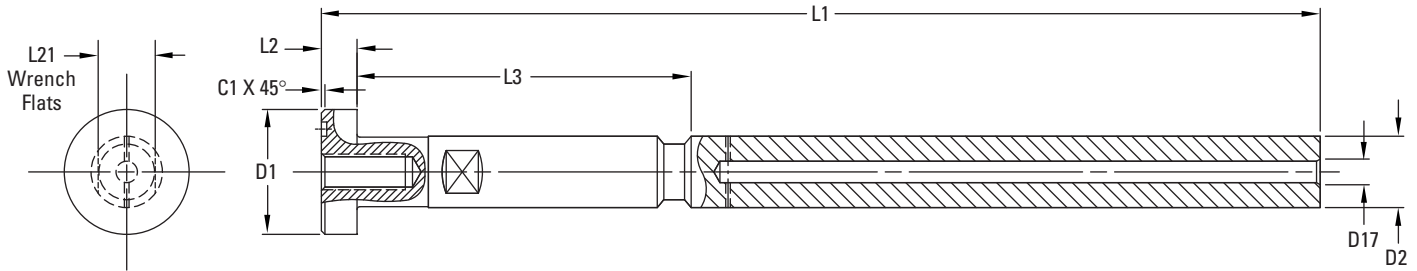


# D-M-E Bottom Last 2-Stage Ejector (TS BL) Component Information

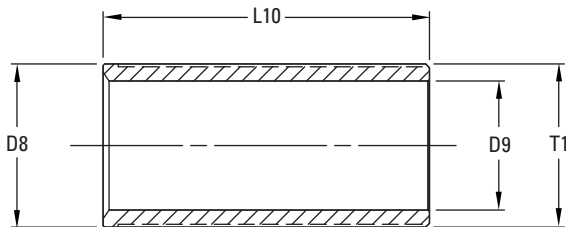
## Center Rod – CR



ASSEMBLY ITEM NUMBER	CENTER ROD DIA	COMPONENT ITEM NUMBER	D1 DIA	D2 DIA	D17 DIA	L1* LENGTH	L2 THICK	L3 LENGTH	L21 FLATS	C1 CHAMFER	
TS BL 20	20mm (Small)	TS BL 20 CR	34.0 <sup>-0.01</sup>	20.0 <sup>-0.01</sup>	6.0	280.0	10.0 <sup>+0.02</sup>	93.66	16.0	1.0	mm
			1.339 <sup>-0.0004</sup>	.787 <sup>-0.0004</sup>	.24	11.02	.394 <sup>+0.001</sup>	3.687	.63	.04	in
TS BL 26	26mm (Medium)	TS BL 26 CR	44.0 <sup>-0.01</sup>	26.0 <sup>-0.01</sup>	6.0	314.0	12.0 <sup>+0.02</sup>	105.67	20.0	1.0	mm
			1.732 <sup>-0.0004</sup>	1.024 <sup>-0.0004</sup>	.24	12.36	.472 <sup>+0.001</sup>	4.160	.79	.04	in
TS BL 32	32mm (Large)	TS BL 32 CR	58.0 <sup>-0.01</sup>	32.0 <sup>-0.01</sup>	8.0	354.0	14.0 <sup>+0.02</sup>	118.80	27.0	1.5	mm
			2.283 <sup>-0.0004</sup>	1.260 <sup>-0.0004</sup>	.31	13.94	.551 <sup>+0.001</sup>	4.677	1.06	.06	in

\*Cutoff on small diameter end only per installation data.

