

D-M-E ACCELERATED EJECTORS

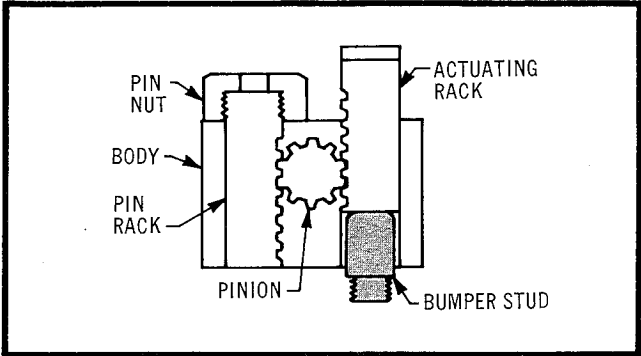
PIN TYPE

Used for individual ejector pin acceleration — one unit to a pin.

Top of pin rack must be counterbored or slotted to receive head of ejector pin being used. Also, pilot hole in pin nut ($\frac{1}{8}$ " on AEP-10, $\frac{1}{4}$ " on AEP-20) must be drilled out for the ejector pin. (See note #1 for further explanation)

PIN TYPE
(SCHEMATIC
VIEW)

Range of ejector pins accommodated is up to $\frac{1}{4}$ " diameter on the AEP-10 and $\frac{1}{2}$ " on the AEP-20. Any number of units can be installed in a mold — but only one per accelerated ejector pin. Bumper stud should be installed in ejector housing to assure positive return.

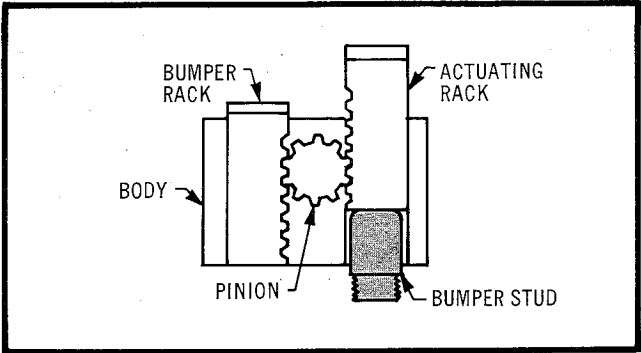


BUMPER TYPE

No pins are installed in this unit. Units themselves (usually 4) are installed in lower ejector plate assembly on dual ejector plate molds.

Clearance holes for actuator rack should be provided through the upper ejector plate assembly to allow contact with actuating stud (not supplied).

BUMPER TYPE
(SCHEMATIC
VIEW)



NOTES:

1. To mount ejector pin in pin type, drill clearance hole for ejector pin in pin nut through existing pilot hole. If ejector pin is to be locked against rotation, mill proper slot across top of pin rack and provide flat (or flats) on ejector pin head to match. If ejector pin does not require locking, either a counterbore or a slot, (as above, without flats in ejector pin head) may be provided.
2. Clearance of up to $\frac{1}{64}$ " approx. all around may be provided in ejector plate for body. Only normal assembly clearance to be provided in ejector retainer plate.
3. Use regular size units on D-M-E standard mold bases having ejector plates and ejector retainer plates 1-1/8" and 5/8" thickness respectively, and the small size units for 1" and 1/2" plates respectively. Other combinations of ejector plates and ejector retainer plates may require installation modifica-

- tions to suit for proper operation.
4. Locate bumper stud within actuating rack working area.
 5. Pin nut to be tightened down fully at final assembly.
 6. Travel 5/8" max. approximately—ratio 2:1.
 7. Apply small amount of grease to racks occasionally.
 8. (If disassembly is ever required.) To reinstall spring with proper tension, hold bumper or pin rack down in molding position, hook short end of spring onto gear bar so that spring's long leg is at approximately 10/11 o'clock—then turn long leg counterclockwise and into slot.
 9. For some applications, Early Ejector Return may be required to prevent pin damage.

