



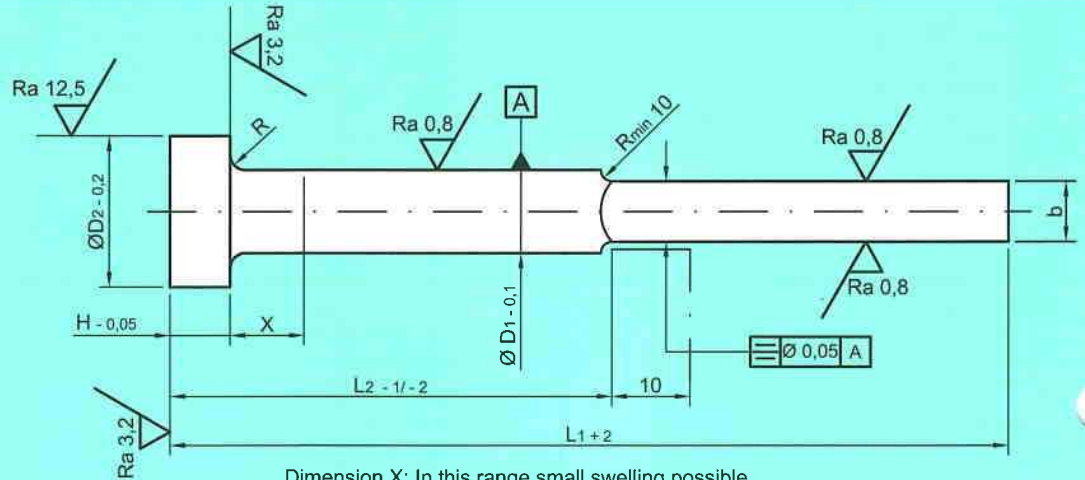
Flat ejectors Type F

DIN ISO 8693

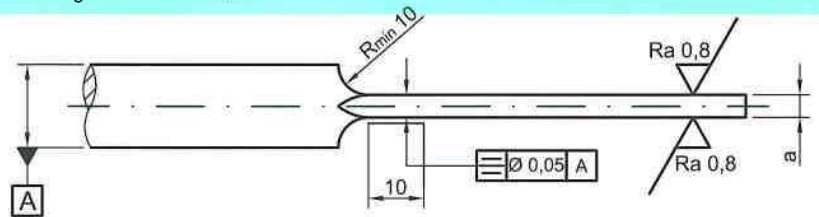
(former DIN 1530 Part 4)

nitrided

- with cylindrical head
- with flat shoulder



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.
Flat ejector pins are always used in places, where the application of round ejector pins is not favourable.

Dimensions

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

Tolerances

Rectangle size $a - 0,015 + b - 0,015$
Shaft diameter $D_1 - 0,1$
Length: Overall $L_1 + 2$
Shaft $L_2 - 1/-2$

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

Hardness

Shaft/flat 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 flat shoulder are ground, hot forged cylindrical head, plasma nitrided and black oxidized*, conserved.

Remarks

Easy cutting of DREI-S ejector pins to any required length is possible avoiding the chip-off of nitrided layer.

* Advantages see below page 3 and 8 (AV03).

Chart

Item No. AF02

Blade portion b + a -0,015	Shaft-Ø D ₁ -0,1	Head-Ø D ₂ -0,2	Head-height H -0,05	Radius R +0,2	63	80	100	125	160	200	250	315	400	Overall length L1 +2 Shaft length L2 -1/-2 approx. length of blade portion		
					32	40	50	63 (60)*	80	100	125	160	200			
3,5 x 1,0	4,0	8	3	0,3												
3,5 x 1,0	4,2															
3,8 x 0,8																
3,8 x 1,0																
3,8 x 1,2																
4,5 x 1,0	5,0				10											
4,5 x 1,2																
4,5 x 1,5																
5,5 x 1,0	6,0	12	5	0,5												
5,5 x 1,2																
5,5 x 1,5																
5,5 x 2,0																
7,5 x 1,2	8,0	14														
7,5 x 1,5																
7,5 x 2,0																
9,5 x 1,5	10,0	16														
9,5 x 2,0																
11,5 x 2,0	12,0	18	7	0,8												
11,5 x 2,5																
15,5 x 2,0	16,0	22														
15,5 x 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**.