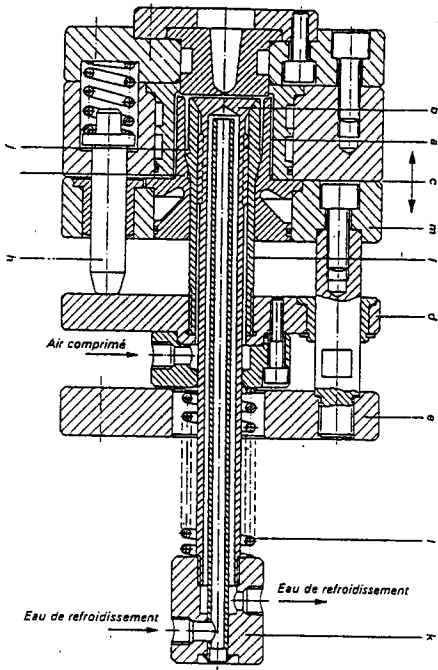
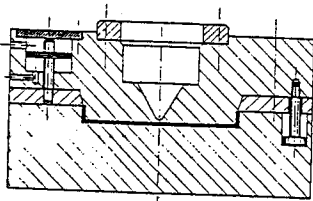
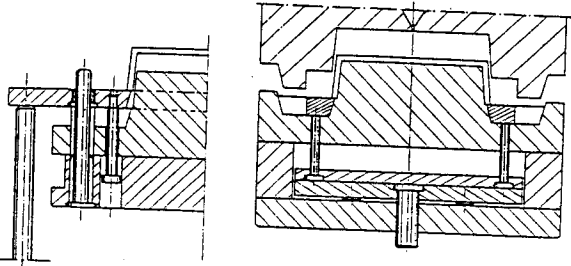


Ejection en deux temps pour démoulage d'un bouchon avec contre-dépouille intérieure



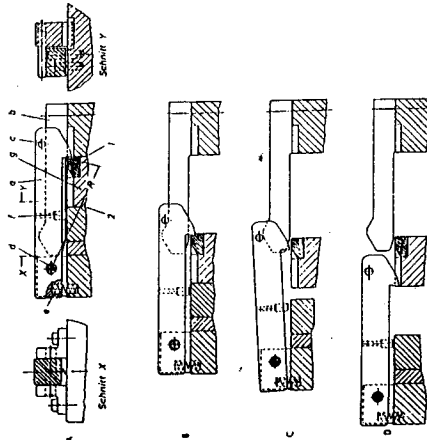
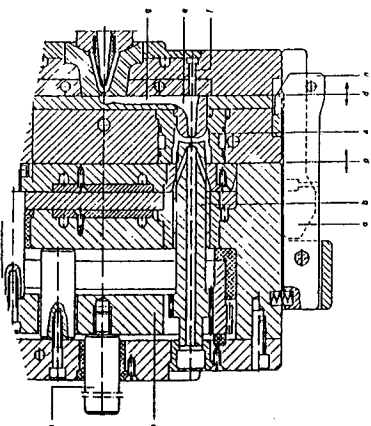
- a Bouchon avec contre-dépouille
- b Soupape d'éjection (avec arrivée d'air)
- c Plan de joint
- d Plaque d'éjection
- e Semelle
- f Noyau intérieur
- g Noyau extérieur
- h Broche de rappel
- i Crantage
- k Tête de raccordement
- l Ressort de rappel d'éjection
- m Plaque porte-poinçon

Commande de la dévêtisseuse

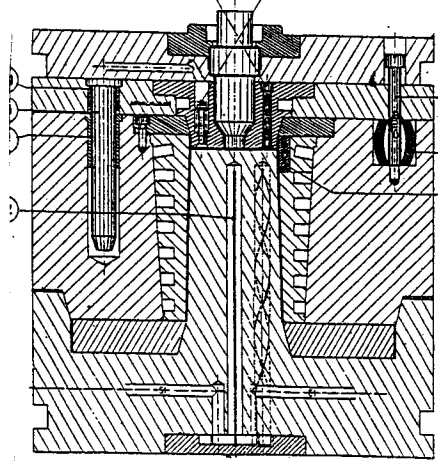


Ejection inversée (colé fixe)

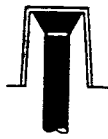
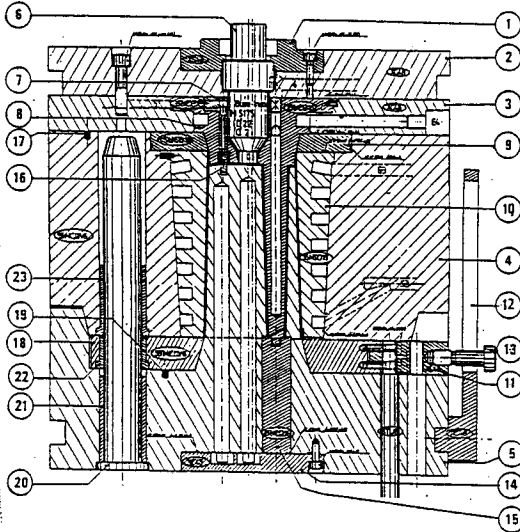
FONCTION EJECTION
Système de retenue de plaque



