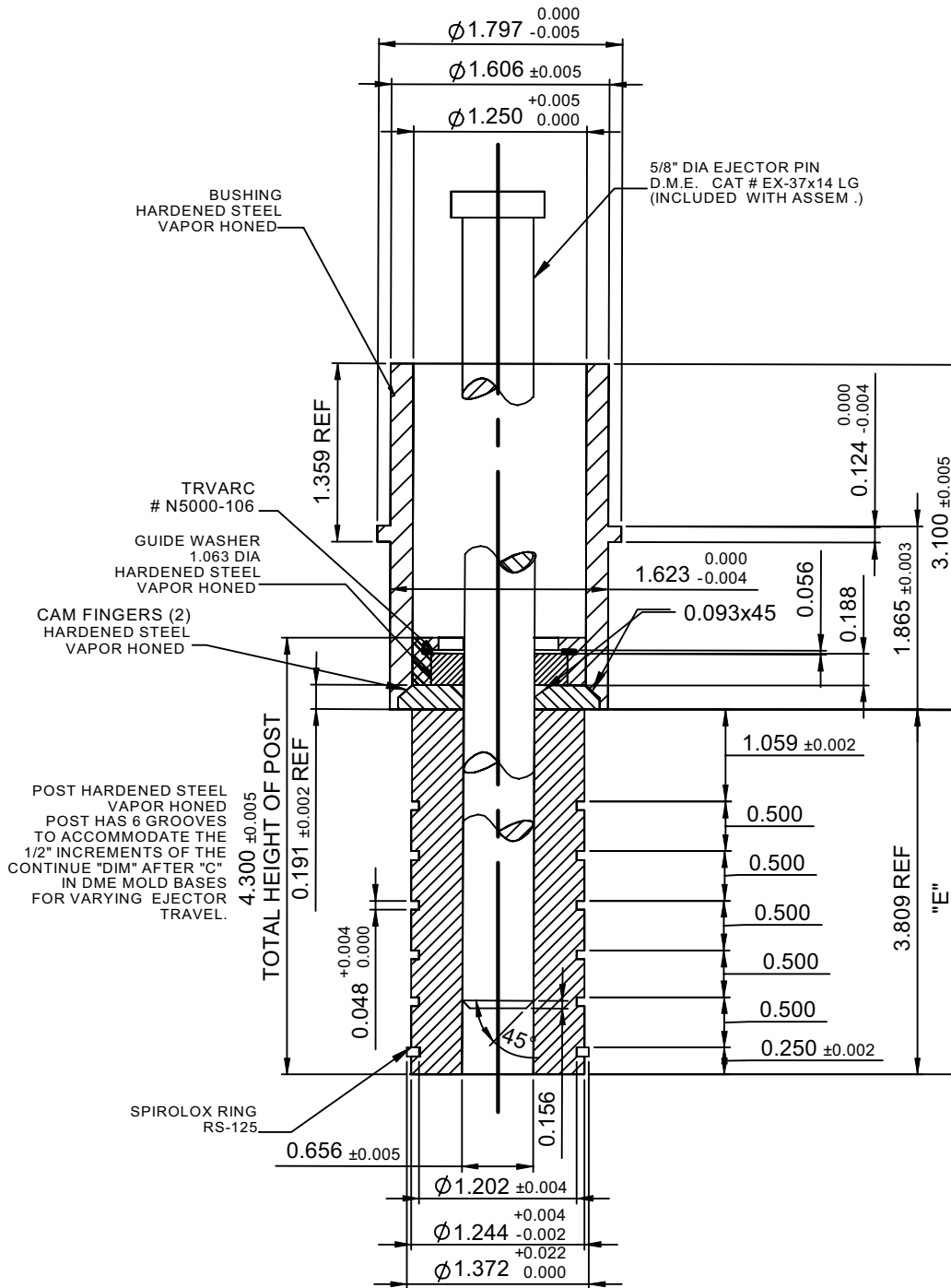


NOTE: All dimensions are in inches.

