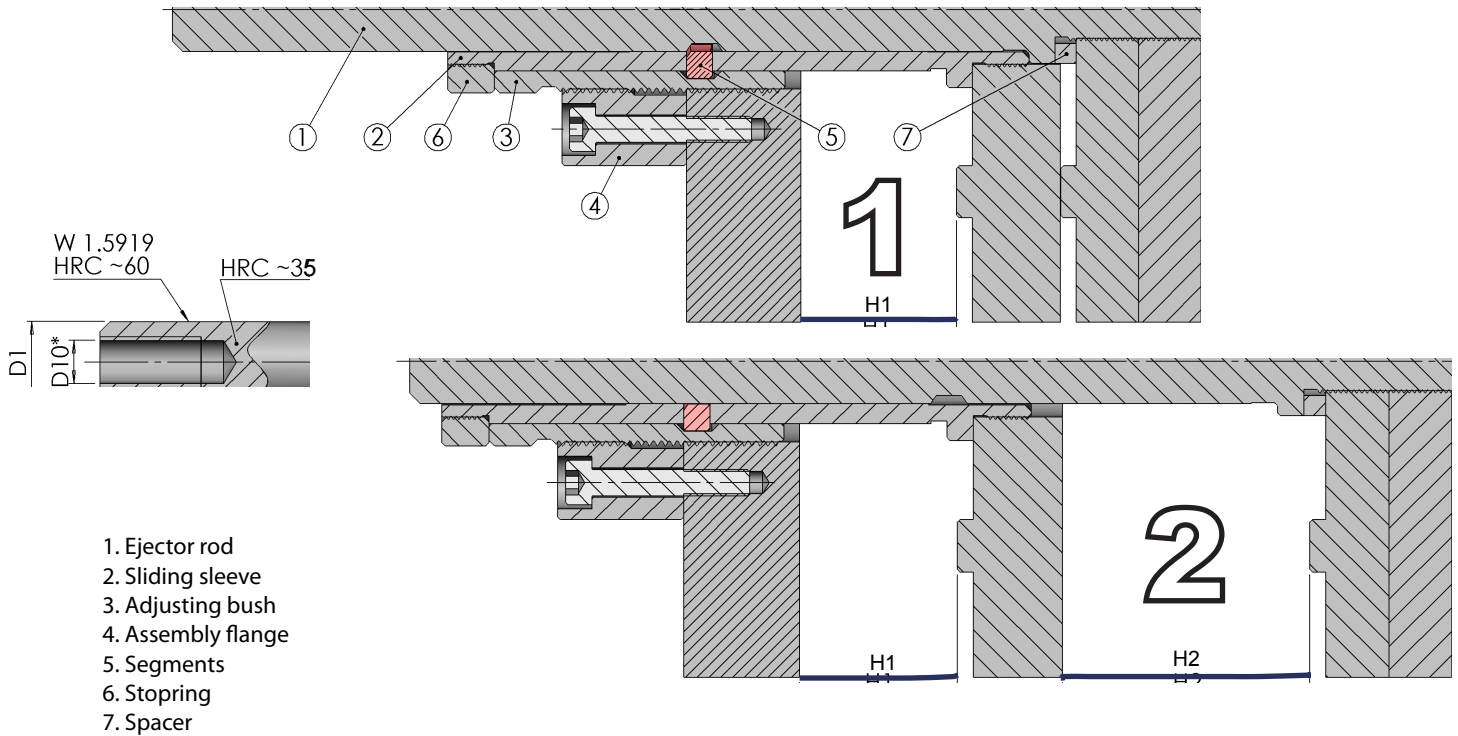


REF	D8	D1	D5	D7	D9	D3	D4	D2	D6
<b>FW 1800 M32x1,5</b>	M32x1,5	16	M12x1,0	M22x1,0	60	46	M5	32	20,6
<b>FW 1800 M42x1,5</b>	M42x1,5	22	M16x1,5	M30x1,5	80	62	M6	42	28,0
<b>FW 1800 M52x1,5</b>	M52x1,5	28	M20x1,5	M38x1,5	90	72	M8	53	36,0
<b>FW 1800 M62x1,5</b>	M62x1,5	37	M24x1,5	M48x1,5	120	80	M8	63	44,0

REF	L7	L6	L4	L2	L1	L3	L5	H1	H2	K1	K6	K2	K5	K3	K4	SW1	SW2	A mm <sup>2</sup>
<b>FW 1800 M32x1,5</b>	200	30	101	11	56	20	16	5-30	50	16	5	9,0	5	8	24	13	20	56
<b>FW 1800 M42x1,5</b>	266	40	132	16	75	30	22	10-40	70	20	6	9,0	6	10	30	17	27	100
<b>FW 1800 M52x1,5</b>	285	45	134	16	75	35	22	10-40	80	22	6	10,5	8	12	30	22	35	152
<b>FW 1800 M62x1,5</b>	300	50	140	16	80	40	22	10-40	80	22	6	10,5	8	12	30	30	44	215



### Fitting:

1. Mount ejector rod no. 1 together with ejector plate. For safety please use LOCTITE C 242.
2. Move over parts no. 2, 3 and 4 together and tighten up part no. 3 (SW2 see chart).
3. Tighten up adjusting bush no. 3 with assembly flange no. 4.
4. Fix assembly flange.

