Positive, precise plate control:

*DME* 2-stage Ejectors (TS) adapt to a number of mold base sizes and plate thicknesses. They are available in two ejection sequences: Top Last (TS) and Bottom Last (BS). Each ejection sequence is available in three sizes to accommodate most standard *DME* mold bases. The stroke range for each ejection stage is determined and fixed by the customer by cutting the Center Rod to the desired length (both TSTL and TSBL types) and by also cutting the Travel Sleeve to the desired length (TSBL type only). Once installed, the *DME* 2-stage Ejector assures positive, precise control of the sequence and distance of each stroke of the two ejector plates. Once installed, there are no adjustments that can be accidentally changed.

**Benefits:**
Both the first stage and second stage strokes are set independently. Easy set-up and installation. Fixed strokes cannot be tampered with or accidentally modified. Internal installation avoids interferences with water line connectors and externally mounted components. Utilizes latching mechanism similar to *DME* Internal Latch lock for smooth operation and guidance. Three sizes, for each style, to choose from to accommodate most standard *DME* mold bases. Hardened steel components for long life. *DME* 2-stage Ejectors are considerably more compact and may be centrally located, the preferred method for locating *DME* 2-stage Ejectors is in pairs, offset from mold center. For more details, assembly guidelines see www.dme.net.

**Selection and design guidelines:**
Select 20 mm Ø (small), 26 mm Ø (medium), or 23 mm Ø (large) 2-Stage Ejector based on the width of the mold base (large molds, thick plates or heavy load applications may require the next size assembly). Determine the travel range for each ejection stroke (first and second), being very careful not to exceed the maximum stroke specified for the chosen 2-Stage Ejector style and size. This selection is based on the specific application. In general, a minimum of two 2-stage Ejectors are required. For larger molds, thick plates, or a application where loads are near maximum, additional assemblies and/or larger assemblies may be required. An application must never exceed the maximum recommended load values. A balanced load must be maintained to avoid cocking and binding which could cause severe overloading. Only one size of 2-stage Ejectors should be used in each mold base.

**Assembly & installation guidelines**
The moldmaker is responsible to cut and/or grind the Center Rod to the required length prior to installation of the 2-Stage Ejector assembly into the mold base. Do not cut off more than the minimum stroke (H2). The recommended tolerance on the Center Rod length after the customer has cut the Center Rod is +0/-0,02 mm or less. Stroke 1 (H1) is reduced by cutting and/or grinding the moving plates end of both the Center Rod. Stroke 2 (H2) is reduced by cutting and/or grinding the stationary platen end of the Center Rod. Minimum H2 specified in chart does not include additional stop pins to stationary-side spacer plate. To reduce H2 even further than what is specified in chart, add stop pins. 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 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.
The top (stationary platen side) ejector plate assembly continues to move through the “second” or remaining stroke until the top ejector plate assembly contacts the top of the ejector box housing.

After a predetermined amount of travel, the latch mechanism latches onto the Center Rod, thereby fixing the position of the bottom (moving platen side) ejector plate assembly.

The top (stationary platen side) ejector plate assembly continues to move through the “second” or remaining stroke until the top ejector plate assembly contacts the top of the ejector box housing.
Centre Rod for TSTL

**TSTL-CR**

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**Travel Sleeve for TSTL**

**TSTL-TS**

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**REF** | **D1** | **D2** | **D17** | **L1*** | **L2** | **L3** | **L22**** | **C1** | **R1**
---|---|---|---|---|---|---|---|---|---
**TSTL 20 CR** | 33 | 26.0 | 0.01 | 5 | 265 | 10 | 16,74 | 72 +0,5 | 1,5 | 0,4
**TSTL 26 CR** | 42 | 26.0 | 0.01 | 6 | 290 | 12 | 22,93 | 76 +0,5 | 2 | 0,8
**TSTL 32 CR** | 53 | 32.0 | 0.01 | 6 | 320 | 15 | 28,25 | 82 +0,5 | 2,5 | 0,8

* Cutoff on both ends of center pin only per installation data.

** Final length must have tolerance of 0/-0,2mm after moldmaker has cut the center pin to the desired length.

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**REF** | **D8** | **D9** | **D20** | **L10** | **L25** | **L26** | **C4**
---|---|---|---|---|---|---|---
**TSTL 20 TS** | 43 | 34 | 50,8 | 79,96 | 12,70 | 6,00 | 0,5
**TSTL 26 TS** | 54 | 43 | 63,0 | 85,82 | 12,70 | 8,00 | 0,5
**TSTL 32 TS** | 68 | 54 | 78,0 | 93,68 | 15,80 | 10,00 | 0,5

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www.m-d-s.co.za
**Body for Cam Fingers for TSTL**

**TSTL-BD**

**Cam Finger Replacement Kit for TSTL**

**TSTL-KT**

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**Table:**

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