

CARBIDE BLOCK DIES

—CONFIGURABLE SIZE TYPE—

SCRAP RETENTION CARBIDE BLOCK DIES

—CONFIGURABLE SIZE TYPE—

PRODUCTS DATA

P.1619

—Straight— RoHS

M	H	Catalog No.
V40 (HIP) 87~88HRA		A WFBLD
		D WFBLDD
		R WFBLDR
		E WFBLDE
		G WFBLDG

Hole shape **A**

⊙ P→min. W max.
P dimension must be within the range of W dimension.

Hole shape **D**

⊙ P ≥ W

Hole shape **R**

⊙ P ≥ W
⊙ 0.15 ≤ R < W/2

Hole shape **E**

⊙ P > W

Hole shape **G**

⊙ P > W

Catalog No.	H	V								R	L	
		min. W max.		min. P max.		min. P max.		min. P max.				
		min.	max.	bmin.	amin.	bmin.	amin.	bmin.	amin.			
A WFBLD D WFBLDD R WFBLDR E WFBLDE G WFBLDG	6.0~ 8.0	1.00~ 4.00	4	4	4	4	5	6	8	9	0.15 ≤ R < W/2	16
	8.1~ 10.0	1.00~ 6.00	4	4	4	4	5	6	8	9		20
	10.1~ 13.0	1.00~ 8.00	5	5	5	5	6	8	9	22		
	13.1~ 16.0	1.00~ 10.00	6	6	6	6	8	10	12	16		25
	16.1~ 20.0	1.50~ 12.00	8	8	8	8	10	12	16	20		30
	20.1~ 25.0	1.50~ 16.00	9	9	9	9	12	16	20	25		35

⊙ V-P=a H-W=b (For shape A, H-P=b)
 ⊙ P-W-R→0.01mm increments V-H→0.1mm increments

Order Catalog No. - 0.1mm increments - L - 0.01mm increments

V - H - L - P - W - R (R only)

WFBLDE - V15.8 - H12.8 - L22 - P7.25 - W5.75

Days to Ship Quotation

Price Quotation

Alterations ⊙ Refer to the page at right.

—Straight— RoHS

M	H	Catalog No.
V40 (HIP) 87~88HRA		A SR-WFBLD
		D SR-WFBLDD
		R SR-WFBLDR
		E SR-WFBLDE
		G SR-WFBLDG

Hole shape **A**

⊙ P→min. W max.
P dimension must be within the range of W dimension.

Hole shape **D**

⊙ P ≥ W
⊙ P-0.4 ≥ 1.5
(P dimension straight section 1.5 mm or longer)

Hole shape **R**

⊙ P ≥ W
⊙ 0.15 ≤ R < W/2
⊙ P-2R ≥ 1.5
(P dimension straight section 1.5 mm or longer)

Hole shape **E**

⊙ P > W

Hole shape **G**

⊙ P > W
⊙ √(P²-W²) ≥ 1.5
(P dimension straight section 1.5 mm or longer)

Catalog No.	H	V								R	L	MT (workpiece material thickness)	C (clearance)
		min. W max.		min. P max.		min. P max.		min. P max.					
		min.	max.	bmin.	amin.	bmin.	amin.	bmin.	amin.				
A SR-WFBLD D SR-WFBLDD R SR-WFBLDR E SR-WFBLDE G SR-WFBLDG	6.0~ 8.0	1.00~ 4.00	4	4	4	4	5	6	8	9	0.15 ≤ R < W/2	16	MT ≥ 0.15 Select a workpiece material thickness of 0.15mm or more. Clearance Punch tip Die shaped hole
	8.1~ 10.0	1.00~ 6.00	4	4	4	4	5	6	8	9		20	
	10.1~ 13.0	1.00~ 8.00	5	5	5	5	6	8	10	12		22	
	13.1~ 16.0	1.00~ 10.00	6	6	6	6	8	10	12	16		25	
	16.1~ 20.0	1.50~ 12.00	8	8	8	8	10	12	16	20		30	
	20.1~ 25.0	1.50~ 16.00	9	9	9	9	12	16	20	25		35	

