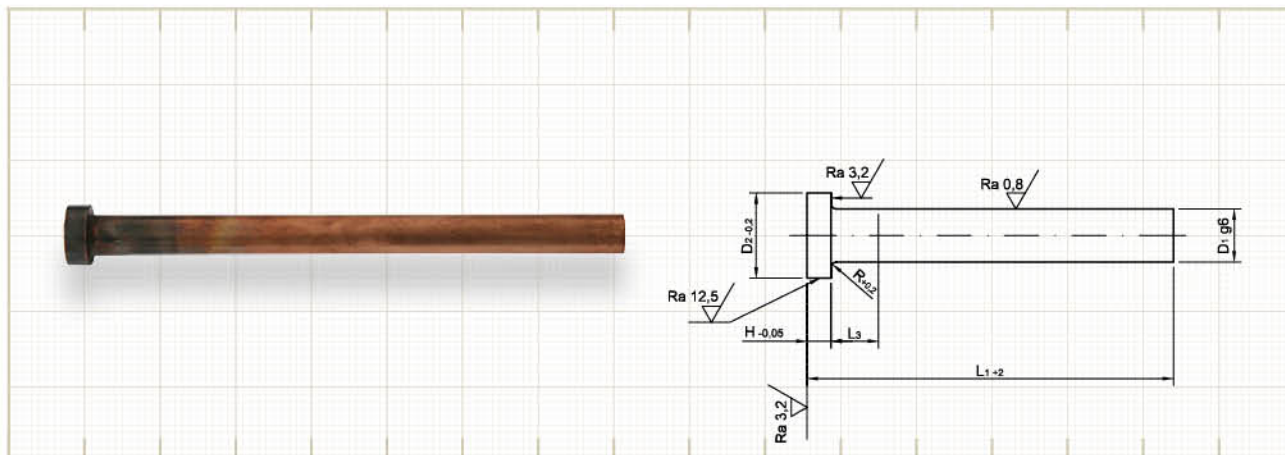


### Izmetalna igla s cilindrično glavo / Podobno DIN ISO 6751 A.

Ejector Pins with cylindrical head / Similar to DIN ISO 6751 A.



#### Obseg uporabe:

Hlajenje oblikovanih delov tlačnega litja in brizganja plastike pri visoko toplotni prevodnosti jeder ali izmetačev.

#### Prednosti:

- boljša kvaliteta izdelka zaradi boljše porazdelitve temperature
- zmanjšanje časa cikla oblikovnih lukenj
- dolga življenjska doba oblikovnih lukenj zaradi optimalnega trenja
- večja toplotna prevodnost kot pri iglah iz WS ali WAS

Dimenzije so prikazane v tabeli.

#### Prileganje / Toleranca:

Premier  $D_1$

| $\varnothing$ | 1.5 - 3 | 3.2 - 6 | 7 - 10 | 12 - 16 |
|---------------|---------|---------|--------|---------|
| g6            | -0,002  | -0,004  | -0,005 | -0,006  |
|               | -0,008  | -0,012  | -0,014 | -0,017  |

Celotna dolžina  $L_{1+2}$

#### Material:

Posebna legura bakra – brez berilija

| Trdota | HB     |
|--------|--------|
| Steblo | 85-210 |

#### Karakteristike:

- 6-krat večja toplotna prevodnost kot pri običajnem orodnem jeklu
- Podobno vročinsko raztezanje kot pri orodnem jeklu
- Korozijska odpornost
- Zelo dobro za obdelavo (struženje, rezkanje, poliranje, jedkanje, erodiranje)
- Možnost nanosa zaščitne prevleke

#### Range of application:

Injection moulding and die-casting with high thermal conductivity

#### Advantages:

- better product quality because of better temperature distribution
- reduced time of the design cycle
- long service life design for optimum friction
- higher thermal conductivity than the WS or WAS pins

The dimensions are shown in the table.

#### Fit / Tolerance:

Diameter  $D_1$

| $\varnothing$ | 1.5 - 3 | 3.2 - 6 | 7 - 10 | 12 - 16 |
|---------------|---------|---------|--------|---------|
| g6            | -0,002  | -0,004  | -0,005 | -0,006  |
|               | -0,008  | -0,012  | -0,014 | -0,017  |

The total length  $L_{1+2}$

#### Material:

Special copper alloy - beryllium-free

| Hardness | HB     |
|----------|--------|
| Shank    | 85-210 |

#### Material properties:

- 6 times higher thermal conductivity than conventional tool steel
- Similar heat expansion as with tool steel
- Corrosion resistance
- Very good for processing (milling, polishing, etching, eroding)
- Protective coating possible