EJECTION PAR DEVETISSAGE

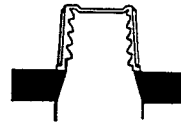


EJECTION PAR DEVETISSAGE



Ejection par soupape

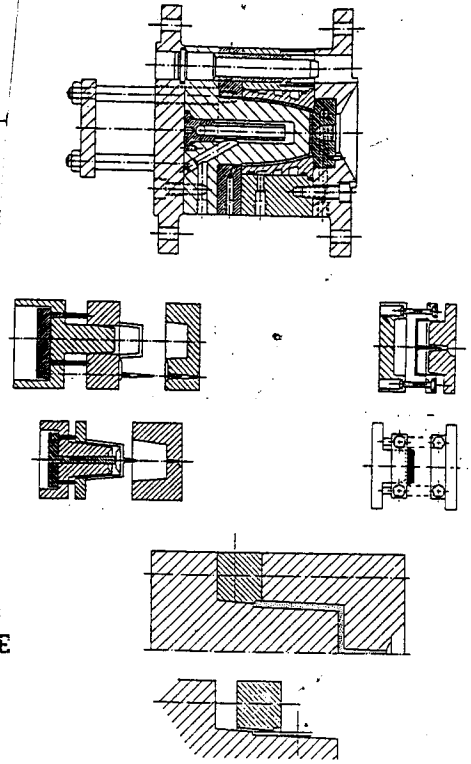
a



Ejection par dévêtisseuse

b

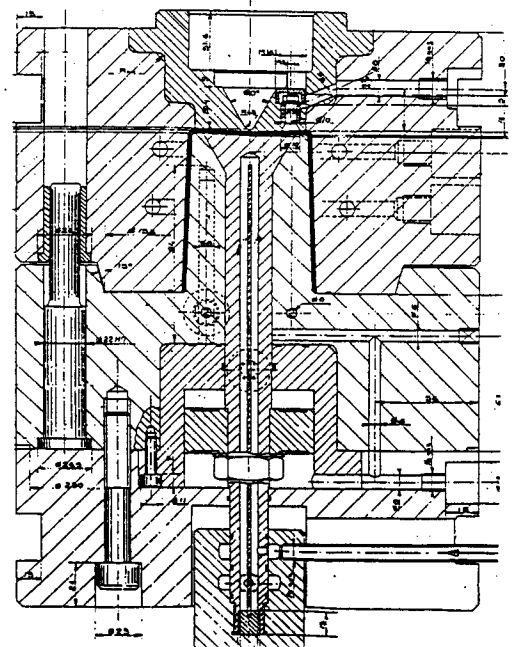
Ejection par dévêtissage

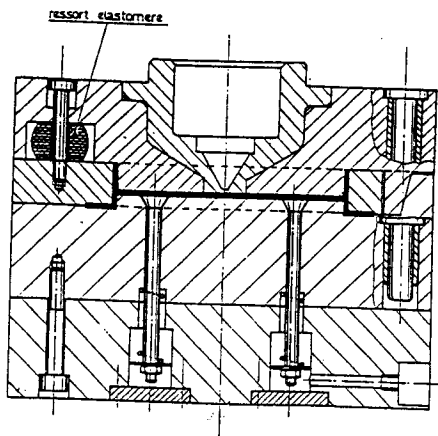


Eject
P. la

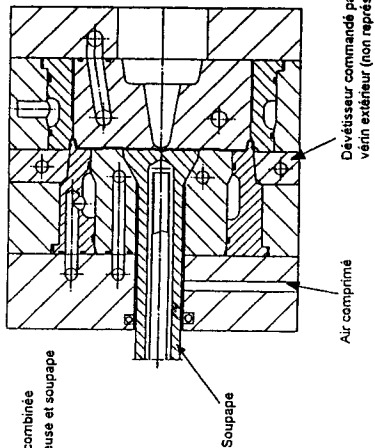
EJ-F1

P. CAS





Dès l'ouverture, les ressorts poussent la bague. La pièce se retrouve coté mobile du elle sera éjectée par les soupapes pneumatiques.



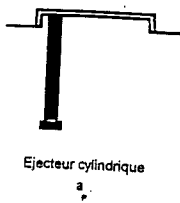
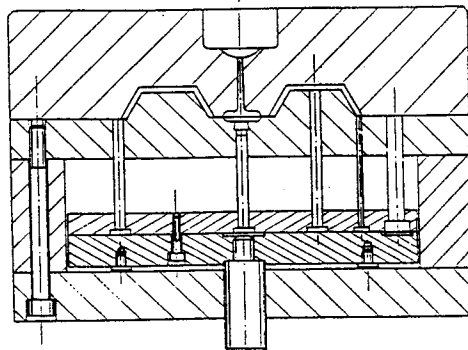
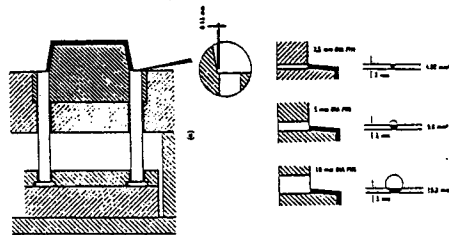
Ejection combinée dévêtisseuse et soupape

