



Positive, precise plate control:

DME 2-stage Ejectors (TS) adapt to a number of mold base size and plate thicknesses. They are available in two ejection sequences: Top Last (TS) and Bottom Last (BS). 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 TSTL and TSBL types) and by also cutting the Travel Sleeve to the desired length (TSBL type only). Once installed, the **DME** 2-stage Ejector assures 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:

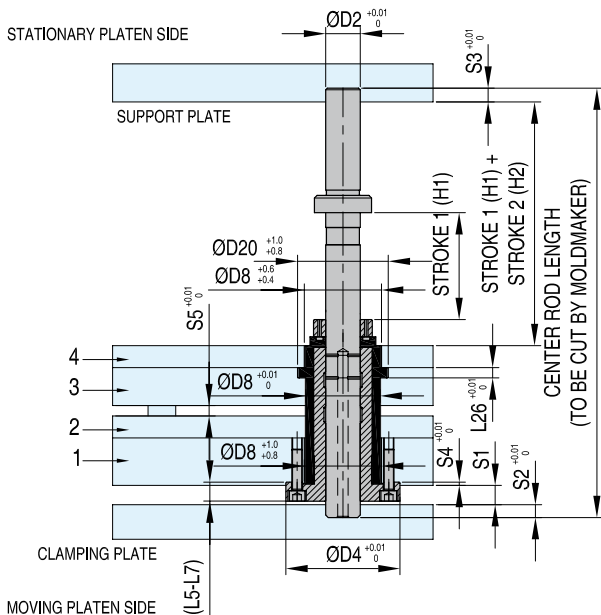
Both the first stage and second stage strokes are set independently. Easy set-up and installation. Fixed strokes cannot be tampered with or accidentally modified. Internal installation avoids interferences with water line connectors and externally mounted components. Utilizes latching mechanism similar to **DME** Internal

Latch lock for smooth operation and guidance. Three sizes, for each style, to choose from to accommodate most standard **DME** mold bases. Hardened steel components for long life. **DME** 2-stage Ejectors are considerably more compact and may be centrally located, the preferred method for locating **DME** 2-stage Ejectors is in pairs, offset from mold center. For more details, assembly guidelines see www.dme.net.

Selection and design guidelines:

Select 20 mm Ø (small), 26 mm Ø (medium), or 23 mm Ø (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 very 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 a 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 over-loading. Only one size of 2-stage Ejectors should be used in each mold base.

REF	Basic center rod dia	H1-Stroke 1		H2-Stroke 2		Max. mold base width	Max. load values static	Max. load values dynamic
		Min.	Max.	Min.	Max.			
TSTL 20 A	20mm	4	79	4	79	Up to 196mm, 1 TSTL 20	600 kg, 5,8 kN	60 kg, 0,58 kN
						Up to 446mm, 2 TSTL 20		
TSTL 26 A	26mm	6	84	6	84	Up to 446mm, 1 TSTL 26	6100 kg, 10,8 kN	110 kg, 1,08 kN
						Up to 596mm, 2 TSTL 26		
TSTL 32 A	32mm	8	92	8	92	Up to 596mm, 1 TSTL 32	2000 kg, 19,6 kN	200 kg, 1,96 kN
						Up to 796mm, 2 TSTL 32		