D-M-E COMPANY

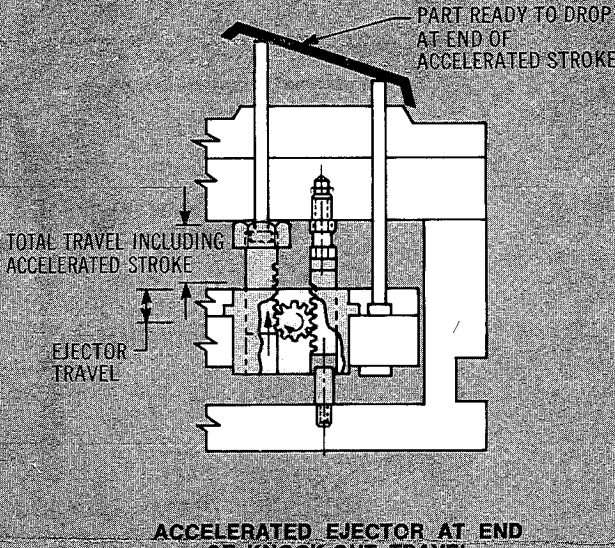
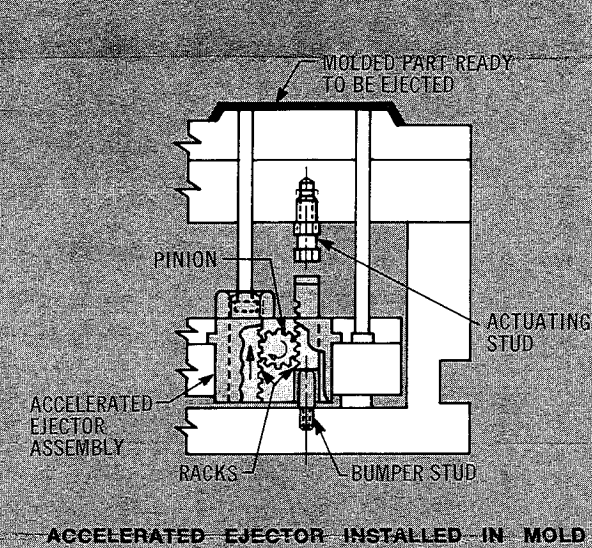
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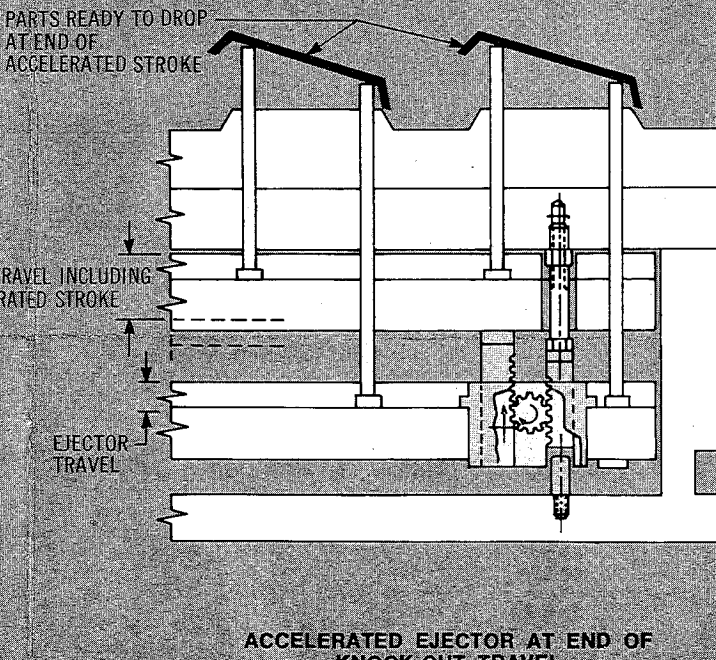
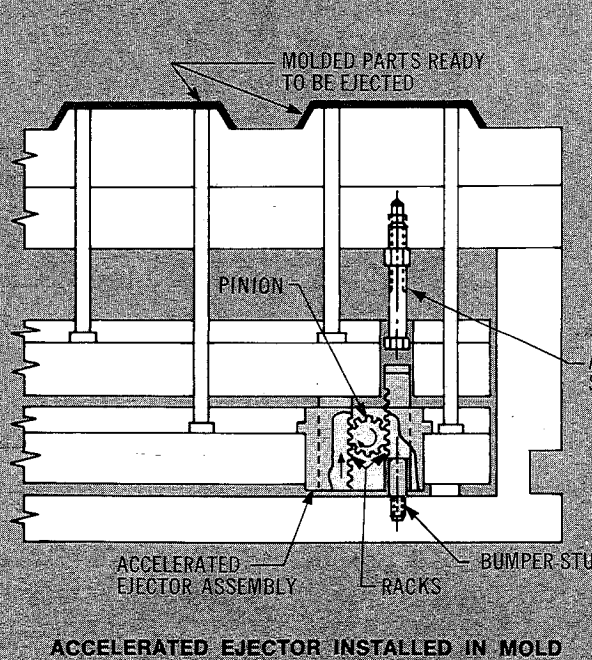
U.S. Patent No. 3,893,644