## Travel Sleeve – TS

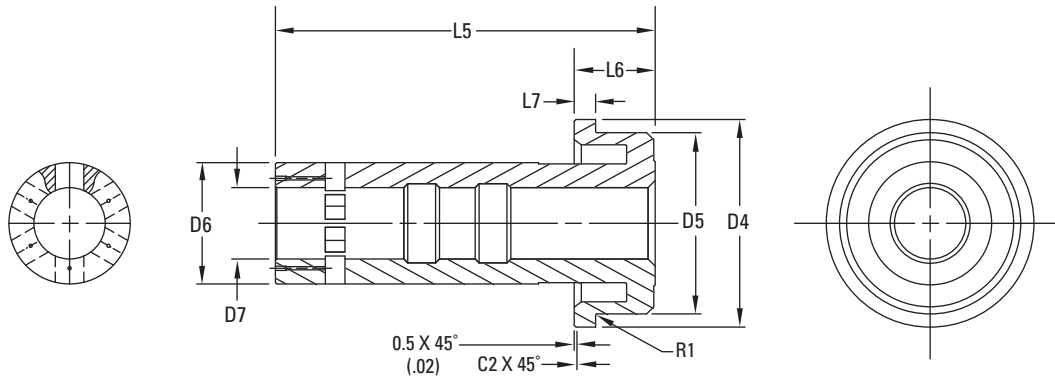


ASSEMBLY ITEM NUMBER	CENTER ROD DIA	COMPONENT ITEM NUMBER	D8 DIA	D9 DIA	L10* LENGTH	T1 THREAD	
TS BL 20	20mm (Small)	TS BL 20 TS	43.00 <sup>-0.03</sup>	34.0	86.0	M43.2 x 1.25	mm
			1.693 <sup>-0.001</sup>	1.34	3.39		in
TS BL 26	26mm (Medium)	TS BL 26 TS	54.00 <sup>-0.03</sup>	43.0	94.0	M54.2 x 1.25	mm
			2.126 <sup>-0.001</sup>	1.69	3.70		in
TS BL 32	32mm (Large)	TS BL 32 TS	68.00 <sup>-0.03</sup>	54.0	105.0	M68.25 x 1.25	mm
			2.677 <sup>-0.001</sup>	2.13	4.13		in

\*Supplied to provide maximum travel with no cutoff. To reduce travel in Stroke 2 (H2), cut threaded end per installation data.

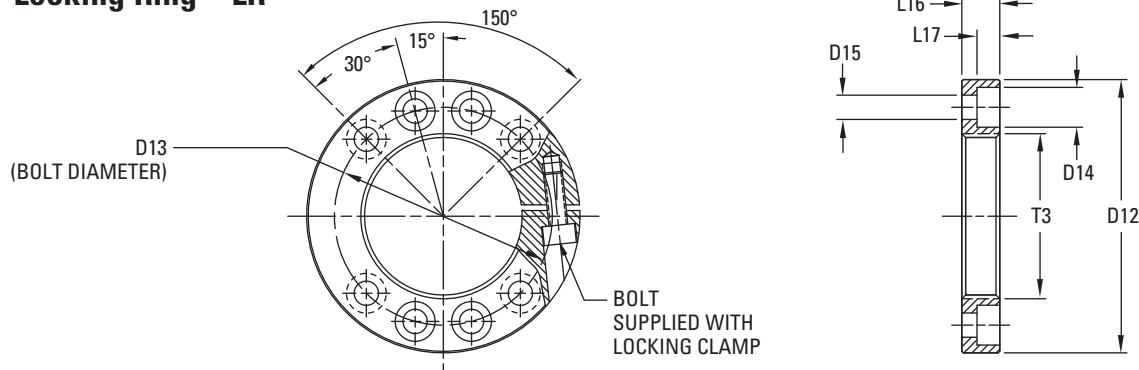
NOTES: All dimensions shown for components are intended for drawing layout purposes only and in some cases have been rounded off. Also, where the same diameter dimension is shown for parts that fit together, the tolerances create the appropriate clearance or fit.

## Body For Cam Fingers – BD (Body only without Cam Fingers)



ASSEMBLY ITEM NUMBER	CENTER ROD DIA	COMPONENT ITEM NUMBER	D4 DIA	D5 DIA	D6 DIA	D7 DIA	L5 LENGTH	L6 THICK	L7 THICK	C2 CHAMFER	R1 RADIUS	
TS BL 20	20mm (Small)	TS BL 20 BD	58.20 <sup>-0.03</sup>	50.8 <sup>-0.2</sup>	34.00	20.00	106.46	22.70	6.0 <sup>-0.01</sup>	.5	.4	mm
			2.291 <sup>-0.001</sup>	2.00 <sup>-0.008</sup>	1.339	.787	4.191	.894	.236 <sup>-0.0004</sup>	.020	.02	in
TS BL 26	26mm (Medium)	TS BL 26 BD	70.00 <sup>-0.03</sup>	62.6 <sup>-0.2</sup>	43.00	26.00	121.22	22.70	6.0 <sup>-0.01</sup>	.5	.4	mm
			2.756 <sup>-0.001</sup>	2.46 <sup>-0.008</sup>	1.693	1.024	4.772	.894	.236 <sup>-0.0004</sup>	.020	.02	in
TS BL 32	32mm (Large)	TS BL 32 BD	87.00 <sup>-0.03</sup>	78.0 <sup>-0.2</sup>	54.00	32.00	139.70	28.88	7.0 <sup>-0.01</sup>	.5	.4	mm
			3.425 <sup>-0.001</sup>	3.07 <sup>-0.008</sup>	2.126	1.260	5.500	1.137	.276 <sup>-0.0004</sup>	.020	.02	in