Soupage

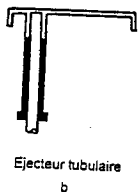
Air comprimé

Dévêtisseur commandé par vain extérieur (non représenté)

Les éjecteurs

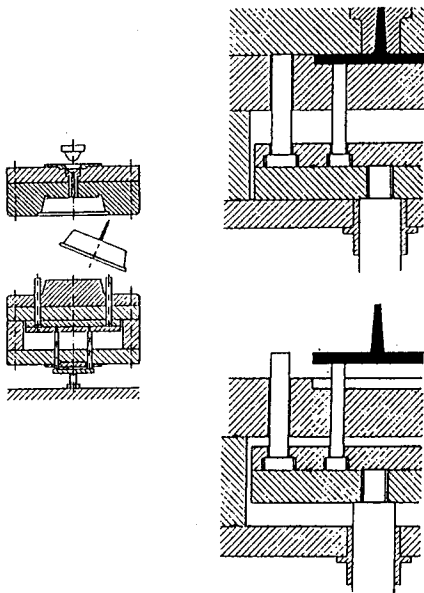


Ejecteur cylindrique a

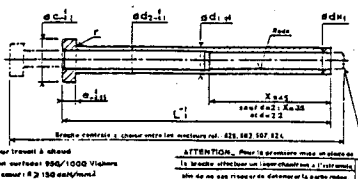


Ejecteur tubulaire b

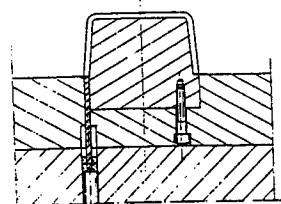
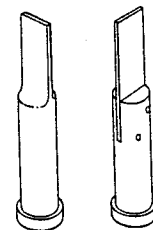
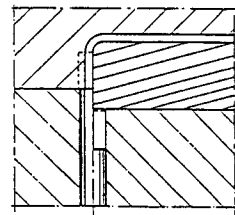
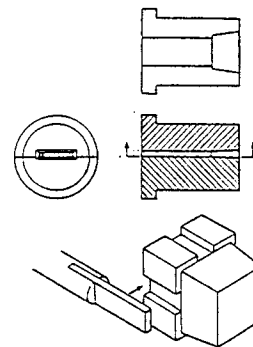
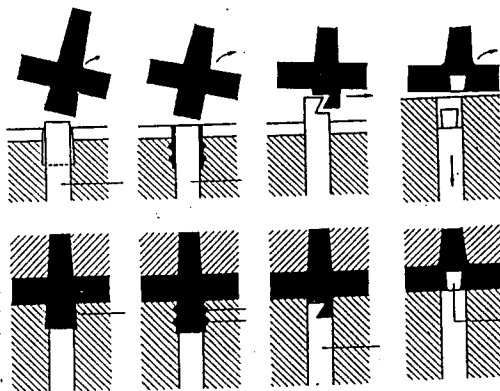
Les éjecteurs



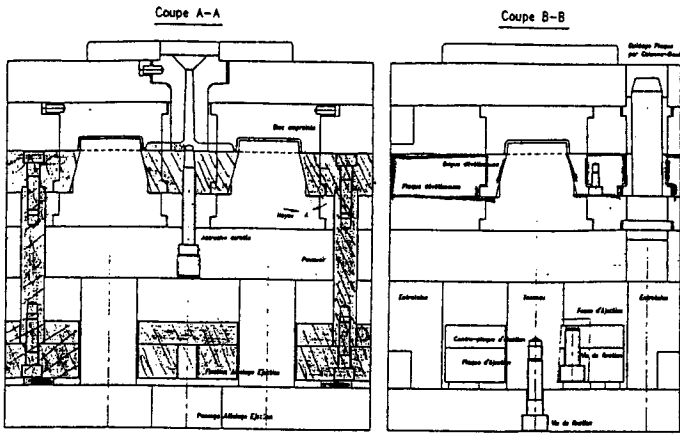
Ejecteurs tubulaires



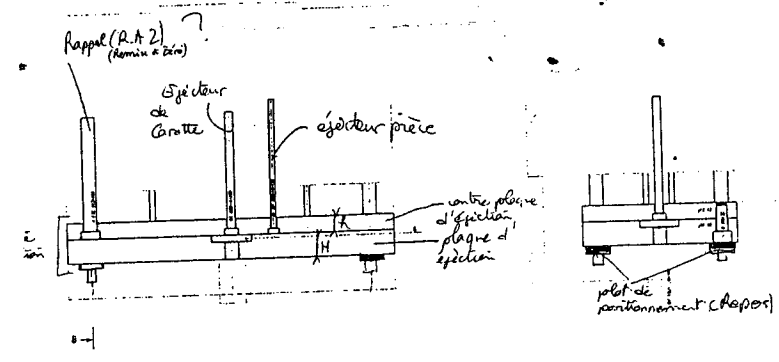
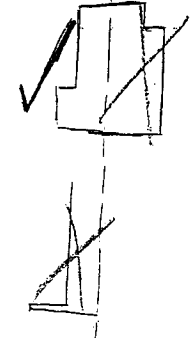
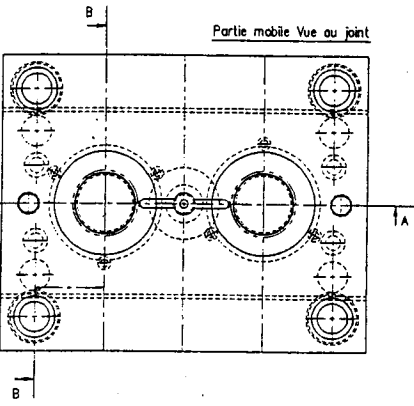
FONCTION EJECTION Arrache carotte



