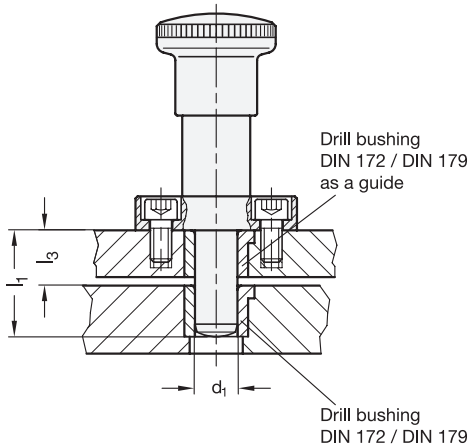


### Construction and Assembly Instructions for GN 817.3 Indexing Plungers (Cylindrical Plunger Pin)



For each plunger pin diameter  $d_1$ , two different pin lengths  $l_1$  are available.

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.

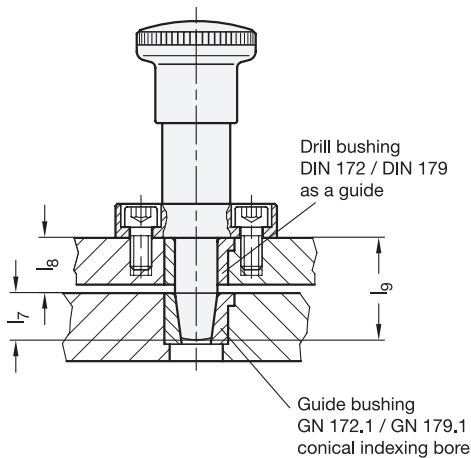
For mounting the bushings with tolerance n6, a hole with tolerance H7, corresponding to the external diameter, is usually provided.

A selection of suitable DIN 172 / DIN 179 press-fit drill bushings, see following page.

see also...

- *Indexing Plungers GN 817.3 (Cylindrical Plunger Pin)* → page 980

### Construction and Assembly Instructions for GN 817.5 Indexing Plungers (Conical Plunger Pin)



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.

When engaged, the pin has to have a minimum remaining stroke of 0.5 mm to make sure that the conical section of the pin is located in the cone of the guide bushing without clearance.

For each plunger pin diameter  $d_1$ , two different pin lengths  $l_1$  are available.

For a safe remaining stroke:  $l_9 = l_1 - 0.5 \text{ mm}$

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

A selection of suitable DIN 172 / DIN 179 press-fit drill bushings with cylindrical bore and GN 172.1 / GN 179.1 press-fit guide bushings with conical bore, see following page.

see also...

- *Indexing Plungers GN 817.5 (Conical Plunger Pin)* → page 981