



29111 Stephenson Hwy.
Madison Heights, MI 48071 USA
800-626-6653

Accelerated Ejectors

Installation Instructions & Dimensions

Used for individual ejector pin acceleration-one unit to a pin. Top of pin rack must be counterbored or slotted to receive head of ejector pin being used. Pilot hole in pin nut (1/8" on AEP-10, 1/4" on AEP-20) must be drilled out for the ejector pin. (See note #1 for further explanation.)

Range of ejector pins accommodated is up to 1/4" diameter on the AEP-10 and 1/2" on the AEP-20. Any number of units can be installed in a mold-but only one per accelerated ejector pin.

Bumper stud should be installed in ejector housing to assure positive return.

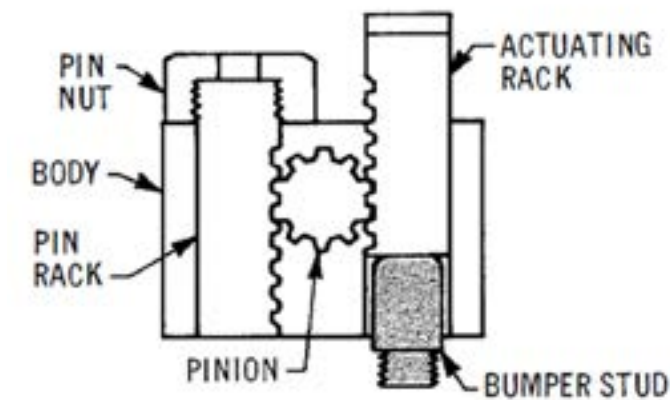
No pins are installed in this unit. Units themselves (usually 4) are installed in lower ejector plate assembly on dual ejector plate molds.

Clearance holes for actuator rack should be provided through the upper ejector plate assembly to allow contact with actuating stud (not supplied.)

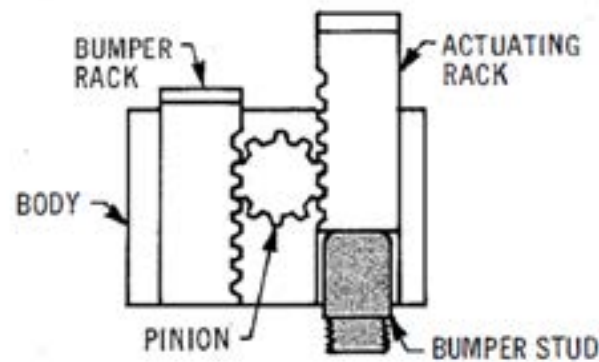
Ejector pins to be accelerated are installed in upper ejector assembly, those not to be accelerated in lower assembly.

When actuating rack contacts actuating stud during press KO stroke, bumper rack pushes upper ejector assembly causing accelerated pin movement.

- NOTES:**
1. To mount ejector pin in Pin Yype, drill clearance holes for ejector pin in pin nut through existing pilot hole. If ejector pin is to be locked against rotation, mill proper slot across top of pin rack and provide flat (or flats) on ejector pin head to match. If ejector pin does not require locking, either a counterbore or a slot, (as above, without flats in ejector pin head) may be provided.
 2. Clearance of up to 1/64" approx. all around may be provided in ejector plate for body. Only normal assembly clearance to be provided in ejector retainer plate.
 3. Use regular size units on DME standard mold bases having ejector plates and ejector retainer plates 1-1/8" and 5/8" thicknes respectively. Use the small size units for 1" and 1/2" plates respectively. Other combinations of ejector plates and ejector retainer plates may require installation modifications to suit for proper operation.
 4. Locate bumper stud within actuating rack working area.
 5. Pin nut to be tightened down fully at final assembly.
 6. Travel 5/8" max. approximately-ratio 2:1.
 7. Apply small amount of grease to racks occasionally.
 8. If disassembly is ever required. To reinstall spring with proper tension, hold bumper or pin rack down in molding position, hook short end of spring onto gear bar so that the spring's long leg is approx. 10/11 o'clock-then turn long leg counterclockwise and into slot.
 9. For some applications, Early Ejector Return may be required to prevent pin damage.



Pin Type (Schematic View)



Bumper Type (Schematic View)