EJ-FL
P-CAS

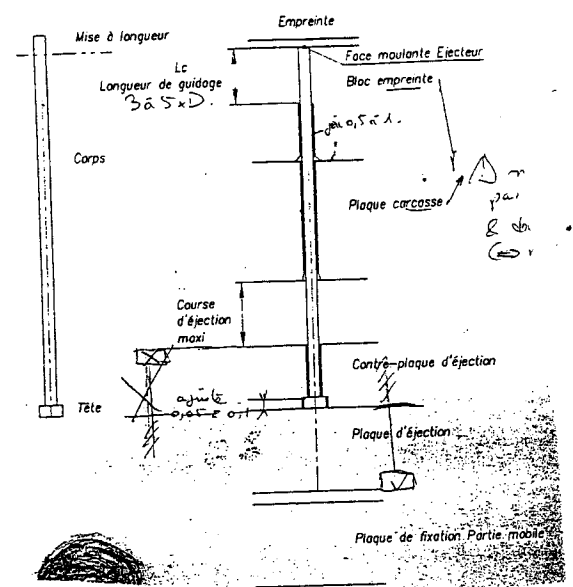
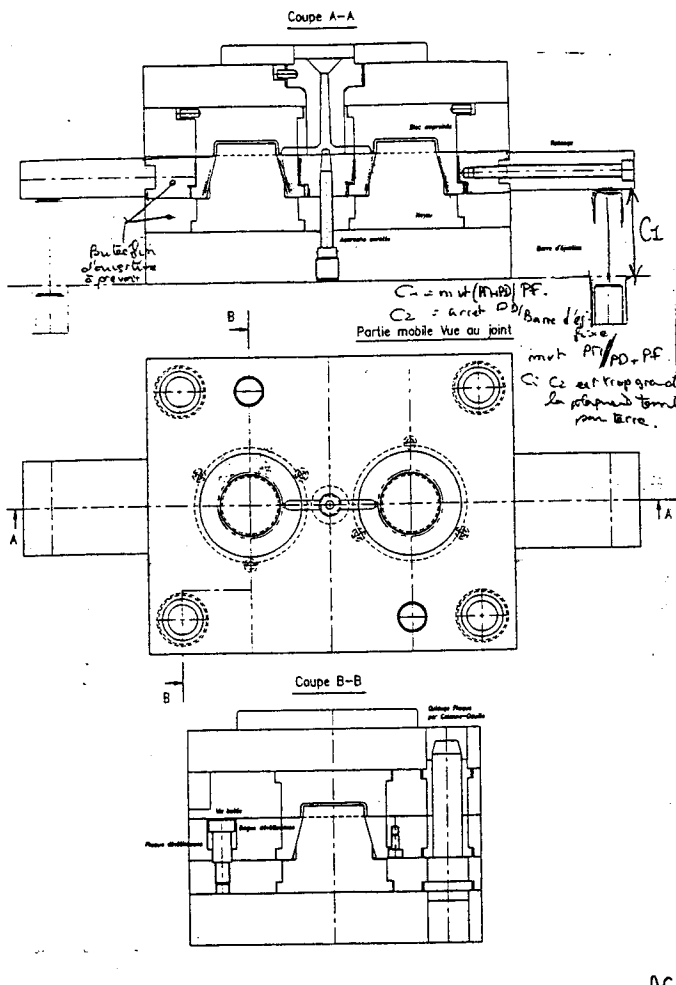


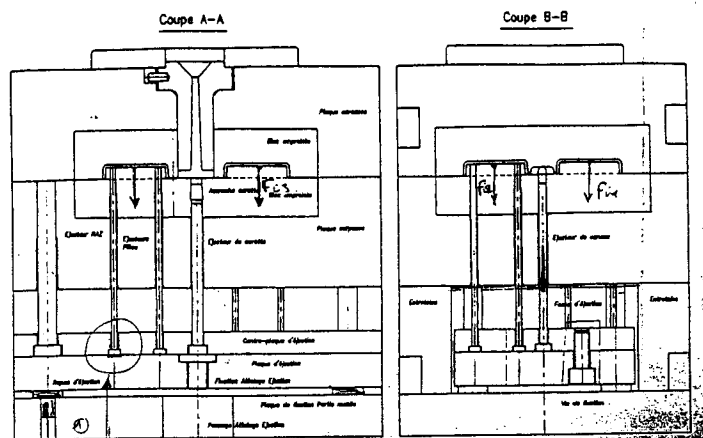
$\sigma_{caillennant} \approx 75\% \times \sigma_{traction}$



