BIS TECHNICS

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Uitwerpers en uitwerperhulzen
Ejecteurs et douilles pour éjecteurs

Voorraadbepaling / *Stock*

Deze artikelen worden in voorraad gehouden in ons magazijn,
tussentijdse verkoop voorbehouden.
Ces articles sont disponibles de notre stock, vente entre-temps exclue.

Deze artikelen zijn voorradig bij onze leveranciers of kunnen snel gemaakt worden.
Ong. 5-10 werkdagen levertijd.
Ces articles sont en stock chez notre fournisseur ou sont produites rapidement.
Délai de livraison: 5-10 jours de travail.

Deze artikelen kunnen op 2-3 weken geleverd worden.
Ces articles peuvent être livrés en 2-3 semaines.

Voor specials en zonder indicatie zijn de levertijden steeds op aanvraag.
Les délais des articles spéciaux et sans indication sont toujours sur demande.

Opgegeven levertijden zijn indicatief. BIS-Technics werkt samen met gerenommeerde transport-bedrijven, maar een garantie met betrekking van de levertijd kan niet worden gegeven.

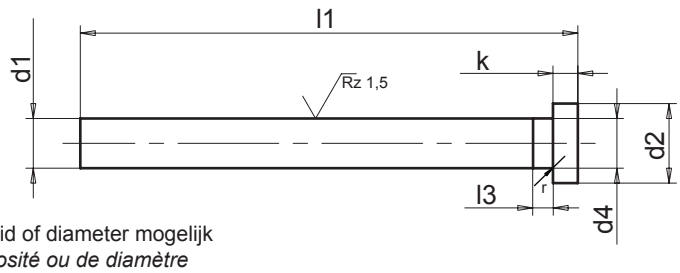
Technische wijzigingen voorbehouden. Aan drukfouten en foutieve technische gegevens en afbeeldingen kunnnen geen rechten worden ontleend.

Les délais sont toujours sous réserve. BIS-Technics collabore avec des transporteurs renommés.
Pourtant nous ne pouvons pas garantir le délai.

Sous réserve des modifications techniques et fautes typographiques. Illustrations peuvent dévier.

Uitwerpers met cilindrische kop / *Éjecteurs à tête cylindrique* DIN ISO 6751

Eberhard WERKZEUGTECHNOLOGIE



* afwijkende oppervlakteruwheid of diameter mogelijk
plusieures possibilités de rugosité ou de diamètre

Uitvoering / *Exécution*

Cilindrische kop gestuikt, schacht fijngeslepen en genitreerd; g6. Mogelijk in zwarte (genitreerd en oxideerd) of in blanke (blank genitreerd) uitvoering.
Tête cylindrique, repoussé à chaud, corps finement rectifié et nitruré; g6
Exécution noir (nitruré et oxidé) ou blanc (nitruré)

Materiaal / *Matière*

HSS

Bestelsleutel / *Exemple de commande*

	Mat.	d3= 8mm	l1= 250mm
I6751	HSS	080	250

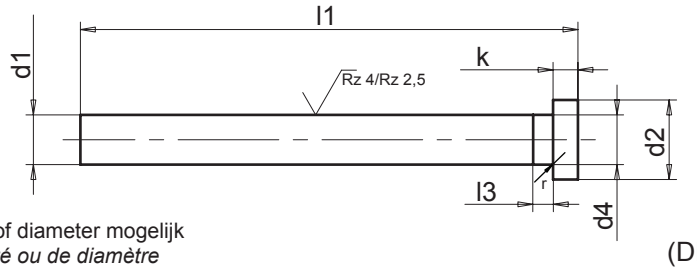
code: I6751HSS080250

d_1 g 6	d_2 0 / – 0,2	d_4	k 0 / – 0,05	r + 0,2 / 0	l_1 + 2 / 0: 40	50	80	100	125	160	200	250	315	400	500	630	l_3
0,7	2,5	d_1+0,03	1,2	0,2	●												5
1,0					●			●									
1,1									●								
1,2					●				●	●	●						
1,4	3,0		1,5								●						
1,5								●	●	●	●						
1,6									●								
1,7									●		●						
1,8									●		●						
1,9									●								
2,0	4,0		2,0					●	●	●	●	●	●				
2,1									●		●						
2,2									●	●	●						
2,3									●								
2,5	5,0			0,3		●		●	●	●	●	●	●				
3,0	6,0		3,0					●	●	●	●	●	●				
3,2										●	●						
3,5	7,0							●	●	●	●	●	●				
3,7												●	●				
4,0	8,0							●	●	●	●	●	●	●			
4,2								●	●	●	●	●					
4,5								●		●	●		●				
5,0	10,0							●	●	●	●	●	●	●		●	
5,2											●		●				
5,5								●			●	●	●				
5,6											●						
6,0	12,0		5,0	0,5				●			●	●	●			●	6
6,5											●	●					
7,0											●	●		●			
7,5											●						
8,0	14,0										●	●	●	●		●	8
8,5											●		●				
9,0											●		●				
9,5								●			●						
10,0	16,0										●	●	●			●	10
11,0											●						
12,0	18,0	d_1+0,04	7,0	0,8			●			●	●	●		●			12
14,0	22,0										●				●		14
15,0											●						
16,0											●						16

● = Standaard afmetingen / *dimensions standards*

Uitwerpers met cilindrische kop / *Éjecteurs à tête cylindrique* DIN ISO 6751

Eberhard WERKZEUGTECHNOLOGIE



* afwijkende oppervlakteruwheid of diameter mogelijk
plusieures possibilités de rugosité ou de diamètre

(DIN 1530 A, genitreerd)

Uitvoering / *Exécution*

O: zwart genitreerd en geoxideerd / *nitruré noir et oxydé*
Uitwerper met warmgestuikte kop. Schacht gehard. ontlaten en fijngeslepen.
Éjecteur avec corps finement rectifié. Tête refoulé à chaud et entièrement rectifiée. Livré monté.

B: Blank genitreerd / *nitruré blanc*

Op aanvraag / *Sur demande*

Uitvoering / *Exécution*:
- INCH

Materiaal / *Matière*

Gereedschapsstaal / *acier allié d' outillage*:
volgens / *selon* 1.2343, 1.2344
ontlaatweerstand / *résistance de trempe*: min. 600°C / 1112°F
ca. 1400 N/mm²

Bestelsleutel / *Exemple de commande*

	d3= 1,9mm	l1= 200mm
D1530AO	019	200
D1530AB	019	200

code: D1530AO019200
code: D1530AB019200

d_1 g 6	d_2 0 / – 0,2	d_4	k 0 / – 0,05	r + 0,2 / 0	l_1 + 2 / 0 100	125	160	200	250	315	400	500	630	800	1000	l_3
1,0	2,5	d_1 + 0,03	1,2	0,2	●	●	●	●								5
1,1					●	●	●	●								
1,2					●	●	●	●								
1,3	3		1,5		●	●	●	●								
1,4					●	●	●	●								
1,5					●	●	●	●	●							
1,6					●	●	●	●								
1,7					●	●	●	●								
1,8					●	●	●	●								
1,9					●	●	●	●								
2,0	4		2		●	●	●	●	●	●	●					
2,1					●	●	●	●	●							
2,2					●	●	●	●	●	●						
2,5	5			0,3	●	●	●	●	●	●						
2,6					●	●	●	●	●	●						
2,7					●	●	●	●	●	●						
2,8					●	●	●	●								