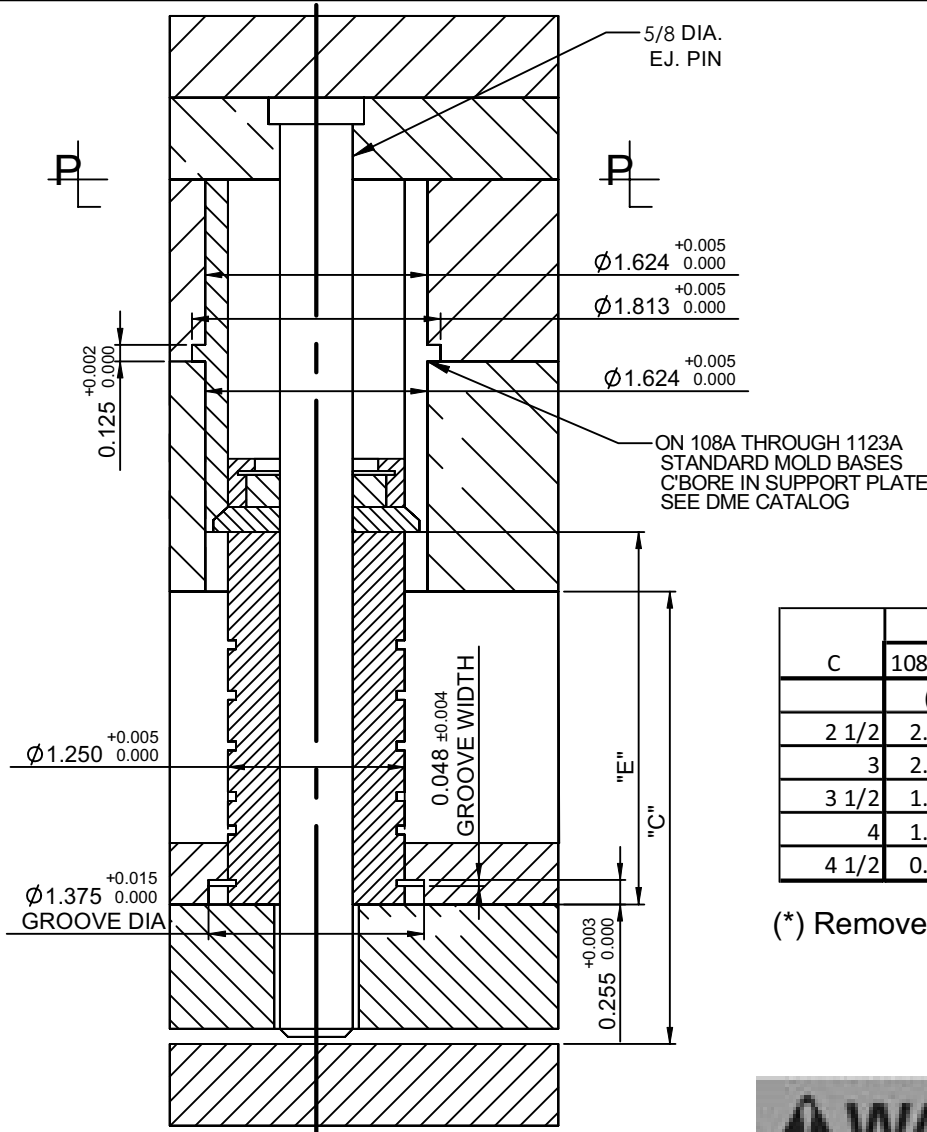
U.S. PATENT NO. 3,516,302  
 EARLY EJECTOR RETURN UNIT  
 DME CAT# ER-101 ASSEMBLY

## EARLY EJECTOR RETURN DIMENSIONS



NOTES:

