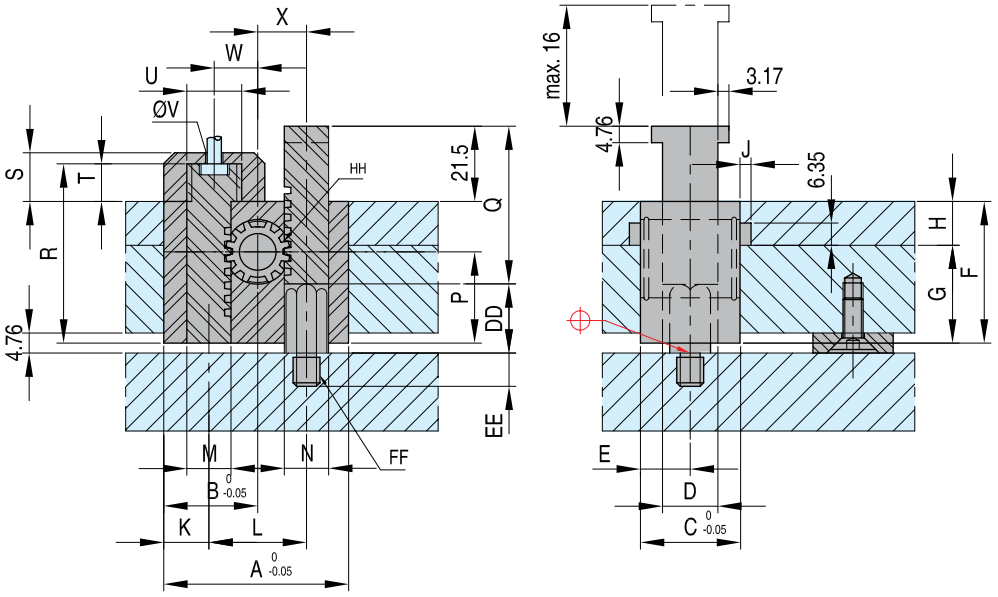
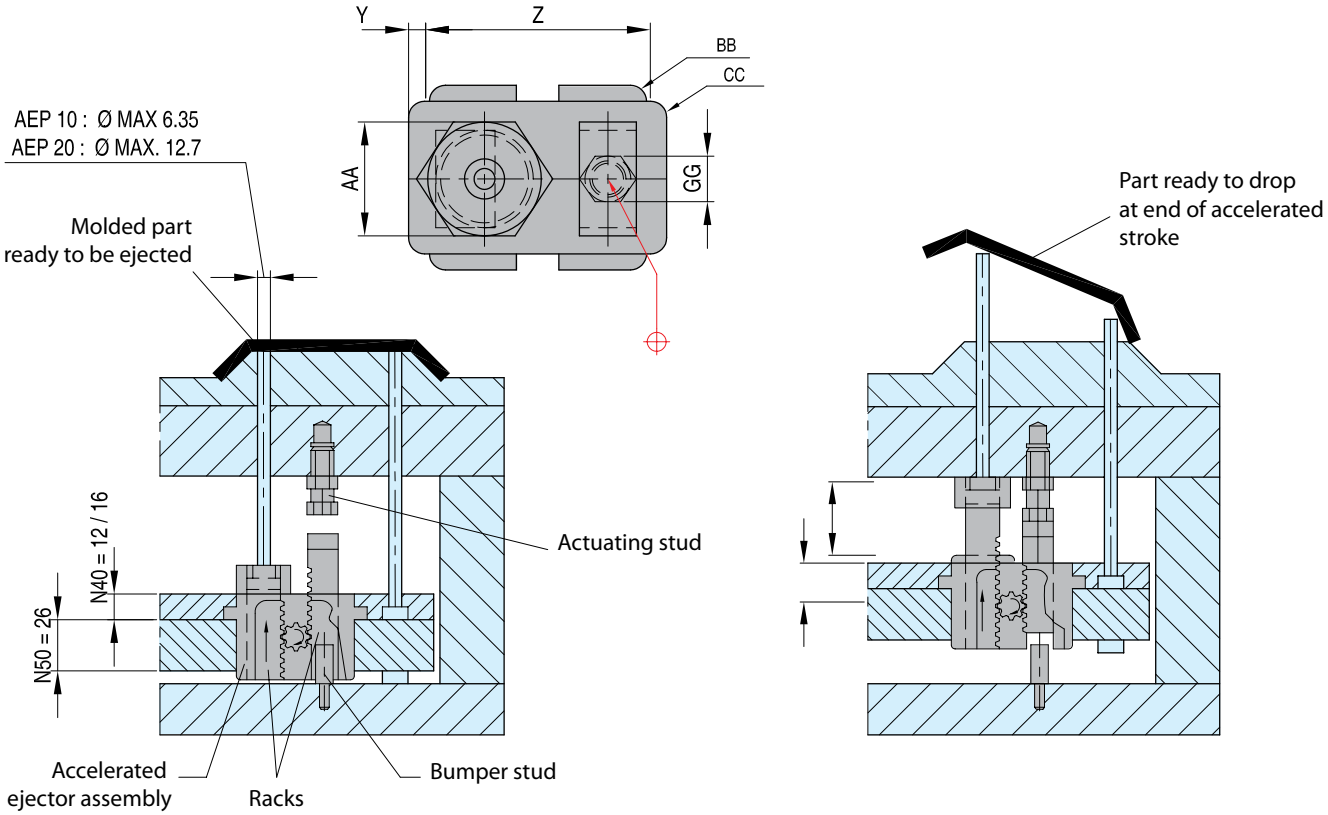
AEP

