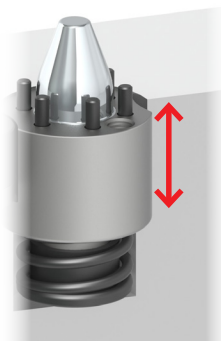


# Usage Guidelines & Recommendations

## Choose the Best Ejection Style based on the Application

### Style: Ejector Pins

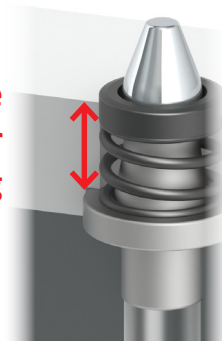
The Ejector Pin style should be the preferred option whenever possible. It is more robust because the Pilot body is fully supported in the Pad/Window.



Fully Supported Body

### Style: Round Stripper

The Round Stripper Style Pilot Assembly is for use with Thin / Soft Stock only. The Round Stripper style will provide a better stripping condition by providing more contact surface between the stripper and the stock.



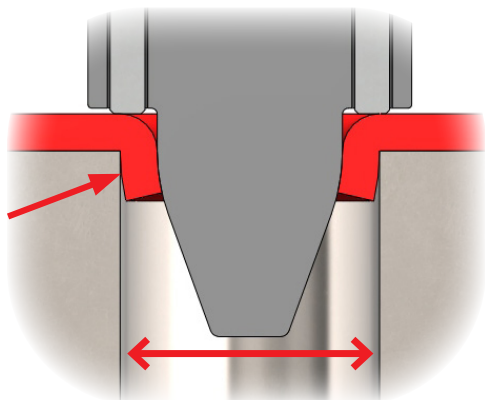
Clearance for Stripper and Spring

Due to its Body not being supported adjacent to the Pilot "Tip", it is less robust than the fully supported Ejector Pin Style Pilot Assembly.

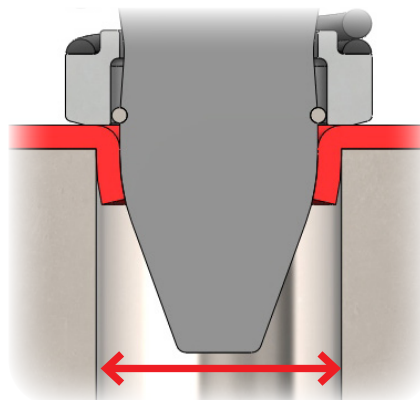
## A properly sized "Receiving Hole" is Important

Clearance minimizes the forces subjected on the Pilot and tooling during a miss-hit situation. The hole below the pilot allows the material to extrude, rather than creating a "pinch trim" situation. See Receiving Hole Guidelines for detailed information on proper sizing.

### Style: Ejector Pins

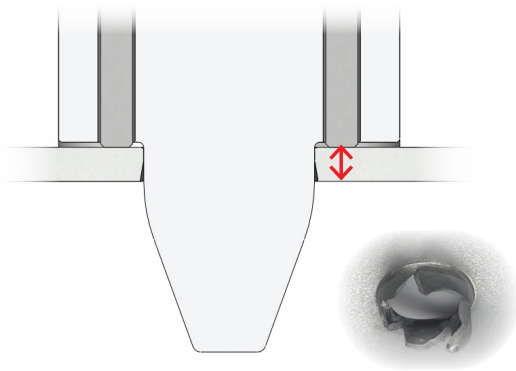


### Style: Round Stripper



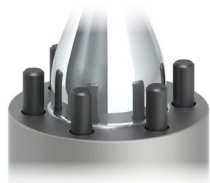
# Usage Guidelines & Recommendations

## Choose a proper Pilot Diameter based on the Stock Thickness

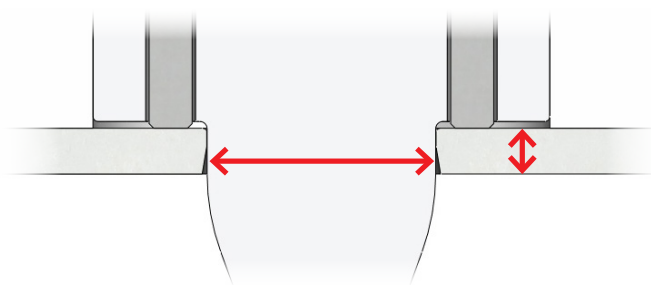


Stock Thickness in relationship to the Pilot Diameter is important for (2) main reasons.

1. To provide enough locating surface area, based on land length and diameter, between the pilot and the stock to effectively locate the stock.
2. To provide a robust assembly that reduces the potential of the Pilot assembly being damaged during "common" mis-hits / mis-feeds where the pilot is required to pierce and/or form the stock.



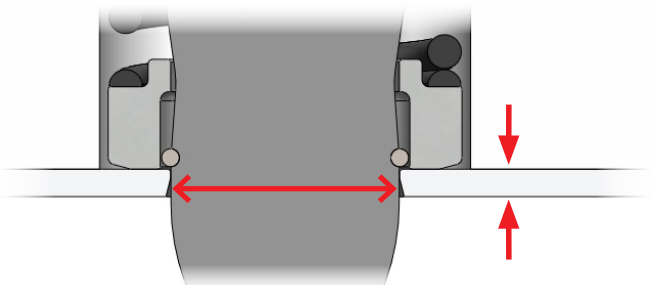
### Max Stock Thickness - Ejector Pin Style



Pilot Dia.	Max Stock Thickness	Pilot Dia.	Max Stock Thickness
.3125"	.050"	8mm	1.27mm
.375"	.075"	10mm	1.9mm
.500"	.100"	13mm	2.5mm
.625"	.125"	16mm	3.2mm
.750"	.150"	20mm	3.8mm



### Max Stock Thickness - Round Stripper Style



Pilot Dia.	Max Stock Thickness	Pilot Dia.	Max Stock Thickness
.375"	.040"	10mm	1.0mm
.500"	.060"	13mm	1.5mm
.625"	.080"	16mm	2.0mm

