

2-STAGE EJECTORS

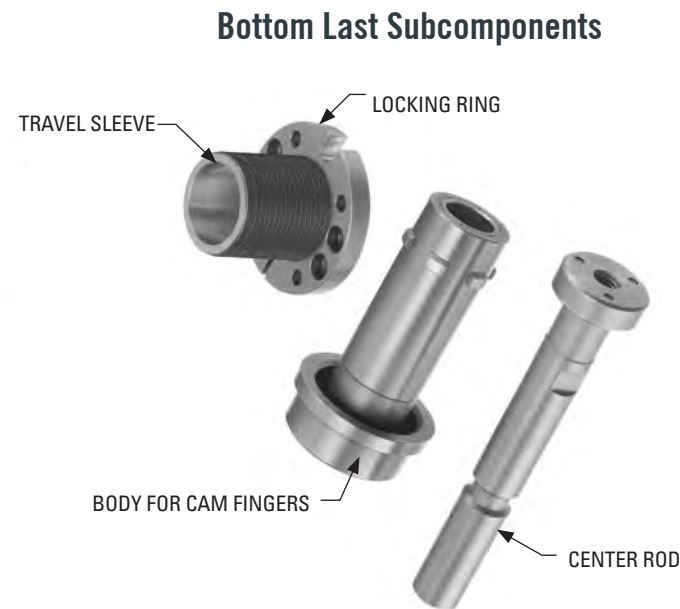
Benefits

Positive, Precise Plate Control

DME 2-Stage Ejectors (TS) adapt to a number of mold base sizes and plate thicknesses. They are available in two ejection sequences: Top Last (TL) and Bottom Last (BL). Each ejection sequence is available in three sizes to accommodate most standard DME mold bases. The stroke range for each ejection stage is determined and fixed by the customer by cutting the Center Rod to the desired length (both TL and BL types) and by also cutting the Travel Sleeve to the desired length (BL type only). Once installed, the DME 2-Stage Ejector ensures positive, precise control of the sequence and distance of each stroke of the two ejector plates. Once installed, there are no adjustments that can be accidentally changed.

Benefits

- Both the first stage and second stage strokes are set independently
- Easy set-up and installation
- Fixed strokes cannot be tampered with or accidentally modified
- Internal installation – avoids interferences with water line connectors and externally mounted components
- Utilizes latching mechanism similar to DME Internal Latch Lock for smooth operation and guidance
- Three sizes to choose from for each style, to accommodate most standard DME mold bases
- Hardened steel components for long life



NOTE: Puller Pins are not shown. Puller Pins must be purchased separately.

2-STAGE EJECTORS

Size and Quantity Selection Guidelines

- Select 20mm diameter (small), 26mm diameter (medium), or 32mm diameter (large) 2-Stage Ejector based on the width of the mold base (large molds, thick plates or heavy load applications may require the next size assembly).
- Determine the travel range for each ejection stroke (first and second), being careful not to exceed the maximum stroke specified for the chosen 2-Stage Ejector style and size. This selection is based on the specific application.
- In general, a minimum of two 2-Stage Ejectors are required. For larger molds, thick plates, or an application where loads are near maximum, additional assemblies and/or larger assemblies may be required. An application must never exceed the maximum recommended load values.
- A balanced load must be maintained to avoid cocking and binding which could cause severe overloading. Only one size of 2-Stage Ejectors should be used in each mold base.

2-STAGE EJECTOR ASSEMBLY ITEM NUMBER	BASIC CENTER ROD DIA	STROKE 1		STROKE 2		RECOMMENDED MAXIMUM MOLD BASE WIDTH	MAXIMUM RECOMMENDED LOAD VALUES (PER ASS'Y)		
		MINIMUM	MAXIMUM	MINIMUM	MAXIMUM		STATIC	DYNAMIC	
2-STAGE EJECTOR TOP LAST (TS TL)									
TSTL20A	20mm (Small)	4.0	79.0	4.0	79.0	Up to 200mm, 1 TL20 Up to 450mm, 2 TL20	5.8 kN	0.58 kN	mm
		.16	3.11	.16	3.11	Up to 8", 1 TL20 Up to 18", 2 TL20	1300 lbf	130.0 lbf	in
TSTL26A	26mm (Medium)	6.0	84.0	6.0	84.0	Up to 450mm, 1 TL26 Up to 600mm, 2 TL26	10.8 kN	1.08 kN	mm
		.24	3.31	.24	3.31	Up to 18", 1 TL26 Up to 26", 2 TL26	2428 lbf	242.8 lbf	in
TSTL32A	32mm (Large)	8.0	92.0	8.0	92.0	Up to 600mm, 1 TL32 Up to 900mm, 2 TL32	19.6 kN	1.96 kN	mm
		.31	3.62	.31	3.62	Up to 26", 1 TL32 Up to 35.5", 2 TL32	4406 lbf	440.6 lbf	in
2-STAGE EJECTOR TOP LAST (TS BL)									
TSBL20A*	20mm (Small)	8.0	82.0	12.0	82.0	Up to 200mm, 1 BL20 Up to 450mm, 2 BL20	5.8 kN	0.58 kN	mm
		.32	3.23	.47	3.23	Up to 8", 1 BL20 Up to 18", 2 BL20	1300 lbf	130.0 lbf	in
TSBL26A*	26mm (Medium)	10.0	92.0	18.0	92.0	Up to 450mm, 1 BL26 Up to 600mm, 2 BL26	10.8 kN	1.08 kN	mm
		.40	3.62	.71	3.62	Up to 18", 1 BL26 Up to 26", 2 BL26	2428 lbf	242.8 lbf	in
TSBL32A*	32mm (Large)	12.0	102.0	24.0	102.0	Up to 600mm, 1 BL32 Up to 900mm, 2 BL32	19.6 kN	1.96 kN	mm
		.47	4.02	.95	4.02	Up to 26", 1 BL32 Up to 35.5", 2 BL32	4406 lbf	440.6 lbf	in

*Puller Pins are **not** included with BL Assemblies and must be ordered separately.