⊙ V-P=a H-W=b (For shape A, H-P=b) ⊙ P-W-R→0.01mm increments V-H→0.1mm increments ⊙ Can be used only for workpiece materials with tensile strengths up to 1,177N/mm² (120kgf/mm²).
 ⊙ Workpiece material thickness and clearance are used as machining data for the scrap retention. Specify the shaped hole dimensions (P-W-R) when selecting the die finishing dimensions.

Order Catalog No. - 0.1mm increments - L - 0.01mm increments - MT - C

V - H - L - P - W - R (R only) - MT - C

SR-WFBLDE - V15.8 - H12.8 - L22 - P7.27 - W5.25 - MT1.50 - C0.105

Alterations Catalog No. - V - H - L(LC) - P-W-R - (BC-LKC, etc.)

SR-WFBLDD - V12.5 - H9.5 - LC28.5 - P6.25-W4.75 - LKC-ANF1.2

Alteration	Code	A	D R E G	1Code
Alterations to shaped hole	BC	Shaped hole depth change 0 ≤ BC ≤ 4 0.1mm increments With scrap retention 1 ≤ BC ≤ Bmax. 0.1mm increments P 1.00 ~ 1.98 3 2.00 ~ 4	Shaped hole depth change 0 ≤ BC ≤ 4 0.1mm increments With scrap retention 1 ≤ BC < 2 0.1mm increments	Quotation
	PKC	Shaped hole tolerance change P+0.01 → +0.005 0	Shaped hole tolerance change P-W±0.01 → +0.01	
Alterations to full length	HVC		H and V are reversed relative to shaped hole. P dimension is machined in direction H and W dimension is machined in direction V. ⊙ P → min. W max.	Quotation
	LC	Full length change 10 ≤ LC < L 0.1mm increments (If combined with LKC-LKZ, 0.01mm increments can be selected.)		
Alterations to full length	LKC	Full length tolerance change L+0.4 → +0.05 +0.2 → 0		
	LKZ	Full length tolerance change L+0.4 → +0.01 +0.2 → 0		

Alteration	Code	A	D R E G	1Code																
Others	VKC	Shape tolerance change H+V+0.005 → +0.003 0		Quotation																
	VKM	Shape tolerance change H+V+0.005 → -0.003 0																		
	VHM	Shape tolerance change H+V+0.005 → -0.005 0																		
Others	ANF	Angular angle change 0 ≤ ANF ≤ 1.2 0.2° increments ⊙ d ≤ dmax. ⊙ d = P+2((L-B) tan(ANF°)) ⊙ P-B tan(ANF°) ≥ 0.6 ⊙ W-B tan(ANF°) ≥ 0.6	<table border="1"> <tr> <th>V</th> <th>d max.</th> </tr> <tr> <td>6.0~ 8.0</td> <td>3.4</td> </tr> <tr> <td>8.0~ 10.0</td> <td>4.4</td> </tr> <tr> <td>10.0~ 13.0</td> <td>6.4</td> </tr> <tr> <td>13.0~ 16.0</td> <td>8.4</td> </tr> <tr> <td>16.0~ 20.0</td> <td>10.6</td> </tr> <tr> <td>20.0~ 25.0</td> <td>12.6</td> </tr> <tr> <td>25.0</td> <td>14.6</td> </tr> </table>	V	d max.	6.0~ 8.0	3.4	8.0~ 10.0	4.4	10.0~ 13.0	6.4	13.0~ 16.0	8.4	16.0~ 20.0	10.6	20.0~ 25.0	12.6	25.0	14.6	
		V	d max.																	
6.0~ 8.0	3.4																			
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20.0~ 25.0	12.6																			
25.0	14.6																			
NDC	No press-in lead																			