
Tools for moulding — Support pillars

Outillage de moulage — Piliers d'entretoisement



Reference number
ISO 10073:2008(E)

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Published in Switzerland

Foreword

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The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 10073 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 8, *Tools for pressing and moulding*.

This second edition cancels and replaces the first edition (ISO 10073:1991), of which it constitutes a minor revision. In particular, the indication of surface textures has been updated in accordance with ISO 1302:2002.

Tools for moulding — Support pillars

1 Scope

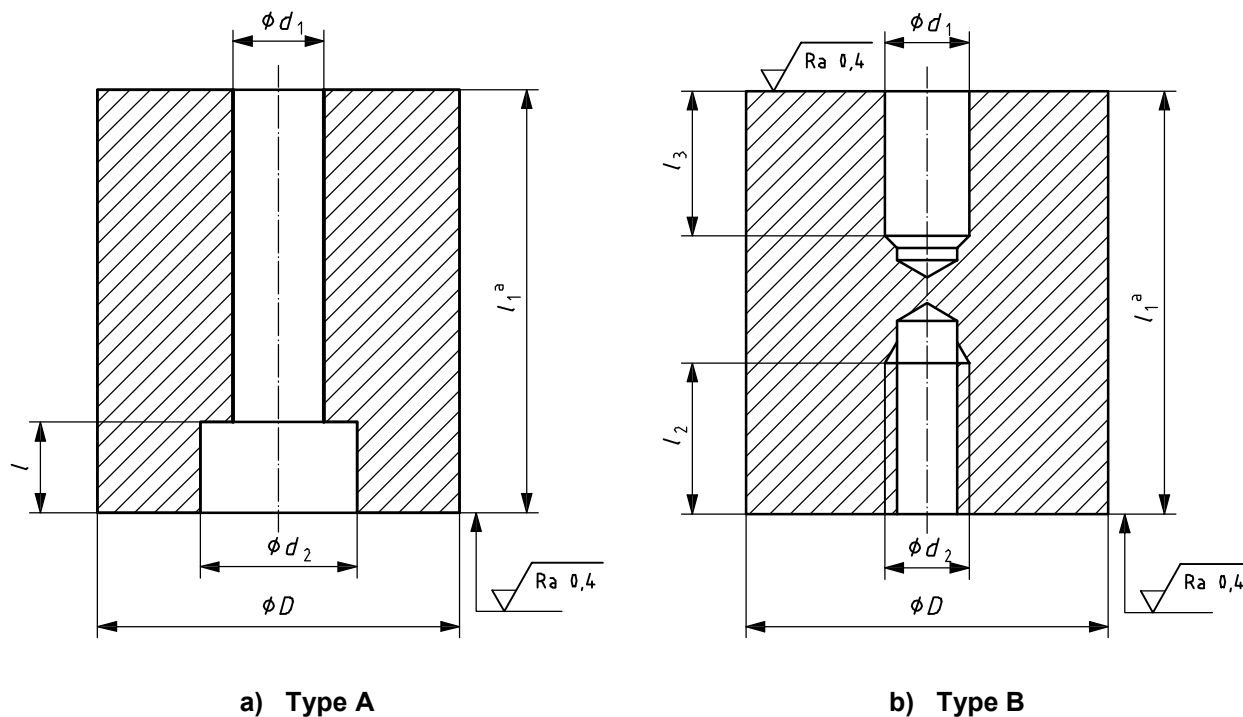
This International Standard specifies the dimensions and tolerances, in millimetres, for support pillars intended for use in pressure die-cast dies and in plastics and rubber moulds.

It covers materials and hardness, and specifies the designation of support pillars which meet its requirements.

2 Dimensions

The dimensions of support pillars shall be in accordance with Figure 1 and Tables 1 and 2.

Surface roughness values in micrometres



^a The spacer blocks and the support pillars shall be ground to the same height when assembled in the completed moulds.

Figure 1 — Support pillars

Table 1 — Dimensions of support pillar, Type A

Dimensions in millimetres

D 0 -0,2	l_1 +0,15 +0,05							d_1^a	d_2	l	Thread size
	40	50	63	80	100	125	160				
25	x	x	x	x	x	x		9	15	9	M8
32	x	x	x	x	x	x		9	15	9	M8
40	x	x	x	x	x	x		11	18	11	M10
50		x	x	x	x	x		11	18	11	M10
63			x	x	x	x	x	13,5	20	13	M12
80			x	x	x	x	x	13,5	20	13	M12

^a In accordance with ISO 273, medium series.

Table 2 — Dimensions of support pillar, Type B

Dimensions in millimetres

D 0 -0,2	l_1 +0,15 +0,05							d_1 H7	d_2	l_2	l_3
	40	50	63	80	100	125	160				
25	x	x	x	x	x	x		8	M8	15	15
32	x	x	x	x	x	x		8	M8	15	15
40	x	x	x	x	x	x		10	M10	18	18
50		x	x	x	x	x		10	M10	18	18
63			x	x	x	x	x	12	M12	20	20
80			x	x	x	x	x	12	M12	20	20

3 Material and hardness

The material shall be low carbon steel. The choice of the low carbon steel, as well as the hardness, shall be left to the manufacturer's discretion.

4 Designation

A support pillar in accordance with this International Standard shall be designated as follows:

- a) "Support pillar";
- b) reference to this International Standard, i.e. ISO 10073;
- c) type (A or B);
- d) exterior diameter, D , in millimetres;
- e) length, l_1 , in millimetres.

EXAMPLE The designation for a support pillar of type A, with an exterior diameter, D , of 25 mm and length, l_1 , of 40 mm, is as follows:

Support pillar ISO 10073 - A - 25 × 40

Bibliography

- [1] ISO 273:1979, *Fasteners — Clearance holes for bolts and screws*
- [2] ISO 1302:2002, *Geometrical Product Specifications (GPS) — Indication of surface texture in technical product documentation*

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ICS 25.120.30

Price based on 4 pages