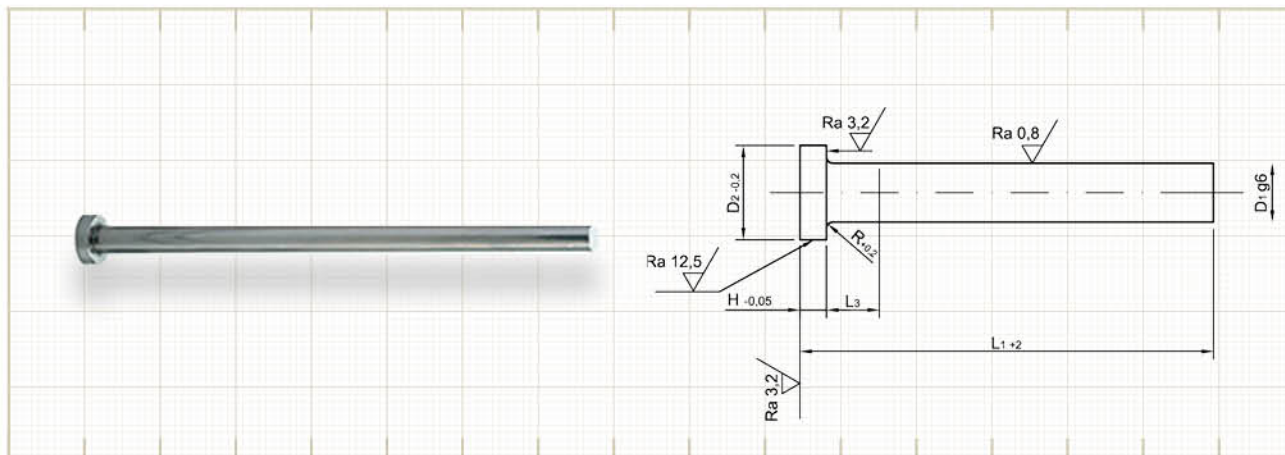


Izmetalna igla, nitrirana in polirana s cilindrično glavo in svetlim površjem.

Ejector Pin, nitrided and polished, cylindrical head and bright surface.



Obseg uporabe::

Za izmet oblikovanih delov iz orodja za tlačno ali vbrizgalno vli-vanje, posebno ko so potrebne visoke temperature, recimo pri predelavi duroplastov. Lahko se uporabljajo tudi za tlačno litje.

Dimenzije so prikazane v tabeli.

Prileganje / Toleranca:

Premier D_1 , dolžina L_2

Ø	1,5 - 3	3,2 - 6	6,2 - 10	10,2 - 18	20 - 25	32 - 40
g6	-0,002	-0,004	-0,005	-0,006	-0,007	-0,009
	-0,008	-0,012	-0,014	-0,017	-0,020	-0,025

Material:

WAS (vroča delovna kovina), primerna za nitriranje.

Št. materiala:

- 1.2343 (X38 Cr Mo V51)
- 1.2344 (X40 Cr Mo V51)

Karakteristike:

Kalična lastnost pribl.: 600°C / 1112°F

Trdota		HRC
Steblo	trdota jedra min.	44 (1400 Mpa)
Površina	plazma nitrirano pribl.	70 (950-1100 HV 0,3 kp)
Glava		45±5 (1250-1670 Mpa)

Obdelava:

Brušeno steblo, vroče kovana cilindrična glava, plazma ni-trirano, svetla površina, korozijsko odporno.

Range of application::

Injection moulding and die-casting, especially when high temperatures are required. For example, in the processing of the thermoset plastics. Can also be used for die casting.

The dimensions are shown in the table.

Fit / Tolerance:

D_1 diameter, length L_2

Ø	1,5 - 3	3,2 - 6	6,2 - 10	10,2 - 18	20 - 25	32 - 40
g6	-0,002	-0,004	-0,005	-0,006	-0,007	-0,009
	-0,008	-0,012	-0,014	-0,017	-0,020	-0,025

Material:

WAS (hot-work tool steel) suitable for nitriding.

Num. of material:

- 1.2343 (X38 Cr Mo V51)
- 1.2344 (X40 Cr Mo V51)

Material properties:

Hardened.: approximately 600 ° C / 1112 ° F

Hardness		HRC
Shank	the hardness of the core min.	44 (1400 Mpa)
Surface	plasma nitrided ap-prox .	70 (950-1100 HV 0,3 kp)
Head		45±5 (1250-1670 Mpa)

Finish:

Ground shank, hot forged cylindrical head, plasma nitrided, bright surface, non-corrosive.