Accelerated ejectors Pin-Type - MINI

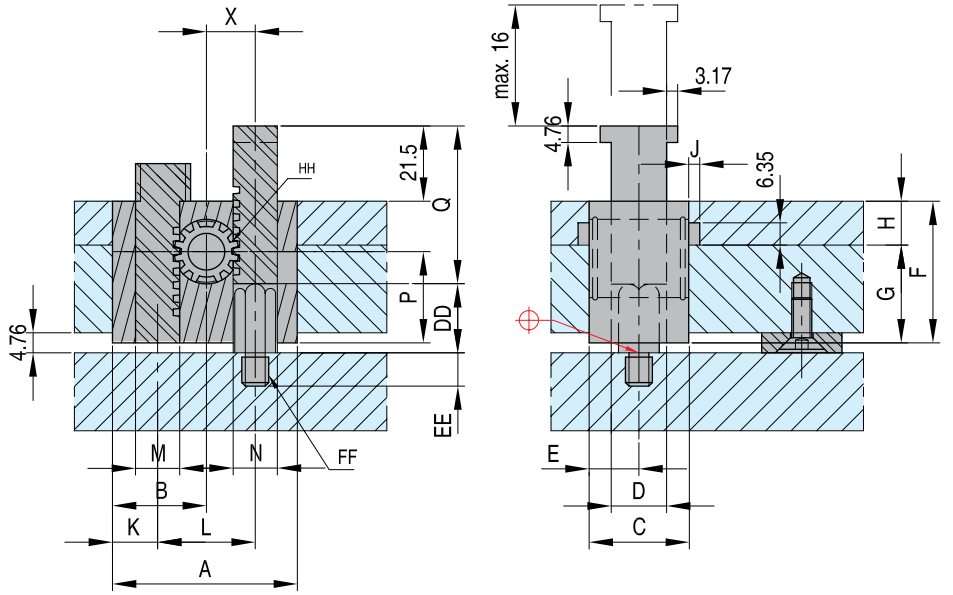


																	Replacement parts	
REF	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	HH Cogs	Springs for	REF
AEP 10	53,97	26,97	28,57	15,87	14,28	40,64	27,94	1/2"	3,17	12,95	28,02	12,70	12,70	26,16	45,29	14	**AEP-10**	**AE 18**
AEP 20	73,03	36,50	41,28	28,57	20,64	47,63	31,75	5/8"	4,75	15,87	41,28	19,05	19,05	25,81	52,39	16	**AEP-20**	**AE 28**
REF	R	S	T	U	V	W	X	Y	Z	AA	BB	CC	DD	EE	FF	GG		
AEP 10	51,44	13,97	10,80	5/8"-18	3,18	12,47	14,0	6,35	41,28	15/16"	6,35	6,35	19,05	9,52	5/16"-18	3/8"		
AEP 20	60,33	17,27	12,70	1 1/8"-12	6,35	15,87	20,64	6,35	60,03	1 3/8"	4,76	6,35	18,29	12,7	3/8"-16	9/16"		

