

JECTOR PUNCHES

—TiCN COATING—

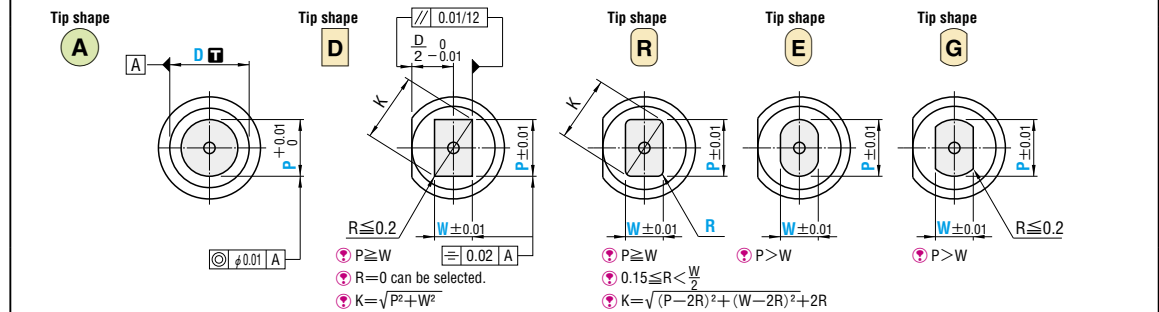
PRODUCTS DATA
P.1601-1604

Calculating the projection length of the jector pin (reference value) **P.241**

For details of jector holes, refer to Jector Punch Blanks. **P.236**
For details of jector pins, refer to Jector Pin Sets. **P.241**

Type	Shank diameter D Tolerance	Material M H	Catalog No.			The tip shape can be selected from Tip shape A~G in the figure below.
			Type	Tip shape	Tip length	
	Dm5	Powdered high-speed steel 64~67HRC	H—PJ H—PJV	A D R E G	S L	

For shank diameter tolerance D, select either m5 or +0.005/0.



Catalog No.			0.01 mm increments												B	H		
Type	Tip shape	Tip length	L						A			D R E G					R	
			(4)	(5)	(6)	(7)	(8)	min.	P max.	P-Kmax.	P-Wmin.	P	R					
Spring reinforced type (D8~25) H—PJ H—PJV	A D R E G	S	(4)	40	50	60	70	80	1.00~	3.99	3.97	1.00	0.15≤R<W/2 (R only)	R	8	7		
			(5)	40	50	60	70	80	2.00~	4.99	4.97	2.00						
			(6)	40	50	60	70	80	2.00~	5.99	5.97	2.00						
			(8)	40	50	60	70	80	90	100	3.00~	7.99					7.97	3.00
			(10)	40	50	60	70	80	90	100	3.00~	9.99					9.97	3.00
			(13)	40	50	60	70	80	90	100	6.00~	12.99					12.97	6.00
Spring reinforced type (D8~25) AH—PJ AH—PJV	E G	L	(4)	50	60	70	80	1.00~	3.99	3.97	2.00	0.15≤R<W/2 (R only)	R	13	8			
			(5)	50	60	70	80	2.00~	4.99	4.97	2.00							
			(6)	50	60	70	80	2.00~	5.99	5.97	2.00							
			(8)	50	60	70	80	90	100	3.00~	7.99					7.97	3.00	
			(10)	50	60	70	80	90	100	3.00~	9.99					9.97	3.00	
			(13)	50	60	70	80	90	100	6.00~	12.99					12.97	6.00	
			(16)	60	70	80	90	100	10.00~	15.99	15.97	6.00	19	13				
			(20)	60	70	80	90	100	13.00~	19.99	19.97	6.00						
			(25)	60	70	80	90	100	18.00~	24.99	24.97	6.00						
			(4)	50	60	70	80	1.00~	3.99	3.97	2.00	0.15≤R<W/2 (R only)			R	19	16	
			(5)	50	60	70	80	2.00~	4.99	4.97	2.00							
			(6)	50	60	70	80	2.00~	5.99	5.97	2.00							
			(8)	50	60	70	80	90	100	3.00~	7.99		7.97	3.00				
			(10)	50	60	70	80	90	100	3.00~	9.99		9.97	3.00				
			(13)	50	60	70	80	90	100	6.00~	12.99		12.97	6.00				
			(16)	60	70	80	90	100	10.00~	15.99	15.97	6.00	25	23				
			(20)	60	70	80	90	100	13.00~	19.99	19.97	6.00						
			(25)	60	70	80	90	100	18.00~	24.99	24.97	6.00						

The spring constants of H—SJV, H—PJV, AH—SJV, and AH—PJV are twice those of H—SJ, H—PJ, AH—SJ, and AH—PJ respectively.
 L(40)→B=6 If full length is (40), tip length is 6 mm in all cases.
 L(50)→B=13 If full length is (50), tip length is 13 mm in all cases.
 A: P>D-0.03→ℓ=0 If P>D-0.03 for a round punch, D-0.01/0.03 (press-in lead) is not included.
 R: P·K>D-0.05→ℓ=0 If P·K>D-0.05 for a shaped punch, D-0.01/0.03 (press-in lead) is not included.
 D(4), (5), and (6) are specifications available for H—SJ, H—PJ, AH—SJ, and AH—PJ only. Spring reinforced types are available for D8~25 only.

Order **Catalog No.** — **L** — **P** — **W** — **R (R only)**
H—PJEL16 — **70** — **P12.00** — **W6.00**

Effect of spring reinforced type
Spring constant is twice that of a standard jector punch. The large spring load results in more effective scrap removal.

