

D-M-E 2-Stage Ejectors

Size and Quantity Selection Guidelines

Selection and design guidelines

- Select 20mm diameter (small), 26mm diameter (medium), or 32mm diameter (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 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 an 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 overloading. Only one size of 2-Stage Ejectors should be used in each mold base.

2-STAGE EJECTOR ASSEMBLY ITEM NUMBER	BASIC CENTER ROD DIA	STROKE 1		STROKE 2		RECOMMENDED MAXIMUM MOLD BASE WIDTH	MAXIMUM RECOMMENDED LOAD VALUES (PER ASS'Y)		
		MINIMUM	MAXIMUM	MINIMUM	MAXIMUM		STATIC	DYNAMIC	
2-STAGE EJECTOR TOP LAST (TS TL)									
TS TL 20 A	20mm (Small)	1.0	79.0	4.0	79.0	Up to 200mm, 1 TL 20 Up to 450mm, 2 TL 20	5.8 kN	0.58 kN	mm
		.04	3.11	.16	3.11	Up to 8", 1 TL 20 Up to 18", 2 TL 20	1300 lbf	130.0 lbf	in
TS TL 26 A	26mm (Medium)	1.0	84.0	6.0	84.0	Up to 450mm, 1 TL 26 Up to 600mm, 2 TL 26	10.8 kN	1.08 kN	mm
		.04	3.31	.24	3.31	Up to 18", 1 TL 26 Up to 26", 2 TL 26	2428 lbf	242.8 lbf	in
TS TL 32 A	32mm (Large)	1.0	92.0	8.0	92.0	Up to 600mm, 1 TL 32 Up to 900mm, 2 TL 32	19.6 kN	1.96 kN	mm
		.04	3.62	.31	3.62	Up to 26", 1 TL 32 Up to 35.5", 2 TL 32	4406 lbf	440.6 lbf	in
2-STAGE EJECTOR BOTTOM LAST (TS BL)									
TS BL 20 A*	20mm (Small)	8.0	82.0	12.0	82.0	Up to 200mm, 1 BL 20 Up to 450mm, 2 BL 20	5.8 kN	0.58 kN	mm
		.32	3.23	.47	3.23	Up to 8", 1 BL 20 Up to 18", 2 BL 20	1300 lbf	130.0 lbf	in
TS BL 26 A*	26mm (Medium)	10.0	92.0	18.0	92.0	Up to 450mm, 1 BL 26 Up to 600mm, 2 BL 26	10.8 kN	1.08 kN	mm
		.40	3.62	.71	3.62	Up to 18", 1 BL 26 Up to 26", 2 BL 26	2428 lbf	242.8 lbf	in
TS BL 32 A*	32mm (Large)	12.0	102.0	24.0	102.0	Up to 600mm, 1 BL 32 Up to 900mm, 2 BL 32	19.6 kN	1.96 kN	mm
		.47	4.02	.95	4.02	Up to 26", 1 BL 32 Up to 35.5", 2 BL 32	4406 lbf	440.6 lbf	in

*Puller Pins are **not** included with BL Assemblies and must be ordered separately.