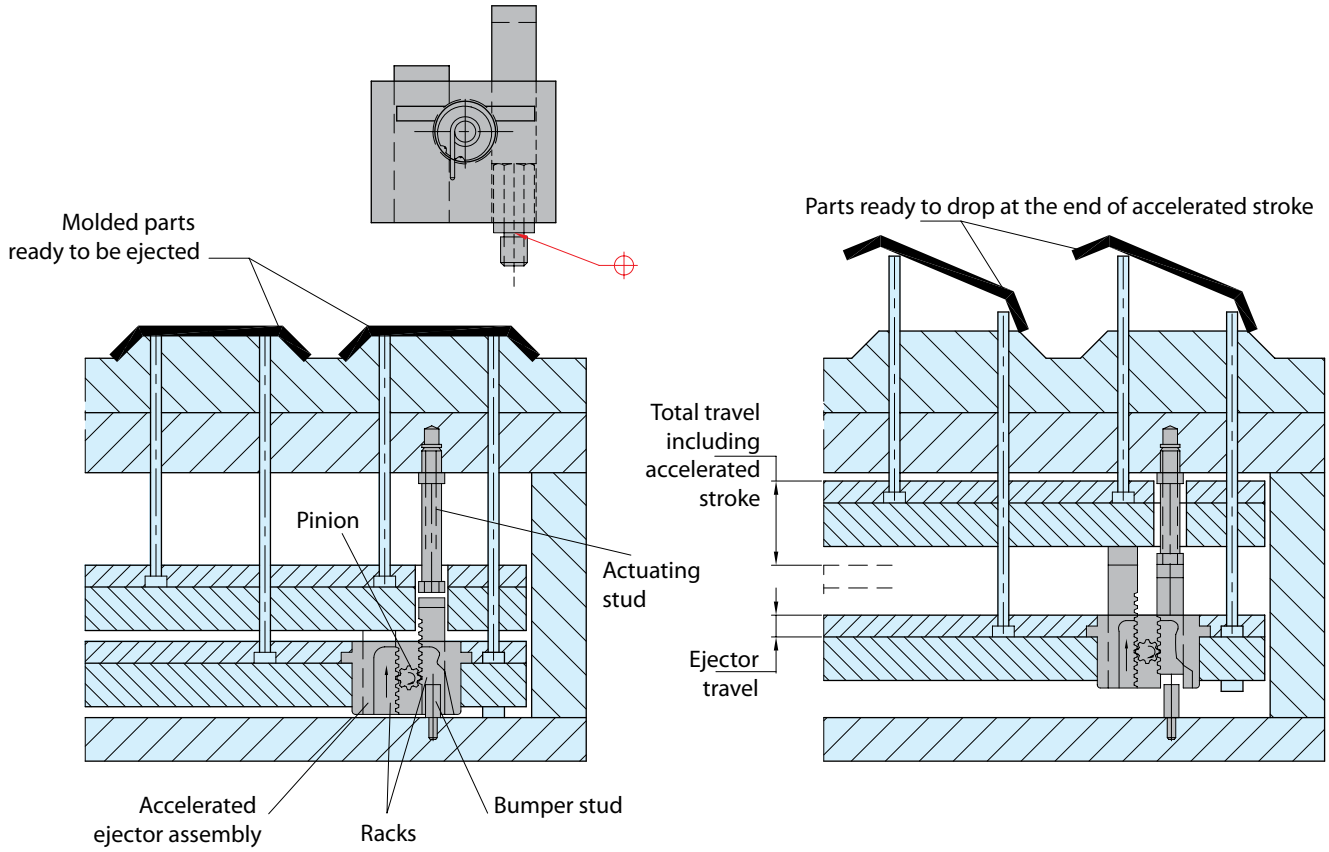


Accelerated ejectors Bumper-Type - MINI

AEB



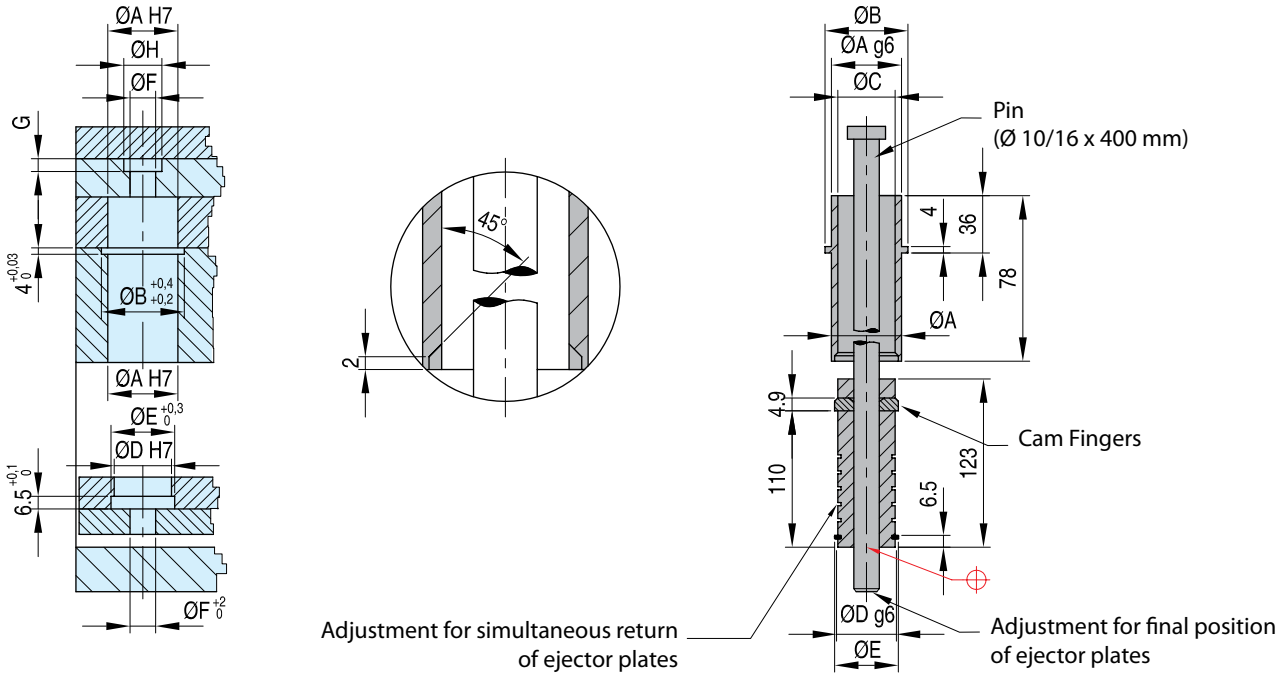
																	Replacement parts	
REF	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	HH Cogs	Springs for	REF
AEB 10	53,97	26,97	28,57	15,87	14,28	40,64	27,94	1/2"	3,17	12,95	28,02	12,7	12,7	26,16	45,29	14	**AEB-10**	**AE 18**
AEB 20	73,03	36,5	41,28	28,57	20,64	47,63	31,75	5/8"	4,75	15,87	41,28	19,05	19,05	25,81	52,39	16	**AEB-20**	**AE 28**
REF	R	S	T	U	V	W	X	Y	Z	AA	BB	CC	DD	EE	FF	GG		
AEB 10	-	-	-	-	-	-	14,0	6,35	41,28	15/16"	6,35	6,35	19,05	9,52	5/16"-18	3/8"		
AEB 20	-	-	-	-	-	-	20,64	6,35	60,03	1 3/8"	4,76	6,35	18,29	12,7	3/8"-16	9/16"		



