



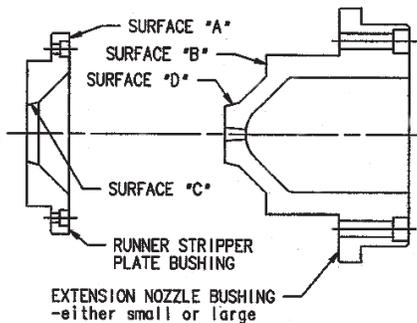
29111 Stephenson Hwy.
Madison Heights, MI 48071 USA
800-626-6653

Three Plate Extension Bushings Installation Instructions

Please read carefully before installing components.

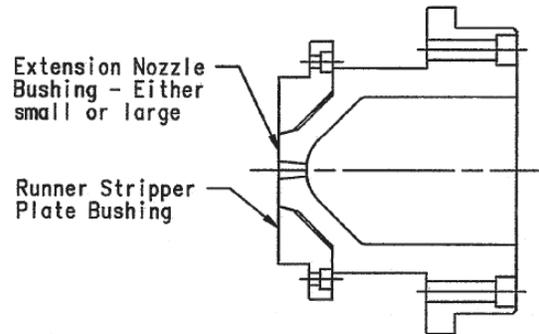
Step #1

Grind surface "A" on the Runner Stripper Plate Bushing until surface "C" on the Runner stripper Bushing and surface "D" on the Extension Nozzle Bushing make contact, while at the same time surface "A" is in contact with surface "B" on the Extension Nozzle Bushing.



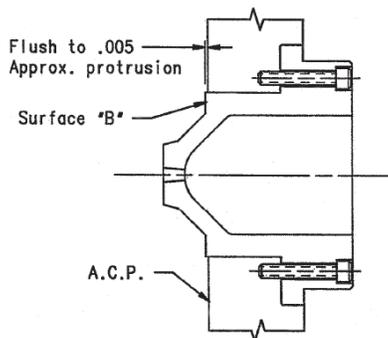
Step #2

The tapered end of the Extension Nozzle Bushing may protrude out of, or be recessed into the Runner Stripper Plate Bushing slightly. These areas of both bushings will be ground flush with the X-1 Stripper Plate in Step #5.



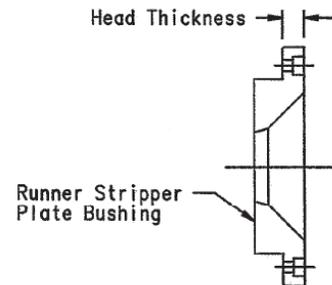
Step #3

See further down for specific machining dimensions for the Extension Nozzle Bushings (small or large) by item # in the "A" Clamping Plate. (A.C.P.) After machining, install the Extension Nozzle Bushing into the "A" Clamping plate (A.C.P.). This dimension should be from flush to .005 approx. protrusion.



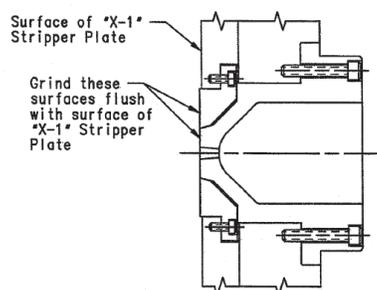
Step #4

Measure the head thickness of the Runner Stripper Plate Bushing after Step #1 has been completed. Add that to the distance the Extension Nozzle Bushing protrudes from the A.C.P. to achieve the counterbore depth in the X-1 Stripper Plate. See further down for specific Runner Stripper Plate Bushing machining dimensions for the X-1 Stripper Plate.



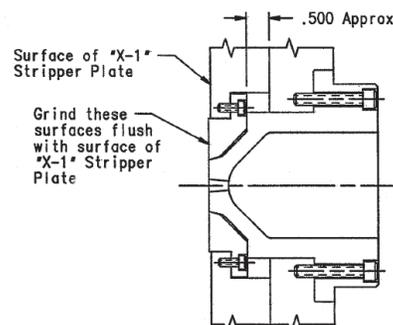
Step #5

Assemble Runner Stripper Plate Bushing into the X-1 Stripper Plate. Grind surfaces of both the Extension Nozzle Plate Bushing and Runner Stripper Plate Bushing flush with the surface of the X-1 Stripper Plate while the A.C.P. and X-1 Mold Plates are held firmly together.



