

ITEM NUMBER	CENTER ROD DIA	CENTER ROD LENGTH	TRAVEL SLEEVE LENGTH	H1 – STROKE 1 ⁽³⁾		H2 – STROKE 2 ⁽⁴⁾		
				MINIMUM	MAXIMUM	MINIMUM	MAXIMUM	
2-STAGE EJECTOR BOTTOM LAST (TS BL)								
TS BL 20 A	20mm (Small)	277.96	86.00	8.0	82.0	12.0	82.0	mm
		10.943	3.386	.32	3.23	.47	3.23	in
TS BL 26 A	26mm (Medium)	311.32	94.00	10.0	92.0	18.0	92.0	mm
		12.257	3.701	.39	3.62	.71	3.62	in
TS BL 32 A	32mm (Large)	352.21	105.00	12.0	102.0	24.0	102.0	mm
		13.867	4.134	.47	4.02	.94	4.02	in

ITEM NUMBER	CENTER ROD DIA	BEP	BER	TEP	TER	T4	S1	S2	S3	S4	S5	
2-STAGE EJECTOR BOTTOM LAST (TS BL)												
TS BL 20 A	20mm (Small)	25.40	12.70	25.40	12.70	M6	11.00	8.00	10.00	4.76	4.00	mm
		1.000	.500	1.000	.500	M6	.433	.315	.394	1.86	.157	in
TS BL 26 A	26mm (Medium)	28.58	12.70	28.58	12.70	M8	14.00	10.00	12.00	4.76	4.00	mm
		1.125	.500	1.125	.500	M8	.551	.394	.472	1.86	.157	in
TS BL 32 A	32mm (Large)	28.58	15.88	28.58	15.88	M10	17.00	12.00	14.00	6.29	6.00	mm
		1.125	.625	1.125	.625	M10	.669	.472	.551	.248	.238	in

Assembly and installation guidelines

- At end of second stroke, Body for Cam Fingers must seat firmly against Center Rod head or spacer plate.
- 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. The recommended tolerance on the Center Rod length after the customer has cut the Center Rod is +0/-0.02mm or less.
- The moldmaker must cut and/or grind the Travel Sleeve to the required length prior to installation of the 2-Stage Ejector assembly into the mold base.
- 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 moving platen end of both the Center Rod and the Travel Sleeve.
- 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.
- A minimum of (4) Puller Pins should be used with each mold. Larger molds may require additional Puller Pins.
- The moldmaker must cut and/or grind the Puller Pins to the required length.
- Puller Pins are **not** included with Bottom Last Assemblies and must be ordered separately.