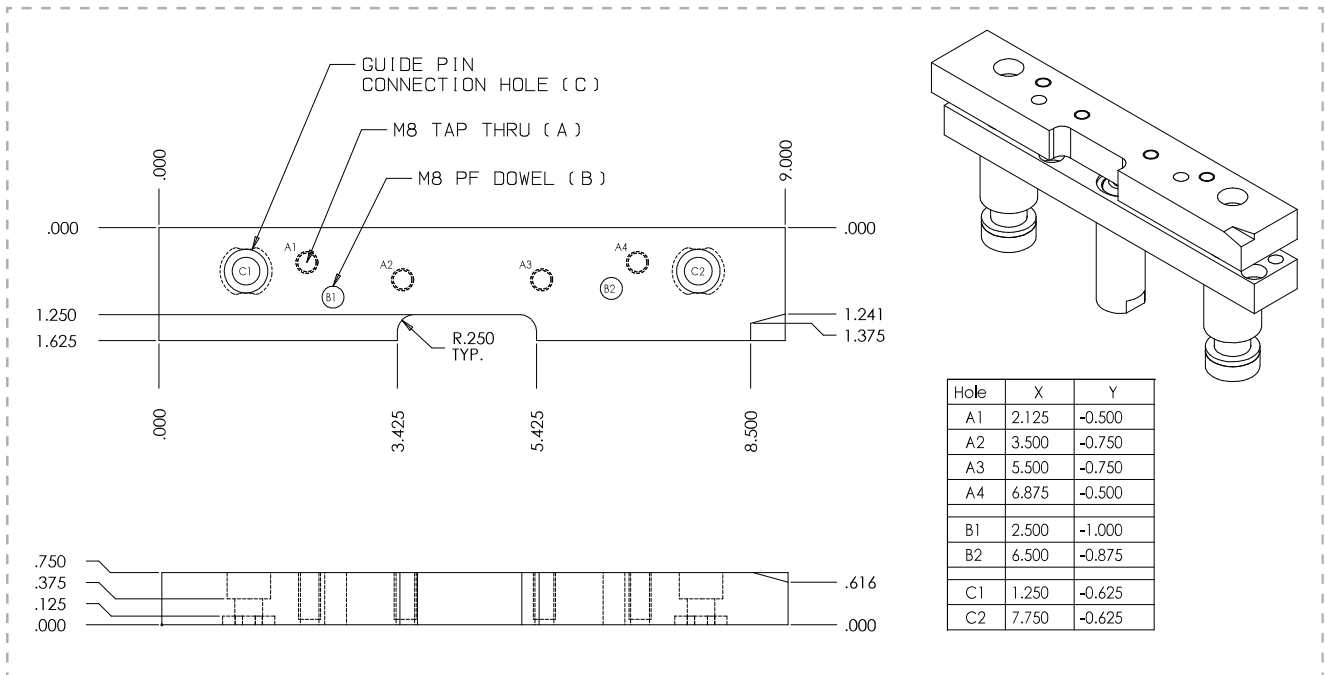


# Made to Order Top Plates



SL will machine all necessary holes, contours, pockets, etc., in the Top Plate for you. This option provides the following advantages:

## 1. High Quality

Standard Lifters uses the latest technology in machines and tooling, providing your Top Plates with accurately machined features every time. All machined entities receive a rust preventative coating through a Black Oxide Process.

## 2. No In-House Machining Needed

No need for a secondary Top Plate set up or scheduled time in the CNC department.

## 3. Bolt On Ready

The diemaker can open the box and assemble the lifter on the die shoe, and immediately install any details that attach to the Top Plate such as stock guides.

