

Early Ejector Return Assembly – General Information

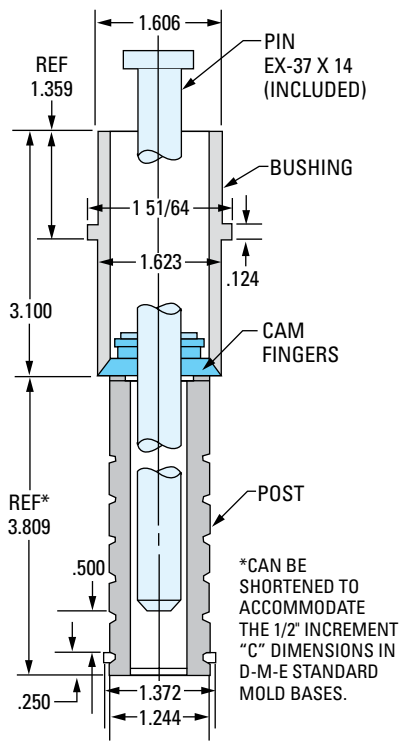
D-M-E Early Ejector Return assemblies are designed to save you time and money. Unique design permits simple, low-cost internal installation. Internal installation also helps control your maintenance costs as there are no outside projections to break or bend or to interfere with water line connections or slide movements. All wear surfaces are hardened to provide long life. The drawings below illustrate the simple, positive operation.

