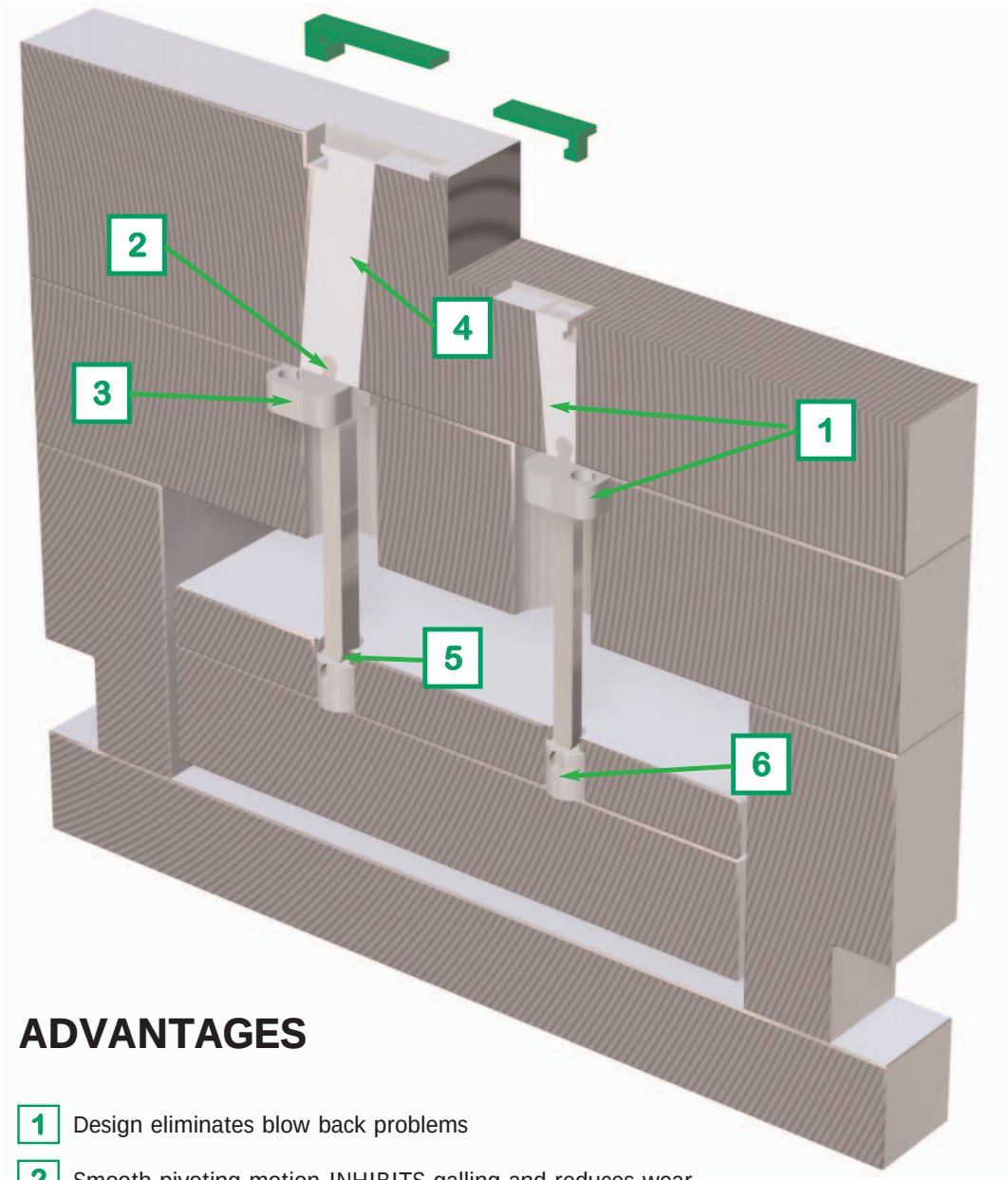
PCS COMPANY

E-Z LIFTER™

Undercut Relief System

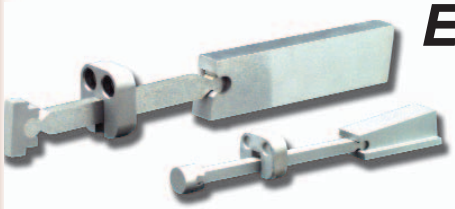
Patent No. 5,281,127



ADVANTAGES

1. Design eliminates blow back problems
2. Smooth pivoting motion INHIBITS galling and reduces wear
3. Heel plates stabilize actuator and ACT as a POSITIVE STOP for the Lifter Blank
4. Pre-hardened Lifter Blanks, no heat treat necessary
5. No moving parts in ejector plate (no wear plate assemblies OR SLIDING SHOES)
6. Simple stationary retainer installed between the ejector plates saves time and machining costs