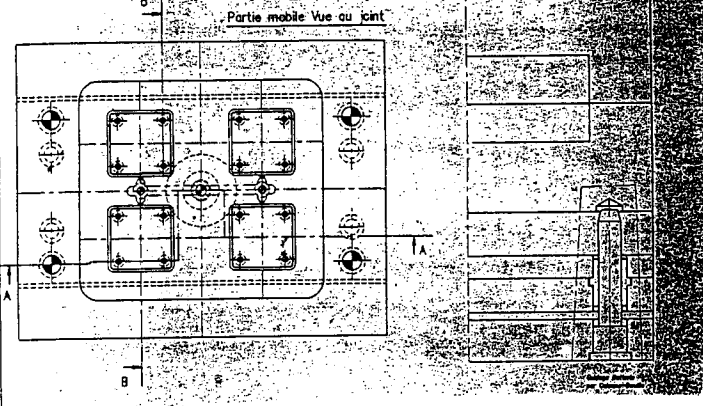
EJF3
LAC

Éjection
LAC

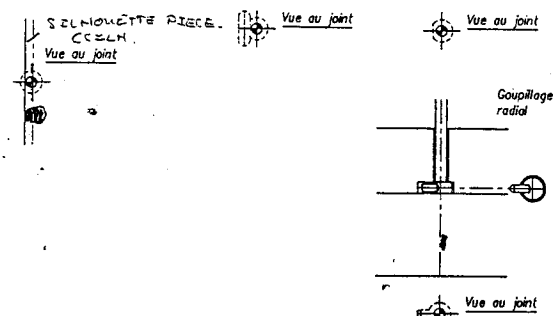
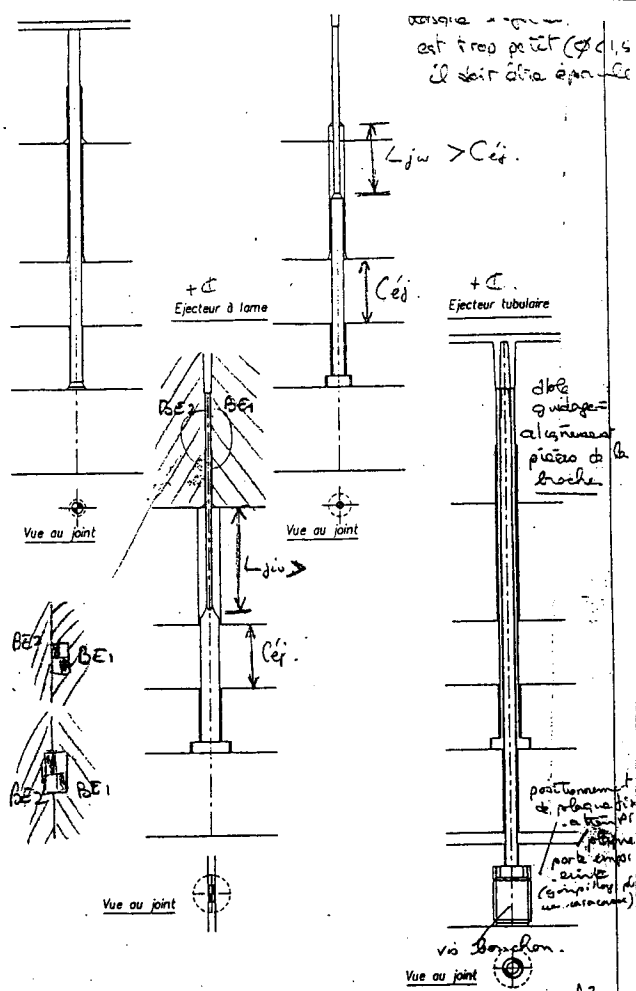
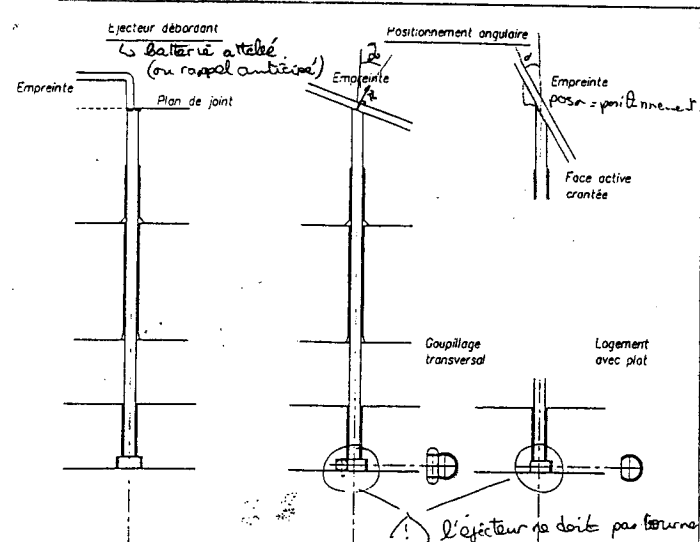