Standardne mere DIN ISO 6751 NINI

Standard dimensions to DIN ISO 6751 NINI

EXACTA
NORMALIJE

D ₁ g6 [mm]	D ₂ x H -0,2 -0,05 [mm]	R +0,2 [mm]	Model A004 L ₁ + 2 [mm]										
			100	125	160	200	250	315	400	500	630	800	1000
1,00	2,5 x 1,2	0,2	●	●	●	●							
1,10			●	●	●	●							
1,20			●	●	●	●							
1,30	3x1,5		●	●	●	●							
1,40			●	●	●	●							
1,50			●	●	●	●	●						
1,60			●	●	●	●							
1,70			●	●	●	●							
1,80			●	●	●	●							
1,90			●	●	●	●							
2,00	4x2		●	●	●	●	●	●	●				
2,10			●	●	●	●	●	●					
2,20			●	●	●	●	●	●					
2,50	5x2		0,3	●	●	●	●	●	●				
2,60				●	●	●	●	●	●				
2,70		●		●	●	●	●	●					
2,80		●		●	●	●							
3,00	6x3	●		●	●	●	●	●	●	●			
3,10		●		●	●	●	●	●	●				
3,20		●		●	●	●	●	●	●				
3,30		●		●	●	●	●						
3,40		●		●	●	●	●						
3,50	7x3	●		●	●	●	●	●	●	●	●		
3,60		●		●	●	●	●	●	●				
3,70		●		●	●	●	●	●	●				
3,80		●		●	●	●	●	●	●				
4,00		8x3		●	●	●	●	●	●	●	●	●	●
4,10	●			●	●	●	●	●	●				
4,20	●			●	●	●	●	●	●	●		●	
4,30	●			●	●	●							
4,40	●			●	●								
4,50	●			●	●	●	●	●	●	●		●	
4,60	●			●	●	●							
4,70	●			●	●	●	●						
4,80	●			●	●								
4,90	●			●	●	●							
5,00	10x3	●		●	●	●	●	●	●	●	●	●	
5,10		●		●	●	●	●	●	●	●			
5,20		●	●	●	●	●	●	●	●	●	●		
5,30		●	●	●	●	●							
5,40		●	●	●	●	●							
5,50		●	●	●	●	●	●	●	●	●	●		

1 Standardne mere DIN ISO 6751 NINI

Standard dimensions to DIN ISO 6751 NINI

D ₁ g6 [mm]	D ₂ x H -0,2 -0,05 [mm]	R +0,2 [mm]	Model A004 L ₁ + 2 [mm]										
			100	125	160	200	250	315	400	500	630	800	1000
6,00	12x5	0,5	●	●	●	●	●	●	●	●	●	●	
6,10			●	●	●	●							
6,20			●	●	●	●	●	●	●	●	●	●	
6,30			●	●	●	●							
6,50			●	●	●	●	●	●	●	●	●	●	
6,60			●	●	●	●							
6,70			●	●	●	●							
6,80			●	●	●	●	●						
6,90			●	●	●	●				●			
7,00			●	●	●	●	●	●	●	●	●	●	
7,20			●	●	●	●	●	●					
7,50			●	●	●	●	●	●	●	●			
8,00	14x5		●	●	●	●	●	●	●	●	●	●	●
8,20			●	●	●	●	●	●	●	●	●		
8,50			●	●	●	●	●	●	●	●	●		
8,70			●	●	●	●							
9,00			●	●	●	●	●	●	●	●	●		
9,50			●	●	●	●	●	●	●	●			
10,00	16x5		●	●	●	●	●	●	●	●	●	●	●
10,20			●	●	●	●	●	●	●	●	●	●	
10,50			●	●	●	●	●	●	●	●	●		
11,00			●	●	●	●	●	●	●	●	●		
11,50			●	●	●	●							
12,00	18x7	0,8	●	●	●	●	●	●	●	●	●	●	●
12,20			●	●	●	●	●	●	●	●	●		
12,50			●	●	●	●	●	●	●	●	●	●	
13,00			●	●	●	●	●	●					
14,00	22x7		●	●	●	●	●	●	●	●	●	●	●
15,00			●	●	●	●	●						
16,00			●	●	●	●	●	●	●	●	●	●	●
18,00			24x7	●	●	●	●	●	●	●	●	●	●
20,00	26x8	1,0		●	●	●	●	●	●	●	●	●	●
25,00	32x10				●	●	●	●	●	●	●	●	●
32,00	40x10					●	●	●	●	●	●	●	●

Igle po naročilu, jih ni na zalogi v skladišču. Pins to order, not in stock.

Opomba: Zaradi svetle površne se izognemo spremembi barve ulitka. Igle lahko preprosto skrajšamo na katerokoli željeno dolžino, ne da bi odluščili nitrirno plast.

Note: With the bright surface we avoid discoloration of the mold. Ejector pin is simply reduced to any desired length, without nitrided layer being peeled off.