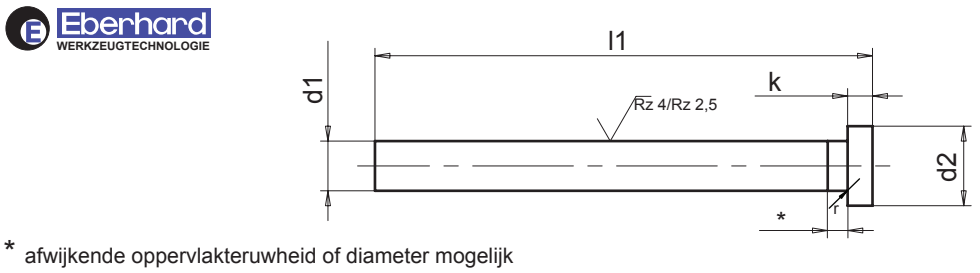
● = Standaard afmetingen / *dimensions standards*

d_1 g 6	d_2 0 – 0,2	d_4	k 0 – 0,05	r + 0,2 0	l_1 + 2 0 100	125	160	200	250	315	400	500	630	800	1000	l_3
3,0	6	d_1+0,03	3	0,3	●	●	●	●	●	●	●	●				5
3,1					●	●	●	●	●	●	●					
3,2					●	●	●	●	●	●	●					
3,3					●	●	●	●								
3,4					●	●	●	●								
3,5	7				●	●	●	●	●	●	●	●	●			
3,6					●	●	●	●	●	●	●					
3,7					●	●	●	●	●	●	●					
3,8					●	●	●	●								
4,0	8				●	●	●	●	●	●	●	●	●	●		
4,1					●	●	●	●	●	●	●					
4,2					●	●	●	●	●	●	●	●		●		
4,3							●	●								
4,4						●	●									
4,5					●	●	●	●	●	●	●	●		●		
4,6						●	●	●								
4,7					●	●	●	●	●							
4,8							●									
4,9								●								
5,0	10				●	●	●	●	●	●	●	●	●	●		
5,1					●	●	●	●	●	●	●	●				
5,2					●	●	●	●	●	●	●	●	●	●		
5,3					●	●	●	●	●							
5,4						●	●	●	●							
5,5					●	●	●	●	●	●	●	●	●	●		
5,7					●											
6,0	12		5	0,5	●	●	●	●	●	●	●	●	●	●	●	6
6,1							●	●								
6,2					●	●	●	●	●	●	●	●	●	●		
6,3							●	●								
6,5					●	●	●	●	●	●	●	●	●	●		
6,6							●	●								
6,7					●	●										
6,8									●							
6,9								●								
7,0					●	●	●	●	●	●	●	●	●	●		
7,2					●	●	●	●	●	●						
7,5					●	●	●	●	●	●	●	●				
8,0	14				●	●	●	●	●	●	●	●	●	●	●	8
8,2					●	●	●	●	●	●	●	●	●			
8,5					●	●	●	●	●	●	●	●	●			

● = Standaard afmetingen / *dimensions standards*

d_1 g 6	d_2 0 – 0,2	d_4	k 0 – 0,05	r + 0,2 0	l_1 + 2 0 100	125	160	200	250	315	400	500	630	800	1000	1250	l_3
8,7	14	d_1+0,03	5	0,5	●	●	●	●									8
9,0					●	●	●	●	●	●	●	●	●				
9,5					●	●	●	●	●	●	●						
10,0	16	d_1+0,04			●	●	●	●	●	●	●	●	●	●	●		10
10,2					●	●	●	●	●	●	●	●	●	●			
10,5					●	●	●	●	●	●	●	●	●	●	●		
11,0					●	●	●	●	●	●	●	●	●				
11,5					●	●	●	●			●						
12,0	18		7	0,8	●	●	●	●	●	●	●	●	●	●	●		12
12,2					●	●	●	●	●	●	●	●	●				
12,5					●	●	●	●	●	●	●	●	●	●			
13,0					●	●	●	●	●	●	●						13
13,5											●						
14,0	22				●	●	●	●	●	●	●	●	●	●	●		14
14,5											●	●					
15,0					●	●	●	●	●								
16,0					●	●	●	●	●	●	●	●	●	●	●	●	16
16,5											●						
18,0	24	d_1+0,07			●	●	●	●	●	●	●	●	●	●	●		18
18,5										●*							
19,0								●									
19,5											●						
20,0	26		8	1,1		●	●	●	●	●	●	●	●	●	●		20
20,2													●				
20,5													●				
25,0	32	d_1+0,1	10				●	●	●	●	●	●	●	●	●		25
32,0	40							●	●	●	●	●	●	●	●		32

Uitwerpers/kernstiften ongenitreerd / *Éjecteurs/core broches non-nitrurées* DIN 1530 A



* afwijkende oppervlakteruwheid of diameter mogelijk
plusieures possibilités de rugosité ou de diamètre

Uitvoering / *Exécution*

Cilindrische kop gestuikt, schacht fijngeslepen; g6.
Tête cylindrique, repoussé, corps finement rectifié; g6

Op aanvraag / *Sur demande*

Uitvoering / *Exécution*:
- INCH

Materiaal / *Matière*

Gereedschapsstaal / *acier allié d' outillage*:
volgens / *selon* 1.2343, 1.2344
ontlaatweerstand / *résistance de trempe*: min. 600°C / 1112°F
ca. 1400 N/mm²

