING UNTIL SURFACE "C" ON THE RUNNER STRIPPER BUSHING AND SURFACE "D" ON THE EXTENSION NOZZLE SURFACE "A" IS IN CONTACT, WHILE AT THE SAME TIME THE EXTENSION NOZZLE BUSHING.



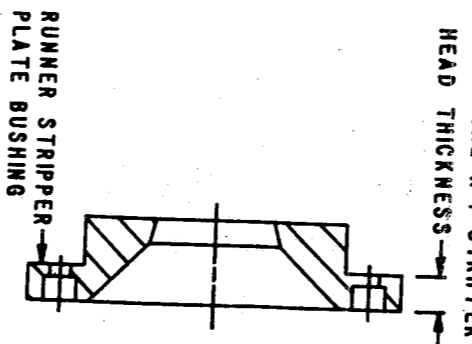
STEP #2:
AFTER STEP #1 THE TAPERED END OF THE EXTENSION NOZZLE BUSHING MAY PROTRUDE OUT OF OR BE RECESSED INTO THE RUNNER STRIPPER PLATE BUSHING SLIGHTLY. THESE AREAS OF BOTH BUSHINGS WILL BE GROUND FLUSH WITH THE X-1 STRIPPER PLATE IN STEP #5.



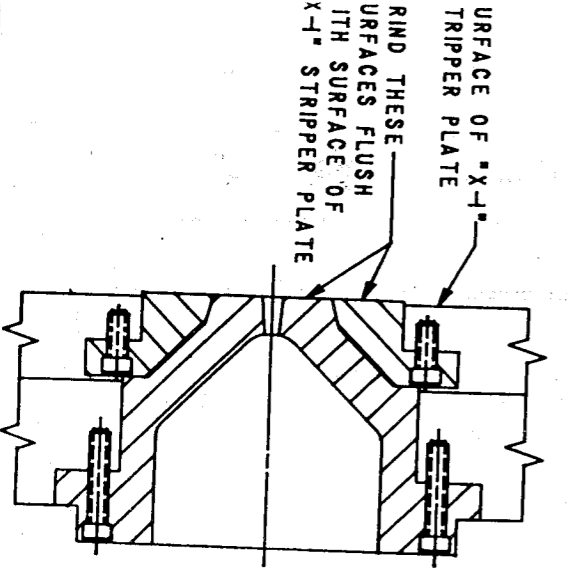
STEP #3:
SEE OTHER SIDE OF INSTALLATION DATA SHEET FOR SPECIFIC MACHINING DIMENSIONS FOR THE EXTENSION NOZZLE BUSHINGS (SMALL OR LARGE) BY CATALOG NUMBER IN THE "A" CLAMPING PLATE (A.C.P.). AFTER MACHINING, INSTALL THE EXTENSION NOZZLE BUSHING INTO THE "A" CLAMPING PLATE (A.C.P.). THEN MEASURE THE DISTANCE THAT SURFACE "B" PROTRUDES OUT OF THE "A" CLAMPING PLATE (A.C.P.). THIS DIMENSION SHOULD BE FROM FLUSH TO .005 APPROX. PROTRUSION.



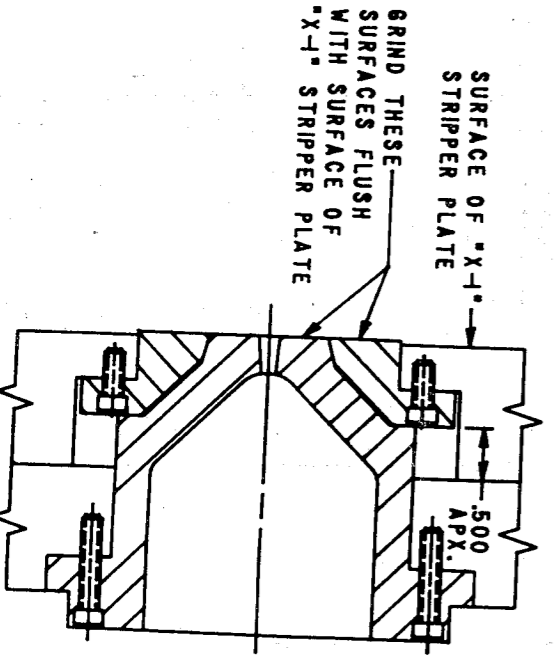
STEP #4:
MEASURE THE HEAD THICKNESS OF THE RUNNER STRIPPER PLATE BUSHING AFTER STEP #1 HAS BEEN COMPLETED. ADD THAT TO THE DISTANCE THE EXTENSION NOZZLE BUSHING PROTRUDES FROM THE A.C.P. TO ACHIEVE THE COUNTER BORE DEPTH IN THE X-1 STRIPPER PLATE. SEE OTHER SIDE OF INSTALLATION DATA SHEET FOR SPECIFIC RUNNER STRIPPER PLATE BUSHING MACHINING DIMENSIONS FOR THE X-1 STRIPPER PLATE. HEAD THICKNESS



STEP #5:
ASSEMBLE RUNNER STRIPPER PLATE BUSHING INTO THE X-1 STRIPPER PLATE. GRIND SURFACES OF BOTH THE EXTENSION NOZZLE BUSHING AND RUNNER STRIPPER PLATE BUSHING FLUSH WITH THE SURFACE OF THE "X-1" STRIPPER PLATE WHILE THE "A.C.P." AND "X-1" OLD PLATES ARE HELD FIRMLY TOGETHER.



WHEN "X-1" STRIPPER PLATE IS 1-3/8 THICK:
THEN THE RUNNER STRIPPER PLATE BUSHING MUST BE RECESSED INTO THE X-1 STRIPPER PLATE AN ADDITIONAL .500, AS SHOWN. A .500 LONGER EXTENSION NOZZLE BUSHING WOULD ALSO BE REQUIRED AND USED IN ALL STEPS #1 THRU #5. ALSO, IN STEP #3 THE APPROX. PROTRUSION WOULD BE .500 TO .505.



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TEB-9999 5-96
MACHINE