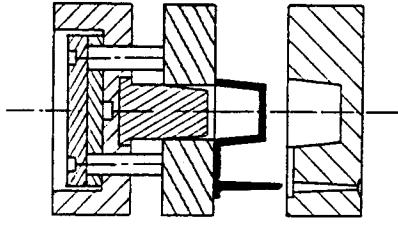
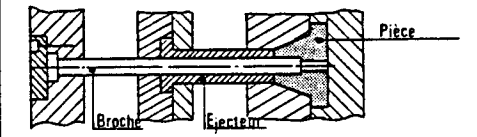
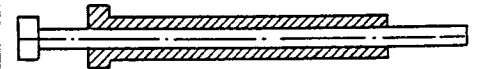
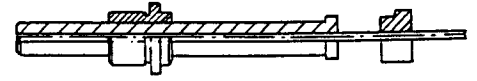
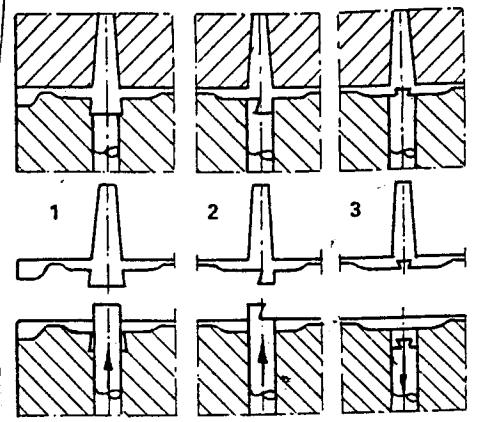
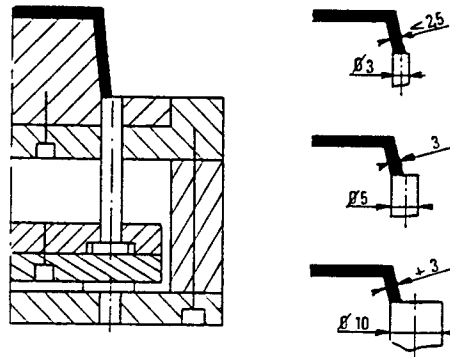
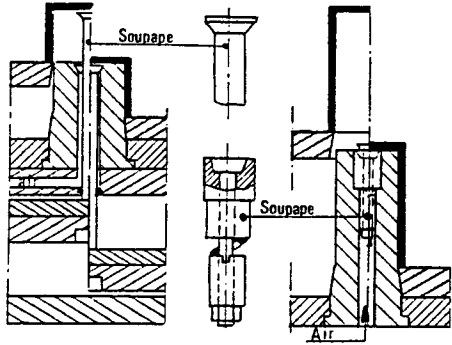
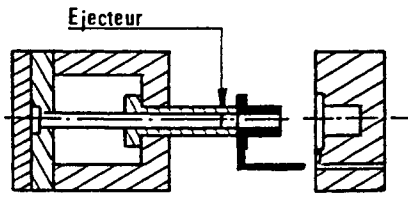
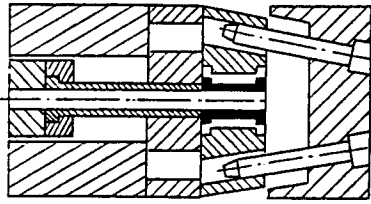
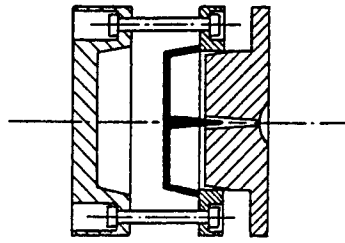
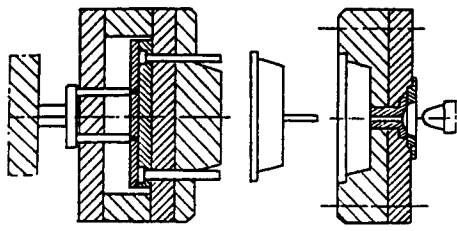


Le système permiéflex est un système plus sûr du point de vue de la sécurité car la ϕ peut se régler.