Bestelsleutel / *Exemple de commande*

	d1= 55mm	l1= 250mm
D1530A	055	0250

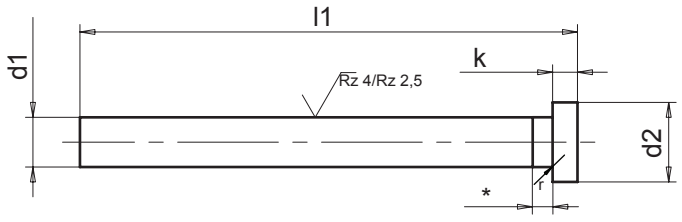
code: D1530A0550250

d_1 g 6 −0,005	d_2 0 −0,2	d_4	k 0 −0,05	r +0,2 0	l_1 +2 0 100	125	160	200	250	315	400	500	630	800	1000	l_3
1,5	3	d_1+0,03	1,5	0,2	●	●										5
2,0	4		2		●	●	●	●	●	●						
2,1								●								
2,2					●			●		●						
2,5	5			0,3	●	●	●		●	●						
2,7					●					●						
3,0	6		3		●	●	●	●	●	●	●	●				
3,2					●	●		●			●					
3,5	7				●	●	●	●	●	●	●					
3,7					●	●			●							
4,0	8				●	●	●	●	●	●	●	●				
4,2					●	●	●	●	●		●	●				
4,5					●	●	●	●	●	●	●	●				
5,0	10				●	●	●	●	●	●	●	●	●			
5,2					●	●	●	●		●		●				
5,5					●	●	●	●	●	●	●	●				
6,0	12		5	0,5	●	●	●	●	●	●	●	●	●			6
6,2					●	●	●	●	●	●	●	●				
6,5					●	●	●	●	●	●	●	●				
7,0					●	●	●	●	●	●	●	●	●			
7,2							●									
7,5					●	●	●	●	●	●	●					
8,0	14				●	●	●	●	●	●	●	●	●	●		8
8,2					●	●	●	●		●	●		●			
8,5					●	●	●	●	●	●	●		●	●		
9,0					●	●	●	●	●	●	●	●	●			
9,5					●	●	●	●	●	●	●	●				
10,0	16	d_1+0,04			●	●	●	●	●	●	●	●	●	●		10
10,2					●	●		●		●	●	●	●			
10,5					●	●	●	●	●	●	●	●	●	●		
11,0					●	●	●	●	●	●	●	●	●			
11,5								●								
12,0	18		7	0,8	●	●	●	●	●	●	●	●	●	●		12
12,2					●	●		●	●	●						
12,5					●	●	●	●	●	●	●		●			
13,0							●	●			●			●		13
13,5											●					
14,0	22				●	●	●	●	●	●	●	●	●	●		14
14,5											●					
15,0					●	●	●	●	●		●					
15,5											●					
16,0					●	●	●	●	●	●	●	●	●	●		16
16,2										●						
16,5												●				
18,0	24	d_1+0,07			●	●	●	●	●	●	●	●	●			18
20,0	26		8	1,1	●	●	●	●	●	●	●	●	●			20
25,0	32	d_1+0,1	10				●		●		●	●	●			25
32,0	40							●		●	●	●				32

● = Standaard afmetingen / *dimensions standards*

Uitwerpers/kernstiften gehard / *Éjecteurs/core broches trempées* DIN 1530 AH

Eberhard WERKZEUGTECHNOLOGIE



* afwijkende oppervlakteruwheid of diameter mogelijk
plusieures possibilités de rugosité ou de diamètre

Uitvoering / *Exécution*

Cilindrische kop gestuikt, schacht gehard en fijngeslepen; g6.
Tête cylindrique, repoussé, corps trempé et finement rectifié; g6

Materiaal / *Matière*

WS:
volgens / *selon* 1.2210, 1.2067 — 60 ± 2 HRC

Bestelsleutel / *Exemple de commande*

	d1= 5,5mm	l1= 250mm
D1530AH	055	0250

code: D1530AH0550250

d_1 g 6	d_2 0 – 0,2	d_4	k 0 – 0,05	r + 0,2 0	l_1 + 2 0: 40	50	63	80	100	125	160	200	250	315	400	500	l_3
0,8					●	●	●	●	●	●	●						
0,9					●	●	●	●	●	●	●						
1,0	2,5		1,2		●	●	●	●	●	●	●	●					
1,1					●	●	●	●	●	●	●	●					
1,2					●	●	●	●	●	●	●	●	●				
1,3					●	●	●	●	●	●	●	●					
1,4					●	●	●	●	●	●	●	●					
1,5					●	●	●	●	●	●	●	●	●	●			
1,6	3		1,5	0,2	●	●	●	●	●	●	●	●	●				
1,7					●	●	●	●	●	●	●	●					
1,8					●	●	●	●	●	●	●	●					
1,9		d_1+0,03			●	●	●	●	●	●	●	●					5
2,0					●	●	●	●	●	●	●	●	●	●	●		
2,1								●	●	●	●	●	●				
2,2	4							●	●	●	●	●	●	●	●		
2,3								●	●	●	●	●	●				
2,4			2					●	●	●	●	●	●				
2,5					●	●	●	●	●	●	●	●	●	●	●	●	
2,6									●	●	●	●	●				
2,7	5			0,3				●	●	●	●	●	●	●	●		
2,8									●	●	●	●		●			
2,9									●	●	●	●					

● = Standaard afmetingen / *dimensions standards*

d_1 g 6	d_2 0 – 0,2	d_4	k 0 – 0,05	r + 0,2 0	l_1 + 2 0														l_3
					40	50	63	80	100	125	160	200	250	315	400	500	630	800	
3,0					●	●	●	●	●	●	●	●	●	●	●	●			
3,1									●	●	●	●	●	●	●				
3,2	6							●	●	●	●	●	●	●	●				
3,3									●	●	●	●							
3,4									●	●	●	●		●		●			
3,5								●	●	●	●	●	●	●	●	●			
3,6									●	●	●	●	●		●				
3,7	7							●	●	●	●	●	●	●	●				
3,8									●	●	●	●		●					
3,9									●	●			●		●				
4,0					●	●	●	●	●	●	●	●	●	●	●	●	●		
4,1									●	●	●	●	●		●				
4,2								●	●	●	●	●	●	●	●	●			
4,3									●	●	●	●							
4,4	8		3	0,3					●	●	●	●							5
4,5								●	●	●	●	●	●	●	●	●			
4,6									●	●	●	●	●		●				
4,7									●	●	●	●	●	●	●				
4,8									●	●		●							
4,9										●		●							
5,0					●	●	●	●	●	●	●	●	●	●	●	●	●	●	
5,1									●	●	●	●			●				
5,2								●	●	●	●	●	●	●	●	●			
5,3									●	●	●	●	●						
5,4	10	d_1+0,03								●	●		●						
5,5									●	●	●	●	●	●	●	●	●	●	
5,6									●	●	●		●		●				
5,7									●	●	●	●	●	●	●				
5,8									●	●	●		●						
5,9											●		●						
6,0					●	●	●	●	●	●	●	●	●	●	●	●	●	●	
6,1									●	●	●	●	●	●					
6,2								●	●	●	●	●	●	●	●	●	●		
6,3									●	●	●	●							
6,4									●	●		●							
6,5									●	●	●	●	●	●	●	●			
6,6	12								●		●	●							6
6,7									●			●	●		●				
6,8										●		●	●						
6,9			5	0,5								●	●						
7,0									●	●	●	●	●	●	●	●			
7,2									●	●	●	●							
7,5									●	●	●	●	●	●	●				
8,0							●	●	●	●	●	●	●	●	●	●	●	●	
8,1										●		●	●						
8,2	14							●	●	●	●	●	●	●	●			●	8
8,5									●	●	●	●	●	●	●				
9,0								●	●	●	●	●	●	●	●	●	●		

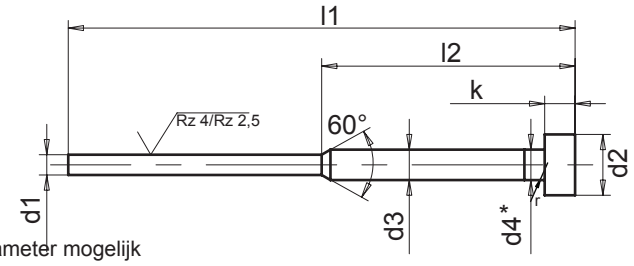
● = Standaard afmetingen / *dimensions standards*

d_1 g 6	d_2 0 – 0,2	d_4	k 0 – 0,05	r + 0,2 0	l_1 + 2 0 40	63	80	100	125	160	200	250	315	400	500	630	800	l_3
9,5	14	d_1+0,03	5	0,5				●	●	●	●	●	●	●				8
10,0	16	d_1+0,04					●	●	●	●	●	●	●	●	●	●	●	10
10,1											●	●						
10,2							●	●	●	●	●	●	●	●		●		
10,5								●	●	●	●	●	●	●		●		
10,7										●								
11,0										●	●	●	●	●		●		
12,0	18		7	0,8			●	●	●	●	●	●	●	●	●	●	●	12
12,1												●						
12,2										●	●		●	●	●			
12,5										●	●	●	●	●		●		
13,0								●	●	●	●	●	●	●				13
14,0	22							●	●	●	●	●	●	●	●		●	14
14,5								●	●	●	●	●	●					
15,0								●	●	●	●	●						
16,0							●	●	●	●	●	●	●	●	●	●	●	16
16,5											●	●		●				
18,0	24	d_1+0,07								●	●	●	●	●	●		●	18
20,0	26		8	1,1				●	●	●	●	●	●	●	●	●	●	20
20,5												●		●				
25,0	32	d_1+0,1	10							●	●	●	●	●	●			25

