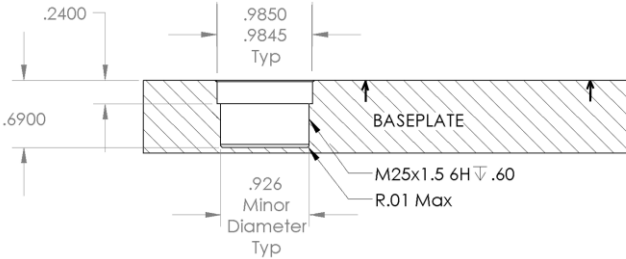


Your Elijah Tooling, Inc. Speedilok™ Smart Locator\* is a unique product used to locate and hold any two objects securely and accurately. It consists of a male locator, called the Post Locator, which mates with a female locator, called the Receiver Locator. These locators have been manufactured to very exacting dimensions to facilitate precise locating capabilities. In order to make best use of this product it is necessary to install them per the following instructions, being careful to hold the precise dimensions shown. Although it is unnecessary to use liners or bushings in conjunction with this product, it may be desirable, especially in soft metals to improve the longevity of the tool. Should that be the case it is necessary to provide a bushing or liner that has an internal diameter of the same dimensions as shown. For the purposes of instruction, a quick change plate will serve as the application for which the product is used, however, Speedilok™ Smart Locators can be used anywhere that accurate locating and superior holding capabilities are required.

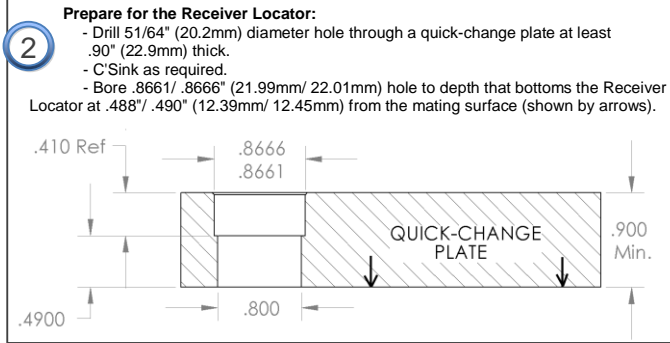
**INSTALLATION INSTRUCTIONS**

Usage of your Speedilok™ Smart Locator (-11 or -15 Assy) requires simple preparation of the Post Locator side (-1 or -5) in the baseplate and the Receiver Locator (-3) in the quick change plate. The -3 can be used interchangeably with the -1 or -5 Post.

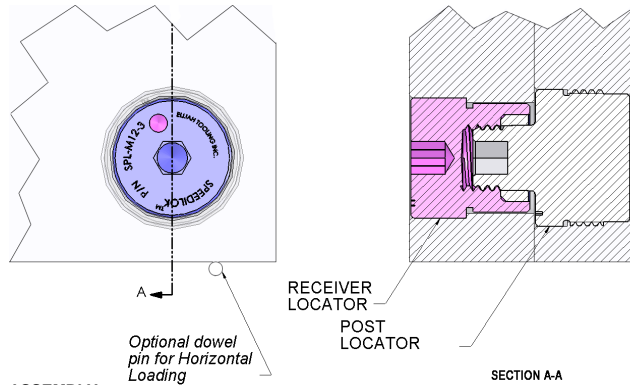
- 1 Prepare for the Post Locator (or non-locator):**
- Drill / C Bore .926" (23.5mm) diameter hole to .690" ± .001" (17.52mm) depth in a baseplate that is at least .75" (19mm) thick.
  - C Sink as required.
  - Tap or thread M25x1.5 6H to a depth of .60" (15.2mm) from the face.
  - Bore .9845/.9850" (25 mm/ 25.02 mm) hole to .240" +.01/-00 (6.1 mm) depth.
  - Using a M6 hex wrench, screw the Post Locator into the hole until it bottoms. The face of the Post Locator should be .010" (.254mm) below the surface. A small amount of resistance should be felt as the Post Locator is screwed in since there is a slight amount of interference between the Locator and bore. Arrows show the mating surface with the quick-change plate.



**Further preparation when Horizontal Machining:**  
 If the quick change plate is heavy and the operator is hand loading it onto the baseplate, it may be desirable to drill (2) dowel pin locations in the baseplate to take the load of the plate before trying to align the Receiver Locator with the Post Locator.



Cross section of Speedilok™ Smart Locator in Assembly



**ASSEMBLY**  
 Drop the Receiver Locator into the bored hole in the quick-change plate. The fit should be close, but the locator should move easily in the hole. Align plate and Locator over the Post Locator and make 2 1/2 turns (or until tight) with a M6 hex wrench to lock down the Receiver Locator. When loading and unloading the quick-change plate do not remove the Receiver Locator - just leave it in the hole. Should you wish to remove it, either use a magnetized hex wrench or screw in a M4x.7 cap screw into the hole on the face of the Receiver and pull it out.

**Privoso:** The Speedilok™ Smart Locator Assembly is not certified to any specification. If loading is a concern, you should perform your own load analysis prior to usage in an application.

\*Patent Pending

**LIMITED WARRANTY** (can also be found at [www.invert-a-bolt.com](http://www.invert-a-bolt.com))

We warrant that within 90 days from the date of shipment, if the product manufactured by us and sold by us (or an authorized distributor) is in the possession of the original buyer, we will replace or repair, at our option, free of charge, any part or parts which upon examination are found to be defective in workmanship or material, and not due to normal wear, provided that, upon our request, the product or parts thereof are returned to our location, with accompanying documentation that the product has been installed, used and maintained in accordance with instructions and has not been subject to abuse. We shall not be liable or responsible for any expense or liability for repairs, additions, or modifications made upon the product without our written consent. This warranty is in lieu of all other express or implied warranties (including without limitation any warranty of merchantability or fitness for a particular purpose.) In no event shall we be liable for any indirect, special, or consequential damages (including, but not limited to, lost profits or other damages from loss of production) caused by defective material, or by unsatisfactory performance of the product, or by any other breach of contract by us. The Elijah Tooling, Inc. Warranty shall apply in all cases to all products manufactured by us and sold by us. Elijah Tooling, Inc. reserves the right to modify or change the design of products shown in this specification/instruction sheet, without notice. Such modifications or changes may include, but are not limited to, changes in finish, materials, specifications, etc., from descriptions and illustrations of products listed herein.

