



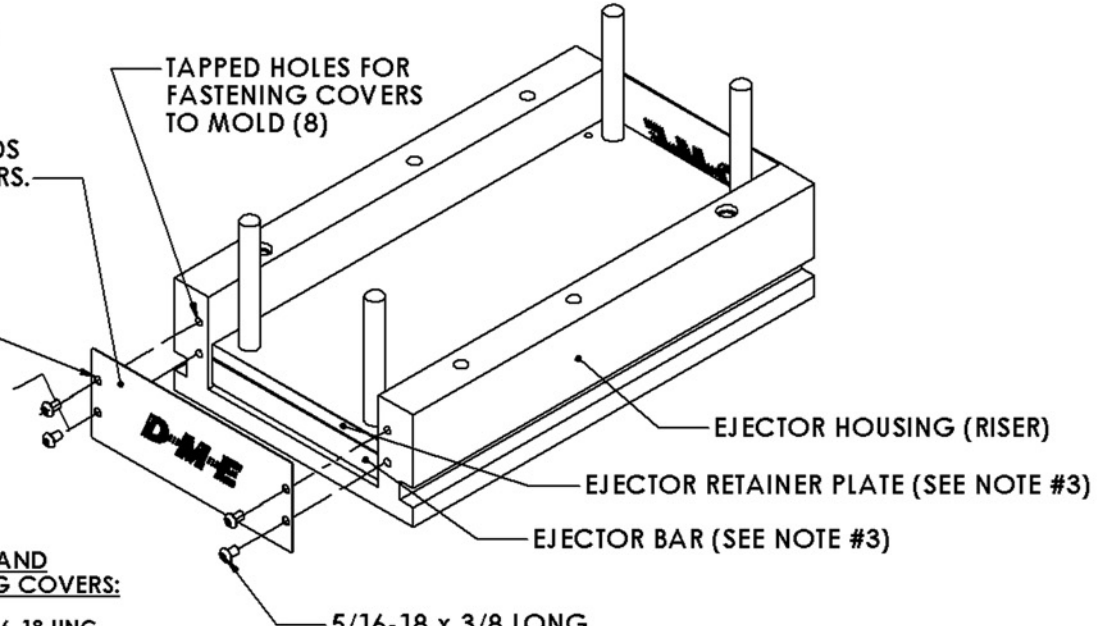
DRILLING & TAPPING IN EJECTOR HOUSING FOR MOUNTING EJECTOR HOUSING COVERS ON OUTSIDE SURFACE OF MOLD

DETAILS FOR CUSTOMER REGARDING DRILLING AND TAPPING HOLES ON ENDS OF EJECTOR HOUSING RISERS TO INSTALL EJECTOR HOUSING COVERS

EJECTOR HOUSING COVER (BOTH ENDS OF MOLD- SEE NOTE #4). COVERS MOUNTED ON OUTSIDE SURFACE OF MOLD ON ENDS OF EJECTOR HOUSING RISERS.

MOUNTING HOLES FOR FASTENING COVERS TO MOLD

TAPPED HOLES FOR FASTENING COVERS TO MOLD (8)



RECOMMENDED DRILLING, TAPPING AND INSTALLATION FOR EJECTOR HOUSING COVERS:

