

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 DIMENSIONS

CATALOG NUMBER	"X _p " +0.030/+0.010 (+0.0012/+0.0004*)	"Y _p " +0.030/+0.010 (+0.0012/+0.0004*)	"Z _p "
VSCL7US	135.000 (5.3150")	80.000 (3.1496")	SEE NOTES
VLCL7US	175.000 (6.8898")	90.000 (3.5433")	
VECL7US	185.000 (7.2835")	100.000 (3.9370")	

Dimensions shown are in millimeters (inches).

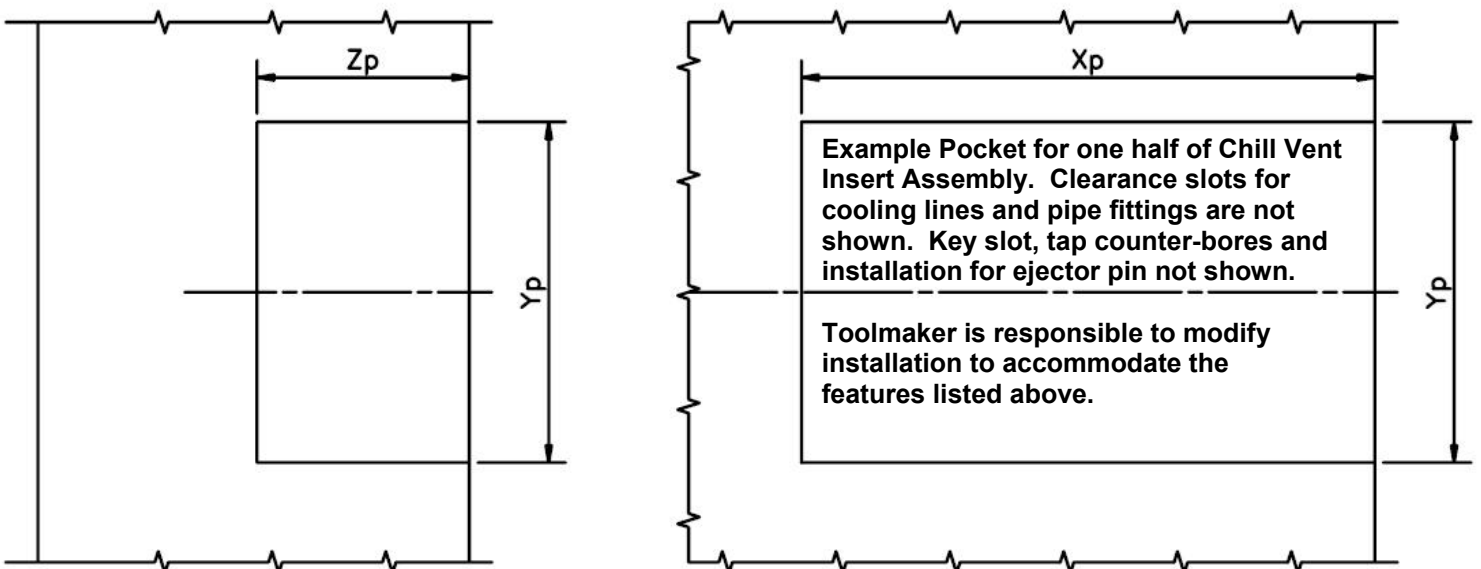
Pocket Notes:

- 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 μm (micrometers). Check for burrs.
- For Z_p, use shim pack to accommodate flushness. Flushness tolerance must be +0.05/-0 (+0.002/-0").