INSTALLATION INSTRUCTIONS AND DIMENSIONS

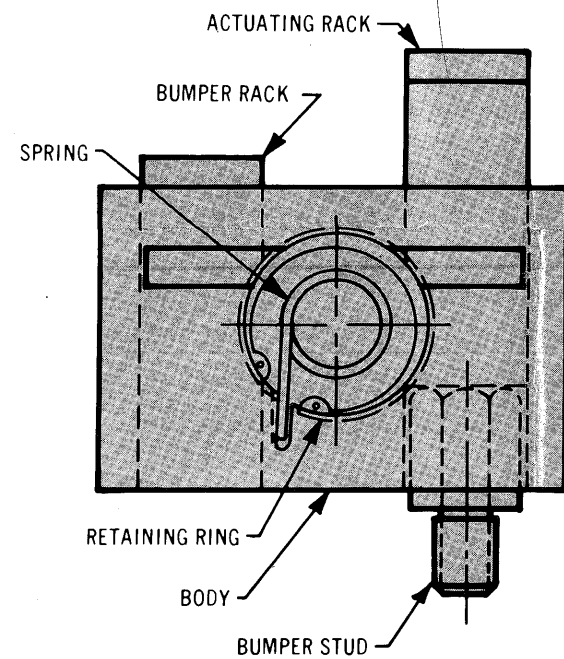
PIN TYPE APPLICATION



BUMPER TYPE APPLICATION



B-M-E ACCELERATED



Accelerated Ejector Dimensions



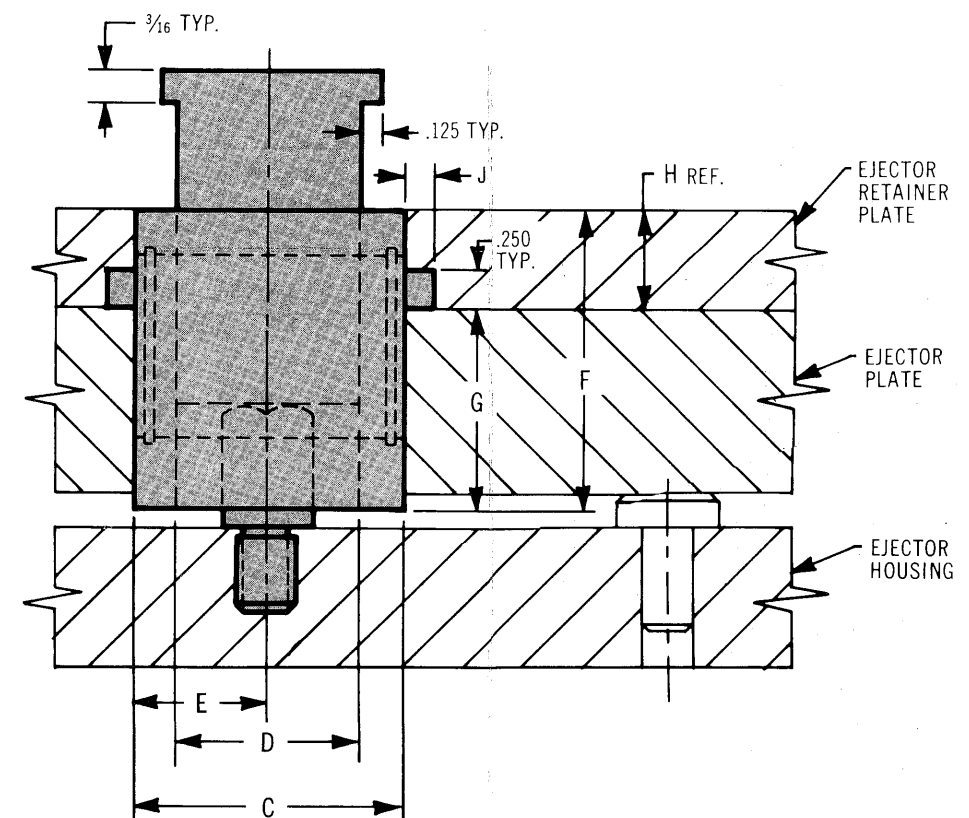
For bumper type . . . (1) Pinion, (1) Body, (1) Actuating Rack, (1) Bumper Rack, (1) Return Spring, (2) Retaining Rings, (1) Bumper Stud.

For pin type (1) Pinion, (1) Body, (1) Actuating Rack, (1) Pin Rack, including pin nut, (1) Return Spring, (2) Retaining Rings, (1) Bumper Stud.

Bumper type unit is identical with pin type, except a bumper rack is substituted for a pin rack.

Bumper and actuating racks for any one size unit are identical.

HH AEP-10 PIN TYPE/AEB-10 BUMPER TYPE	HH AEP-20 PIN TYPE/AEB-20 BUMPER TYPE
PINION—20 PITCH .700 P.D.—14 TEETH 20° PRESSURE ANGLE	PINION—16 PITCH 1.000 P.D.—16 TEETH 20° PRESSURE ANGLE

[illegible]