● = Standaard afmetingen / *dimensions standards*

Uitwerpers/kernstiften gehard / *Éjecteurs/core broches trempées* DIN 1530 C

Eberhard WERKZEUGTECHNOLOGIE



* afwijkende oppervlakteruwheid of diameter mogelijk
plusieures possibilités de rugosité ou de diamètre

Uitvoering / *Exécution*

C:
Cilindrische kop gestuikt, schacht fijngeslepen en zwart genitreerd
Tête cylindrique, repoussé, corps finement rectifié et nitruré noir

CBLANK:
Cilindrische kop gestuikt, schacht fijngeslepen en blank genitreerd
Tête cylindrique, repoussé, corps finement rectifié et nitruré blanc

Materiaal / *Matière*

Gereedschapsstaal / *acier allié d' outillage*:
volgens / *selon* 1.2343, 1.2344
ontlaatweerstand / *résistance de trempe*: min. 600°C / 1112°F
ca. 1400 N/mm²

Bestelsleutel / *Exemple de commande*

	d1= 1,3mm	l1= 160mm
D1530C	130	160
D1530CBLANK	130	160

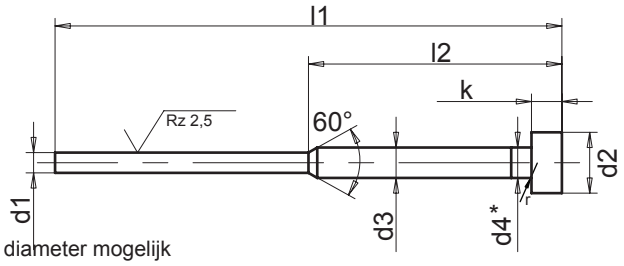
code: D1530C130160
code: D1530CBLANK130160

d_1 g 6 opgaand 0,1 *montant 0,1*	d_2 0 – 0,2	d_4	d_3 0 – 0,1	k 0 – 0,05	r + 0,2 0	l_1 + 2 0					l_3
						80	100	125	160	200	
						l_2 – 1 – 2					
						35	50	50	75	75	
0,6–1,4	4	d_3+0,03	2	2	0,2	●	●	●	●	●	5
1,5– 2,4	6		3	3	0,3	●	●	●	●	●	
2,5	6		3	3	0,3		●	●	●	●	
2,6–2,9	6		3	3	0,3						
3,0–3,5	8		4	3	0,3						

● = Standaard afmetingen / *dimensions standards*

Uitwerpers/kernstiften gehard / *Éjecteurs/core broches trempées* DIN 1530 CH

Eberhard WERKZEUGTECHNOLOGIE



* afwijkende oppervlakteruwheid of diameter mogelijk
plusieures possibilités de rugosité ou de diamètre

Uitvoering / *Exécution*

CH:
Cilindrische kop gestuikt, schacht gehard en fijngeslepen
Tête cylindrique, repoussé, corps trempé et finement rectifié

Materiaal / *Matière*

WS:
volgens / *selon* 1.2210, 1.2067 — 60 ± 2 HRC

Bestelsleutel / *Exemple de commande*

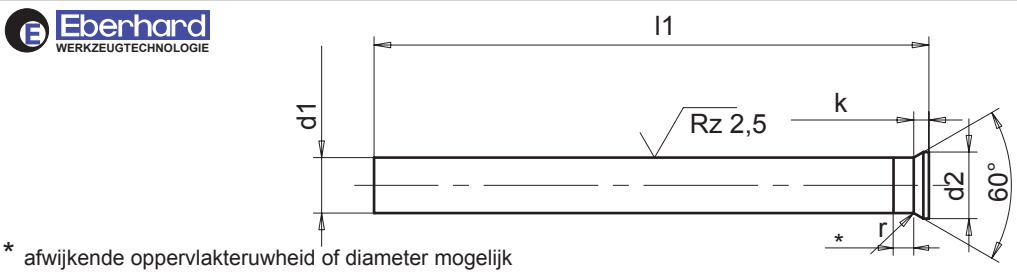
	d1= 1,3mm	l1= 160mm
D1530CH	130	160

code: D1530CH130160

d_1 g 6 opgaand 0,1 *montant 0,1*	d_2 0 – 0,2	d_4	d_3 0 – 0,1	k 0 – 0,05	r + 0.2 0	l_1 +2 0 / l_2 -1 -2: 63 / 25	80 / 35	100 / 50	125 / 50	160 / 75	200 / 75	250 / 100	315 / 160	l_3
0,5	4	d_1+0,03	2	2	0,2		●	●	●	●				5
0,6 + 0,7							●	●	●	●	●			
0,8						●	●	●	●	●	●	●		
0,85										●	●			
0,9						●	●	●	●	●	●			
0,95											●			
1,0						●	●	●	●	●	●	●		
1,1							●	●	●	●	●	●		
1,2						●	●	●	●	●	●	●		
1,3 + 1,4							●	●	●	●	●	●		
1,5	6		3	3	0,3		●	●	●	●	●	●	●	
1,6							●	●	●	●	●	●		
1,7 bis 1,9							●	●	●	●	●			
2,0							●	●	●	●	●	●	●	
2,1 bis 2,4							●	●	●	●	●			
2,5								●	●	●	●	●	●	

● = Standaard afmetingen / *dimensions standards*

Uitwerpers/kernstiften met conische kop / *Éjecteurs/core broches à tête conique* DIN 1530 D



* afwijkende oppervlakteruwheid of diameter mogelijk
plusieures possibilités de rugosité ou de diamètre

Uitvoering / *Exécution*

D:
Kop gestuikt, schacht gehard en fijngeslepen; g6
Tête repoussé, corps trempé et finement rectifié; g6

