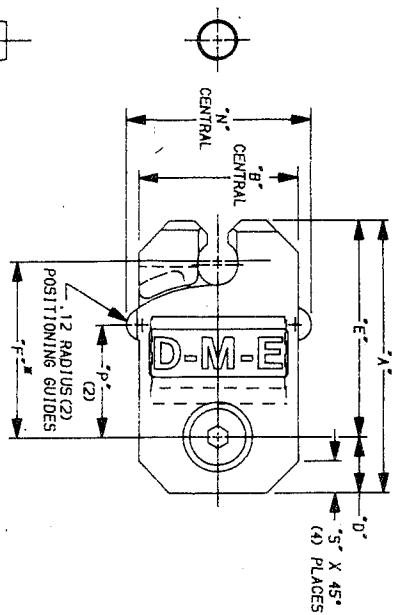
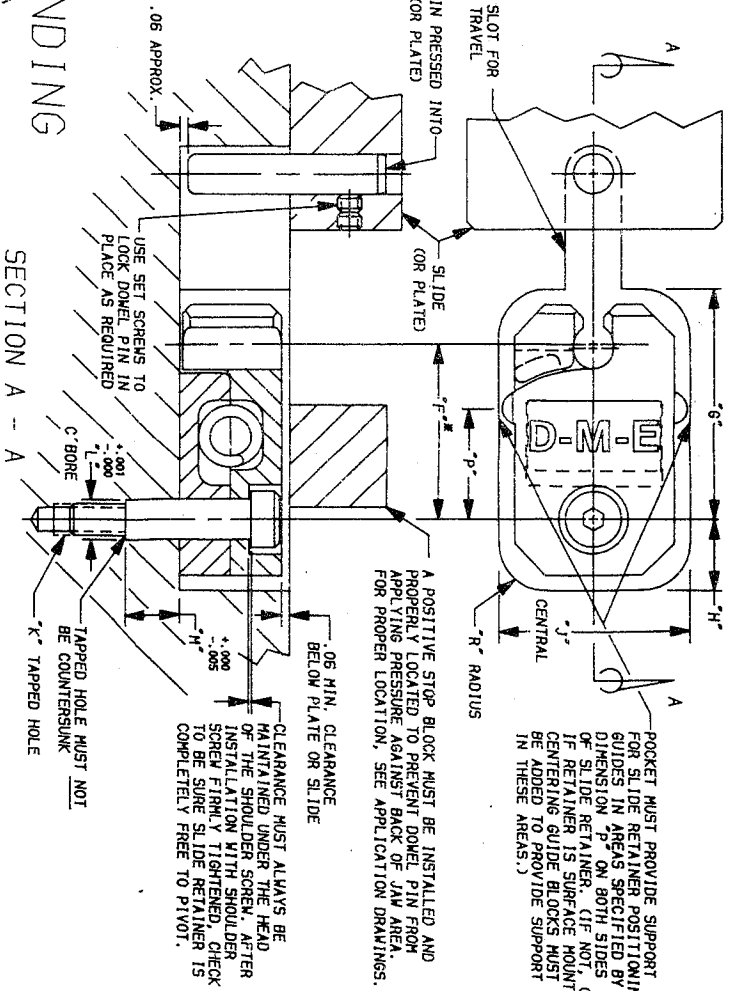


### SLIDE RETAINER DIMENSIONS



### SLIDE RETAINER POCKET DIMENSIONS (SLIDE APPLICATION SHOWN)



NOTE, REFER TO PAGE 2, NOTE 3, CONCERNING DIMENSION "F", AS WELL AS, ADDITIONAL NOTES ON PAGE 2 CONCERNING BASIC DESIGN, INSTALLATION AND OPERATION GUIDELINES.