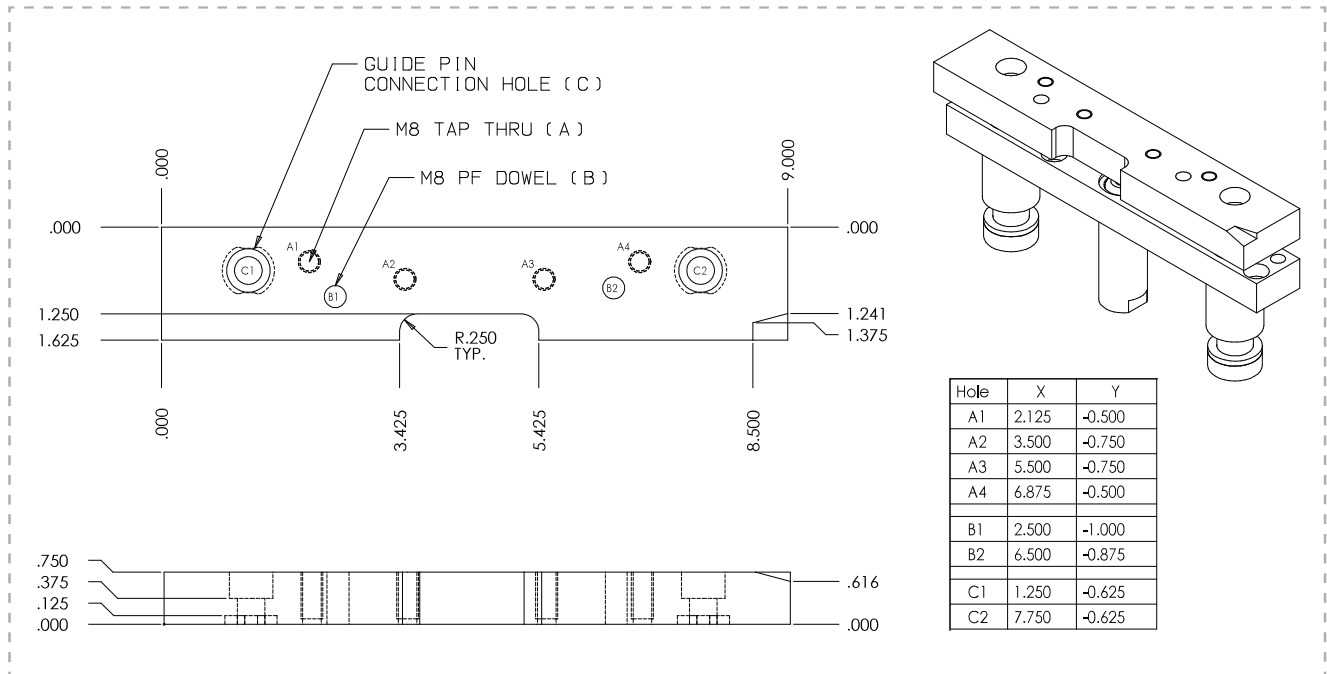
## 4. Consistent and Accurate

Standard Lifters machines all features including the Guide Pin connections at the same time. This ensures that all machined entities are accurately related to each other. Mistakes are typically made when the Top Plate is setup for additional machining.

Currently over 50% of all SL Lifters sold feature "Made To Order Top Plates." These customers have realized the advantages listed above and are benefiting from them.

*Note: 3D contour machining is not available*

# Made to Order Top Plate Dimensioned Print Example



## Another Option

If you desire a Top Plate that is a custom length and width, but would prefer to do the machining in-house, please do the following:

1. Send us a print of the Top Plate
2. Dimension the Length, Width and Locations of the Guide Pins
3. Note on the print that you will be performing the additional machining in-house

# Made to Order Top Plate Checklist

*\*In short, we send your file to our machining department and all of the dimensions and information they require need to be on your print.*

- We prefer that the file be sent as a PDF
- Make all lines/arcs/dimensions Black in color
- Remove all Lifter Base entities from print
- Create Side Views as needed - especially for Top Plates that are not standard thickness
- Guide Pin connection holes need to be shown and locations dimensioned
- Reamed Holes need to be labeled for fit and the depth dimensioned
- Contours need to be fully dimensioned
- Dimension off a corner not a hole - preferably off the back left or front right corner
- Dimension's need to include a callout in English units even if Metric is primary
- If the tolerance of your dimension is not noted, we will use the chart shown below to determine it

## Tolerances:

	<b>Fractional</b>	<b>Angular</b>	<b>2 Place Dec.</b>	<b>3 Place Dec.</b>	<b>4 Place Dec.</b>
<b>English</b>	+ - 1/16"	+ - 5 Deg.	+ - .010"	+ - .001"	+ - .0003"

## Unless otherwise specified ...

- Reamed Holes will be 1.5 times diameter deep or through
- Tapped holes will be 2 times diameter deep or through
- Contours will have a tolerance of +/- .003"
- Reamed holes will be machined with a nominal ream
- All sharp edges will be chamfered or deburred
- If a hole is dimensioned without a call out it will be assumed to be a drilled hole