# Standardne mere Bakreni izmetači Ampcoloy 940

## Standard dimensions of Copper ejectors Ampcoloy 940

| D <sub>1</sub><br>g6<br>[mm] | D <sub>2</sub> x H<br>-0,2<br>-0,05<br>[mm] | R<br>+0,2<br>[mm] | Model A007<br>l <sub>1</sub> + 2 [mm] |     |     |     |     |     |     |
|------------------------------|---------------------------------------------|-------------------|---------------------------------------|-----|-----|-----|-----|-----|-----|
|                              |                                             |                   | 100                                   | 160 | 200 | 250 | 315 | 400 | 500 |
| 2,00                         | 4x2                                         | 0,2               | ●                                     | ●   |     | ●   |     |     |     |
| 2,50                         | 5x2                                         | 0,3               | ●                                     | ●   |     | ●   |     |     |     |
| 2,70                         |                                             |                   | ●                                     | ●   |     | ●   |     |     |     |
| 3,00                         |                                             |                   | ●                                     | ●   |     | ●   |     |     |     |
| 3,20                         | 6x3                                         |                   | ●                                     | ●   |     | ●   |     |     |     |
| 3,50                         |                                             |                   | ●                                     | ●   |     | ●   |     |     |     |
| 3,70                         | 7x3                                         |                   | ●                                     | ●   |     | ●   |     |     |     |
| 4,00                         |                                             |                   | ●                                     | ●   | ●   | ●   | ●   |     |     |
| 4,20                         |                                             |                   | ●                                     | ●   | ●   | ●   |     |     |     |
| 4,50                         | 8x3                                         |                   | ●                                     | ●   | ●   | ●   |     |     |     |
| 5,00                         |                                             |                   | ●                                     | ●   | ●   | ●   | ●   |     |     |
| 5,20                         |                                             |                   | ●                                     | ●   | ●   | ●   |     |     |     |
| 6,00                         | 10x3                                        |                   | ●                                     | ●   | ●   | ●   |     |     |     |
| 6,20                         |                                             |                   | ●                                     | ●   | ●   | ●   |     |     |     |
| 7,00                         |                                             |                   | ●                                     | ●   | ●   | ●   |     |     |     |
| 8,00                         | 12x5                                        | 0,5               | ●                                     | ●   | ●   | ●   | ●   |     |     |
| 8,20                         |                                             |                   | ●                                     | ●   | ●   | ●   |     |     |     |
| 10,00                        |                                             |                   | ●                                     | ●   | ●   | ●   |     |     |     |
| 12,00                        | 14x5                                        |                   | ●                                     | ●   | ●   | ●   | ●   |     |     |
| 14,00                        |                                             |                   | ●                                     | ●   | ●   | ●   | ●   |     |     |
| 16,00                        |                                             |                   | ●                                     | ●   | ●   | ●   | ●   |     |     |
| 12,00                        | 18x5                                        | 0,8               | ●                                     | ●   | ●   | ●   | ●   |     |     |
| 14,00                        | 22x5                                        |                   | ●                                     | ●   | ●   | ●   | ●   | ●   |     |
| 16,00                        |                                             |                   | ●                                     | ●   | ●   | ●   | ●   | ●   |     |

### Tehnični podatki:

- Natezalna trdnost R<sub>m</sub>: 650-750 N / mm<sup>2</sup>
- Meja prožnosti (0,2 % meja lezenja): 500-650 N/mm<sup>2</sup>
- Specifična toplota: pribl.: 380 J / kgK
- Toplotna prevodnost pri 20 ° C / 68°F pribl.: 200 W / mK
- Koeficient vročinskega raztezanja 20-200 ° C: 0,000016 K
- Mehčalna točka: 420 ° C / 788°F

### Obdelava:

Brušeno steblo, vroče kovana cilindrična glava

### Technical data:

- Tear strength R<sub>m</sub>: 650-750 N / mm<sup>2</sup>
- The yield strength (0.2 % creep limit): 500-650 N / mm<sup>2</sup>
- Specific heat capacity: approx.: 380 J / kgK
- Thermal conductivity at 20 ° C / 68 ° F.: about 200 W / mK
- The coefficient of heat expansion of 20-200 ° C: 0,000016 K
- Softening point: 420 ° C / 788 ° F

### Finish:

Ground shank, hot forged cylindrical head

**Opomba:** Pri predelavi plastike, ojačane s steklenimi vlaknami, je priporočljivo oplašanje z nanosi za zmanjšanje obrabe.

**Note:** In the processing of plastics, reinforced with fiberglass, protective coating is recommended to reduce wear and tear.