Application Guidelines Available Upon Request



E-Z Lifter Application Guide

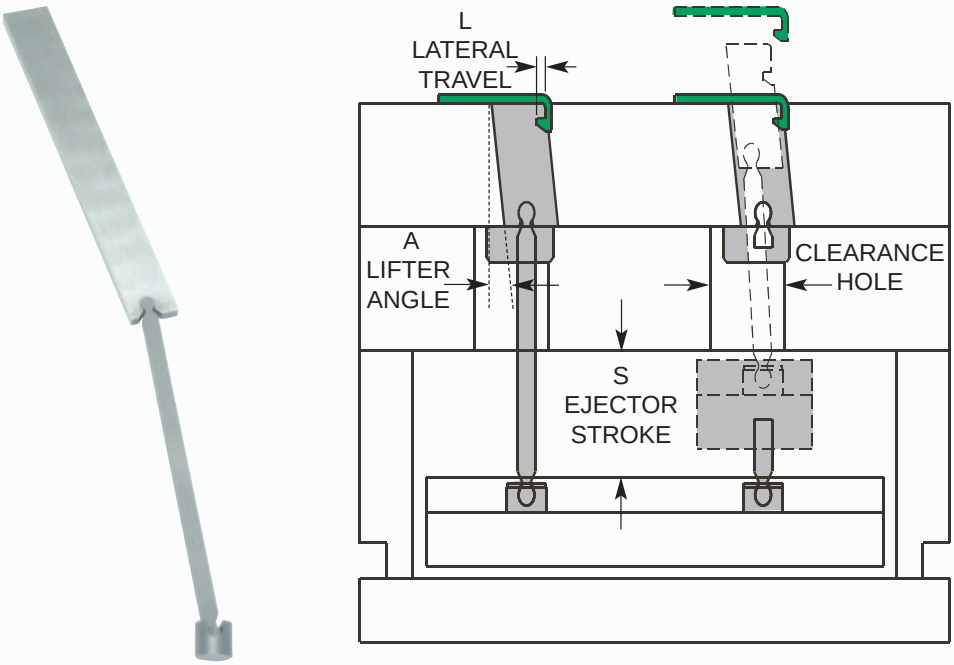
Choosing your E-Z Lifter System

Patent No. 5,281,127

1. Determine a Lifter Blank Size

A. MINI B. STANDARD C. COMPACT

2. Determine / Calculate Angle



TYPICAL EXAMPLES

EJECTION STROKE (S)	LIFTER ANGLE (A)						
	5°	6°	7°	8°	9°	10°	11°
.813	.071	.085	.100	.114	.129	.143	.158
1.063	.093	.112	.131	.149	.168	.187	.207
1.563	.137	.164	.192	.220	.248	.276	.304
2.063	.180	.217	.253	.290	.327	.364	.401
2.563	.224	.269	.315	.360	.406	.452	.498
3.063	.268	.322	.376	.430	.485	.540	.595

TO DETERMINE ANGLE

L/S = Tan A

SEE CHART FOR REFERENCE

Phone 800.521.0546
www.pcs-company.com
Fax 800.505.3299

E-Z Lifter Application Guide

Choosing your E-Z Lifter System

Patent No. 5,281,127

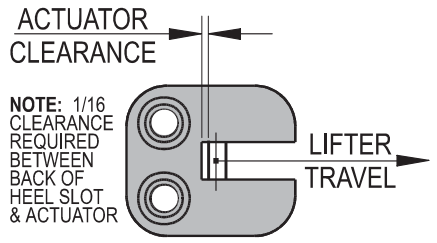
3. Choose Heel Plate Size & Position

A. Standard

B. Mini / Compact

STANDARD

MINI / COMPACT



4. Determine Retainer Type

A Heeled

B Blind Pocket

C Round

HEELED

BLIND POCKET

ROUND

5. Determine Actuator Length

A. Retainer type will determine the actuator length

B. Determine distance between the knuckle centerline of the Lifter Blank to the knuckle centerline of the Retainer while the Lifter is in the retracted position

NOTE: Blank length, ejector plate thickness, or retainer position can be adjusted to accommodate standard actuator lengths.