**Recommended lubricants:** C 135, C 138/139, C 170, etc.

### Installation instructions:

This device is preferably screwed together with the hydraulic machine ejector.

The required internal or external thread of part no. 1 has to be made adequately. The ejector rod no. 1 may not be shortened by more than length  $k_1$ , if the total stroke  $h_3$  ( $h_3 = h_1 + h_2$ ), including a possible deeper run in of part no. 1 into part no. 2, is not be maintained.

By rotating adjustment of bush no. 3 the first stroke  $h_1$  is continuously adjusted. With stroke  $h_1$  both ejector pin plates are moved simultaneously. On the following stroke  $h_2$  only the second ejector pin plate movement is continued. Choose the thickness of the spacer ring no. 7 so, that there is at least 0,05 mm clearance between the ejector pin plates (see fig. 1).

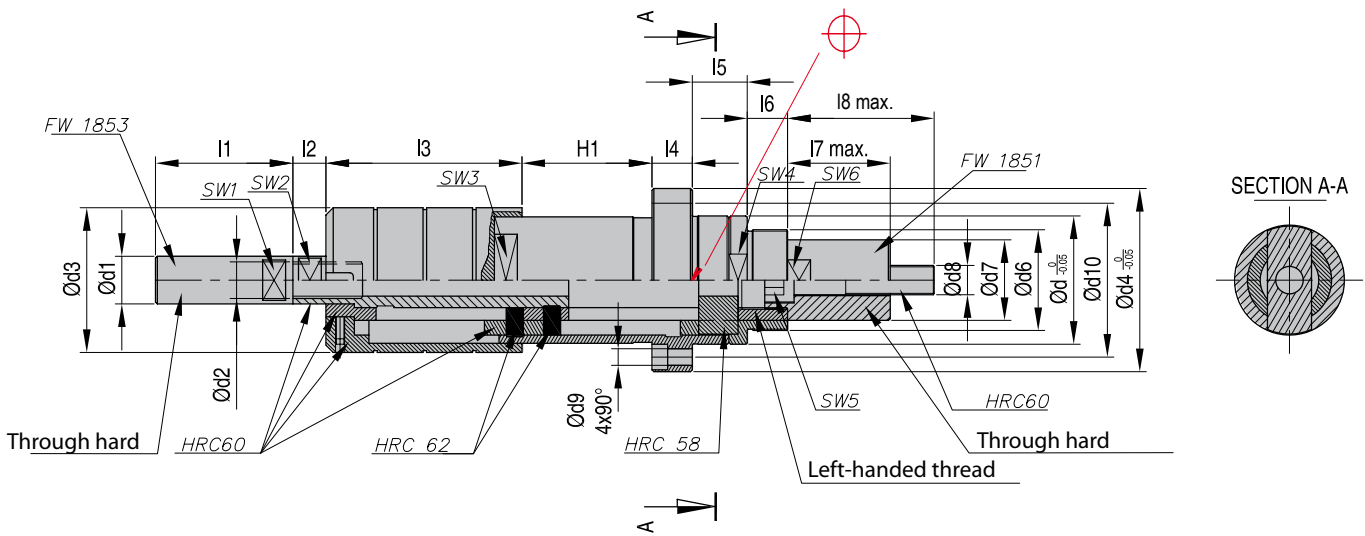




The two-stage single-stroke ejector can be integrated into injection molding tools.

