

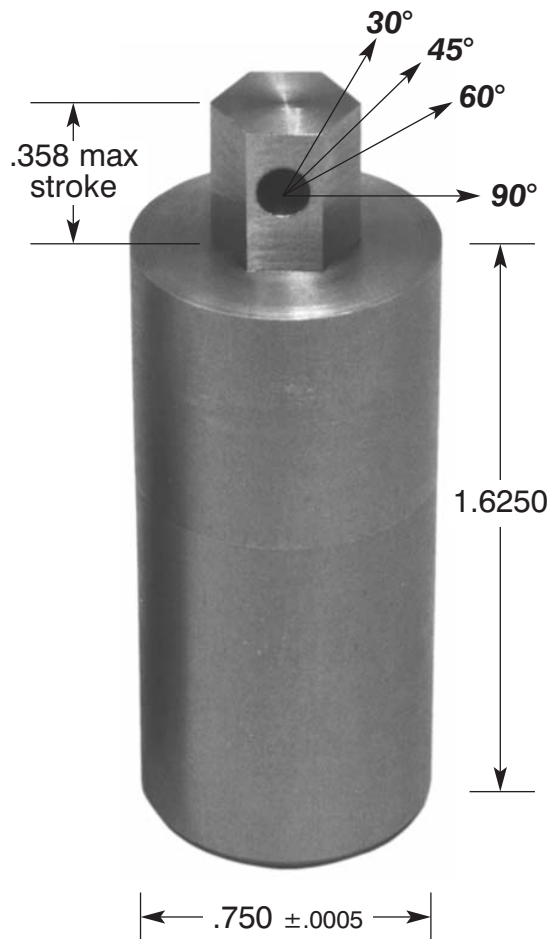


FIXED ANGLE AIR EJECTORS

Model MAJ3

Item #106541 / Item #106540 / Item #106538 / Item #106536

INSTRUCTION MANUAL



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IMS Company
10373 Stafford Road
Chagrin Falls, OH 44023-5296

Telephone: (440) 543-1615
Fax: (440) 543-1069
Email: sales@imscompany.com
Website: www.imscompany.com

INSTALLING FIXED ANGLE AIR EJECTOR

AIR SUPPLY

1. 3/8" Air Line
2. Clean, dry, oiled. Use silicone oil if compatible with oiler.
3. 30 to 150 psi

DIAMETER OF HOLE IN MOLD

1. Measure ejector O.D. near closed end. Nominal size is .750".
2. Drill and ream mold .0005" to .001" smaller than ejector.
3. This will give press-fit tight enough to hold ejector and keep it from turning without loading bore. Piston could bind in loaded bore.

DEPTH OF HOLE

1. Ejector body is 1.625" long.
2. Allow ejector to stick up above mold surface just enough that you can finish ejector to match mold surface. No more than .060" can be taken off.
3. If drilling blind hole, be sure to ream to full depth.

INSTALLATION

1. Make sure air passage is pointing in correct direction.
2. Use arbor press or soft brass tools to install ejector in mold.