Phone 800.521.0546
www.pcs-company.com
Fax 800.505.3299

E-Z Lifter ™ Application Guide

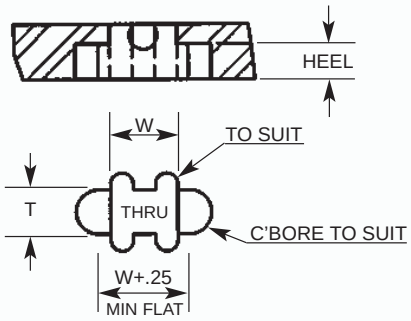
Patent No. 5,281,127

Retainer Pockets

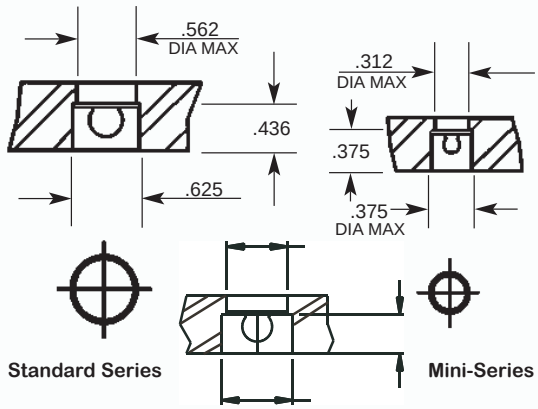
Retainers come in three styles:
- Heeled
- Round
- Blind Pocket

Retainers secure the lower knuckle of the Actuator to the ejector assembly. Pocket machining details are shown for most standard mold base assemblies in the illustration below.

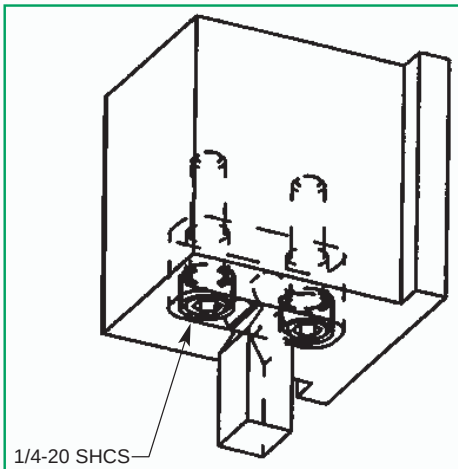
Blind Pocket Retainers are designed to be used at either end of the Actuator:
Pocket into the bottom of large custom made lifters for linkage to the ejector assembly.
Pocket into the pin plate or ejector plate for retrofit situations or as an alternate to the heeled and round retainers. See illustrations below for examples of these applications.



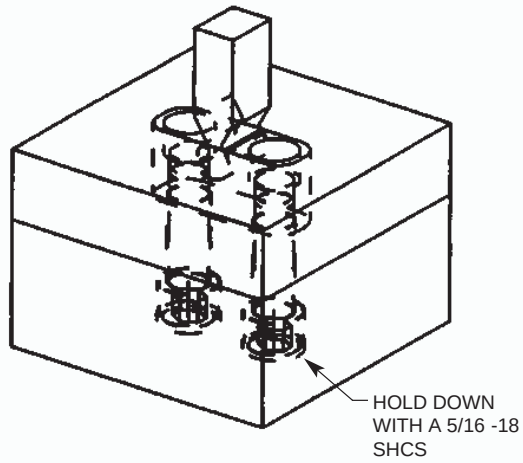
Typical Heeled Retainer Pocket



Typical Round Retainer Installation



Blind Pocket Retainer used with a custom Lifter Blank



Blind Pocket Retainer in the Ejector Plates

Centering Washer

The centering washer with the round retainers is necessary to keep the axis of the Actuators centered in the round Retainer pocket. This washer in conjunction with the heel plate assures that the thrust will be along the axis of the Actuator. The illustration at the right is a typical installation of the round retainer with the centering washer.
When adjusting final height on the retainer, grind only the bottom surface of the retainer as shown below.