

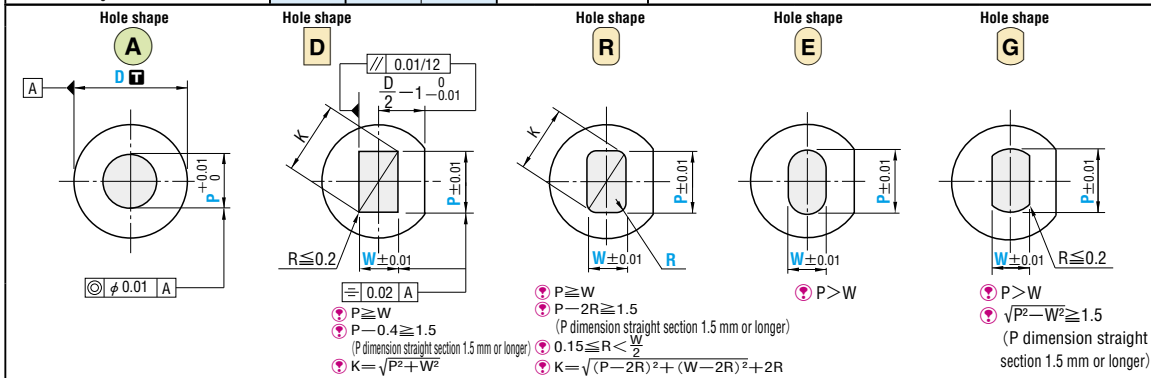
# SCRAP RETENTION ANGULAR BUTTON DIES

—STRAIGHT—



Straight type	Shank diameter D tolerance	M H	D dimension	Catalog No.	The hole shape can be selected from A D R E G below.
	Dn5	Equivalent to SKH51 61~64HRC Equivalent to SKD11 60~63HRC Equivalent to SKD11 60~63HRC	D4~5	SR-ASD	
			D6~25	SR-ASD	
			D8~25	SR-ASD	
			D4~25	SR-PASD	
			D8~25	SR-PASD	
			D4~5	SRA-ASD	
D+0.005/0	Equivalent to SKH51 61~64HRC Equivalent to SKD11 60~63HRC Equivalent to SKD11 60~63HRC	D4~5	SRA-ASD		
		D6~16	SRA-ASD		
		D8~16	SRA-ASD		
		D4~16	SRA-PASD		
		D8~16	SRA-PASD		
		D8~16	SRA-PASD		

For shank diameter tolerance D, select either n5 or +0.005/0.



D tolerance	Catalog No.	Type	D	L	0.01mm increments				MT (workpiece material thickness)	C (clearance)
					A min. . P max.	D R E G P-Kmax. P-Wmin.	R	R		
4	(Dn5) (D+0.005/0) (Equivalent to SKH51)	A SR-ASD SRA-ASD (Powdered high-speed steel)	(4)	8 13 16 20 22 25 30	1.00~ 1.50	—	—	—	C ≥ 0.010	
				5	8 13 16 20 22 25 30	1.00~ 2.50	—			—
6	(Dn5) (D+0.005/0) (Equivalent to SKD11)	A SR-ASD SRA-ASD D SR-ASDD SRA-ASDD R SR-ASDR SRA-ASDR E SR-ASDE SRA-ASDE G SR-ASDG SRA-ASDG	(6)	16 20 22 25 30 35	1.00~ 3.00	—	—	MT ≥ 0.15 Select a workpiece material thickness of 0.15 mm or more.	Select a clearance of 0.010 mm or more.	
				8	16 20 22 25 30 35	1.00~ 4.00	4.00			1.00
10	(Powdered high-speed steel)	A SR-PASD SRA-PASD D SR-PASDD SRA-PASDD R SR-PASDR SRA-PASDR E SR-PASDE SRA-PASDE G SR-PASDG SRA-PASDG	(10)	16 20 22 25 30 35	2.00~ 6.00	6.00	1.20	0.15 ≤ R < W/2 (R only)		
				13	16 20 22 25 30 35	3.00~ 8.00	8.00			1.50
16			(16)	16 20 22 25 30 35	5.00~ 10.00	10.00	2.00			
				20	16 20 22 25 30 35	7.00~ 12.00	12.00		3.00	
25			(25)	16 20 22 25 30 35	10.00~ 16.00	16.00	3.00			