PATENT PENDING

#### SLIDE RETAINER DIMENSIONS

CATALOG NUMBER	"A" DIM.	"B" DIM.	"C" DIM.	"D" DIM.	"E" DIM.	"F" DIM.	"G" DIM.	"H" DIM.	"J" DIM.	"K" RAD.	"L" TAPPED HOLE AND TAP DEPTH BELOW C-BORE	"M" C-BORE DEPTH	"N" C-BORE DEPTH	"P" DIM.	"R" CHAM.	"S" DIM.	"T" DIM.	"U" DIM.	"V" DIM.	"W" DIM.	"X" DIM.	"Y" DIM.	"Z" DIM.	
PSL0001	1.50	.76	.63	.27	1.23	.980	.94	.61	1.4	1.35	.39	1.00	.31	#10-24 X .50 DEEP	.249	.310	.310							
PSL0002	2.13	1.26	.79	.44	1.69	1.375	1.44	.88	1.01	1.81	.56	1.50	.37	1/4-20 X .56 DEEP	.3115	.430	.430							
PSL0003	3.38	1.76	1.18	.75	2.63	2.125	1.94	1.57	.38	2.75	.88	2.00	.50	5/16-18 X .62 DEEP	.374	.580	.580							

#### SLIDE RETAINER POCKET DIMENSIONS

CATALOG NUMBER	"A" DIM.	"B" DIM.	"C" DIM.	"D" DIM.	"E" DIM.	"F" DIM.	"G" DIM.	"H" DIM.	"J" DIM.	"K" RAD.	"L" TAPPED HOLE AND TAP DEPTH BELOW C-BORE	"M" C-BORE DEPTH	"N" C-BORE DEPTH	"P" DIM.	"R" CHAM.	"S" DIM.	"T" DIM.	"U" DIM.	"V" DIM.	"W" DIM.	"X" DIM.	"Y" DIM.	"Z" DIM.	
PSL0001	1.50	.76	.63	.27	1.23	.980	.94	.61	1.4	1.35	.39	1.00	.31	#10-24 X .50 DEEP	.249	.310	.310							
PSL0002	2.13	1.26	.79	.44	1.69	1.375	1.44	.88	1.01	1.81	.56	1.50	.37	1/4-20 X .56 DEEP	.3115	.430	.430							
PSL0003	3.38	1.76	1.18	.75	2.63	2.125	1.94	1.57	.38	2.75	.88	2.00	.50	5/16-18 X .62 DEEP	.374	.580	.580							

- SLIDE RETAINER ASSEMBLY CONSISTS OF:
- 1 - TOP - JAW PLATE
  - 1 - BOTTOM - JAW PLATE
  - 1 - COMPRESSION SPRING - CUSTOM DESIGN
  - 1 - SHOULDER SCREW - WITH THREAD LOCKING ELEMENT
  - 1 - DOWEL PIN

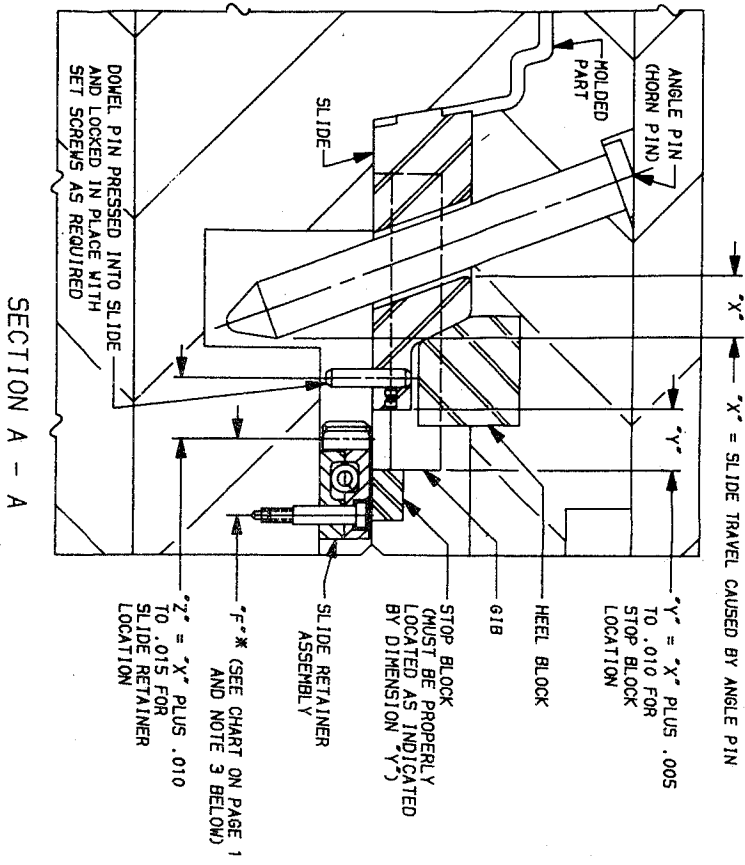


## D-M-E SLIDE RETAINER INSTALLATION DATA

Please read carefully before installing slide retainer  
REFER TO CHARTS AND APPLICATION DRAWINGS FOR INSTALLATION DIMENSIONS