1. DRILL, TAP AND COUNTERSINK FOR 5/16-18 UNC CLASS 3-A BUTTON HEAD CAP SCREWS IN LOCATIONS, AS SHOWN IN "FIGURE 1", ON BOTH ENDS OF EJECTOR HOUSING RISERS FOR MOUNTING EJECTOR HOUSING COVERS ON OUTSIDE SURFACE OF MOLD.
2. FASTEN EJECTOR HOUSING COVERS TO MOLD WITH 5/16-18 x 3/8 LONG BUTTON HEAD CAP SCREWS ON BOTH ENDS OF MOLD.
3. EJECTOR RETAINER PLATE AND EJECTOR BAR MUST BE SHORTER THAN THE NOMINAL MOLD BASE LENGTH BY .110 MINIMUM (OR .055 ON EACH END OF MOLD). THIS PROVIDES SOME CLEARANCE BETWEEN THE EJECTOR HOUSING COVERS AND THE ENDS OF THE EJECTOR ASSEMBLY.
4. STANDARD (FLAT) EJECTOR HOUSING COVERS ARE AVAILABLE FROM D-M-E FOR MOST APPLICATIONS WHEN THE EJECTOR RETAINER PLATE AND EJECTOR BAR ARE A MINIMUM OF .110 SHORTER THAN THE NOMINAL MOLD BASE LENGTH (OR .055 SHORTER ON EACH END OF MOLD).
5. IT IS RECOMMENDED THAT EJECTOR HOUSING COVERS BE INSTALLED ON BOTH ENDS OF EACH MOLD BASE TO REDUCE ANY PINCH POINT HAZARDS DURING MOLD OPERATION.
6. OCCASIONALLY, EXTERNAL MOLD COMPONENTS ARE INSTALLED ON THE ENDS OF THE MOLD, WHICH MAY REQUIRE MODIFICATIONS TO THE COVERS. HOWEVER, ANY MODIFICATION OF EJECTOR HOUSING COVERS MUST STILL PROVIDE ADEQUATE COVERAGE TO REDUCE ANY PINCH POINT HAZARDS DURING MOLD OPERATION.
7. FOR EXTENDED EJECTOR BAR APPLICATIONS, WHERE THE EJECTOR BAR IS LONGER THAN THE MOLD BASE LENGTH, THE CUSTOMER MUST FABRICATE EJECTOR HOUSING COVERS TO SUIT FOR BOTH ENDS OF MOLD TO REDUCE ANY PINCH POINT HAZARDS DURING MOLD OPERATION. REFER TO INFORMATION ON INSTRUCTION SHEET EHCS-9985 FOR RECOMMENDED CUSTOMER FABRICATION OF EJECTOR HOUSING COVERS ON BOTH ENDS OF MOLD BASE USING THE SAME MOUNTING HOLE POSITIONS, AS SHOWN IN "FIGURE 1".

RECOMMENDED DIMENSIONS FOR DRILLING & TAPPING

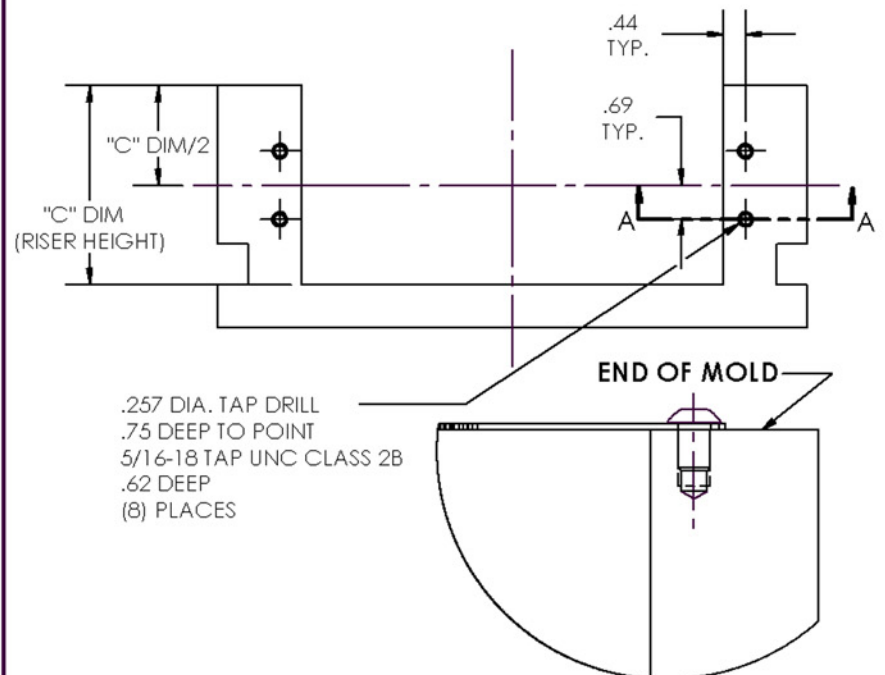


FIGURE 1
(ALL DIMENSIONS ARE IN INCHES)

SECTION A-A
(ENLARGED WITH EJECTOR HOUSING COVER AND BUTTON HEAD CAP SCREW SHOWN)