EJFK ZAC

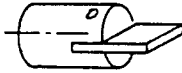




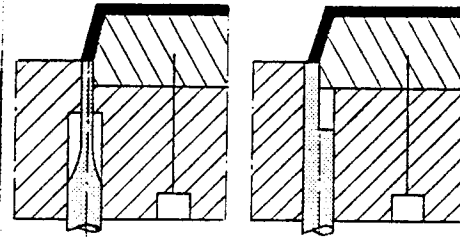
• **Lame usinée dans la masse**



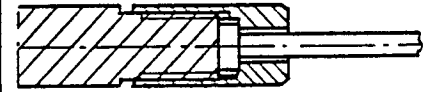
• **Lame rapportée**



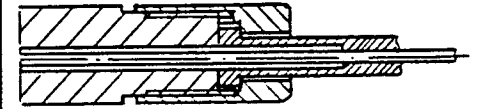
• **Mise en œuvre**



• **Montage pour éjecteur simple**



• **Montage pour éjecteur tubulaire**



EJFS MEMOTECH

Soupape à air comprimé régulé

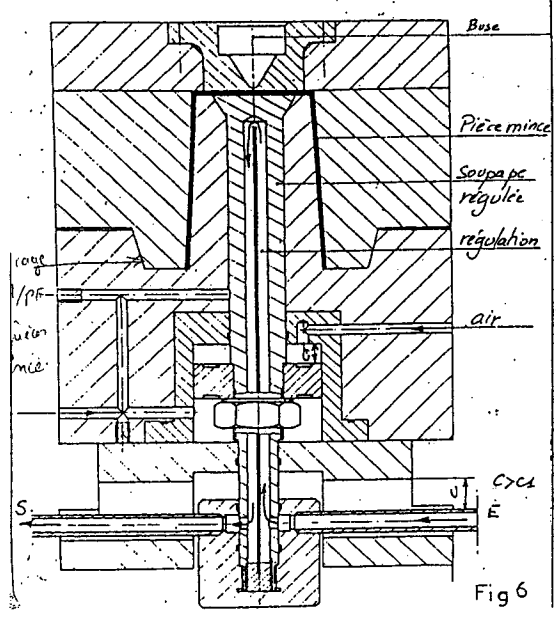


Fig 6

Fonctionnement: Dès l'ouverture au plan de joint (PJ) les ressorts élastomère poussent la plaque. La pièce est extraite de sur la PF, et se retrouve sur PH où elle sera éjectée par les soupapes pneumatiques.

Soupape commandée par air. Rappel par ressort

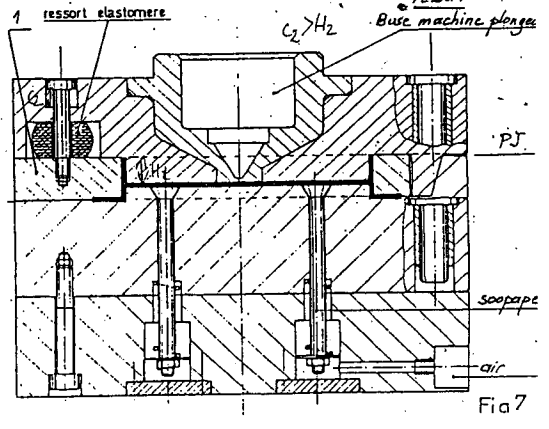
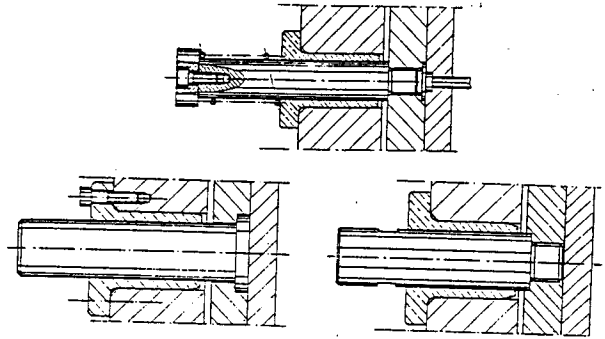


Fig 7

Queue d'éjection



FONCTION EJECTION PAR DEVÉTISSEGE

Principe

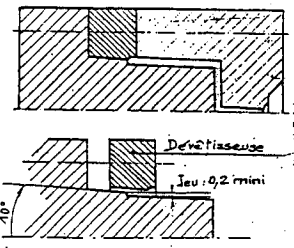


Fig 8

Utilisation: pièces minces

DOC 5/5

sur Plan de joint de géométrie simple

Conception:

- guidage de la plaque: capotés de PH.

- Dévêtisseuse rapportée sur la plaque

- Approche sur pentes

$\alpha = 10^\circ$ mini

Fig 9 multicompos

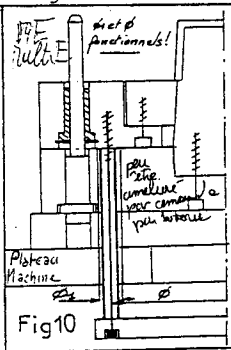
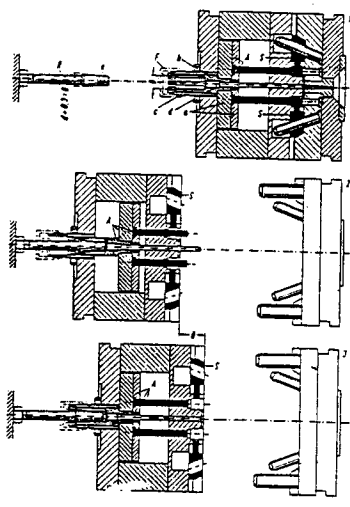