Days to Ship **Quotation**

Alterations **Catalog No.** — **L(LC-LCT-LMT)** — **P(PC)** — **W(WC)** — **R** — **(BC-HC-TC, etc.)**
H—PJS6 — **LC58** — **P3.00** — **W2.80** — **HC8**

Alteration	Code	A	D R E G	1Code																																			
Alterations to tip	PC WC	Tip dimension change PC≥PCmin. 0.01 mm increments (If combined with PKC, 0.001 mm increments can be selected.) ⊗ Cannot be used for D4.	Tip dimension change PC·WC≥PC·WCmin. 0.01 mm increments ⊗ Cannot be used for D4.																																				
		<table border="1"> <tr><th>D</th><th>PCmin.</th></tr> <tr><td>5</td><td>1.800</td></tr> <tr><td>6</td><td>1.800</td></tr> <tr><td>8</td><td>2.500</td></tr> <tr><td>10</td><td>2.800</td></tr> <tr><td>13</td><td>5.000</td></tr> <tr><td>16</td><td>8.000</td></tr> <tr><td>20</td><td>9.000</td></tr> <tr><td>25</td><td>9.000</td></tr> </table>	D	PCmin.	5	1.800	6	1.800	8	2.500	10	2.800	13	5.000	16	8.000	20	9.000	25	9.000	<table border="1"> <tr><th>D</th><th>PC·WCmin.</th></tr> <tr><td>5</td><td>1.80</td></tr> <tr><td>6</td><td>1.80</td></tr> <tr><td>8</td><td>2.50</td></tr> <tr><td>10</td><td>2.80</td></tr> <tr><td>13</td><td>5.00</td></tr> <tr><td>16</td><td>5.00</td></tr> <tr><td>20</td><td>5.00</td></tr> <tr><td>25</td><td>5.00</td></tr> </table>	D	PC·WCmin.	5	1.80	6	1.80	8	2.50	10	2.80	13	5.00	16	5.00	20	5.00	25	5.00
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25	5.00																																						
BC	Tip length change (shorter than standard) 2≤BC<B 0.1 mm increments																																						
SC	Lapping of tip ⊗ P dimension tolerance and increment are the same. The base material is finished before the coating is applied. ⊗ R=0 cannot be selected for the tip shape D corners.																																						
PRC	Rounding of tip side edge 0.3≤PRC≤1 0.1 mm increments ⊗ PRC≤(P-d,-0.5)/2 d, dimension P.236 ⊗ Cannot be combined with PCC.																																						
PCC	Chamfering to tip side edge 0.3≤PCC≤1 0.1 mm increments ⊗ PCC≤(P-d,-0.5)/2 d, dimension P.236 ⊗ Cannot be combined with PRC.																																						
PKC	Tip tolerance change P+0.01⇔+0.005 0 ⊗ P dimension can be selected in 0.01 mm increments. ⊗ Cannot be used for D>13.	Tip tolerance change P·W±0.01⇔+0.01 0 ⊗ Cannot be used for D>13.																																					
Alterations to full length	LC	Full length change (reduction in tip length) LC<L 0.1 mm increments ⊗ Tip length B is shortened by (L-LC). (If combined with LKC, 0.01 mm increments can be selected.) ⊗ Projection length of jector pin is 2 mm.																																					
	LCT	Changes to head thickness tolerance and full length are processed using a single code. The allowable range of change, increment, ordering process, and notes (⊗) are the same as for LC.	TKC Head thickness tolerance change T+0.3⇔+0.02 0⇔+0	LC Full length change L+0.3⇔+0.1 0⇔+0																																			
	LMT	Changes to head thickness tolerance and full length are processed using a single code. The allowable range of change, increment, ordering process, and notes (⊗) are the same as for LC.	TKM Head thickness tolerance change T+0.3⇔-0.02 0⇔-0.02	LC Full length change L+0.3⇔+0.1 0⇔+0																																			
	LKC	Full length tolerance L+0.3⇔+0.05 change																																					
	Alterations to head	KC	Addition of single key flat to head 																																				
WKC		Addition of double key flats in parallel 																																					
KFC		Double key flats at 0° and a selected angle 1° increments ⊗ Cannot be combined with KC-WKC.	Double key flats at 0° and a selected angle 1° increments ⊗ Cannot be combined with KC-WKC.																																				
NKC		No key flat																																					

Alteration	Code	A	D R E G	1Code
Alterations to head	HC	Head diameter change D≤HC<H 0.1 mm increments		
	TC	Head thickness change 3.5≤TC<5 0.1 mm increments (if combined with TKC-TKM-LCT-LMT, 0.01 mm increments can be selected.) ⊗ Full length L is shortened by (5-TC). If combined with LC/LCT/LMT, full length remains as specified.		
	TKC	Head thickness tolerance change T+0.3⇔+0.02 0⇔+0		
	TKM	Head thickness tolerance change T+0.3⇔+0 0⇔-0.02		
Alterations to shank	TCC	Chamfering of head This improves the strength of the punch head. P.1611 0.1 mm increments 0.5≤TCC≤(H-D)/2 ⊗ If H≤5, then TCC is 0.5.		
	RC	Head thickness is machined to a tolerance of -0.04~0 relative to the retainer surface. ⊗ Cannot be used for D+0.005/0 types.		
	SKC	Single key flat on shank D4~6 P≤D-1.2 W≤D-1.2 (Machining width 0.5) D8~ P≤D-2.2 W≤D-2.2 (Machining width 1) ⊗ Cannot be combined with KC-WKC-KFC.		
	AC	The jector pin is removed to create an air path and the side vent hole is plugged from the inside by inserting a resin (ABS) ring.		
Alterations to shank	NC	The jector pin is removed. ⊗ Cannot be combined with AC.		
	NDC	No press-in lead ℓ≥3⇔ℓ=0		

P Price **Quotation**

Quotation

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