



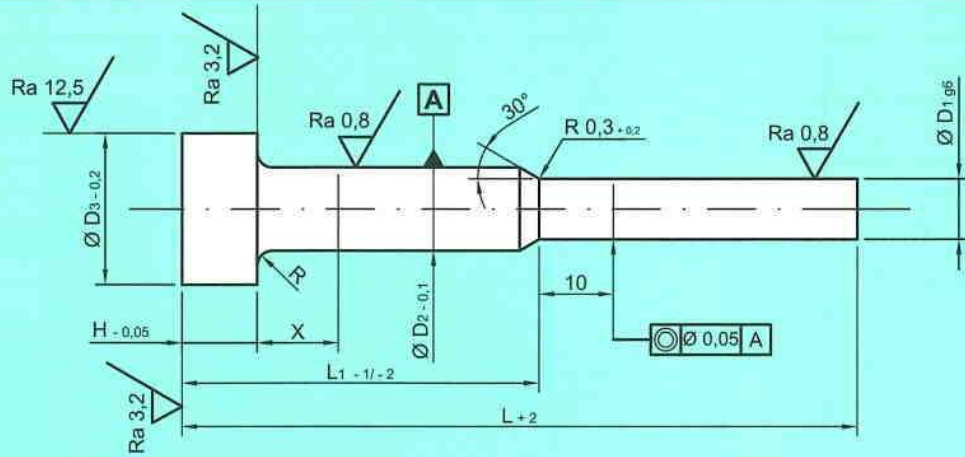
Ejector pins Type C

DIN ISO 8694

(former DIN 1530 Part 2)

nitrided

- with cylindrical head and shouldered shaft
- coated with MoS₂-gliding laquer



Dimension X: In this range small swelling possible.
All edges without burr.

Application

For demoulding of parts from diecasting dies, particularly for processing of refractory metal alloys. The shouldered, nitrided ejectors are especially used where extremely high loads are put on the buckling strength.

Dimensions

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

Tolerances

Shoulder diameter D₁

	0,80 - 2,50 Ø
g6	- 0,002 - 0,008

Shaft diameter D₂ - 0,1

Length: Overall L + 2
Shaft L₁ - 1/- 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/shoulder: Core hardness min. HRC 44 (approx. 1400 MPa)
Surface: plasma nitrided and black oxidized* 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 and shouldered portion are ground, hot forged cylindrical head, plasma nitrided and black oxidized*, coated with MoS₂-gliding laquer. * Advantages see below page 3 and 8 (AV03).

Shoulder-Ø	Shaft-Ø	Head-Ø	Head height	Radius	80	100	125	160	200	Overall length L +2 Shaft length L ₁ -1/-2 approx. length of shouldered portion
D ₁ g6	D ₂ -0,1	D ₃ -0,2	H -0,05	R +0,2	32 (35)* 48 (45)*	50 50	50 75	63 (75)* 97 (85)*	80 (75)* 120 (125)*	
0,8	2	4	2	0,2						
0,9										
1,0										
1,1										
1,2										
1,3										
1,4										
1,0	3	6	3	0,3						
1,5										
1,6										
1,7										
1,8										
1,9										
2,0										
2,2										
2,5										

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

Other sizes on request.

* On all lengths put in brackets stock keeping is running out, manufacturing only on request.

Remarks

Due to coating with MoS₂-gliding lacquer almost non-abrasive surface condition.
 Contamination of dies is avoided.
 Optimal emergency running properties.
 Easy cutting of **DREI-S** ejector pins to any required length is possible avoiding the chip-off of nitrided layer.
 Ejector pins, type C are also available in **imperial sizes**.
 Please ask for quotation.