Materiaal / *Matière*

WS:
volgens / *selon* 1.2210, 1.2067 60 ± 2 HRC

Bestelsleutel / *Exemple de commande*

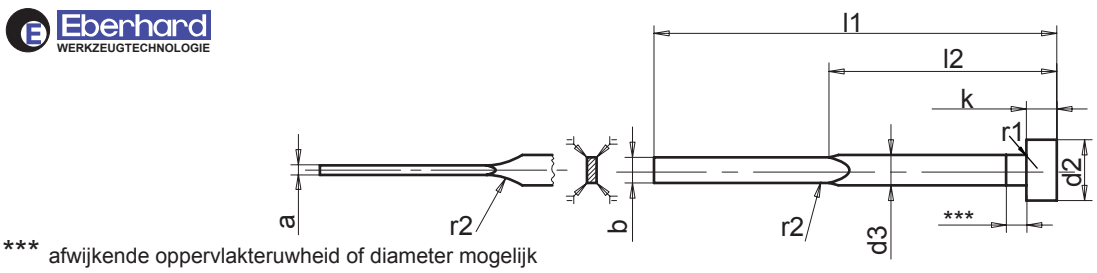
	d1= 1,3mm	l1= 160mm
D1530D	130	160

code: D1530D130160

d_1 g 6	d_2	Tol.	d_3	k + 0,2 0	r	l_1 + 2 0 100	125	160	200	250	315	l_2
0,7	1,3	± 0,05	d_1+0,02	0,72	0,2 + 0,2	●						5
0,8	1,4			0,92		●	●	●	●			
0,9	1,6			1,01		●	●	●	●			
1,0	1,8		d_1+0,03	1,19	$0,4^{+0,3}_{0}$	●	●	●	●			
1,1				1,11		●	●	●	●			
1,2	2,0			1,19		●	●	●	●			
1,25				1,15		●	●	●				
1,3				1,11		●	●	●	●			
1,4	2,2			1,19		●	●	●	●			
1,5				1,11		●	●	●	●			
1,6	2,5			1,28		●	●	●	●			
1,7				1,19		●	●	●	●			
1,75				1,15		●	●	●				
1,8	2,8			1,37		●	●	●	●			
1,9				1,28		●	●	●	●			
2,0	3,0	± 0,1		1,37		●	●	●	●	●		
2,1	3,2			1,45		●	●	●	●			
2,2				1,37		●	●	●	●			
2,25				1,32		●						
2,3	3,5			1,54		●	●	●	●			
2,4				1,45		●	●	●	●			
2,5				1,37	$0,6^{+0,4}_{0}$	●	●	●	●	●		
2,6	4,0			1,71		●	●	●	●			
2,7				1,63		●	●	●	●	●		
2,75				1,58		●			●			
2,8				1,54		●	●	●	●	●		
2,9				1,45		●	●		●			
3,0	4,5			1,80		●	●	●	●	●		
3,1				1,71		●	●	●	●	●		
3,2				1,63		●	●	●	●	●		
3,25				1,58		●	●		●			
3,3				1,54		●	●	●	●			
3,35				1,50			●	●				
3,4				1,45		●	●	●	●			
3,5	5,0			1,80		●	●	●	●	●		
3,6				1,71		●		●	●			
3,7				1,63		●	●		●			
3,75				1,58					●			
3,8				1,54		●	●		●			
3,9				1,45		●	●	●	●			
4,0	5,5			1,80		●	●	●	●	●	●	
4,1				1,71		●	●	●	●			
4,2				1,63		●	●	●	●			

d_1 g 6	d_2	Tol.	d_3	k + 0,2 0	r	l_1 + 2 0 100	125	160	200	250	315	l_2
4,25	5,5	± 0,1	d_1+0,03	1,58	$0,6^{+0,4}_{0}$	●			●			5
4,3				1,54		●	●	●	●			
4,4				1,45		●	●	●	●			
4,5	6,0			1,80		●	●	●	●	●		
4,6				1,71		●	●		●			
4,7				1,63		●	●		●			
4,75				1,58		●						
4,8				1,54		●	●	●	●			
4,9				1,45		●			●			
5,0	6,5			1,80		●	●	●	●	●	●	6
5,1				1,71		●		●	●			
5,2				1,63		●	●	●	●			
5,25				1,58		●						
5,3				1,54			●		●			
5,4				1,45			●		●			
5,5	7,0			1,80		●	●	●	●			
5,6				1,71		●	●		●			
5,7				1,63			●	●	●			
5,8				1,54			●		●			
5,9				1,45					●			
6,0	8,0	± 0,2	d_1+0,04	2,23	$1,0^{+0,5}_{0}$	●	●	●	●	●	●	
6,1				2,15		●						
6,2				2,06		●	●	●	●			
6,3				1,97			●		●			
6,5	9,0			3,17		●	●	●	●			
6,7				2,99		●	●	●	●			
7,0				2,73		●	●	●	●			
7,5	10,0			3,17		●	●	●	●			
7,9				2,82		●						
8,0				2,73		●	●	●	●	●	●	8
8,1				2,65					●			
8,2				2,56		●			●			
8,4				2,39			●		●			
8,5	11,0			3,17		●	●	●	●			
9,0				2,73		●	●	●	●			
9,5	12,0			3,17				●				
10,0				2,73		●	●	●	●	●	●	10
11,0	13,0			2,73		●	●	●	●			
11,5	14,0			3,17			●					
12,0	14,0			2,73		●	●	●	●	●	●	
13,0	15,0			2,73				●	●			
14,0	16,0			3,23		●	●	●	●	●	●	
16,0	18,0			3,23		●	●	●	●	●	●	

Bladuitwerpers / *Ejecteurs lame* DIN 1530 FA



*** afwijkende oppervlakteruwheid of diameter mogelijk
plusieures possibilités de rugosité ou de diamètre

Uitvoering / *Exécution*

FA:
Kop gestuikt, schacht geslepen, zwart genitreerd
Wordt toegepast bij drukgietwerk
Tête repoussé à chaud, corps nitruré noir, pour moules

Op aanvraag / *Sur demande*

Met hoekradius R0,20mm (4x)
Avec radius R0,20mm (4x)

Materiaal / *Matière*

Gereedschapsstaal / *acier allié d' outillage*:
volgens / *selon* 1.2343, 1.2344
ontlaatweerstand / *résistance de trempe*: min. 600°C / 1112°F
ca. 1400 N/mm²

