Ejector Sleeve and Center Pin Combination Example

<table>
<thead>
<tr>
<th>Center Pin Shaft Diameter</th>
<th>Suffix</th>
<th>Tolerance</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ø 0.505</td>
<td>-0.005</td>
<td>+0.005</td>
</tr>
</tbody>
</table>

Ejector sleeve hole diameter V tolerance

- Suitable
- Unsuitable

- Because the clearance between the ejector sleeve and center pin is kept to 0.005 mm or more, this is used in cases where the plastic is toxic to the development of burns, and for precision products.
- The smaller clearance required for those than the ejector sleeve and center pin 0.01 mm can be achieved.

Pass-through test pin Carbide pin gauge

- Combination: 3 stage recessed hole
- Minimum clearance value: 0.01 mm

Pass-through Test Standards for the Ejector Sleeve

- Ejector sleeve and center pin combination example

Ejector sleeve and center pin fit clearance

- The figures on the left show sleeve fit, when the same dimensions have been specified for ejector sleeve hole diameter V and center pin shaft diameter (D or P).
- Minimum clearance: 0.005 mm for center pin shaft diameter tolerance center pin.

Hole Diameter V Ø 0.85 and Shaft Diameter D or P Ø 0.8 Combination

- Minimum clearance value required for the center pin to pass through the ejector sleeve.

Hole Diameter V Ø 0.85 and Shaft Diameter D or P Ø 0.8 Combination

- Minimum clearance: 0.005 mm for center pin shaft diameter tolerance center pin.

Pass-through test pin standards for the ejector sleeve

- The figures on the left show sleeve fit when the same dimensions have been specified for ejector sleeve hole diameter V and center pin shaft diameter (D or P).

Ejector Sleeve Combination for Minimizing the Maximum Clearance

- Minimum clearance: 0.01 mm or more
- Minimum clearance: 0.005 mm or more

Ejector Sleeve/H7 Fit Clearance Range (maximum and minimum values)

- Minimum clearance: 0.01 mm or more
- Minimum clearance: 0.005 mm or more

Precautions when inserting a stepped center pin's shaft diameter

- The ejector sleeves have been designed to be used in combination with the center pins.
- Smooth sliding will not be possible if the fit section of the hole diameter (V) is too long for the center pin. This can lead to excessive wear, especially when the center pin is large, this is used in applications where the plastic is conducive to the development of burns.

Ejector sleeve and center pin fit clearance

- The ejector sleeves have been designed to be used in combination with the center pins.
- Smooth sliding will not be possible if the fit section of the hole diameter (V) is too long for the center pin. This can lead to excessive wear, especially when the center pin is large, this is used in applications where the plastic is conducive to the development of burns.

Pass-through test pin standards for the ejector sleeve

- The ejector sleeves have been designed to be used in combination with the center pins.
- Smooth sliding will not be possible if the fit section of the hole diameter (V) is too long for the center pin. This can lead to excessive wear, especially when the center pin is large, this is used in applications where the plastic is conducive to the development of burns.

Ejector Sleeve Resealed Hole (C)

- The resealed hole (C) is only applied with rough finishing. The precision standards regard a product acceptable of the corresponding straight center pin able to pass through the sleeve.

Precision Standards for the Ejector Sleeve Resealed Hole (C)

- The ejector sleeves have been designed to be used in combination with the center pins.
- Smooth sliding will not be possible if the fit section of the hole diameter (V) is too long for the center pin. This can lead to excessive wear, especially when the center pin is large, this is used in applications where the plastic is conducive to the development of burns.

Precautions when inserting a stepped center pin's shaft diameter (D) into an ejector sleeve's resealed hole (C)

- The precision standards of the resealed hole (C) is tested by inserting the appropriate standard pass-through test pin through the ejector sleeve and test pin.
- The hole diameter of the ejector sleeve is 0.85 mm larger than the center pin shaft diameter tolerance center pin.
- For this reason, CSD 0.5 is necessary in order to be able to insert a stepped center pin's shaft diameter (D) into the resealed hole (C) without problems. Please take note of this.