DME TOGGLE-LOK

POSITIVE EARLY EJECTOR PLATE RETURN

INSTALLATION INSTRUCTIONS FOR STANDARD SIDE MOUNT CATALOG NO. TLSM-200

WARNING **Failure to comply with these warnings may lead to personal injury. COMPONENT FALL DUE TO GRAVITY. PINCH OR CRUSH HAZARD.**

The DME Toggle-Lok assembly is comprised of lever arms which when partially unfastened from a mold and released, may swing down due to gravity. Care needs to be taken when installing, adjusting or repairing this assembly, either on a bench or in an injection press. When servicing a mold while it is installed in an injection molding press, always ensure the press guard doors are interlocked with the operation of the machine platens. Do not attempt to service this product while the mold is in the press if the press guard doors are not interlocked with the operation of the machine platens. It is safer and more effective to service the mold when it is on a work bench. Wear proper protective equipment including gloves and eye protection. These instructions must be passed on to the end user who should read them carefully before using this product. Failure to do so may result in serious injury.

Installation instructions:

The Side Mount is used when the ejector plate is approximately flush with the end of the mold. Refer to the table provided in the DME Mold Components Catalog for the specific Side Mount required for your Toggle-Lok package.

NOTE: Please refer to the DME Mold Components Catalog page titled, “Basic Design Guidelines for Standard Mold Bases,” for additional information.

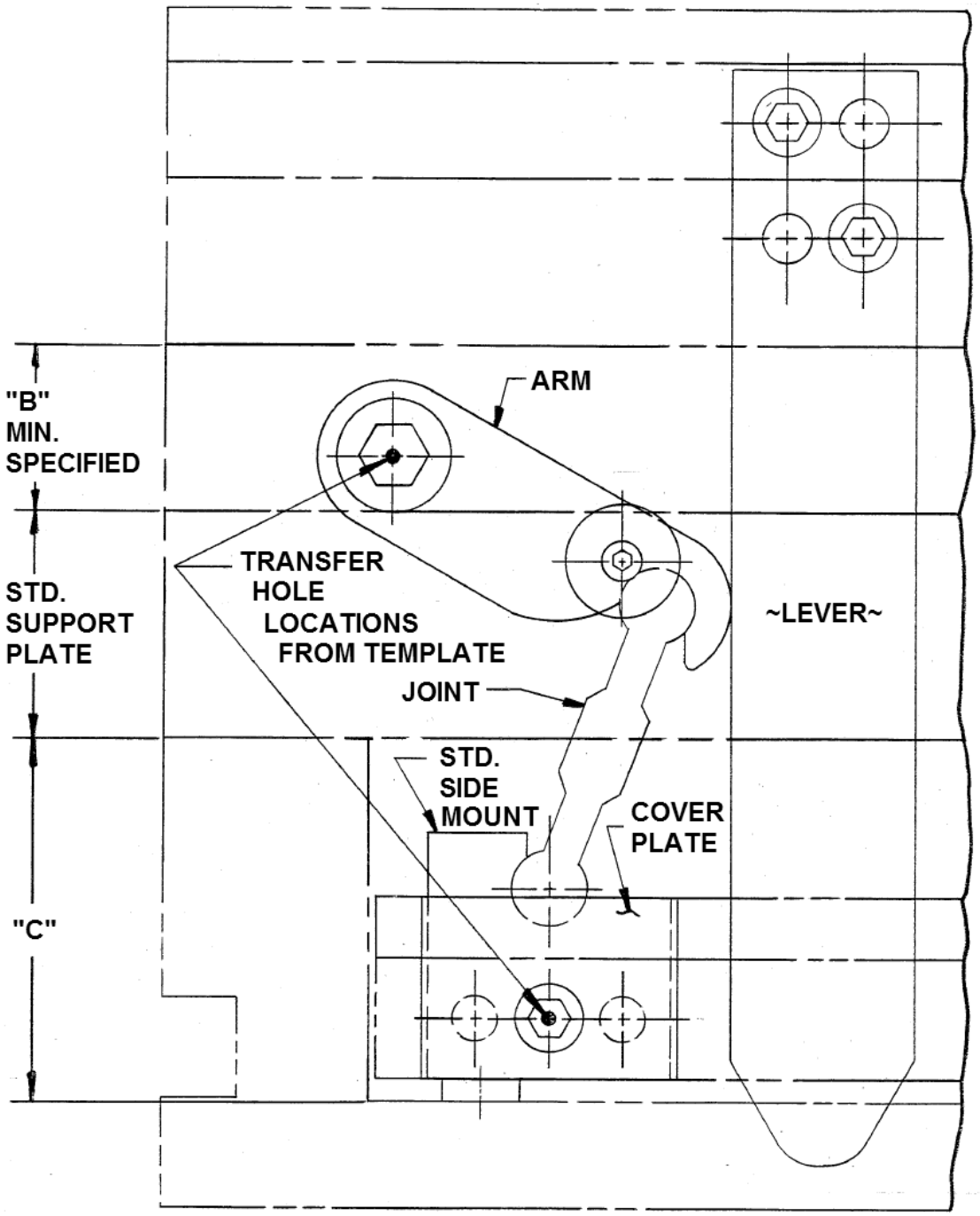
1. Entire setup is made with mold in the fully closed position.
2. Plate the lever on either end of the mold where the housing is open for the ejector plate:
   a) Central to mold if style X
   b) As specified in table for style Y
   c) As far out from centerline of mold as possible, keeping mounts on ejector plate for style Z.
3. Check to be sure levers, mounts, arms and joints including their mounting screws and dowels will not interfere with other mold components through their entire movement.
4. The lead-in end of all levers must be the same height and sides must be square to the top of the mold. Locate and drill, or transfer if lever has mounting holes for two 3/8-16 UNC S.H.C.S. Tighten S.H.C.S. and check for proper location and squareness. Maintaining correct position, locate, or (if lever has mounting holes) transfer from lever