\* D = (4), (5), and (6) are specifications available for shape A (round) only. They are not available for shapes D R E G.  
 \* D = (20) and (25) are specifications available for shank diameter tolerance of Dn5 only.  
 \* Can be used only for workpiece materials with tensile strengths up to 1177 N/mm² (120 kgf/mm²).  
 \* MT (workpiece material thickness) and C (clearance) are used as data for machining the scrap retention grooves.  
 \* Specify the shaped hole dimensions (P·W·R) when selecting the button die finishing dimensions.

Order **Catalog No.** — L — P — W — R (R only) — MT — C  
 SR-ASDE 8 — 20 — P3.80 — W2.00 — MT1.50 — C0.105

Days to Ship **Quotation**

Alterations **Catalog No.** — L (LC-SLC) — P (PC) — W (WC) — R — MT — C — (BC-KC, etc.)  
 SR-ASD 6 — 16 — P2.47 — MT1.50 — C0.105 — LKZ

Alteration	Code	A	D R E G	1Code
Alterations to shaped hole	PC WC	Shaped hole diameter change min.: $\frac{P}{W} < \frac{PC}{WC} \leq \frac{P-Wmin.}{2} \geq 1.00$ 0.01 mm increments		
		max.: $\frac{P}{W} < \frac{PC}{WC} \leq P \cdot Kmax. + 0.2$ 0.01 mm increments		
	BC	Shaped hole depth change $\frac{P}{1.00 \sim 1.99} \frac{Bmax.}{3}$ $\frac{P}{2.00 \sim 3.99} \frac{Bmax.}{4}$ 1 ≤ BC ≤ Bmax. 0.1 mm increments	Shaped hole depth change 1 ≤ BC ≤ 2 0.1 mm increments	
Alterations to full length	PKC	Shaped hole diameter tolerance change $P \pm 0.01 \rightarrow +0.005$ $0 \rightarrow 0$	Shaped hole diameter tolerance change $P \cdot W \pm 0.01 \rightarrow +0.01$ $0 \rightarrow 0$	
	LC	Full length change $10 \leq LC < L$ 0.1 mm increments (If combined with LKC-LKZ, 0.01 mm increments can be selected.) * Press-in lead is shortened by (L-LC).		
	LKC LKZ	Full length tolerance change $L + 0.4 \rightarrow +0.05$ $+0.2 \rightarrow 0$ * Cannot be used for L (LC) < 10. Full length tolerance change $L + 0.4 \rightarrow +0.01$ $+0.2 \rightarrow 0$ * Cannot be used for L (LC) < 16.		
Alterations to full length	SLC	Changes to full length and full length tolerance are processed using a single code. The allowable range of change, increment, ordering process, and notes (*) are the same as for LC.	LC Full length change + LKC Full length tolerance change $L + 0.4 \rightarrow +0.05$ $+0.2 \rightarrow 0$	

Alteration	Code	A	D R E G	1Code
Others	KC	Addition of single key flat * Cannot be used for D4~6.	Key flat position change 180° 270° 90° 1° increments	
	WKC	Addition of double key flats in parallel * Can be combined with KC for shapes D R E G. * Cannot be used for L (LC) < 16. * Cannot be used for D4~6.		
	KM	Addition of key groove to prevent lifting * Cannot be used for D < 6. * Cannot be combined with WKC-ANF. * If D=6, can be used for hole shape A only.	 5 ≤ l < L 0.1 mm increments	
Others	ANF	Angular angle change $0.6 \leq ANF \leq 1.2$ 0.2° increments d ≤ dmax. $d = P + 2((L-B) \tan(ANF))$ $P - B \tan(ANF) \geq 0.6$ $W - B \tan(ANF) \geq 0.6$ * Cannot be used for P, W < 1.0.	 Taper 1/50 Angle one side 0.573°	

Price **Quotation**

BUTTON DIES