

## TEVAC EJECTOR SLEEVES

**For correct product, order by Part Number, followed by "L" length. Example: ES-4-L7**

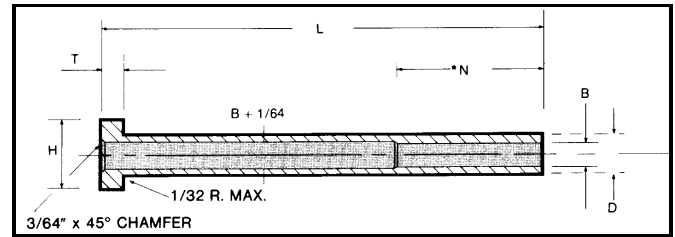
Tevac's Ejector Sleeves have forged heads for maximum strength and are supplied heat treated, ground, nitrided and polished to a surface hardness of 65-75 Rc to reduce friction and wear. The bore or bearing diameter is finish reamed, nitrided and honed concentric with the O.D. of the sleeve. The hardened bore prevents scoring and permits closer fitting of the pin to reduce the possibility of flashing.



Part Number	B I.D.	D O.D.	H Head	T Head
ES-1-	3/32	3/16	3/8	3/16
ES-2-	1/8	7/32	13/32	3/16
ES-3-	5/32	1/4	7/16	3/16
ES-4-	3/16	5/16	1/2	1/4
ES-5-	7/32	11/32	9/16	1/4
ES-6-	1/4	3/8	5/8	1/4
ES-7-	5/16	7/16	11/16	1/4
ES-8-	3/8	1/2	3/4	1/4
ES-9-	7/16	5/8	7/8	1/4
ES-10-	1/2	11/16	15/16	1/4
ES-11-	9/16	3/4	1	1/4
ES-12-	5/8	7/8	1 1/8	1/4
ES-13-	3/4	1	1-1/4	1/4

### Lengths

L = 3"  
L = 4"  
L = 5"  
L = 6"  
L = 7"  
L = 8"  
L = 9"  
L = 10"  
L = 11"  
L = 12"



\* (N) - 1-3/4 for ES-1 and ES-2  
\* (N) - 2-1/4 for ES-3 and Larger

### TOLERANCES

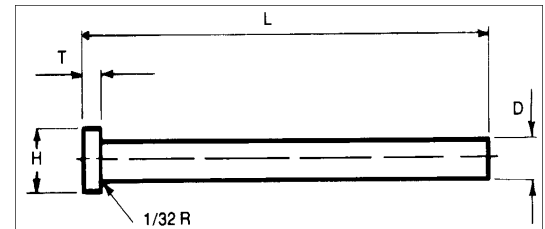
PIN DIAMETER (D)	+0.000 -0.001
HEAD DIAMETER (H)	+0.000 -0.010
HEAD THICKNESS (T)	+0.000 -0.002
LENGTH (L)	+0.031 -0.000
SLEEVE I.D. (B)	+0.0003 -0.0000

**Custom Sizes Available !**

**For correct product, order by Part No. followed by "L" length. Example: CP-1-L3**

Tevac's Standard Core Pins are made from chromium Die steel and are available in two hardness ranges. They are finish ground to standard sizes with a tolerance of plus .001minus .000 but may be relieved or reground. The heads are solid forged and annealed to permit easier machining and stamping, heads are marked (H or S) for easier identification. Surface finish is maintained to the same high standards as Tevac's Ejector Pins and Sleeves. Tevac's Core pin Reamers .001 oversize for correct sizing of holes are available for all sizes.

## TEVAC STANDARD CORE PINS HARDENED AND PRECISION GROUND



L = 3"  
L = 6"  
L = 10"

### STANDARD HARDNESS

CP pins 30 - 35 Rc

**HIGH HARDNESS**  
CPH pins 50 - 55 Rc

### RECOMMENDED HEAT TREATMENT

CP Pins may be heat treated to raise the hardness, by oil or water quenching the end only, from a "Bright Red" temperature of 880°/920° C. (Preferably from a cyanide bath to control temperature and minimize scaling).

Temper to Straw Colour  
160°/200° C.

STANDARD HARDNESS			
Part Number	D PIN DIA.	H HEAD DIA.	T HEAD THICK
CP-1-	3/32	1/4	1/8
CP-2-	7/64	1/4	1/8
CP-3-	1/8	1/4	1/8
CP-4-	9/64	1/4	1/8
CP-5-	5/32	9/32	5/32
CP-6-	11/64	11/32	3/16
CP-7-	3/16	3/8	3/16
CP-8-	13/64	3/8	3/16
CP-9-	7/32	13/32	13/16
CP-10-	1/4	7/16	3/16
CP-11-	9/32	7/16	1/4
CP-12-	5/16	1/2	1/4
CP-13-	11/32	9/16	1/4
CP-14-	3/8	5/8	1/4
CP-15-	13/32	11/16	1/4
CP-16-	7/16	11/16	1/4
CP-17-	15/32	3/4	1/4
CP-18-	1/2	3/4	1/4
CP-19-	9/16	13/16	1/4
CP-20-	5/8	7/8	1/4
CP-21-	3/4	1"	1/4

HIGH HARDNESS			
Part Number	D PIN DIA.	H HEAD DIA.	T HEAD THICK
CPH-1-	3/32	1/4	1/8
CPH-2-	7/64	1/4	1/8
CPH-3-	1/8	1/4	1/8
CPH-4-	9/64	1/4	1/8
CPH-5-	5/32	9/32	5/32
CPH-6-	11/64	11/32	3/16
CPH-7-	3/16	3/8	3/16
CPH-8-	13/64	3/8	3/16
CPH-9-	7/32	13/32	13/16
CPH-10-	1/4	7/16	3/16
CPH-11-	9/32	7/16	1/4
CPH-12-	5/16	1/2	1/4
CPH-13-	11/32	9/16	1/4
CPH-14-	3/8	5/8	1/4
CPH-15-	13/32	11/16	1/4
CPH-16-	7/16	11/16	1/4
CPH-17-	15/32	3/4	1/4
CPH-18-	1/2	3/4	1/4
CPH-19-	9/16	13/16	1/4
CPH-20-	5/8	7/8	1/4
CPH-21-	3/4	1"	1/4

### TOLERANCES

PIN DIAMETER (D)	+0.001 -0.000
HEAD DIAMETER (H)	+0.000 -0.010
HEAD THICKNESS (T)	+0.000 -0.002
LENGTH (L)	+0.030 -0.000