Bestelsleutel / *Exemple de commande*

	a= 2mm	b= 7,5mm	l1= 200mm
D1530FA	020	075	200

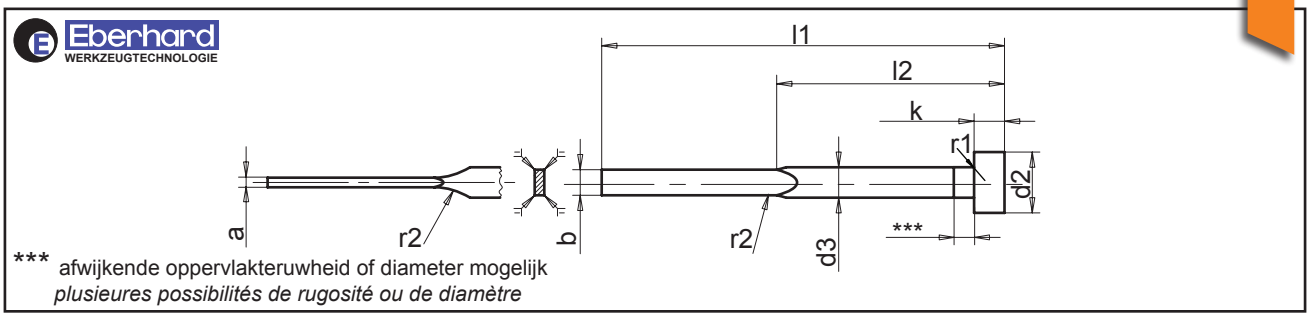
code: D1530FA020075200

a	b	d_3	d_2	k	r_1	r_2	l_1 + 2/0								
							63	80	100	125	160	200	250	315	400
0 – 0,015 ***	0 – 0,015 ***	h11	0 – 0,2	0 – 0,05	+ 0,2 0	min	l_2 – 1/– 2								
							30**	40	50	60**	80	100	125	160	200
0,8	3,5	4,0	8	3	0,3	10	●	●	●	●	●				
1,0							●		●	●					
1,2							●			●					
1,0		4,2					●	●	●	●	●				
0,8	3,8							●	●	●	●	●			
1,0							●	●	●	●	●	●			
1,2								●	●	●	●	●	●		
0,8	4,5	5	10							●	●				
1,0								●	●	●	●	●			
1,2								●	●	●	●	●			
1,5								●	●	●	●	●	●		
0,8	5,5	6	12	5	0,5					●	●				
1,0								●	●	●	●	●	●	●	
1,2								●	●	●	●	●	●		
1,5									●	●	●	●		●	
2,0									●	●	●	●			
1,2	7,5	8	14						●	●	●	●	●	●	
1,5										●	●	●	●	●	
1,6											●				
2,0										●	●	●	●	●	
1,5	9,5	10	16								●	●	●	●	
2,0											●	●	●	●	●
2,0	11,5	12	18	7	0,8							●	●	●	●
2,5												●	●	●	●
2,0	15,5	16	22									●	●	●	●
2,5												●	●	●	●

● = Standaard afmetingen / *dimensions standards*

** Partly available from stock with 32 mm / 63 mm.
*** These limit values apply for 100 mm length (l_2). For lengths (l_2) > 100 the limit values are to be multiplied by (l_1–l_2) 10^{-2}. The tolerance value reaches its maximum at the base 2. Please note on the orders d_3 measurement.

Bladuitwerpers / *Ejecteurs lame* DIN 1530 FAH



Uitvoering / *Exécution*

FAH:
Kop gestuikt, schacht gehard en fijngeslepen
Wordt toegepast bij druk- en spuitgietwerk
Tête repoussé à chaud, corps trempé et finement rectifié, pour moules

Op aanvraag / *Sur demande*

Met hoekradius R0,20mm (4x)
Avec radius R0,20mm (4x)

Materiaal / *Matière*

WS:
volgens / *selon* 1.2210, 1.2067 — 60 ± 2 HRC

Bestelsleutel / *Exemple de commande*

	a= 2mm	b= 7,5mm	l1= 200mm
D1530FAH	020	075	200

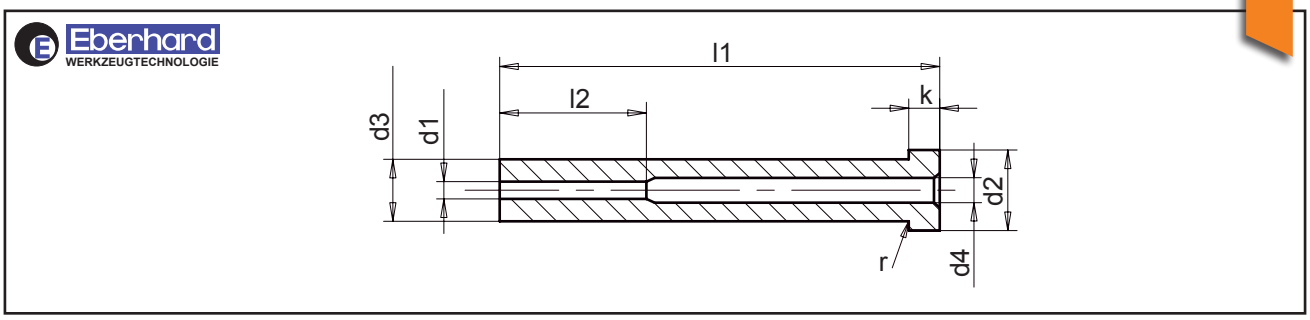
code: D1530FAH020075200

a	b	d_3	d_2	k	r_1	r_2	l_1 + 2/0								
							63	80	100	125	160	200	250	315	400
0 – 0,015 ***	0 – 0,015 ***	h11	0 – 0,2	0 – 0,05	+ 0,2 0	min	l_2 – 1/– 2								
							30**	40	50	60**	80	100	125	160	200
0,6	1,8	2	4	2	0,2	10				●	●				
0,6	2,5	3	6	3	0,3							●			
0,6	2,8									●		●			
0,7												●			
0,8									●	●	●	●			
1,0									●	●	●	●			
0,8	3,5	4	8				●	●	●	●	●				
1,0							●	●	●	●	●				
1,2							●	●	●	●	●	●			
1,0		4,2					●	●	●	●	●	●			
0,6	3,8									●		●			
0,8							●	●	●	●	●	●	●		
1,0							●	●	●	●	●	●	●		
1,2								●	●	●	●	●	●		
1,0	4,5	5	10					●	●	●	●	●	●		
1,2								●	●	●	●	●	●		
1,5								●	●	●	●	●	●		
1,0	5,5	6	12	5	0,5			●	●	●	●	●	●	●	
1,2								●	●	●	●	●	●	●	
1,5								●	●	●	●	●	●	●	
2,0								●	●	●	●	●	●	●	
1,2	7,5	8	14						●	●	●	●	●	●	
1,5									●	●	●	●	●	●	●
2,0									●	●	●	●	●	●	●
1,5	9,5	10	16								●	●	●	●	
2,0											●	●	●	●	●
2,0	11,5	12	18	7	0,8				●			●	●	●	●
2,5												●	●	●	●
2,0	15,5	16	22									●	●	●	●
2,5														●	●

● = Standaard afmetingen / *dimensions standards*

*** These limit values apply for 100 mm length (l_2). For length (l_2) > 100 the limit values are to be multiplied by (l_1–l_2) 10^{-2}. The tolerance value reaches its maximum at base 2.
** Partly available from stock with 32 mm / 63 mm.
Please note on the orders d_3 measurement.

Uitwerphulzen / *Douilles pour éjecteur* DIN 16756



Uitvoering / *Exécution*

BN:
Blank genitreerd; kop gestuikt, schacht fijngeslepen en genitreerd
Geleidingsboring genitreerd en gehoond
Nitruré blanc; tête refoulé à chaud, corps finement rectifié et nitruré
Alésage de guidage nitruré et honé

Materiaal / *Matière*

Gereedschapsstaal / *acier allié d' outillage*:
volgens / *selon* 1.2343, 1.2344
ontlaatweerstand / *résistance de trempe*: min. 600°C / 1112°F
ca. 1400 N/mm^2

