

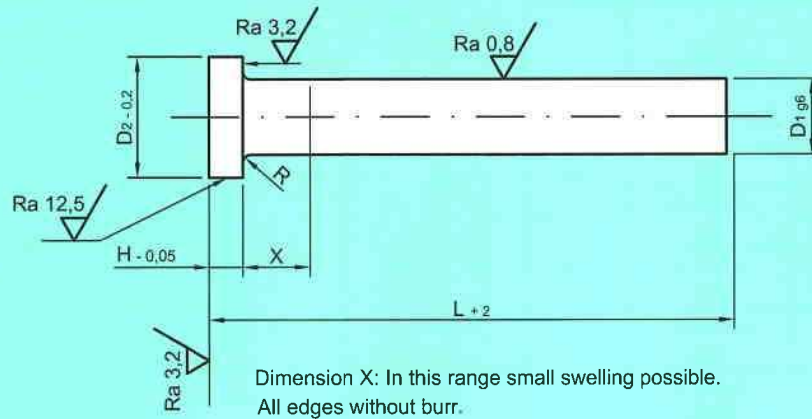


Ejector pins / Core pins Type A

non-nitrided
- with cylindrical head

similar to DIN ISO 6751

(former similar to DIN 1530 Part 1)



Application

Application as core pin or profiled ejector pin.
Machining to any required dimension or shape is possible.

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 - 12 Ø	20 Ø
g 6	- 0,002	- 0,004	- 0,005	- 0,006	- 0,007
	- 0,008	- 0,012	- 0,014	- 0,017	- 0,020
minus approx. 4µm for the following nitriding.					

Overall length $L + z$

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: min HRC 44 (approx. 1400 MPa)
Head: HRC 45 ±5 (1250 - 1670 MPa)

Finish

Ground shaft, hot forged cylindrical head, stress-relieved, conserved

Remarks

Please avoid extreme heating (blue colouring) during turning or milling operations, by using a qualified cooling agent.
Stock removal only with one cut is recommended.

The nitriding treatment should be carried out by a well-experienced nitriding shop.
A surface hardness of approx. HRC 70 (950 - 1100 HV 0,3 kp) can be obtained.

Shaft-Ø D ₁ g6	Head-Ø D ₂ -0,2	Head-height H -0,05	Radius R +0,2	Overall length L + 2												
				60/63	80	100	125	160	200	250	315	400	500	630		
1,5	3	1,5	0,2													
2,0	4	2														
2,2																
2,5	5	3	0,3													
2,7																
3,0	6	5														
3,2																
3,5	7	7														
3,7																
4,0	8	8														
4,2																
4,5	10	10														
5,0																
5,2	12	12	0,5													
5,5																
6,0	14	14														
6,2																
6,5	16	16														
7,0																
7,5	18	18														
8,0																
8,2	20	20														
8,5																
9,0	22	22														
9,5																
10,0	24	24														
10,2																
10,5	26	26														
11,0																
12,0	28	28														
12,2																
12,5	30	30														
14,0																
16,0	32	32														
18,0																
20,0	34	34	1,0													

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