Assembly & installation guidelines

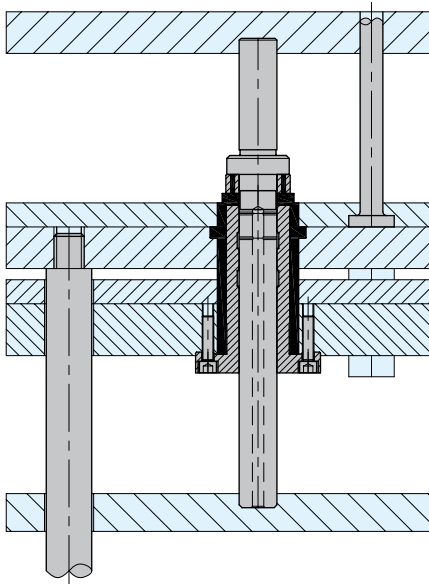
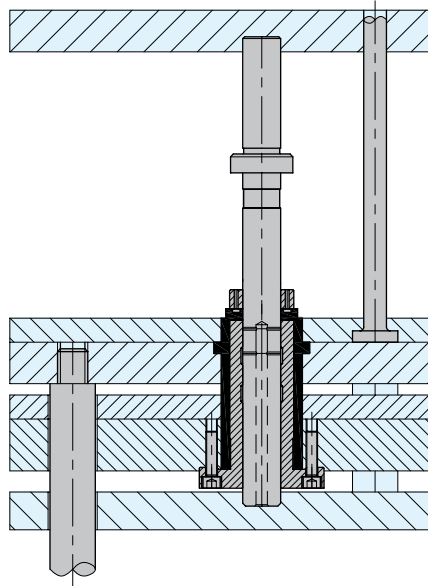
The moldmaker is responsible to cut and/or grind the Center Rod to the required length prior to installation of the 2-Stage Ejector assembly into the mold base. Do not cut off more than the minimum stroke (H2). The recommended tolerance on the Center Rod length after the customer has cut the Center Rod is +0/-0,02 mm or less. Stroke 1 (H1) is reduced by cutting and/or grinding the moving plates end of both the Center Rod. Stroke 2 (H2) is reduced by cutting and/or grinding the stationary platen end of the Center Rod. Minimum H2 specified in chart does not include additional stop pins to stationary-side spacer plate. To reduce H2 even further than what is specified in chart, add stop pins. All 2-stage Ejectors in a mold must be cut to the same strokes. It is recommended that guided ejection be used. Ejector speed must be controlled, ensuring that excessive shock loading does not occur. 2-Stage Ejectors are not suitable for severe load conditions. 2-Stage Ejectors must not be exposed to temperatures that exceed 150°C at any time. Lubricate all metal-to-metal contact areas initially and periodically as required. A good grade of moldmakers non-melting type grease for the appropriate temperature should be used.

REF	Center rod length	Stroke 1		Stroke 2		1	2	3	4	S1	S2	S3	S4	S5
		Min.	Max.	Min.	Max.									
TSTL 20 A	262,96	4	79	4	79	26	12	26	12	8	8	8	3	4,26
TSTL 26 A	285,32	6	84	6	84	26	12	26	12	10	10	10	4	10,62
TSTL 32 A	316,68	8	92	8	92	26	16	26	16	15	12	12	4	9,80



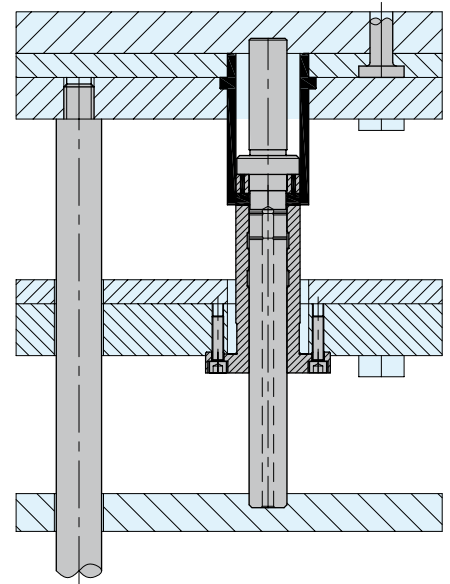
TOP LAST SEQUENCING

1 EJECTOR PLATES BACK



2 FIRST EJECTOR STROKE

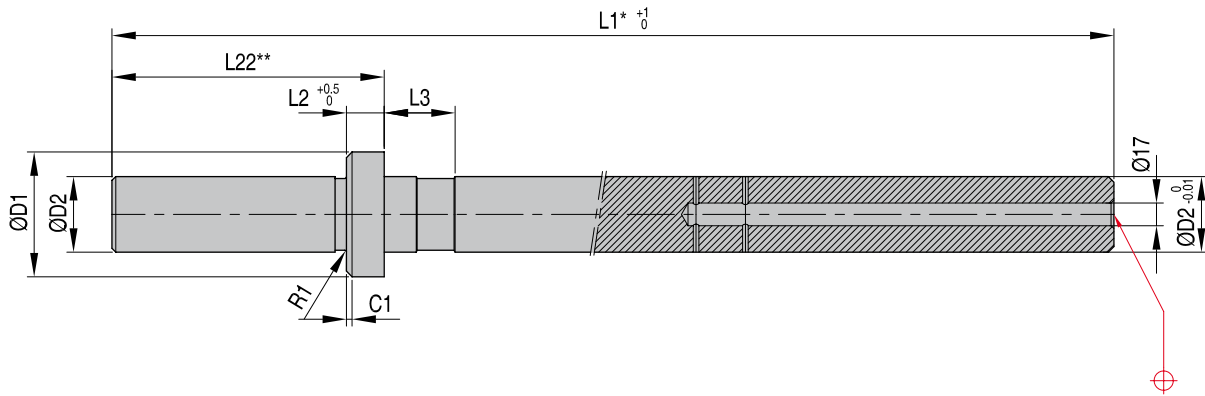
After a predetermined amount of travel, the latch mechanism latches onto the Center Rod, thereby fixing the position of the bottom (moving platen side) ejector plate assembly.