Bestelsleutel / *Exemple de commande*

	d1= 4mm	l1= 125mm	d2= 6mm
D16756BN	040	125	060

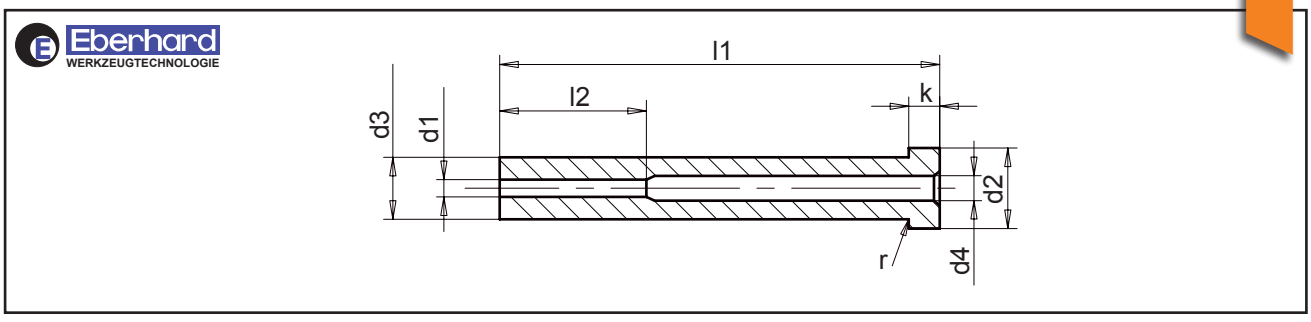
code: D16756BN040125060

d_1 H5	d_3 g 6	d_4	d_2 0 − 0,2	k 0 − 0,05	r + 0,2 0	l_2 + 2 0	l_1 + 1 0 50	60	75	100	125	150	175	200	225	250	275	300	325	400
1,5	3	1,8	6	3	0,3	35	●	●	●	●	●	●	●							
1,6		2						●	●	●	●	●	●							
1,7										●	●									
2	4	2,5	8					●	●	●	●	●	●	●	●					
2,2								●	●	●	●	●	●	●	●					
2,5	5	3	10					●	●	●	●	●	●	●	●					
2,7								●	●	●	●	●	●	●	●					
3		3,5				45		●	●	●	●	●	●	●	●	●				
3,2								●	●	●	●	●	●	●	●	●				
3,5		3,8								●	●	●	●	●						
3,5	6	4	12	5	0,5			●	●	●	●	●	●	●	●	●	●	●	●	
3,7								●	●	●	●	●	●	●	●	●	●	●	●	
4		4,5						●	●	●	●	●	●	●	●	●	●	●	●	
4	8		14															●		
4,2		5						●	●	●	●	●	●	●	●	●	●	●	●	
4,5								●	●	●	●	●	●	●	●	●	●	●	●	
5	7	5,5	12							●										
5	8		14					●	●	●	●	●	●	●	●	●	●	●	●	●
5,2								●	●	●	●	●	●	●	●	●	●	●	●	
5,5		5,8							●	●	●	●	●	●	●	●	●			
6,0	9	6,5													●	●				
6,0	10		16					●	●	●	●	●	●	●	●	●	●	●	●	●
6,2								●	●	●	●	●	●	●	●	●	●	●	●	●
7,0		7,5												●	●	●				
8	12	8,5	20	7	0,8			●	●	●	●	●	●	●	●	●	●	●	●	●
8,2								●	●	●	●	●	●	●	●	●	●	●	●	●
9,0		9,3								●	●	●		●						
10	14	10,5	22						●	●	●	●	●	●	●	●	●	●		
10,5		11							●	●	●	●	●	●	●	●	●	●		
12	16	12,5							●	●	●	●	●	●	●	●	●	●	●	●
12,5		13							●	●	●	●	●	●	●	●	●	●		
16	20	16,5	26		1	50				●	●			●	●	●				

● = Standaard afmetingen / *dimensions standards*

* = Bij totaallengte 400 mm is de l2 100mm lang/
Si l1=400 mm , l2=100mm

Uitwerphulzen / *Douilles pour éjecteur* DIN 16756



Uitvoering / *Exécution*

GEHARD / *TREMPÉ*:
Blank genitreerd; kop gestuikt, schacht fijngeslepen
Nitruré blanc; tête refoulé à chaud, corps finement rectifié
Speciaal voor pers- en spuitgietwerk
Pour presses et moules.

Materiaal / *Matière*

WS:
volgens / *selon* 1.2210, 1.2067 60 ± 2 HRC

Bestelsleutel / *Exemple de commande*

	d1= 4mm	l1= 125mm	d2= 6mm
D16756GEHARD	040	125	060

code: D16756GEHARD040125060

d_1 H5	d_3 g 6	d_4	d_2 0 – 0,2	k 0 – 0,05	r + 0,2 0	l_2 + 2 0	l_1 + 1 0 50	60	75	100	125	150	175	200	225	250	275	300	325	400
1,5	3	1,8	6	3	0,3	35	●	●	●	●	●	●	●							
1,6		2					●	●	●	●	●	●	●	●						
1,6	4	2,5	8									●								
1,8	3	2,1	6							●	●									
1,9		2,2								●	●									
2,0	4	2,5	8				●	●	●	●	●	●	●	●	●	●				
2,2							●	●	●	●	●	●	●	●	●	●				
2,5		2,8								●	●	●	●	●	●					
2,5	5	3	10				●	●	●	●	●	●	●	●	●	●	●			
2,7							●	●	●	●	●	●	●	●	●					
3,0		3,5				45	●	●	●	●	●	●	●	●	●	●	●	●		
3,0	6		12	5	0,5					●	●	●	●	●	●	●	●			
3,2	5		10	3	0,3		●	●	●	●	●	●	●	●	●	●	●	●		
3,5		3,8									●	●	●	●						
3,5	6	4	12	5	0,5		●	●	●	●	●	●	●	●	●	●	●	●		
3,7							●	●	●	●	●	●	●	●	●					
4,0	5,5	4,5	10	3									●	●						
4,0	6		12	5			●	●	●	●	●	●	●	●	●	●	●	●	●	●
4,0	6,2										●									
4,0	8		14						●	●	●									
4,2	6		12												●	●	●	●		
4,2	8		14				●	●	●	●	●	●	●	●	●	●				
4,5	6	4,8	12							●	●	●	●	●	●					
4,5	7	5												●						
4,5	8		14				●	●	●	●	●	●	●	●	●	●				
5,0	7	5,5	12										●	●	●	●				
5,0	8		14				●	●	●	●	●	●	●	●	●	●	●	●	●	●
5,2							●	●	●	●	●	●	●	●	●	●	●	●	●	●
5,5		5,8							●	●	●	●	●	●	●	●	●			
6,0	9	6,5											●		●	●	●	●		
6,0	10		16				●	●	●	●	●	●	●	●	●	●	●	●	●	●
6,2							●	●	●	●	●	●	●	●	●	●				
6,5		7									●									
7,0		7,5							●	●	●			●	●	●				
8,0	11	8,5											●	●	●	●		●		
8,0	12		20	7	0,8			●	●	●	●	●	●	●	●	●				
8,2								●	●	●	●	●	●	●	●	●	●			
8,5		9								●	●			●	●	●				
9,0		9,3								●	●									
10,0	14	10,5	22					●	●	●	●	●	●	●	●	●	●	●	●	●
10,2											●			●	●	●				
10,5		11								●	●	●	●	●	●	●			●	
11,0		11,5								●	●									
12,0	16	12,5						●	●	●	●	●	●	●	●	●	●			
12,5		13							●	●	●	●	●	●	●	●				
16,0	20	16,5	26		1	50				●	●			●						

● = Standaard afmetingen / *dimensions standards*

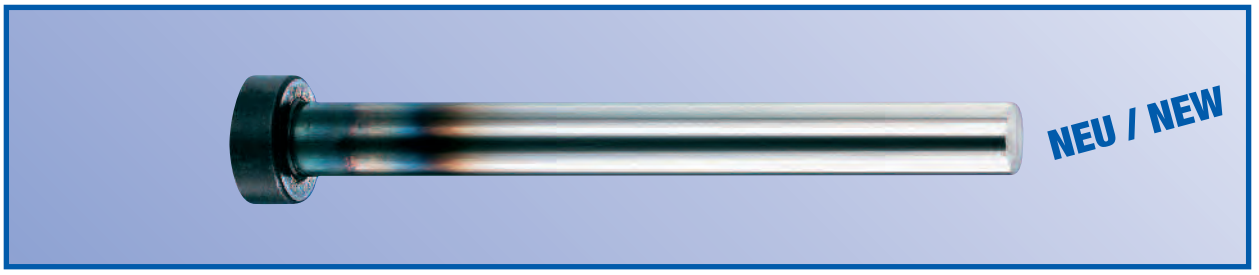
* = Bij totaallengte 400 mm is de l2 100mm lang

