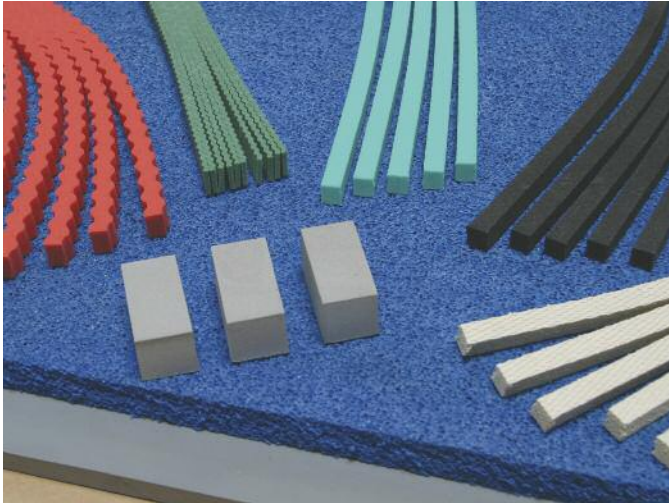


Ejection Material Basics

Guidelines for selecting the correct ejectors.



Selecting the correct ejection material/rubber is fundamental in constructing effective steel rule dies. Whether platen or rotary - ejectors have to perform - providing a mix of reliability, durability and value. Select the wrong ejection, and resulting production delays and quality issues can cause major problems.

Wagner carries a complete line of ejection materials from the industry's leading sources. We can supply ejectors from DianSuply, Kodiak Rubber, Monroe - names that are synonymous with quality, performance and value. We even carry specialized rotary ejectors from National.

Below are some facts to consider when selecting ejection materials:

Platen Dies:

Open Cell Materials:

Platen dies require ejectors to compress and rebound. Heat due to high press speeds can be a factor, but not in the extreme range that can typically lead to ejector blow-out or failure.

Open Cell - Product Areas

DianSuply: F-70, B-65, K-60, 6320
Kodiak: KO-11, KO-10, KO-2B, KO-3, KO-4
Monroe: 6500, 2700, 15700

Open Cell - Waste Areas

DianSuply: F-70, B-65, 61X, T-75
Kodiak: KO-1, KO-18, KO-2G
Monroe: 3500

Closed/Micro Cell - Product Areas

DianSuply: RD-73, G-257
Kodiak: Red Grizz, KO-15
Monroe: MR-75, Red Rhino, MR50, MR24, MR1100

Closed/Micro Cell - Waste Areas

DianSuply: GN-88, R-82
Kodiak: Green Grizz, KO-20T
Monroe: Green G'rilla, MR40, BK85

Slots and Small Scrap Areas

DianSuply: Dura-Bull - Kodiak: KO-20T - Monroe: SuperStrip
National: Dura Strip

Rotary Dies:

Rotary dies subject ejectors to a wide range of forces, not only compression and rebound, but centrifugal forces and resulting heat from high rotation speeds and die to anvil contact.

Open Cell - Not recommended.

Closed & Micro Cell - Product Areas

DianSuply: G-257, SK-55
Kodiak: KO-15
Monroe: 12000, 22000, 10000 Series

Closed & Micro Cell - Waste Areas & Slots

DianSuply: G-257, Dura-Bull
Kodiak: KO-15, KO-20T
Monroe: 10000, 22000 Series, MR40, SuperStrip
National: Dura Strip, Dura Strip Scalloped
Wagner: Vulcan Scalloped

Options:

Top-Coated ejectors for rotary applications are also available. Contact us for more information.



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