When X-1 Stripper Plate is 1-3/8" thick:

The runner stripper Plate Bushing must be recessed into the X-1 Stripper plate an additional .500 as shown. A .500 longer Extension Nozzle Bushing would also be required and used in all Steps 1-5. Also, in Step #3 the approximate protrusion would be .500 to .505.





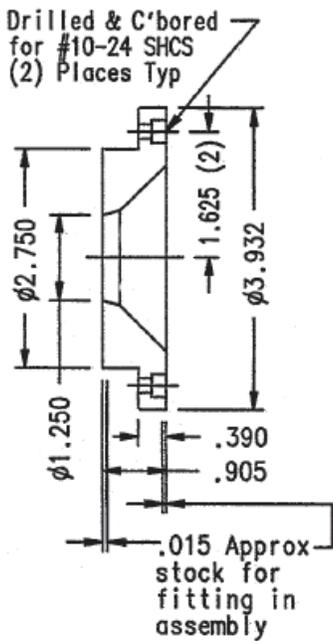
29111 Stephenson Hwy.
Madison Heights, MI 48071 USA
800-626-6653

Three Plate Extension Bushings Installation Instructions

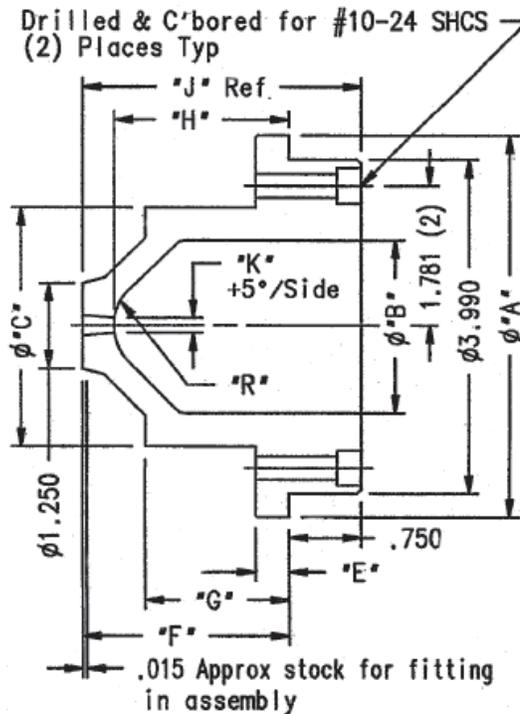
Please read carefully before installing components.
Drawings in inches and not to scale.

The Runner Stripper Plate Bushing Item Number TEB-0001 is used with all sizes of both the small and large Extension Nozzle Bushings. The small or large Extension Nozzle Bushings is typically selected based on the thickness of the "A" clamping plate. (A.C.P.) and the I.D. clearance required for the nozzle of the molding machine.

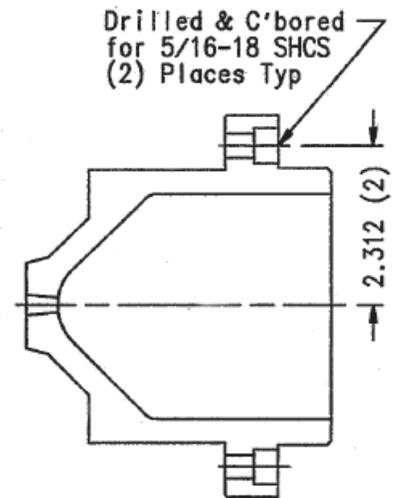
Runner Stripper
Plate Bushing
Item# TEB-0001
[Includes (2) #10-24
x 1/2 long SHCS]



Extension Nozzle Bushing
(Small)
Item# TEB-0002 thru TEB-0005
[Includes (2) #10-24x 1-1/4 long SHCS]