Uitwerper met DLC-coating / *Ejecteur avec revêtement DLC*

acc. to DIN ISO 6751 (DIN 1530 standard part 1, type AH, hardened); DLC-coated

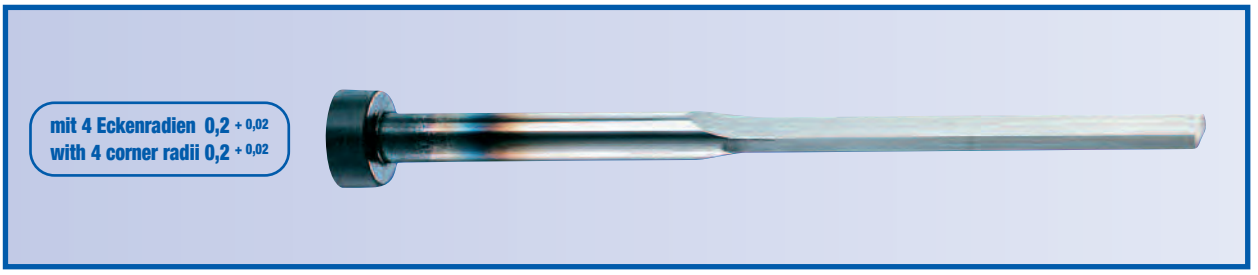
Inox en zuurbestendige uitwerper / *Ejecteur inox et résistant à l'acide*

similar to DIN ISO 6751

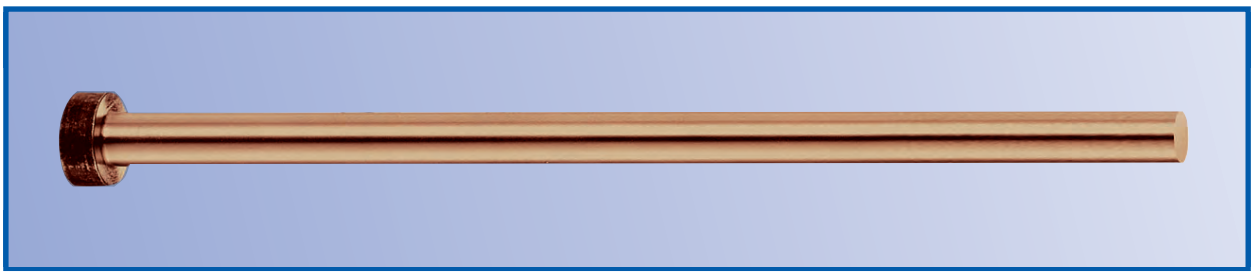


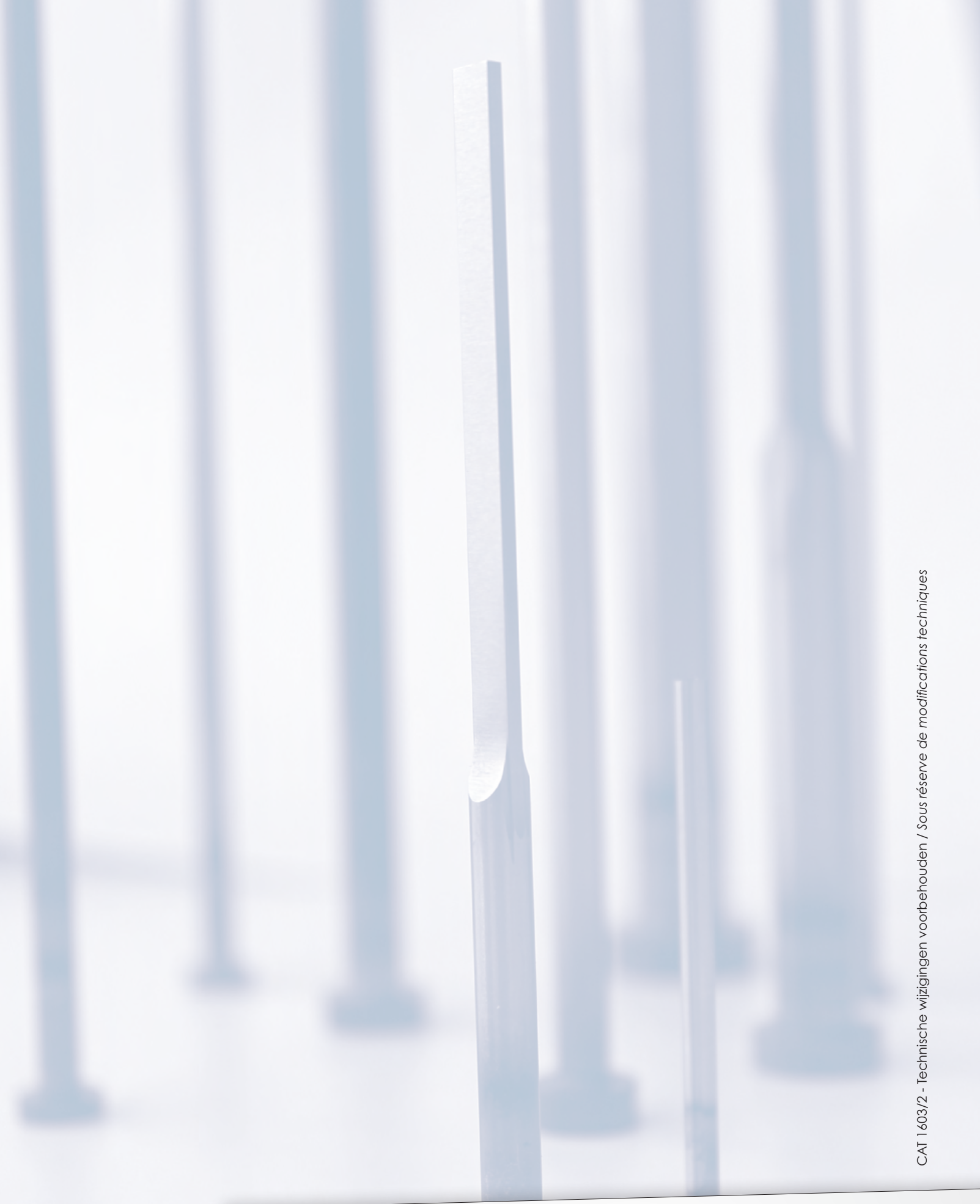
Bladuitwerper met 4 afgeronde hoeken / *Ejecteur lame avec 4 angles arrondis*

rectangular stepped point – blade ejector acc. to DIN ISO 8693 (DIN 1530 part 4, type FAH, hardened)



Uitwerper in koper / *Ejecteur en cuivre*





CAT 1603/2 - Technische wijzigingen voorbehouden / *Sous réserve de modifications techniques*

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