ER

Early ejector return assembly

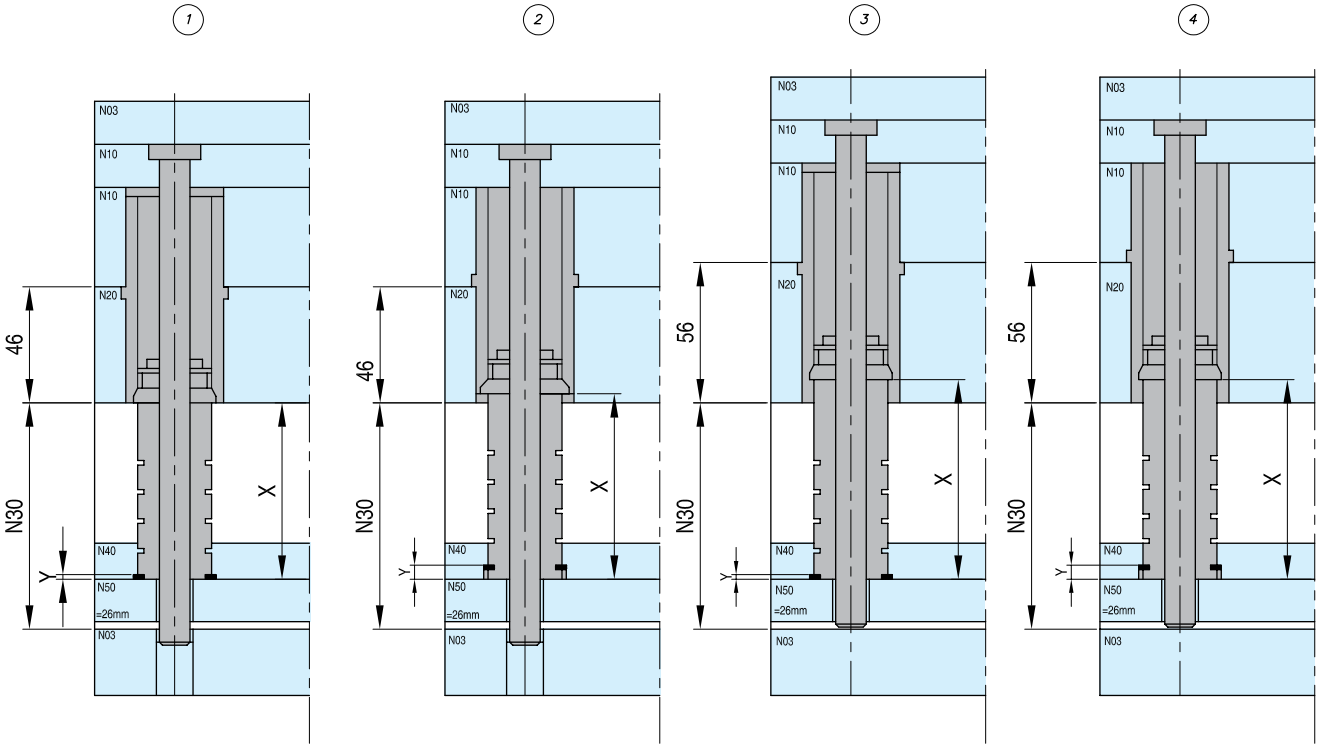
Operation facilities:
- injection and diecasting molds
- prevents damage of mold cavities and ejectors
- valve plates
- molds with multistage mold releasing movement
- Early ejector return assemblies save you time and money.
- Unique design permits low costs.
- Long life due to precise parts and hardened surfaces.
- Prevents valuable mold components from mechanical damage.



