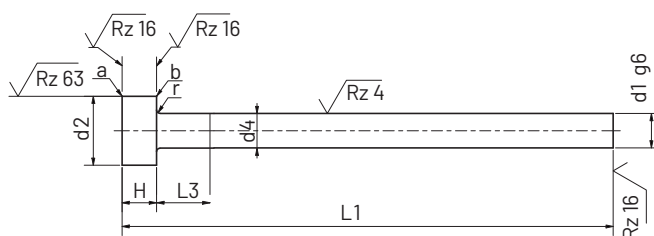


2 Izmetalna igla Ejector Pin

Bakreni izmetači Copper Ejectors

Ampcoloy 940



a = rob brez robov | edge free of burr
b = zaobljen rob | rounded edge

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

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

Obseg uporabe:

Brizganje in tlačno litje z visoko toplotno prevodnostjo

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:

Premer D1

\varnothing	1,5 - 3	3,2 - 6	7 - 10	12 - 16
g_6	-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

Toplotna prevodnost:

Pribl. 20°C ~ 180-208 W/m²K

Natezna trdnost:

Pribl. 650 N/mm²

Trdota:

Steblo: HRC min 180 HB

Glava: HRC min 180 HB

Karakteristike:

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 D1

\varnothing	1,5 - 3	3,2 - 6	7 - 10	12 - 16
g_6	-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 copper alloy.

Thermal conductivity:

Approx. 20°C ~ 180-208 W/mK

Tensile strength:

Approx. 650 N/mm²

Hardness:

Shank: HRC min 180 HB

Head: HRC min 180 HB

Opomba | Note

Pri predelavi plastike, ojačane s steklenimi vlaknami, je priporočljivo oplaščenje z nanosi za zmanjšanje obrabe.

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



- 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

Tehnični podatki:

- Natezalna trdnost Rm: 650-750 N / mm²
- Meja prožnosti (0,2 % meja lezenja): 500-650 N/mm²
- 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.

Material properties:

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

Technical data:

- Tear strength Rm: 650-750 N / mm²
- The yield strength (0.2 % creep limit): 500-650 N / mm²
- 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.

D1 g6 [mm]	D2 x H -0,2 -0,05 [mm]	R +0,2 [mm]	Model A007 L1+2 [mm]						
			160	200	250	315	400	500	
2,00	4x2	0,2	●		●				
2,50	5x2	0,3	●		●				
2,70			●		●				
3,00	6x3		●		●				
3,20			●		●				
3,50	7x3		●		●				
3,70			●		●				
4,00	8x3		●	●	●	●			
4,20			●	●	●				
4,50			●	●	●				
5,00	10x3		●	●	●	●			
5,20			●	●	●				
6,00	12x5	0,5	●	●					
6,20			●	●	●				
7,00			●		●				
8,00	14x5		●	●		●			
8,20			●	●	●				
10,00	16x5		●	●		●	●		
12,00	18x5	0,8	●	●		●	●		
14,00	22x5		●	●		●	●	●	
16,00			●	●		●	●	●	