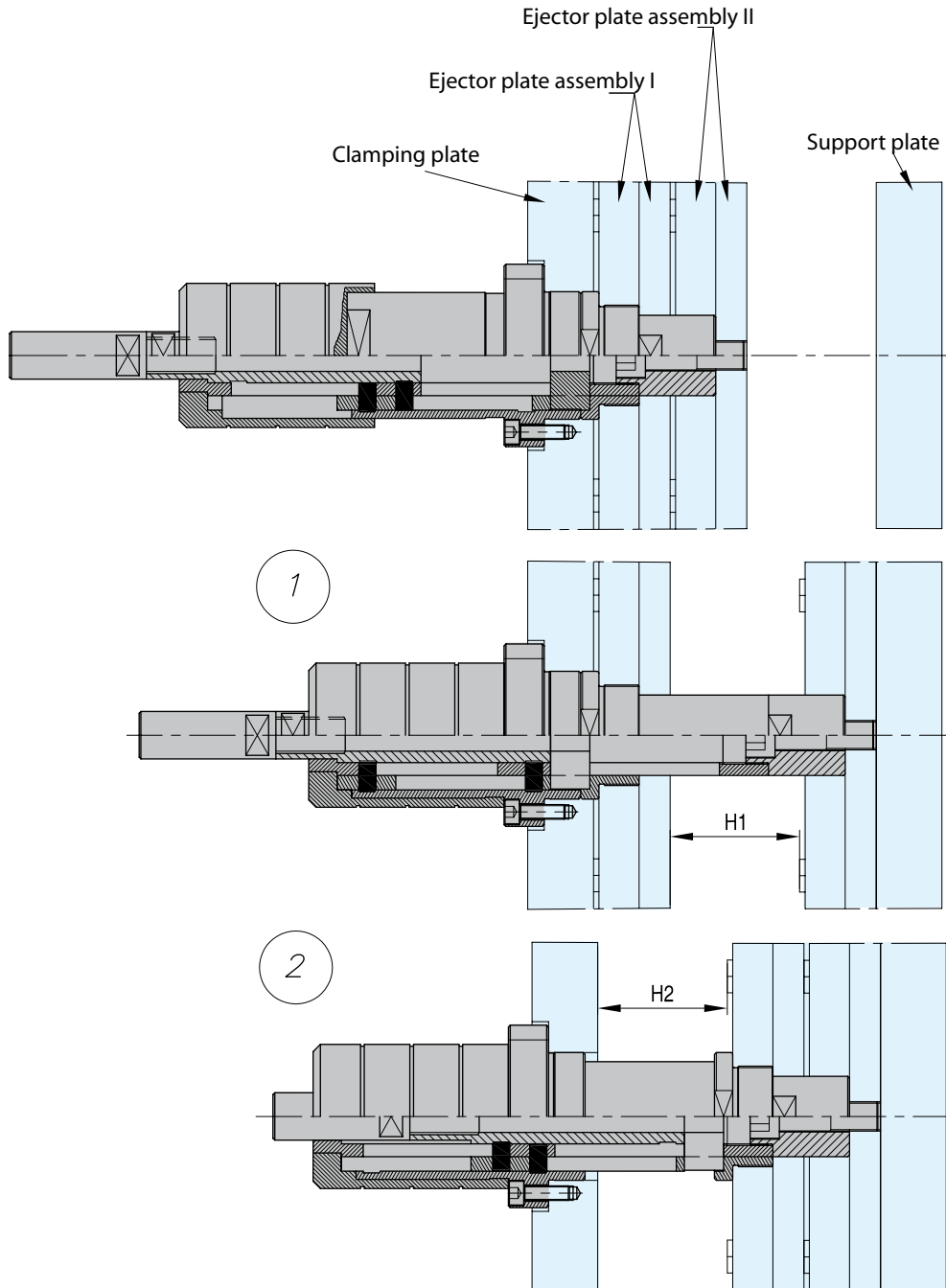
This ejector automatically divides the motion into two sequential strokes.

The functional sequence associated with this makes it possible to create new mold ejection mechanisms.



REF d x H1 max	H1 max	H2	d1	d2	d3	d4	d6	d7	d8	d9	d10
<b>FW 1850 50x32</b>	5-32	12-32	18	M12	56	75	M40x1,5	31,5	M12x1,25	M6x16	62
<b>FW 1850 58x40</b>	5-40	15-40	22	M16	64	90	M45x1,5	36,0	M14x1,50	M8x20	72
<b>FW 1850 58x56</b>	5-56	25-65	22	M16	64	90	M45x1,5	36,0	M14x1,50	M8x20	72
<b>FW 1850 70x71</b>	10-71	20-71	26	M20	79	100	M55x1,5	44,0	M16x1,50	M8x25	84

REF	l2	l3	l4	l5	l6	l7 max.	l8 max.	SW1	SW2	SW3	SW3 Nm	SW4	SW5	SW6
<b>FW 1850 50x32</b>	12	58	14	25	17	36	50	14	14	36	120	46	6	27
<b>FW 1850 58x40</b>	15	68	16	25	17	45	66	18	18	41	160	55	8	32
<b>FW 1850 58x56</b>	15	84	16	25	17	45	66	18	18	41	120	55	8	32
<b>FW 1850 70x71</b>	18	107	22	30	22	56	80	22	24	50	200	65	10	38



**Features:**

- Secured position of the ejector plates due to built-in-low-wear interlocks.
- Infinitely variable strokes
- High operational reliability of the ejector components due to forcedcontrolled stroke actions
- Simplified operations of angled and rotating mold ejection components.
- Space-saving installation in the ejector bolt area.
- The tool height remains unchanged.

**Design considerations:**

A detachable fixed connection between ejector bolt (FW 1850) and the machine ejector is necessary, preferably using the pneumatic rapid-action coupling PN 1680. The ejector plates cannot be pushed by return pins due to the tool closing movement! Ejector plate guidance by four guides in the ejector plates to prevent tilting. A stroke limitation is preferable to keep the ejector plates separate in the end position. Centre misalignment compensation between machine ejector and tool preferably by pneumatic rapid-action coupling PN 1680. Adapter for tool on MAP will be made, as necessary, preferably from centering flange R 19.

CAD reference point