REF	A	B	C	D	E	F	G	H
ER 100 E	32	35	24,2	24	27	10	5	17
ER 101 E	42	46	32,2	32	36	16	7	24

Dimensions for installation in **DME** standard molds

ER



Ex.N30	X 1	Y 1	X 2	Y 2	X 3	Y 3	X 4	Y 4
66	36	2,5	40	6,5	46	2,5	50	6,5
86	56	2,5	60	6,5	66	2,5	70	6,5
106	76	2,5	80	6,5	86	2,5	90	6,5
126	96	2,5	100	6,5	106	2,5	110	6,5

1. Four units minimum per mold are preferred. Two units per mold mounted on the centerline of the mold are a must.
2. Use guided ejection in the ejector assembly.
3. Use only in a horizontal press.
4. If used in an unbalanced mold. Uneven loading could occur.
5. Lubricate occasionally with a lithium type grease.
6. Timing is critical: all units to be timed within ±0,013mm of one another.
7. No preload of unit.

Spare Parts			
Bushing	Post	Pin	Set: cam finger washer, upper and lower snap ring
ERB 100 E	**ERS 100 E**	**EPA 05**	**ER 100 RK E**
ERB 101 E	**ERS 101 E**	**EPA 05**	**ER 101 RK E**

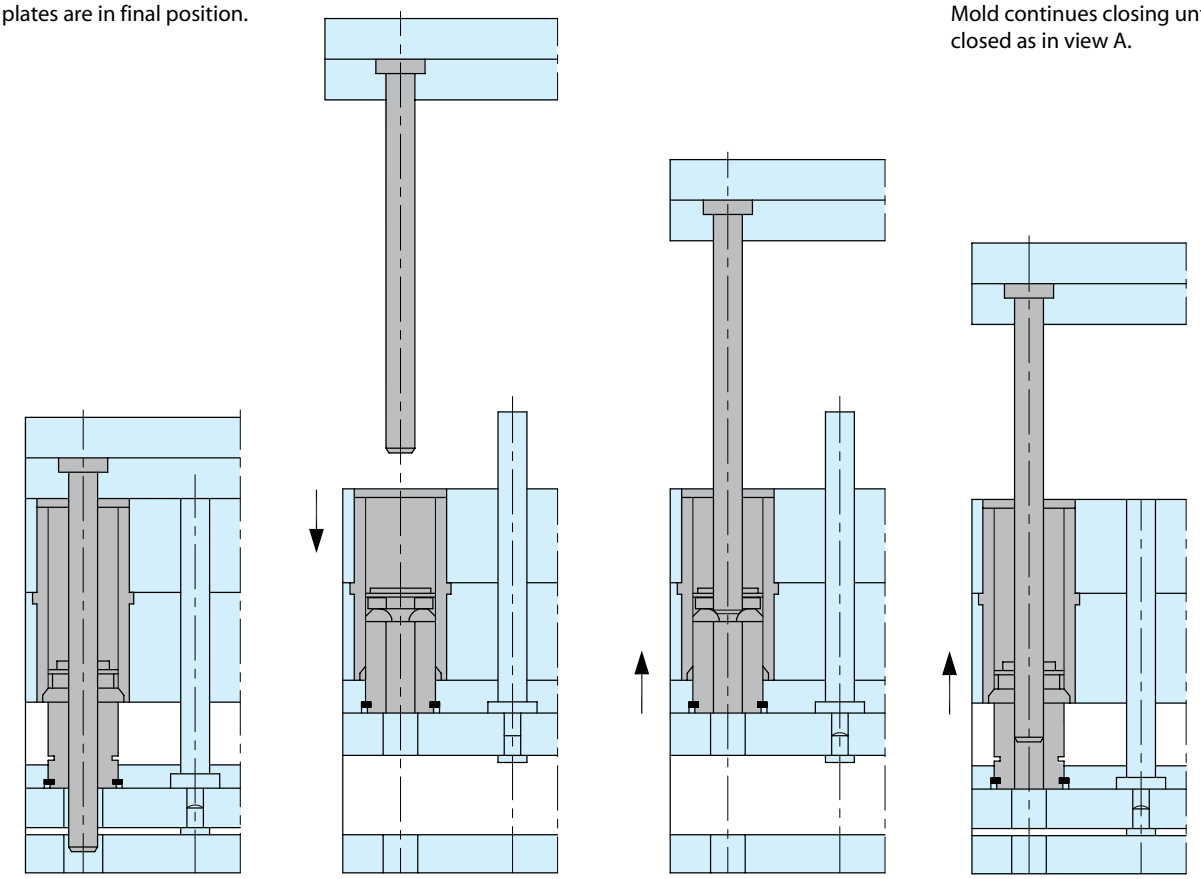
ER — Early ejector return assembly

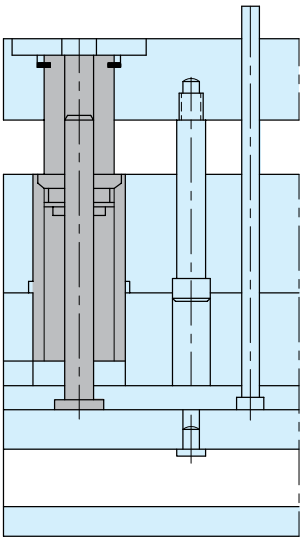
View A: Mold closed, molding position.
Post and cam fingers must be coordinated, so that the pin can slip into post when ejector plates are in final position.

