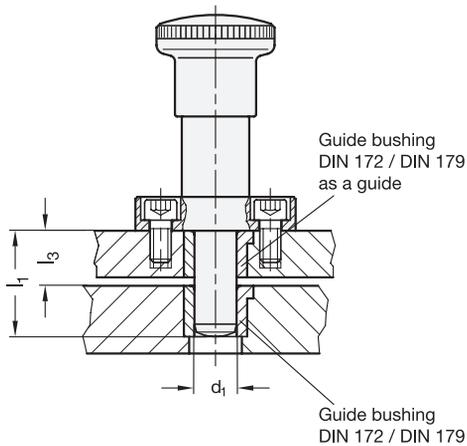


### Construction and assembly instructions for indexing plungers GN 817.3 (Plunger pin cylindrical)



Two different plunger pin lengths  $l_1$  are available for each indexing plunger diameter  $d_1$ .

The length  $l_3$  must ensure that the plunger pin fully disengages, bushing length and plate thickness plus any gap can then be selected within certain margins.

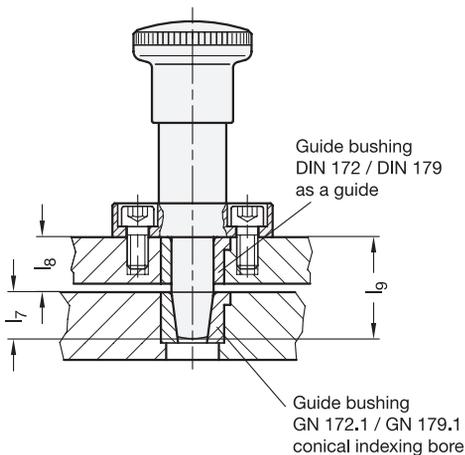
For mounting bushings with tolerance n6, a hole with tolerance H7 corresponding to the external diameter is usually provided.

A selection of suitable guide bushings DIN 172 and DIN 179 is given below on.

see also...

- *Indexing Plungers GN 817.3 (Plunger Pin Cylindrical)*  
→ Page 938

### Construction and assembly instructions for indexing plungers GN 817.5 (Plunger pin conical)



The length  $l_7$  is determined by the penetration depth of the plunger pin into the cone of the bushing.

The length  $l_8$  must ensure that the plunger pin fully disengages, bushing length and plate thickness plus any gap can then be selected within certain margins.

If engaged, the pin must have a minimum remaining stroke of 0,5 mm to make sure that the conical section of the pin is located without clearance in the cone of the guide bushing.

Two different plunger pin lengths  $l_1$  are available for each indexing plunger diameter  $d_1$  (see product table).

For a safe remaining stroke length:  $l_8 = l_1 - 0,5 \text{ mm}$

For mounting bushings with tolerance n6, a hole with tolerance H7 corresponding to the external diameter is usually provided.

A selection of suitable guide bushings DIN 172 / DIN 179 with cylindrical bore and guide bushings GN 172.1 / GN 179.1 with conical bore is given below on.

see also...

- *Indexing Plungers GN 817.5 (Plunger Pin Conical)*  
→ Page 939