Extension Nozzle Bushing
(Large)
Item# TEB-0006 thru TEB-0011
[Includes (2) 5/16-18
x 7/8 long SHCS]



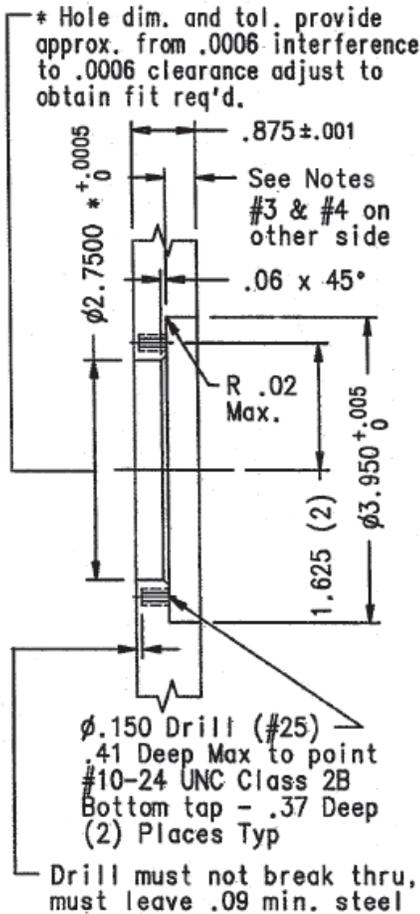
Item #	"R" Sper. Rad.	"A" Dia.	"B" Dia.	"C" Dia.	"E"	"F"	"G"	"H"	"J"	"K"
TEB-0002	1/2	4.490	2.375	3.120	.375	2.265	1.377	1.875	3.015	.156
TEB-0003	3/4							1.812		
TEB-0004	1/2							2.375		
TEB-0005	3/4							2.312		
TEB-0006	1/2	5.490	3.250	3.932	.750	2.765	1.877	2.375		
TEB-0007	3/4							2.312		
TEB-0008	1/2							2.875		
TEB-0009	3/4							2.312		
TEB-0010	1/2	5.490	3.250	3.932	.750	3.265	2.377	3.375	4.015	
TEB-0011	3/4							3.312		



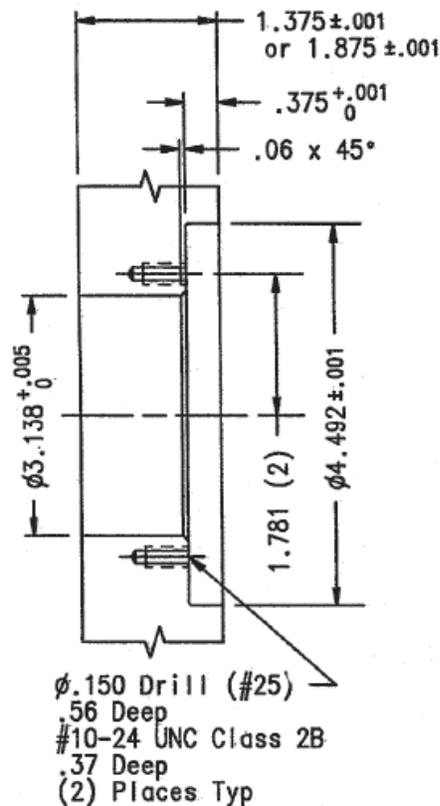
29111 Stephenson Hwy.
Madison Heights, MI 48071 USA
800-626-6653

Suggested Mold Base Machining Dimensions for Installing Three Plate Extension Bushings

Machining Dimensions in X-1 Stripper Plate for Runner Stripper Plate Bushing
Item# TEB-0001



Machining Dimensions in "A" Clamping Plate (A.C.P.) for Extension Nozzle Bushing - Small -
Item# TEB-0002 Thru TEB-0005



Machining Dimensions in "A" Clamping Plate (A.C.P.) for Extension Nozzle Bushing - Large -
Item# TEB-0006 Thru TEB-0011

