



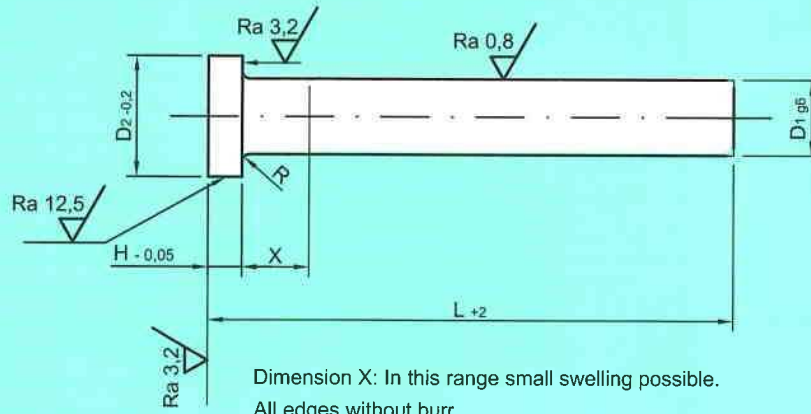
Ejector pins "Nini" Type A

nitrided
- with cylindrical head
- with **bright** surface



DIN ISO 6751

(former DIN 1530 Part 1)



Application

For demoulding of parts from compression- or injection moulds, particularly when high temperatures are required, e.g. for the processing of thermoset material. By all means, these pins can also be used in diecasting dies.

Dimensions

Refer to chart overleaf, all dimensions are shown in "mm".

Tolerances

Shaft diameter D_1

	1,5 - 3 Ø	3,2 - 6 Ø	6,2 - 10 Ø	10,2 - 18 Ø	20 - 25 Ø	32 Ø
g 6	- 0,002	- 0,004	- 0,005	- 0,006	- 0,007	- 0,009
	- 0,008	- 0,012	- 0,014	- 0,017	- 0,020	- 0,025

Overall length: $L + 2$

For other tolerances please refer to drawing and chart. Untoleranced dimensions according to DIN ISO 2768-m.

Material

Hot work steel (WAS), fit for nitriding
Material-No. 1.2343 (X 38 Cr Mo V 51)
1.2344 (X 40 Cr Mo V 51)

Characteristic

Tempering properties approx. 600° C / 1112° F

Hardness

Shaft: Core hardness min. HRC 44 (approx. 1400 MPa)
Surface: plasma nitrided to approx. HRC 70 (950 - 1100 HV 0,3 kp). Because of the thin nitrided layer only checking according to Vickers max. 0,3 kp is allowed.
Head: HRC 45 ±5 (1250 - 1670 MPa)

Finish

Ground shaft, hot forged cylindrical head, plasma nitrided, bright surface, conserved.

Remarks

Due to bright surface discolouration of mouldings is avoided. Easy cutting of DREI-S ejector pins to any required length is possible avoiding the chip-off of nitrided layer.

Shaft-Ø D ₁ g6	Head-Ø D ₂ -0,2	Head-height H -0,05	Radius R +0,2	Overall length L +2														
				100	125	160	200	250	315	400	500	630	800	1000				
1,5	3	1,5	0,2															
2,0	4	2																
2,2																		
2,5			5	0,3														
2,7																		
3,0	6	3	0,3															
3,2																		
3,5				7	0,5													
3,7																		
4,0	8	5	0,5															
4,2																		
4,5				10	0,8													
5,0																		
5,2	12	7	0,8															
5,5																		
6,0				14	1,0													
6,2																		
6,5	16	10	1,0															
7,0																		
7,5																		
8,0	18	12	1,0															
8,2																		
8,5	22	14	1,0															
9,0																		
9,5				24	1,0													
10,0																		
10,2	26	16	1,0															
10,5																		
11,0																		
12,0	18	18	0,8															
12,2																		
12,5	22	20	0,8															
14,0																		
16,0				24	8	1,0												
18,0																		
20,0	32	10	1,0															
25,0																		
32,0	40	10	1,0															

The marked squares indicate **DREI-S** standard sizes.
Other sizes on request.

Please note

The "Nini's" are also available with **TiN-coating** (PVD-treatment).
 This special process extends the service life of **DREI-S** ejector pins even further.
 Ask for quotation.