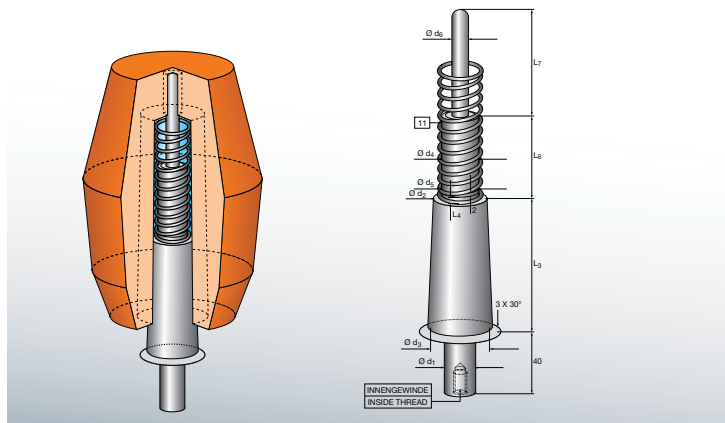




# Spring Pins for EXACTCAST ADS

Trouble-free use of ini-risers on molding lines of all types of compaction

## Riser Types & Dimensions



- The spring pin creates a separating layer of sand between the mini-riser and the casting, which in its turn produces a perfect casting surface in this area
- At the same time the pin protects the mini-riser from being destroyed by the compaction processes on the molding line

Spring pins for EXACTCAST ADS are available in the following dimensions:

Type	Spring pin dimensions												Spring DIN	Thread
	Ø d <sub>1</sub> mm	Ø d <sub>2</sub> mm	Ø d <sub>3</sub> mm	Ø d <sub>4</sub> mm	Ø d <sub>5</sub> mm	Ø d <sub>6</sub> mm	L <sub>3</sub> mm	L <sub>4</sub> mm	L <sub>6</sub> mm	L <sub>7</sub> mm				
S-5	10	12	14	8	10.0	5.0	30	3	15	42	1.00 x 10.0 x 39.0	M 4 x 25		
S-12	10	17	19	10	12.0	5.0	30	3	15	46	1.25 x 12.5 x 40.0	M 4 x 25		
S-16	10	17	20	14	15.0	5.0	50	3	25	50	1.60 x 16.0 x 51.1	M 4 x 25		
S-19	10	21	24	14	15.0	5.0	50	3	25	50	1.60 x 16.0 x 51.1	M 4 x 25		
S-20	10	17	20	10	11.5	5.0	50	4	35	60	1.50 x 12.5 x 65.0	M 4 x 25		
S-27	10	22	24	10	11.5	5.0	50	4	35	57	1.50 x 12.5 x 65.0	M 4 x 25		
S-32	10	23	26	15	16.0	10.0	60	4	30	35	1.50 x 17.0 x 59.5	M 4 x 25		
S-61	20	33	35	22	23.5	10.0	50	4	55	50	2.00 x 25.0 x 88.5	M 8 x 25		
S-85	20	34	39	22	23.5	10.0	60	5	55	70	2.00 x 25.0 x 88.5	M 8 x 30		
S-86	20	34	39	22	23.5	10.0	60	5	55	70	2.00 x 25.0 x 88.5	M 8 x 30		
S-111	20	44	49	28	29.0	10.0	52	7	48	75	3.20 x 35.2 x 88.5	M 8 x 25		
S-133	20	44	49	22	23.0	10.0	65	7	55	58	3.00 x 25.0 x 97.0	M 8 x 25		
S-164	20	54	59	28	29.0	10.0	52	7	58	67	3.20 x 35.2 x 88.5	M 8 x 25		
S-193	20	53	57	29	30.0	10.0	55	7	70	53	2.50 x 32.0 x 110.0	M 8 x 25		
S-237	20	61	64	35	36.5	10.0	55	7	65	70	4.00 x 40.0 x 105.0	M 8 x 25		
S-425	20	61	64	35	36.5	10.0	55	7	65	70	4.00 x 40.0 x 105.0	M 8 x 25		
S-540	20	68	75	51	53.0	10.0	99	6	92	115	3.50 x 59.0 x 125.0	M 8 x 30		
S-550	20	68	75	51	53.0	10.0	99	6	92	115	3.50 x 59.0 x 125.0	M 8 x 30		

The separating layer of sand should have a height of 40% of the diameter (d<sub>u</sub>) of the riser.