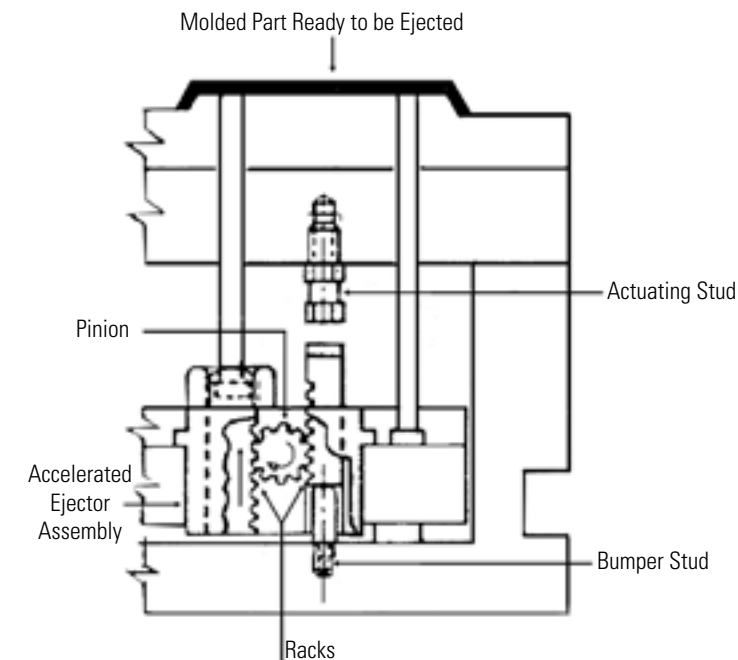
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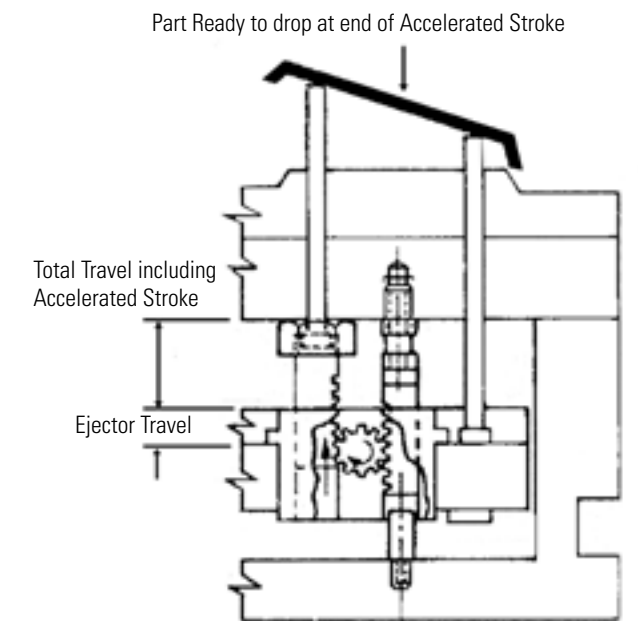
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PIN TYPE APPLICATION

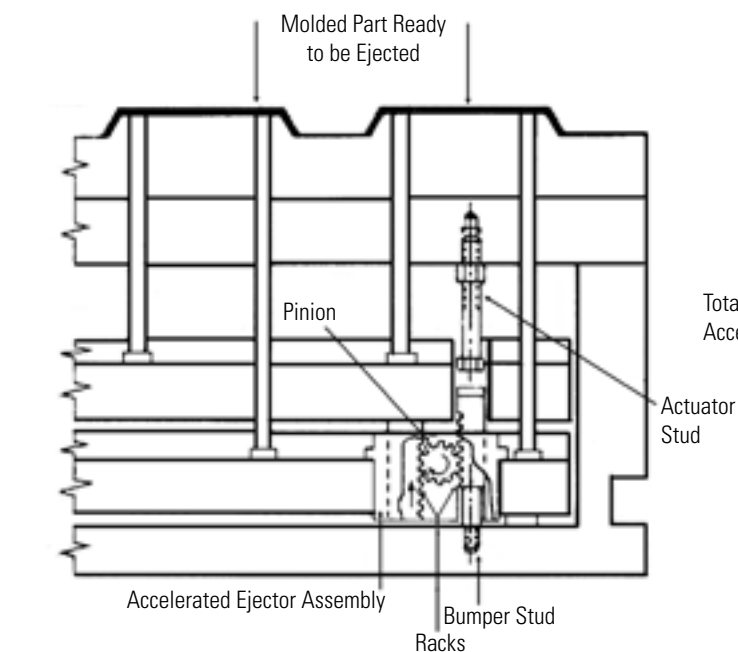


Accelerated Ejector Installed in Mold

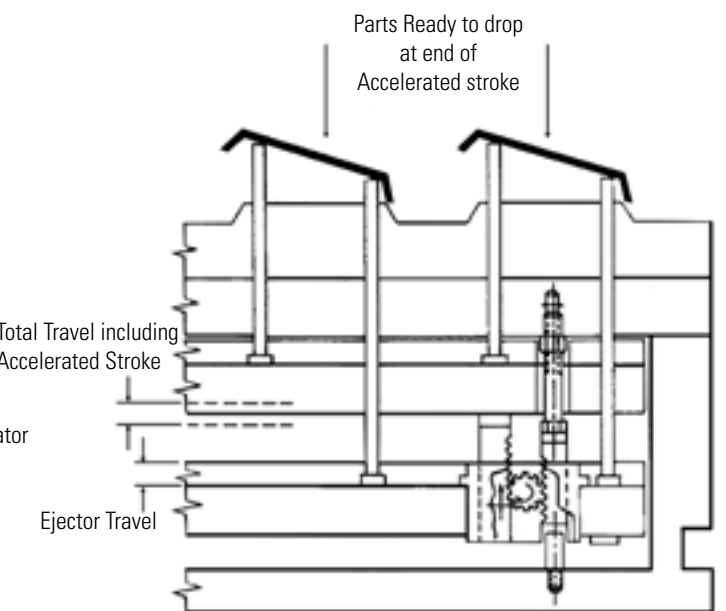


Accelerated Ejector at End of Knock-Out Travel

BUMPER TYPE APPLICATION



Accelerated Ejector Installed in Mold



Accelerated Ejector at End of Knock-Out Travel