## Locking Ring – LR



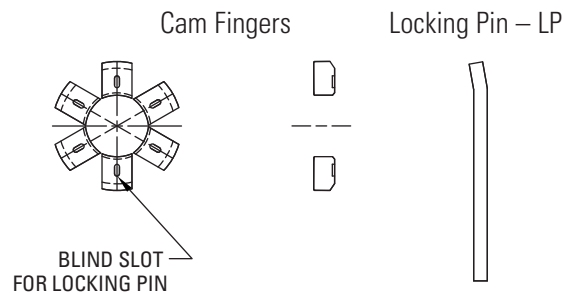
ASSEMBLY ITEM NUMBER	CENTER ROD DIA	COMPONENT ITEM NUMBER	D12 DIA	D13 DIA	D14 DIA	D15 DIA	L16 LENGTH	L17 LENGTH	T3 THREAD	
TS BL 20	20mm (Small)	TS BL 20 LR	72.0	57.4	10.5	6.4	10.0	6.0	M43.2 x 1.25	mm
			2.83	2.26	.41	.25	.39	.24		in
TS BL 26	26mm (Medium)	TS BL 26 LR	90.0	72.0	13.8	8.6	13.0	8.1	M54.2 x 1.25	mm
			3.54	2.83	.54	.34	.51	.32		in
TS BL 32	32mm (Large)	TS BL 32 LR	112.0	90.0	16.8	10.8	16.0	10.1	M68.25 x 1.5	mm
			4.41	3.54	.66	.43	.63	.40		in

NOTES: All dimensions shown for components are intended for drawing layout purposes only and in some cases have been rounded off. Also, where the same diameter dimension is shown for parts that fit together, the tolerances create the appropriate clearance or fit.

# D-M-E Bottom Last 2-Stage Ejector (TS BL) Component Information

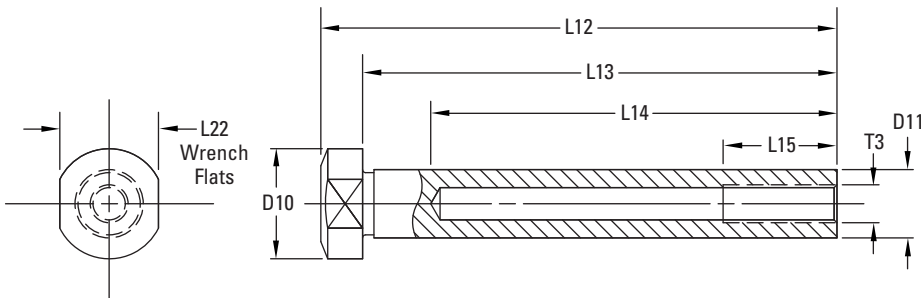
## Cam Finger Replacement Kit – KT

With (6) Cam Fingers, and (8) Locking Pins



ASSEMBLY ITEM NUMBER	CENTER ROD DIA	KIT ITEM NUMBER
TS BL 20	20mm (Small)	TS BL 20 KT
TS BL 26	26mm (Medium)	TS BL 26 KT
TS BL 32	32mm (Large)	TS BL 32 KT

## Puller Pin – PP



ASSEMBLY ITEM NUMBER	CENTER ROD DIA	COMPONENT ITEM NUMBER	D10 DIA	D11 DIA	L12 LENGTH	L13 LENGTH	L14 LENGTH	L15 LENGTH	L22 FLATS	T3 THREAD	
TS BL 20	20mm (Small)	TS BL 20 PP	29.0	18.0	136.0	125.0	107.0	30.0	26.0	M10	mm
			1.14	.71	5.35	4.92	4.21	1.18	1.02		in
TS BL 26	26mm (Medium)	TS BL 26 PP	34.0	21.0	153.0	139.0	120.0	40.0	30.0	M12	mm
			1.34	.83	6.02	5.47	4.72	1.57	1.18		in
TS BL 32	32mm (Large)	TS BL 32 PP	43.0	26.0	171.0	154.0	138.0	50.0	36.0	M16	mm
			1.69	1.02	6.73	6.06	5.43	1.97	1.42		in

NOTE: A minimum of (4) Puller Pins should be used with each mold. Larger molds may require additional Puller Pins. Puller Pins are **not** included with BL Assemblies and must be ordered separately.

NOTES: All dimensions shown for components are intended for drawing layout purposes only and in some cases have been rounded off. Also, where the same diameter dimension is shown for parts that fit together, the tolerances create the appropriate clearance or fit.