SLIDE RETAINER ASSEMBLIES		SLIDE RETAINER REPLACEMENT COMPONENTS							
CATALOG NUMBER	MAXIMUM RECOMMENDED HOLDING WEIGHT	SPRINGS - CUSTOM DESIGN	SHOULDER SCREWS - WITH THREAD LOCKING ELEMENT	DOWEL PINS					
PSL0001	22 POUNDS	PSL0006	CATALOG NUMBER 14345BN	NOMINAL SHOULDER DIAMETER .250	SHOULDER LENGTH .750	THREAD #10-24	CATALOG NUMBER 1411ADP	NOMINAL DIAMETER .250	LENGTH 1.25
PSL0002	44 POUNDS	PSL0009	CATALOG NUMBER 51615BN	NOMINAL SHOULDER DIAMETER .312	SHOULDER LENGTH 1.000	THREAD 1/4-20	CATALOG NUMBER 516112DP	NOMINAL DIAMETER .312	LENGTH 1.50
PSL0003	88 POUNDS	PSL0012	CATALOG NUMBER 381123BN	NOMINAL SHOULDER DIAMETER .375	SHOULDER LENGTH 1.500	THREAD 5/16-18	CATALOG NUMBER 38214DP	NOMINAL DIAMETER .375	LENGTH 2.25

