IMPORTANT SAFETY INFORMATION

BEFORE USING THIS PRODUCT
REFER TO IMPORTANT SAFETY INFORMATION AT MANUFACTURER’S WEBSITE:
http://www.ngkmetals.com/index.cfm/m/19

ADDITIONAL INFORMATION MAY BE FOUND AT:
http://www.osha.gov/dts/hib/hib_data/hib19990902.html

READ ALL INSTRUCTIONS BEFORE HANDLING THIS PRODUCT INCLUDING THE MSDS.
THIS INSTRUCTION IS TO BE PASSED ALONG TO THE END USER.

INSTALLATION INSTRUCTIONS

Pocket Notes:
- Perpendicularity and Parallelism of pockets must be machined such that Chill Vent insert halves mate after installation without gaps between insert halves.
- Corner radii of Chill Vent insert pockets are to be machined to suit dimensions shown. Toolmaker is responsible for modification of corner radii of Chill Vent Inserts to accommodate machining method used.
- All surfaces of pocket to have a surface finish no greater than 0.8 \( \mu \)m (micrometers). Check for burrs.
- For Zp, use shim pack to accommodate flushness. Flushness tolerance must be +0.05/-0 (+0.002/-0”).

**POCKET DIMENSIONS**

<table>
<thead>
<tr>
<th>CATALOG NUMBER</th>
<th>“Xp”</th>
<th>“Yp”</th>
<th>“Zp”</th>
</tr>
</thead>
<tbody>
<tr>
<td>VSCL7US</td>
<td>135.00</td>
<td>80.000</td>
<td>3.1496*</td>
</tr>
<tr>
<td>VECL7US</td>
<td>185.00</td>
<td>100.00</td>
<td>3.9370*</td>
</tr>
</tbody>
</table>

Dimensions shown are in millimeters (inches).

**COMPONENT INSERT DIMENSIONS**

<table>
<thead>
<tr>
<th>CATALOG NUMBER</th>
<th>“X”</th>
<th>“Y”</th>
<th>“Z”</th>
<th>D1</th>
<th>P</th>
<th>K</th>
<th>B</th>
<th>SCREW THREAD</th>
<th>L1</th>
<th>F1</th>
<th>D2</th>
<th>T</th>
</tr>
</thead>
<tbody>
<tr>
<td>VSCL7US</td>
<td>135.00</td>
<td>80.00</td>
<td>50.00</td>
<td>10.00</td>
<td>26.00</td>
<td>55.00</td>
<td>40.0</td>
<td>5/16-18 UNC</td>
<td>20.00</td>
<td>1/2-14 NPT</td>
<td>18.00</td>
<td>45.00</td>
</tr>
<tr>
<td>VLCL7US</td>
<td>175.00</td>
<td>90.00</td>
<td>50.00</td>
<td>10.00</td>
<td>30.00</td>
<td>65.00</td>
<td>60.0</td>
<td>3/4-14 NPT</td>
<td>25.00</td>
<td>3/4-14 NPT</td>
<td>23.00</td>
<td>45.00</td>
</tr>
<tr>
<td>VEC7US</td>
<td>185.00</td>
<td>100.00</td>
<td>50.00</td>
<td>10.00</td>
<td>35.00</td>
<td>65.00</td>
<td>60.0</td>
<td>3/4-14 NPT</td>
<td>25.00</td>
<td>3/4-14 NPT</td>
<td>23.00</td>
<td>50.00</td>
</tr>
</tbody>
</table>

Example Pocket for one half of Chill Vent Insert Assembly. Clearance slots for cooling lines and pipe fittings are not shown. Key slot, tap counter-bores and installation for ejector pin not shown.

Toolmaker is responsible to modify installation to accommodate the features listed above.
**Installation Notes:**

- 10mm DIN Ejector Pin to be used with this product.
- Key slots provided on product as shown. Toolmaker is responsible for keying product.
- Tap threads are provided in product for retaining screws. Customer to supply screws.
- Customer to supply NPT pipe fittings. High-temperature pipe thread sealant is recommended to be used with this product.
- Once installed, Chill Vent insert halves must align properly to achieve good seal-off between mating surfaces. Use a blue-off compound to check for proper fit. Adjust shim pack accordingly during installation until desired mating seal-off is achieved.

**Dimensions shown are in millimeters (inches).**

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**NOTICE:**

DME shall not be liable for misuse or failure to follow the enclosed instructions and specifications. DME hereby disclaims all implied warranties, including merchantability and fitness for a particular purpose. In no event shall DME be responsible for loss of use, revenue or profit, or for incidental or consequential damages.

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