1. MACHINE HOLES AND COUNTERBORES AS REQUIRED. (SEE OTHER SIDE)
2. SHORTEN POST AS INDICATED IN CHART.
3. IF "B" PLATE IS LESS THAN 1.375 THICK SHORTEN UPPER PORTION OF BUSHING SO THAT TOP OF BUSHING IS AT LEAST 0.016" BELOW PARTING LINE OF MOLD.
4. CUT ACTUATING PIN TO PROPER LENGTH FOR EARLY RETURN TIMING REQUIRED AND GRIND 0.156" MIN X45 CHAMFER AT END OF THE PIN. LENGTH FROM TOP OF ACTUATING PIN TO BEGINNING OF 45 DEGREE CHAMFER TO BE SAME ON ALL PINS +/- .005".
5. REPOSITION SPIROLOX RING IN GROOVE AT END OF POST.
6. ASSEMBLE BUSHING IN SUPPORT PLATE AND "B" PLATE.
7. ASSEMBLE POST IN EJECTOR RETAINER PLATE.
8. ASSEMBLE ACTUATING PIN IN "A" PLATE.
9. WHEN "B" PLATE IS LESS THAN 1.375" THICK AND "C" DIM IS 4.5", CHECK AND ADJUST EJECTOR TRAVEL SO THAT CAM FINGERS DO NOT PROJECT BEYOND TOP OF BUSHING AT END OF EJECTOR STROKE.
10. LUBRICATE OCCASIONALLY.
11. CAUTION: EJECTOR TRAVEL MUST NOT BEGIN UNTIL ACTUATING PIN IS COMPLETELY WITHDRAWN FROM POST AND CAM FINGERS. FOR ADDITIONAL INSTALLATION INFORMATION, SEE D.M.E CATALOG.



## SUGGESTED MOLD DIMENSIONS

C	MOLD BASE SIZE					
	108A THRU 1123A		1212A THRU 1329A		1518A THRU 2435A	
	(*)	E	(*)	E	(*)	E
2 1/2	2.500	1.309	-	-	-	-
3	2.000	1.809	2.000	1.809	1.500	2.309
3 1/2	1.500	2.309	1.500	2.309	1.000	2.809
4	1.000	2.809	1.000	2.809	0.500	3.309
4 1/2	0.500	3.309	0.500	3.309	0.000	3.809

(\*) Remove this amount of stock from bottom end of post.



### **FAILURE TO COMPLY COULD RESULT IN SERIOUS INJURY**

The Early Ejector Return assembly is intended to be used with molding plastic. The Early Ejector Return assembly is intended to cross the mold parting line, and is intended to be used for returning the ejector plate assembly of a mold to a fully retracted position, a motion which is driven by the closing motion of the mold and injection molding machine platens. Machine guard doors must be present and interlocked with the motion of the injection machine platens. Failure to comply could cause serious injury to personnel.

Ejector box housing guards are recommended if the injection molding machine allows actuation of the ejector plates while the machine guard doors are open. Failure to comply could cause possible injury to personnel.

Care must be taken when installing, adjusting or servicing the Early Ejector Return assembly, as improper handling or use may result in equipment damage and possible injury to personnel.

To avoid damage, misuse or personal injury during installation, adjustment or servicing of the Early Ejector Return assembly:

1. Please read all instructions carefully before installing the Early Ejector Return assembly into the mold.
2. Follow all recommended installation instructions. For additional information, see D-M-E Catalog.
3. Do not expose the Early Ejector Return assembly to temperatures in excess of 300°F (150°C) at any time.
4. Allow the Early Ejector Return assembly surfaces to cool down to room temperature before adding lubricant. Lubricate occasionally.
5. When servicing the Early Ejector Return assembly and/or replacing the CAM Fingers, wear protective gloves and goggles or a protective face shield.
6. Do not attempt to close the mold if the Early Ejector Return assembly or CAM Fingers appear damaged.
7. Ejector travel must not begin until the Actuating Pin is completely withdrawn from Post and CAM Fingers.
8. A minimum of four Early Ejector Return assemblies are recommended to be used for an ejector plate assembly. Early Ejector Return assemblies placement should be balanced across the ejector plate assembly. Guided Ejection is recommended.