View B: Mold open, mold release position.
During ejection the cam fingers have slipped into bushing and inner diameter is reduced.

View C: Mold closing.
Pin is pressing the cam fingers and pushes ejector plates back.

View D: Mold continues closing.
Ejector plate has been pushed all the way back.
Cam fingers have slipped outward into counterbore in bushing allowing actuator pin to slip by.
Mold continues closing until completely closed as in view A.

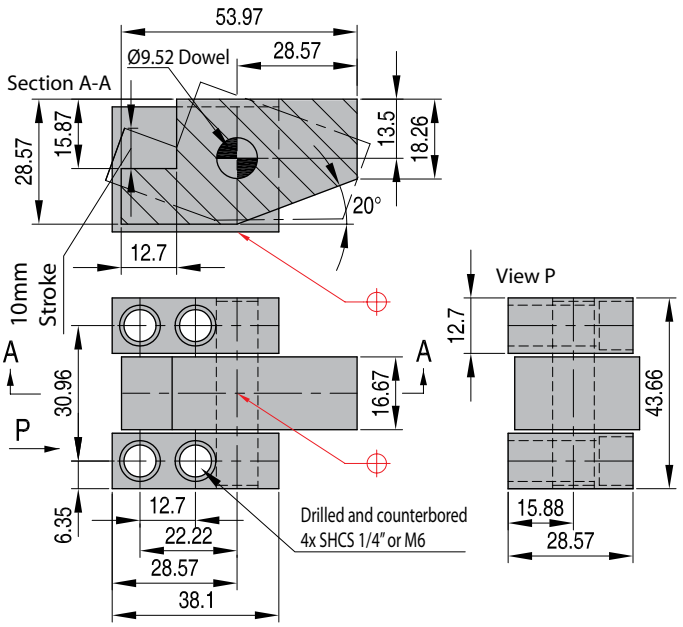




Installation for Ejector pin travel beyond stripper plate.
Stripper plate moves forward until cam fingers slip outward into counterbore in bushing and ejector plate continues to travel.

Accelerated knock-outs

AKO



The accelerated knock-outs are simple in design, using a pivot-type motion for accelerated ejection. Mechanical advantage is 2:1. They will accommodate ejector pins up to 9,5mm in diameter. (Pins with head diameters over 15,8mm can be ground down to fit). Simplicity of design permits accelerated knock-outs to be either inserted into the ejector plate (as shown below) or top mounted, depending on space available for the ejection movement.