3 SECOND EJECTOR STROKE

The top (stationary platen side) ejector plate assembly continues to move through the "second" or remaining stroke until the top ejector plate assembly contacts the top of the ejector box housing.

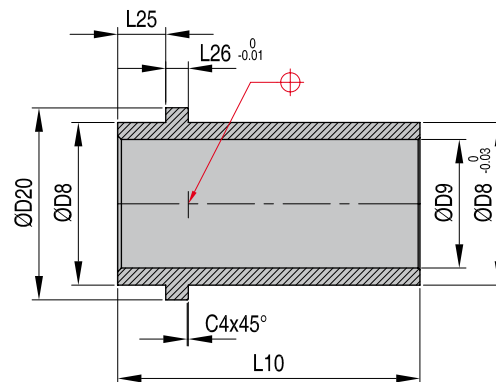




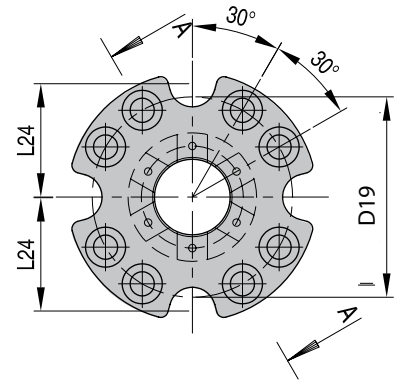
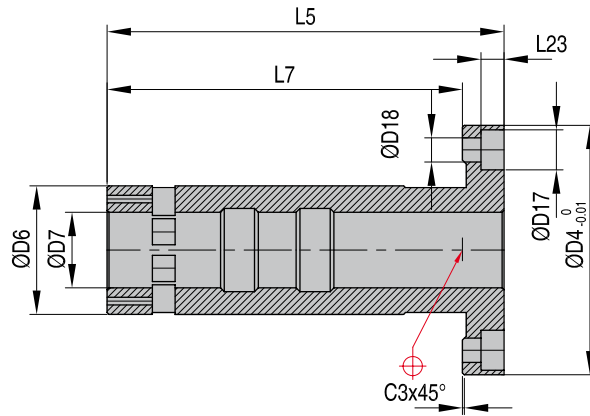
REF	D1	D2	D17	L1*	L2	L3	L22**	C1	R1
TSTL 20 CR	33	20 0 -0,01	5	265	10	18,74	72 +0,5 0	1,5	0,4
TSTL 26 CR	42	26 0 -0,01	6	290	12	22,93	76 +0,5 0	2	0,8
TSTL 32 CR	53	32 0 -0,01	6	320	15	28,25	82 +0,5 0	2,5	0,8

* Cutoff on both ends of center pin only per installation data.

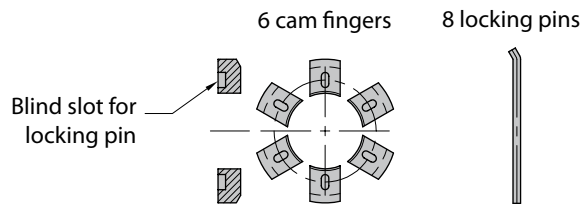
** Final length must have tolerance of 0/-0,2mm after moldmaker has cut the center pin to the desired length.



REF	D8	D9	D20	L10	L25	L26	C4
TSTL 20 TS	43	34	50,8	79,96	12,70	6,00	0,5
TSTL 26 TS	54	43	63,0	85,32	12,70	8,00	0,5
TSTL 32 TS	68	54	78,0	93,68	15,88	10,00	0,5



REF	D4	D6	D7	D17	D18	D19	L5	L7	L23	L24	C3
TSTL 20 BD	66	34	20	10,6	6,4	53	104	94,0	6,1	30	0,5
TSTL 26 BD	84	43	26	13,8	8,7	67	116	103,0	8,2	37	0,5
TSTL 32 BD	105	54	32	16,8	10,8	85	131	113,4	10,2	47	0,6



REF
TSTL 20 KT
TSTL 26 KT
TSTL 32 KT

