

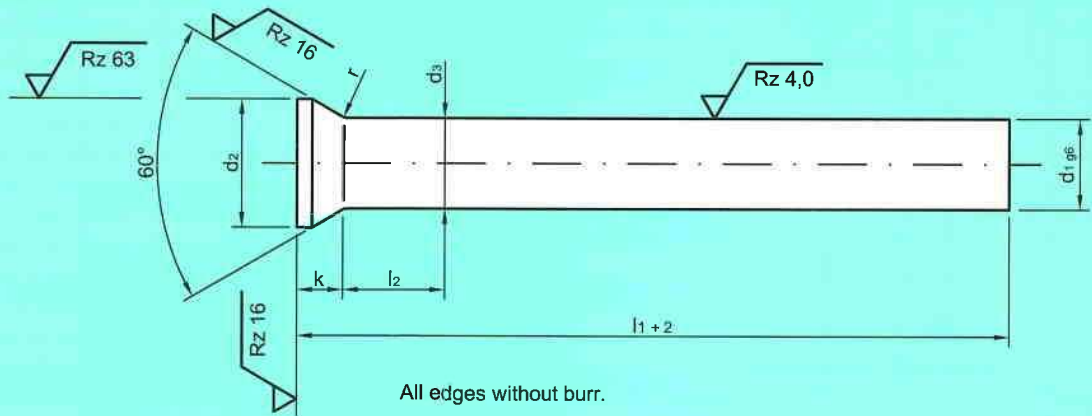


# Ejector pins Type DN

**nitrided**

- with 60°- conical head
- coated with MoS<sub>2</sub>-gliding lacquer

DIN 1530 Part 3



## Application

For demoulding of parts from diecasting dies, particularly for processing of refractory metal alloys.

## Dimensions

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

## Tolerances

Shaft diameter  $d_1$

	1,5 - 3 Ø	4 - 6 Ø	8 - 10 Ø	12 - 16 Ø
g 6	- 0,002	- 0,004	- 0,005	- 0,006
	- 0,008	- 0,012	- 0,014	- 0,017

Overall length  $l_{1+2}$

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: Core hardness approx. to 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

Ground shaft, hot forged 60°-conical head, plasma nitrided and black oxidized\*, coated with MoS<sub>2</sub>-gliding lacquer.

## Remarks

Due to coating with MoS<sub>2</sub>-gliding lacquer almost non abrasive surface condition.

Optimal emergency running conditions. Due to the small head diameter, these pins offer the advantage that mounting into the mould with minimum centre-to-centre distances is possible.

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).

Shaft-Ø d <sub>1</sub> g6	Head-Ø d <sub>2</sub>	Head-Ø- Tol. ± 0,05	Head height k +0,2	Radius r	Swelling d <sub>3</sub>	Length of swelling l <sub>2</sub>	Overall length l <sub>1</sub> + 2								
							100	125	160	200	250	315	400		
1,5	2,2	± 0,1	1,11	0,4 <sup>+0,3</sup>	d1 +0,03	5									
2,0	3,0		1,37				0,6 <sup>+0,4</sup>								
2,5	3,5														
3,0	4,5														
4,0	5,5		± 0,2	1,8			1,0 <sup>+0,5</sup>	d1 +0,04	10						
5,0	6,5			2,73						1,5 <sup>+0,5</sup>					
6,0	8														
8,0	10														
10,0	12	3,23													
12,0	14														
14,0	16														
16,0	18														

The marked squares indicate **DREI-S** standard sizes.  
**Delivery is possible while stocks last, then only on request.**