SLIDE APPLICATION

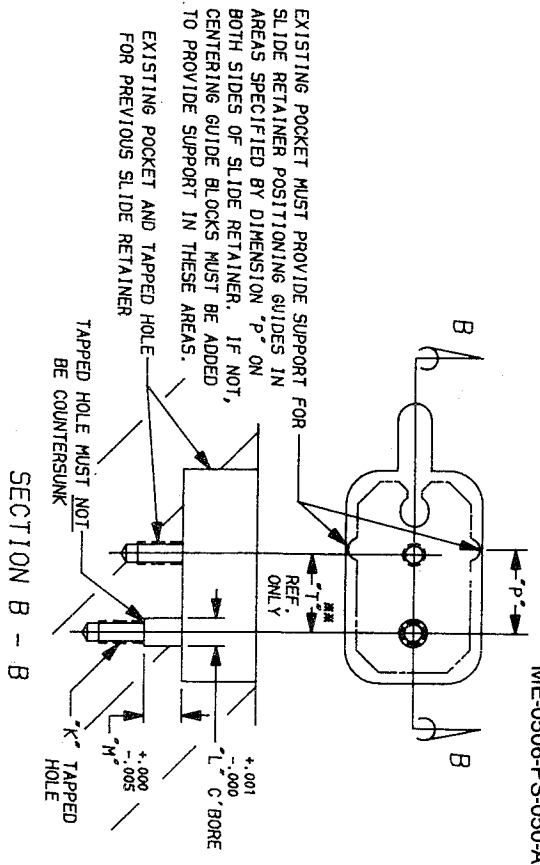


BASIC DESIGN, INSTALLATION AND OPERATION GUIDELINES

1. INITIAL AND PERIODIC LUBRICATION MUST BE APPLIED AS PART OF REGULAR MAINTENANCE, EVERY 100,000 CYCLES OR MORE FREQUENTLY AS REQUIRED. ALL METAL-TO-METAL CONTACT AREAS OF SLIDE RETAINER AND ITS COMPONENTS MUST BE LUBRICATED. A GOOD GRADE OF MOLDFORMERS' NON-MELTING TYPE GREASE FOR THE APPROPRIATE TEMPERATURE SHOULD BE USED.
2. SLIDE RETAINER MUST NOT BE OPERATED AT TEMPERATURES EXCEEDING 225°F.
3. \* DIMENSION "F", THE DISTANCE FROM THE CENTERLINE OF THE DOWEL PIN TO THE CENTERLINE OF THE SHOULDER SCREW PLUS INSTALLATION TOLERANCE AS SPECIFIED IN APPLICATION DRAWINGS, IS IMPORTANT TO MAINTAIN.
4. A POSITIVE STOP BLOCK MUST BE INSTALLED AND PROPERLY LOCATED TO PREVENT DOWEL PIN FROM APPLYING PRESSURE AGAINST BACK OF JAW AREA (WHICH COULD CAUSE BENDING OR SHEARING OF DOWEL PIN OR SHOULDER SCREW). FOR PROPER LOCATION, SEE APPLICATION DRAWINGS.
5. IF TWO OR MORE SLIDE RETAINERS ARE USED, ALL RETAINERS MUST BE MOUNTED UNIFORMLY FOR A BALANCED OPERATION. WHEN FOUR PSL0002 SLIDE RETAINERS WITH A RATING OF 44 POUNDS EACH ARE USED, THE TOTAL HOLDING CAPACITY IS 176 POUNDS AS LONG AS THE RETAINERS ARE UNIFORMLY MOUNTED.
6. ONLY ONE SIZE OF SLIDE RETAINER MUST BE USED FOR ANY APPLICATION WHEN MORE THAN ONE UNIT IS REQUIRED.
7. BOTTOM OF MOUNTING POCKET MUST PROVIDE A SMOOTH SURFACE FOR SLIDE RETAINER TO PIVOT FREELY.

RETROFITTING

PSL/ID 5/96  
ME-0506-PS-050-A



RETROFITTING NEW SLIDE RETAINER INTO APPLICATIONS WHERE PREVIOUS SLIDE RETAINER HAS BEEN USED

SLIDE RETAINER CATALOG NUMBER	"K" TAPPED HOLE AND TAP DEPTH BELOW C'BORE	"L" C'BORE DEPTH	"M" C'BORE DIM.	"P" REF. ONLY	"T" REF. ONLY	FOR REPLACEMENT OF SLIDE RETAINER CATALOG NUMBER
PSL0001	#10-24 X .50	.249	.310	.61	.620	HRT-22
PSL0002	1/4-20 X .56	.3115	.430	.88	.875	HRT-44
PSL0003	5/16-18 X .62	.374	.580	1.57	1.325	HRT-88

\*\* DIMENSION "T" IS FOR REFERENCE ONLY. SEE PAGES 1 AND 2 FOR CHARTS AND APPLICATION DRAWINGS TO DETERMINE SPECIFIC INSTALLATION DIMENSIONS.

8. DRILLING, TAPPING AND C'BORING FOR SHOULDER SCREW AT A NEW LOCATION IS REQUIRED TO RETROFIT NEW SLIDE RETAINER INTO ANY APPLICATION WHERE PREVIOUS SLIDE RETAINER HAS BEEN USED. ALSO, MOUNTING POCKET MUST PROVIDE SUPPORT FOR SLIDE RETAINER POSITIONING GUIDES IN AREAS SPECIFIED BY DIMENSION "P" ON BOTH SIDES OF SLIDE RETAINER. IF NOT, CENTERING GUIDE BLOCKS MUST BE ADDED TO PROVIDE SUPPORT IN THESE AREAS.
9. REPLACE SLIDE RETAINER ASSEMBLY WHENEVER TOTAL WEAR IN JAW AREA EXCEEDS .015. DOWEL PIN MUST ALSO BE REPLACED WHENEVER TOTAL WEAR EXCEEDS .015.
10. REPLACE CUSTOM DESIGNED COMPRESSION SPRING FOR EACH SIZE SLIDE RETAINER, AS SPECIFIED IN CHART ON PAGE 1. SAFETY GLASSES MUST ALWAYS BE WORN WHEN WORKING WITH OR COMPRESSING SPRINGS. TO REMOVE OR INSTALL SPRING, USE VISE GRIPS TO COMPRESS SPRING JUST FAR ENOUGH TO ALLOW SPRING TO ENTER SPRING POCKET IN TOP JAW PLATE. PLACE SPRING IN POCKET WITH SPRING O.D. CLOSE TO EDGE OF POCKET NEAREST SHOULDER SCREW AND WITH UNGROUND AREAS ON ENDS OF SPRING LOCATED TOWARD SHOULDER SCREW.
11. USE ONLY D-M-E SHOULDER SCREWS, AS SPECIFIED IN CHART ON PAGE 1, WITH THREAD LOCKING ELEMENT TO PREVENT THEM FROM WORKING OR VIBRATING LOOSE.