



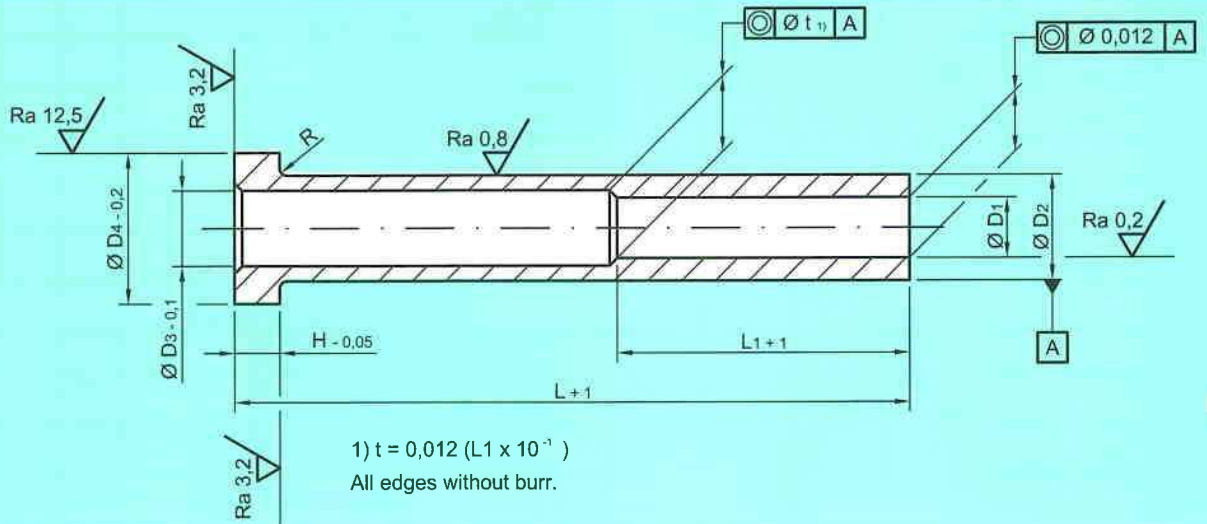
# Ejector sleeves

**nitrided**

- with cylindrical head

## DIN ISO 8405

(former DIN 16756)



### Application

For demoulding of parts from injection moulds or diecasting dies, particularly for processing of refractory metal alloys. The ejector sleeves operate like ejector pins and strip-off mouldings along fixed core pins.

### Dimensions

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

### Tolerances

Internal diameter  $D_1$

H5	1,5 - 3 $\varnothing$	3,2 - 6 $\varnothing$	6,2 - 10 $\varnothing$	12 $\varnothing$
	+ 0,004	+ 0,005	+ 0,006	+ 0,008

Shaft diameter  $D_2$

g6	3 $\varnothing$	4 - 6 $\varnothing$	8 - 10 $\varnothing$	12 - 16 $\varnothing$
	- 0,002	- 0,004	- 0,005	- 0,006
	- 0,008	- 0,012	- 0,014	- 0,017

Clearance hole  $D_3 - 0,1$

Overall length  $L + 1$

Guiding length  $L_1 + 1$

For other tolerances please refer to drawing or 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

Internal diameter D <sub>1</sub> H 5	Shaft-Ø D <sub>2</sub> g6	Clearance hole D <sub>3</sub> -0,1	Head-Ø D <sub>4</sub> -0,2	Head height H -0,05	Radius R +0,2	Honed length L <sub>1</sub> +1	Overall length L + 1												
							75	100	125	150	175	200	225	250	275	300			
1,5	3	1,8	6	3	0,3	35													
2,0																			
2,2	4	2,5 (2,4)	8																
2,5	5	3,0	10																
2,7																			
3,0		3,5 (3,3)																	
3,2		3,5																	
3,5	6	4,0	12	5	0,5	45													
3,7																			
4,0		4,5 (4,3)																	
4,2	8	4,5	14																
5,0		5,5 (5,3)																	
5,2		5,5																	
6,0	10	6,5 (6,3)	16																
6,2		6,5																	
8,0		8,5 (8,3)																	
8,2	12	8,5	20	7	0,8														
10,0	14	10,5	22																
12,0		12,5																	
12,5	16	13,0																	

The marked squares indicate **DREI-S** standard sizes.

**Other sizes on request.**

**Hardness**                      Shaft:                                      Core hardness approx. HRC 44 (approx. 1400 MPa)

   Surface:                                      Shaft and bore hole 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**                                      Shaft nitrided and fine ground, guide hole honed, nitrided, hot forged cylindrical head, conserved.

**Remarks**                                      On request sleeves are supplied together with core- or ejector pins.  
Please indicate when ordering.  
The pins are approx. 50 mm longer than the sleeves.

**The sleeves are also available as stepped design, on request**