COMPONENT INSERT DIMENSIONS

CATALOG NUMBER	"X"	"Y"	"Z"	∅ D1	"P"	"K"	"B"	SCREW THREAD	"L1"	"F1" x THREAD DEPTH	∅ D2	"T"
	+0/-0.06 (+0/-0.003*)	+0/-0.05 (+0/-0.002*)	+0.05/-0 (+0.002/-0*)	+0.02/-0 (+0.001/-0*)		+/-0.046 (+/-0.0018*)						
VSCL7US	135.00 (5.315")	80.00 (3.150")	50.00 (1.968")	10.00 (0.394")	26.0 (1.02")	55.00 (2.165")	40.0 (1.575")	5/16-18 UNC	20.00 (0.787")	1/2-14 NPT x 10.0 (0.39)	18.00 (0.709")	45.00 (1.772")
VLCL7US	175.00 (6.890")	90.00 (3.543")	50.00 (1.968")	10.00 (0.394")	30.0 (1.18")	65.00 (2.559")	60.0 (2.36")	1/2-13 UNC	25.00 (0.984")	3/4-14 NPT x 12.0 (0.47)	23.00 (0.906")	45.00 (1.772")
VECL7US	185.00 (7.283")	100.00 (3.937")	50.00 (1.968")	10.00 (0.394")	35.0 (1.38")	65.00 (2.559")	60.0 (2.36")	1/2-13 UNC	25.00 (0.984")	3/4-14 NPT x 12.0 (0.47)	23.00 (0.906")	50.00 (1.968")

