

ITEM NUMBER	CENTER ROD DIA	CENTER ROD LENGTH	H1 – STROKE 1 ⁽²⁾		H2 – STROKE 2 ⁽³⁾		
			MINIMUM	MAXIMUM	MINIMUM	MAXIMUM	
2-STAGE EJECTOR TOP LAST (TS TL)							
TS TL 20 A	20mm (Small)	262.96	1.0	79.0	4.0	79.0	mm
		10.353	.04	3.11	.16	3.11	in
TS TL 26 A	26mm (Medium)	285.32	1.0	84.0	6.0	84.0	mm
		11.233	.04	3.31	.24	3.31	in
TS TL 32 A	32mm (Large)	316.68	1.0	92.0	8.0	92.0	mm
		12.468	.04	3.62	.31	3.62	in

ITEM NUMBER	CENTER ROD DIA	BEP	BER	TEP	TER	S1	S2	S3	S4	S5	
TS TL 20 A	20mm (Small)	25.40	12.70	25.40	12.70	8.00	8.00	8.00	3.00	4.76	mm
		1.000	.500	1.000	.500	.315	.315	.315	.118	.188	in
TS TL 26 A	26mm (Medium)	28.58	12.70	28.58	12.70	10.00	10.00	10.00	4.00	4.76	mm
		1.125	.500	1.125	.500	.394	.394	.394	.157	.188	in
TS TL 32 A	32mm (Large)	28.58	15.88	28.58	15.88	15.00	12.00	12.00	4.00	4.76	mm
		1.125	.625	1.125	.625	.591	.472	.472	.157	.188	in

Assembly and installation guidelines

- At end of first stroke, Body for Cam Fingers must seat firmly against Center Rod flange.
- The Body must not apply full static pressure against Cam Fingers at end of first stroke.
- The moldmaker must 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/-0.02mm or less.
- Stroke 1 (H1) is reduced by cutting and/or grinding the moving platen end of 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 table does not include additional stop pins to stationary-side spacer plate. To reduce H2 even further than what is specified in table, 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 (300°F) 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.