INTERNATIONAL STANDARD

ISO 16915

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Tools for moulding — Sprue pullers

Outillage de moulage — Arrache-carottes

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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.

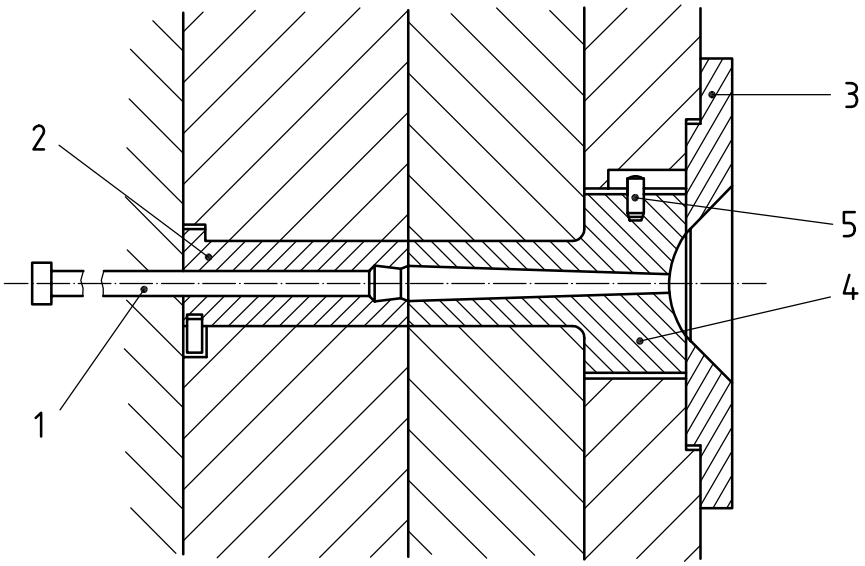
ISO 16915 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 8, *Tools for pressing and moulding*.

Tools for moulding — Sprue pullers

1 Scope

This International Standard specifies the main dimensions and tolerances, in millimetres, of sprue pullers, which are used mainly in injection moulds for plastics and rubbers. See the example of application in Figure 1.

It also specifies the material, hardness and designation of sprue pullers conforming to this International Standard.



Key

1 ejector pin (ISO 6751)
2 sprue puller (ISO 16915)
3 locating ring (ISO 10907-1)
4 sprue bush (ISO 10072)
5 parallel pins (ISO 8734)

Figure 1 — Application example of sprue pullers

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

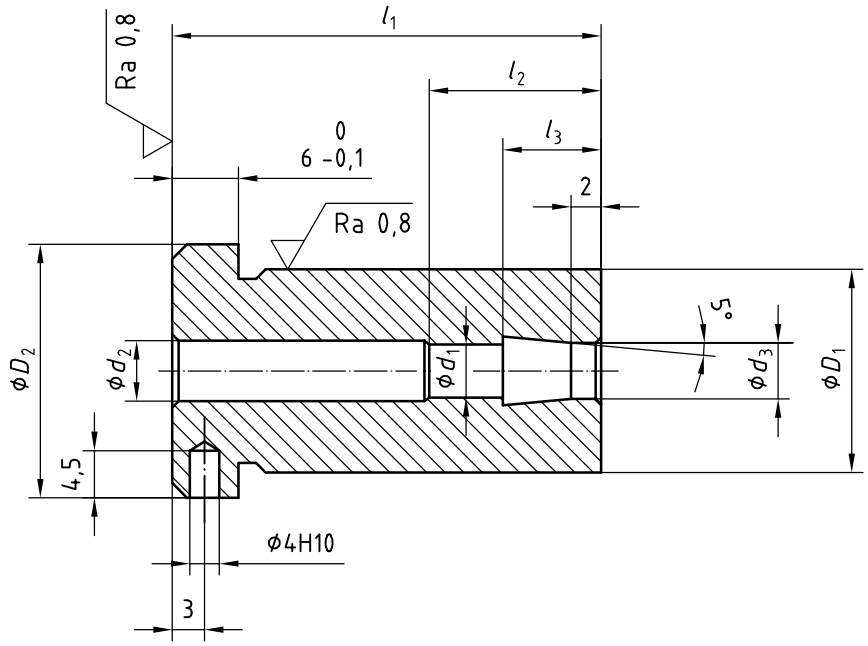
ISO 2768-1, *General tolerances — Part 1: Tolerances for linear and angular dimensions without individual tolerance indications*

ISO 4957, *Tool steels*

3 Dimensions

See Figure 2 and Table 1.

Dimensions in millimetres,
surface roughness values in micrometres
General tolerance: ISO 2768-m



NOTE Chamfers are left to the manufacturer's discretion.

Figure 2 — Sprue puller

4 Material and hardness

Sprue pullers shall be made from tool steel in accordance with ISO 4957.

The minimal hardness shall be 50 HRC.

5 Designation

Sprue pullers in accordance with this International Standard shall be designated by:

a) “Sprue puller”;

b) reference to this International Standard, i.e. ISO 16915;

c) diameter $D_{1,}$ in millimetres;

d) length l_1, in millimetres.

EXAMPLE A sprue puller with a diameter $D_1 = 12$ mm and a length of $l_1 = 50$ mm is designated as follows:

Sprue puller ISO 16915 - 12 × 50

Table 1

Dimensions in millimetres

D_1 k6	l_1 $^{+0,5}_{+0,3}$	d_1 H7	D_2 $^{0}_{-0,2}$	d_2 $^{+0,7}_{+0,3}$	d_3 $^{+0,1}_{0}$	l_2	l_3
12	20	4	16	—	4,2	—	7
	25			4		18	
	32						
	40						
	50						
16	25	6	20	—	6,2	—	7
	32			6		25	
	40						
	50						
	63						
20	32		24				
	40						
	50						
	63						
	80						
25	40	8	29	8	8,2	28	9,5
	50						
	63						
	80						
	100						

Bibliography

[1] ISO 6751:1998, *Tools for moulding — Ejector pins with cylindrical head*

[2] ISO 8734:1997, *Parallel pins, of hardened steel and martensitic stainless steel (Dowel pins)*

[3] ISO 10072:1993, *Tools for moulding — Sprue bushes — Dimensions*

[4] ISO 10907-1:1996, *Tools for moulding — Locating rings — Part 1: Locating rings for mounting without thermal insulating sheets in small or medium moulds — Types A and B*

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