for dowels. Then drill and ream for 3/8 -inch diameter dowels. Place lever spacer under lever and assembly with screws and dowels.

5. Transfer holes by placing template (furnished) against the lever, while maintaining the bottom of template flush with bottom of ejector plate. Drill and tap for 1/2-13 UNC shoulder screw at top of template and at bottom for 3/8-16 UNC S.H.C.S. See reference drawing which is attached to these installation instructions.

   NOTE: To assure proper template is being used for setup, confirm that catalog number on template corresponds with that specified in table for specific Toggle-Lok package used.

6. Repeat above procedure on opposite side of lever by reversing transfer template. Keep side of template marked “Lever” against lever and side of template marked “Ejector Plate” flush with bottom of ejector plate.
7. Install arm using shoulder screw facing opening of arm down.
8. Install standard Side Mount with 3/8-16 UNC S.H.C.S., leaving off the cover plate.
9. Place joint in Side Mount.
10. Repeat steps 7, 8 and 9 on opposite side of Lever.
11. Repeat all previous steps on opposite end of the mold.
12. Maintaining parallelism with the bottom of the ejector plate, move Side Mount until arm comes in contact with Lever.
13. Ensuring the correct adjustment in step 12, tighten screw and transfer from mount for 3/8 -inch diameter dowels. Remove mount, drill and ream, maintaining transferred location, and install two 3/8 -inch diameter dowels.
14. With mount and dowels in place, remove screw and add cover plate; reassemble screw.
15. Repeat steps 12 through 14 for all mounts.
16. Maintain 1/64 inch clearance between mount and end of mold as specified in brochure. Customer to make spacer to suit, as necessary.
17. Dry cycle mold on bench to check for proper operation of early return.

    NOTE: For smoother operation, a thin coat of heavy grease should be applied to leavers and arms.

NOTE: DRAWING BELOW IS FOR REFERENCE ONLY, AND IS NOT TO SCALE. ALWAYS USE PROPER TEMPLATE INCLUDED WITH ASSEMBLY.