Fig 10

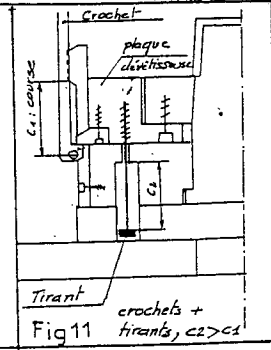


Fig 11

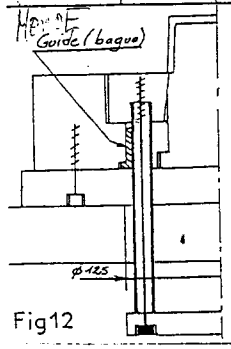


Fig 12

COMMANDES COMMANDES

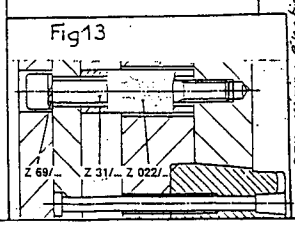


Fig 13

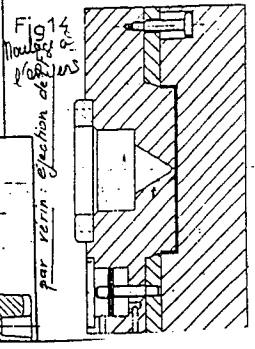
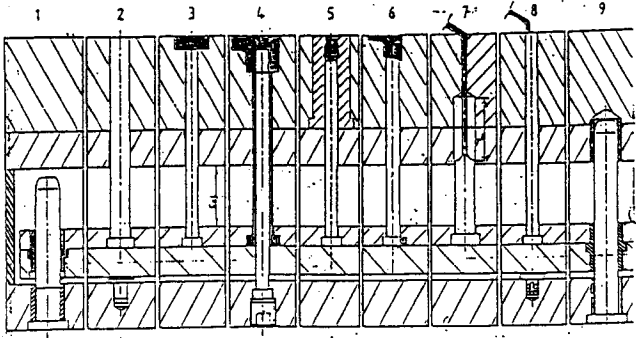


Fig 14

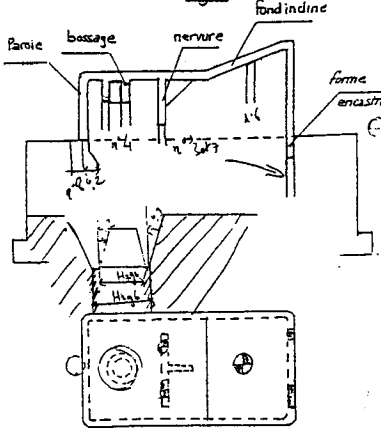
EJ F6 MARNANDE



Symboles \odot \ominus \oplus \ominus \oplus \ominus \oplus \ominus \oplus \ominus

Fig 5

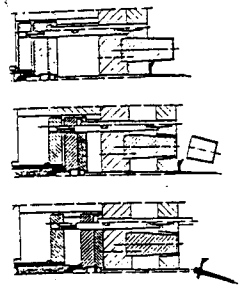
NOMS	RP Fig.
Ejecteur de forme	6
Ejecteur débordant	8
Colonne de guidage	1
Rappel de batterie	2
Ejecteur cylindrique	3
Ejecteur plat	7
Attache carotte	5
Ejecteur tubulaire	4
Colonne de guidage recentree	9



- Mettre sur les deux vue le ou les types d'éjecteurs correspondants à la situation

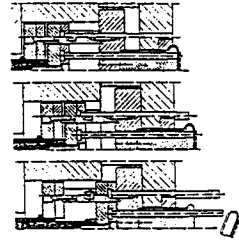
EJECTEUR BI-ETAGE

Exemples d'application

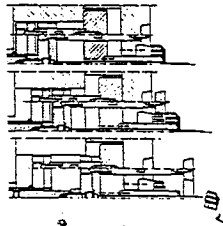


COURSE 1: déviter la pièce du noyau
COURSE 2: éjecter la carotte de la plaque dévêssuse

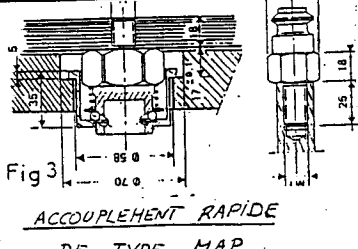
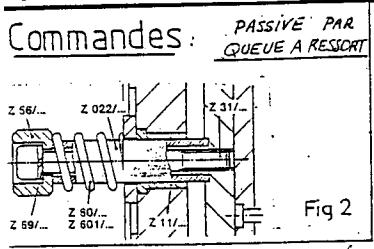
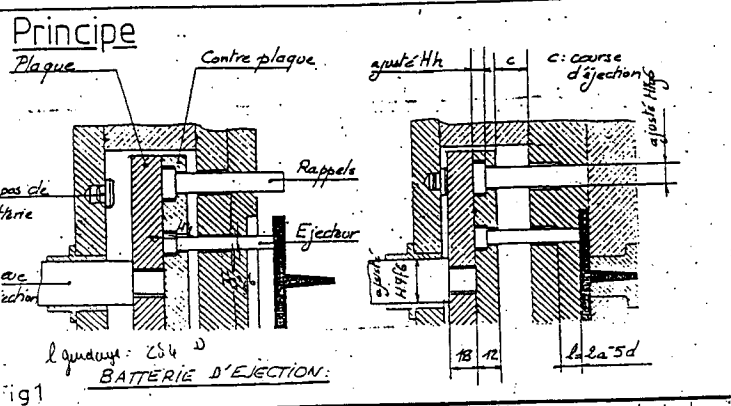
COURSE 1: faire avancer le noyau pour libérer le contour extérieur
COURSE 2: déviter la pièce du noyau



COURSE 1: déviter la pièce du noyau pour que l'intérieur puisse s'élargir
COURSE 2: déviter la pièce du noyau intérieur et éjecter la carotte



EJF7 MARRANDIE



Si on rajoute colonne de guidage, les rappels montés qui servent à ne pas laisser le sol qui se relève (si rajoute colonne de guidage pour l'attache l'autre au 1/2 course)

Systeme actif car commande par vérin d'éjection