CHILL VENT POCKET DETAIL

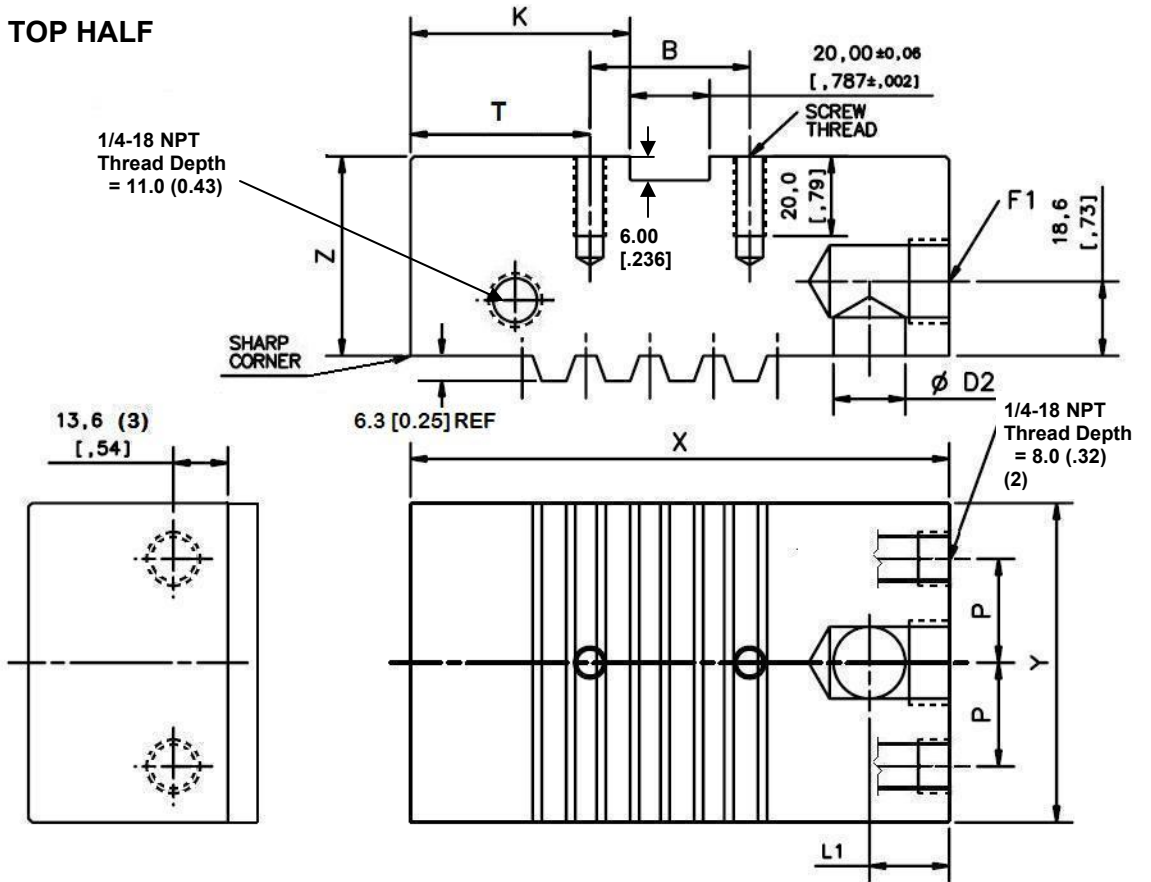


CHILL VENT INSERT — COMPONENT DETAILS

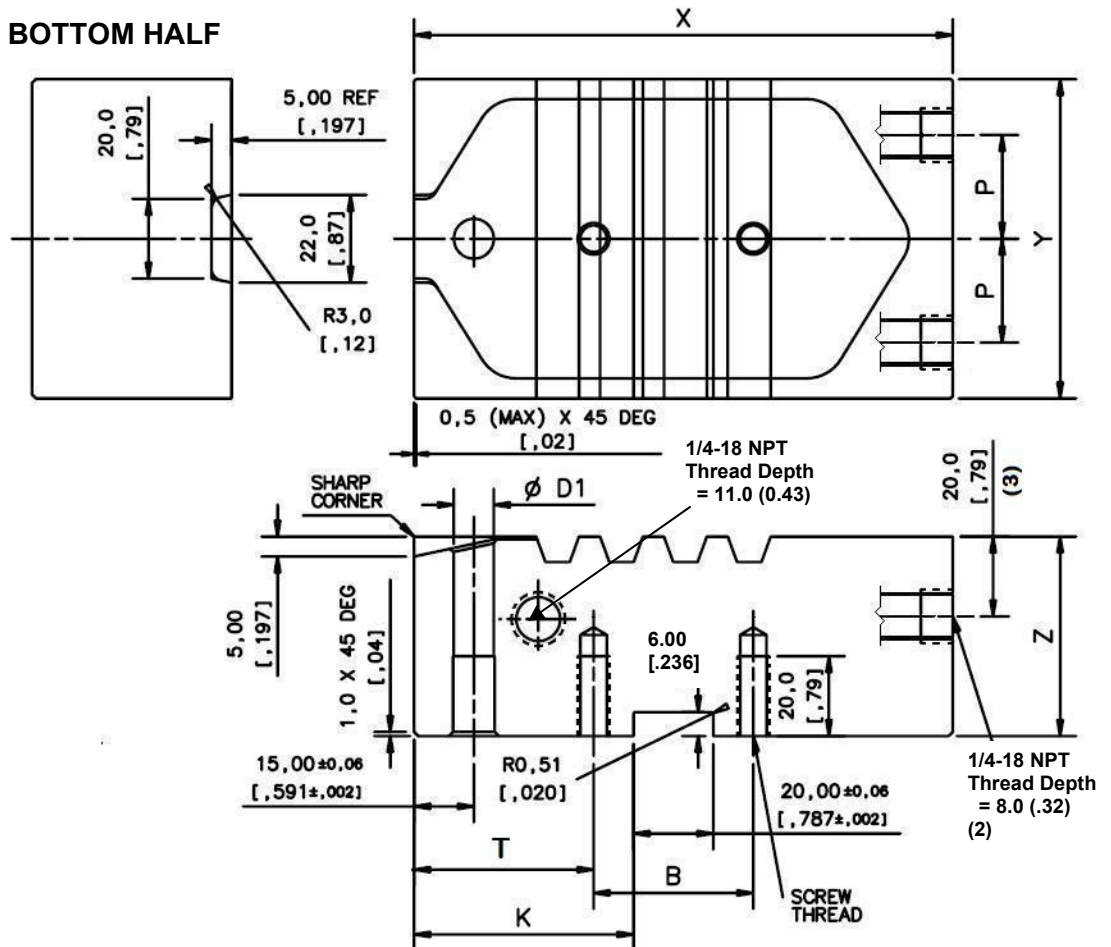
Installation Notes:

- 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.

TOP HALF



BOTTOM HALF



Dimensions shown are in millimeters (inches).

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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