For returning ejector plate before mold is closed

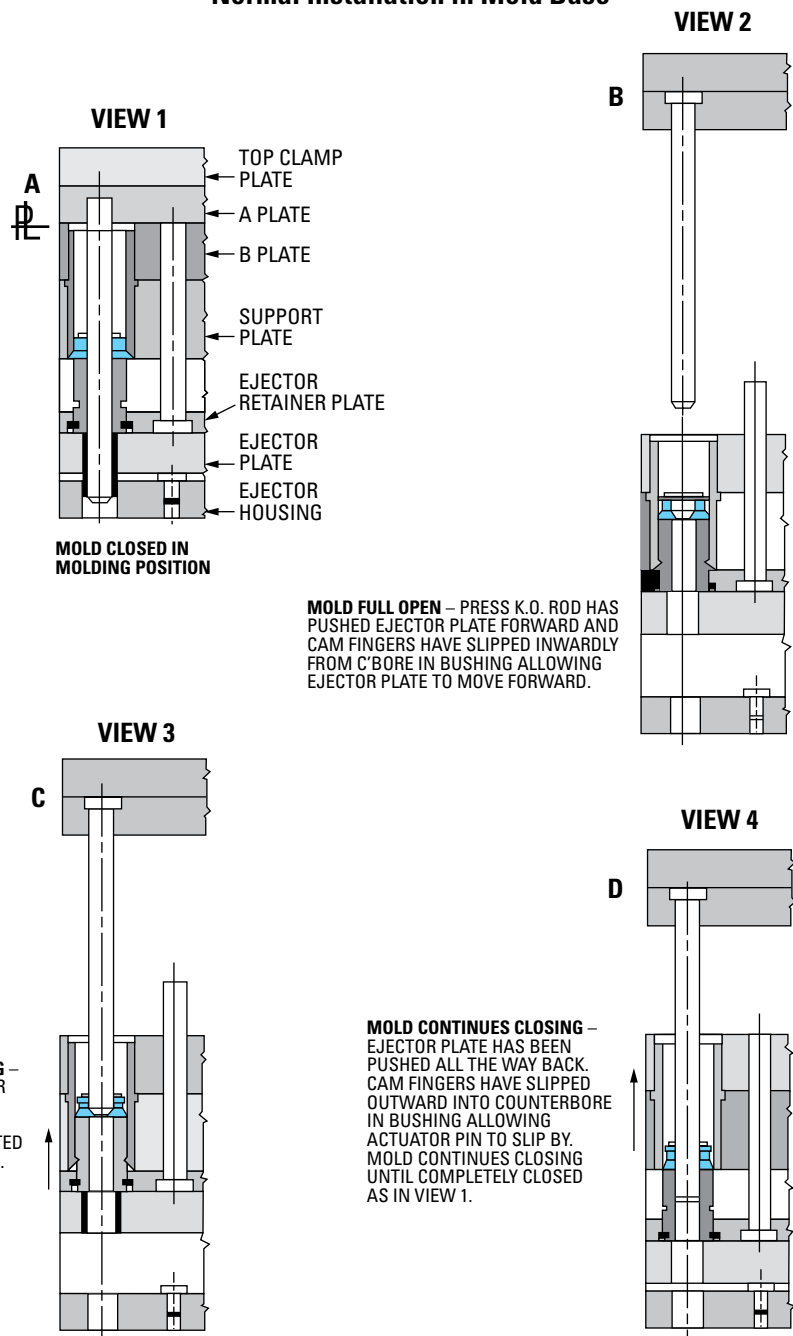


U.S. Patent No. 3,516,302

Early Ejector Return Unit Assembly



Early Ejector Return Operation Sequence Normal Installation in Mold Base



ITEM NUMBER
ER-101
Early Ejector Return Assembly

ITEM NUMBER
ER-101-RK
Replacement Parts Kit
Kit consists of:
1 set of cam fingers
1 guide washer
1 snap ring (lower)
1 snap ring (upper)

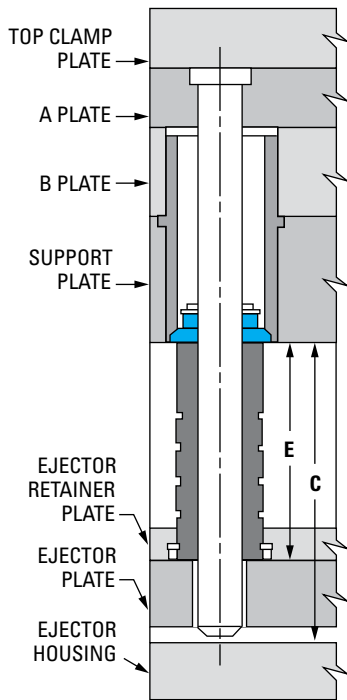
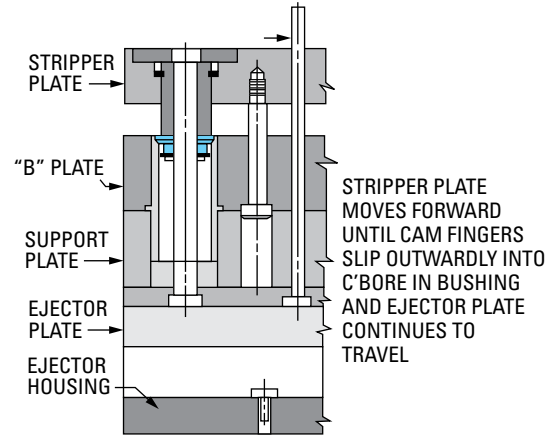
Early Ejector Return Assembly – Installation

Installation for Ejector Pin Travel Beyond Stripper Plate

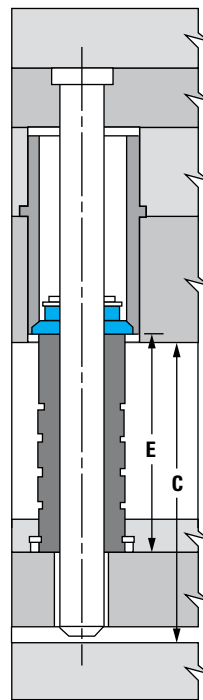
NOTES:

1. Care should be taken to ensure that the ejection assembly is evenly loaded. It is recommended that Guided Ejection be used.
2. Four (4) early ejector return assemblies are recommended per mold. Larger molds may require additional assemblies.
3. Timing of all units to be within ± 0.005 inch.

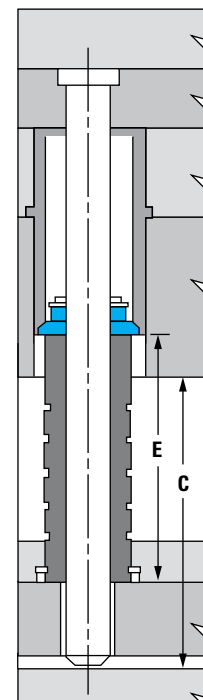
When mold design or components restrict the use of an internally installed return assembly, please refer to D-M-E's externally mounted Toggle-Lok.



108A THRU 1123A
STANDARD MOLD BASE



1212A THRU 1329A
STANDARD MOLD BASE



1518A THRU 2435A
STANDARD MOLD BASE

Determining Post Length

C	MOLD BASE SIZE						C
	108A THRU 1123A		1212A THRU 1329A		1518A THRU 2435A		
	*	E	*	E	*	E	
2 1/2	2.500	1.309	—	—	—	—	2 1/2
3	2.000	1.809	2.000	1.809	1.500	2.309	3
3 1/2	1.500	2.309	1.500	2.309	1.000	2.809	3 1/2
4	1.000	2.809	1.000	2.809	.500	3.309	4
4 1/2	.500	3.309	.500	3.309	.000	3.809	4 1/2

*Remove this amount of stock from bottom end of post.