



JECTOR DRAWING PUNCHES

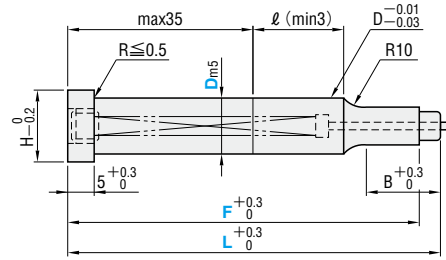
—DICOAT® TREATMENT·TiCN COATING—



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.239

Type	Material	Surface	Shank diameter D	Catalog No.
Regular type	Equivalent to SKD11	60 ~ 63HRC Surface 3000HV	4 ~ 25	Dicoat® treatment T-SJ
	Powdered high-speed steel	64 ~ 67HRC Surface 3000HV	4 ~ 25	TiCN coating H-PJ
Punch with locating dowel hole	Equivalent to SKD11	60 ~ 63HRC Surface 3000HV	10 ~ 25	Dicoat® treatment T-SJ-C
				TiCN coating H-SJ-C



$\text{T-SJ-C} \rightarrow \text{T} = 5_{+0.03}^{+0.01}$

Shape P.673

B	H	Catalog No.			L	0.01mm increments		dmin.	
		Type	Shape	D		min. P max.	Vmin.		
8	7	Regular type	Dicoat® treatment T-SJ	TiCN coating H-PJ	40 50 60 70 80	4	2.00 ~ 3.99	1.00	1.00
	5						2.00 ~ 4.99	2.00	2.00
	6						2.00 ~ 5.99	2.00	2.00
13	11	with locating dowel hole	T-SJ-C	H-SJ-C	(40) (50) 60 70 80 90 100	8	3.00 ~ 7.99	3.00	3.00
	10					3.00 ~ 9.99	3.00	3.00	
	13					6.00 ~ 12.99	6.00	6.00	
19	19	(D10 ~ 25) (L60 ~ 100)				16	10.00 ~ 15.99	6.00	6.00
	20					13.00 ~ 19.99	6.00	6.00	
	25					18.00 ~ 24.99	6.00	6.00	

- $L(40) \rightarrow B=6$ If full length L is (40), tip length B is 6mm in all cases.
- $L(50) \rightarrow B=13$ If full length L is (50), tip length B is 13mm in all cases.
- $T-SJ-C \rightarrow D \geq 10, L \geq 60$ For T-SJ-C, D is 10~25 and full length L is 60 or more.
- $T-SJ-C L=60 \rightarrow B=13$ If full length L is 60 for T-SJ-C, tip length B is 13mm in all cases.
- $P > D - 0.03 \rightarrow \ell = 0$ If $P > D - 0.03$, $D_{-0.01}^{-0.03}$ (press-in lead) is not included.
- For the shapes with dimension d, pay special attention to dmin.



Alterations

Catalog No. —

L(LC) —

P·E·V·R·Q·A·K·F·S —

(HC·TC...etc.)

T-SJ2C 16 —

LC75.0 —

P12.00—V9.50—A30—F65.0—S3 —

LKC

Alterations	Code	Spec.	1Code
	HC	Head diameter change $D \leq HC < H$ 0.1mm increments	
	TC	Head thickness change $3.5 \leq TC < 5$ 0.1mm increments (if combined with TKC·TKM, 0.01mm increments can be selected.) Full length is shortened by $(5-TC)$.	
	TCC	Chamfering of head This improves the strength of the punch head. P.1611 0.1 mm increments $0.5 \leq TCC \leq (H-D)/2$ If $H \leq 5$, then TCC is 0.5.	
	KC	Addition of single key flat to head	Quotation
	WKC	Addition of double key flats in parallel	
	RC	Head thickness is machined to a tolerance of $-0.04 \sim 0$ relative to the retainer surface.	
	TKC	Head thickness tolerance change $5_{+0.3}^0 \rightarrow +0.02$ Cannot be used for punches with locating dowel holes.	
	TKM	Head thickness tolerance change $5_{+0.3}^0 \rightarrow +0.02$ Cannot be used for punches with locating dowel holes.	
Full length	LC	Full length change $LC < L$ 0.1mm increments Tip length B is reduced by $(L-LC)$. Projection length of jector pin is 2mm.	
	LKC	L dimension tolerance change $L_{+0.3}^0 \rightarrow +0.05$	

Alterations	Code	Spec.	1Code	
Alterations to tip		SC	Lapping of tip P dimension tolerance and increment remain the same. The base material is finished before the coating is applied. Cannot be used for Dicoat® treatment punches. Cannot be used for shapes 2A-2C·3C-4C-6C-3D·4D-5D·9D. Cannot be combined with AKC·KKC·RKC·QKC.	
		AKC	Angle A tolerance change $A \pm 30' \rightarrow \pm 10'$ Cannot be used for Dicoat® treatment punches.	
		KKC	Angle K tolerance change $K \pm 30' \rightarrow \pm 10'$ Cannot be used for Dicoat® treatment punches.	
		RKC	R dimension tolerance $R \pm 0.5 \rightarrow \pm 0.05$ Cannot be used for Dicoat® treatment punches. Can be used for $0.1 \leq R \leq 10$.	Quotation
		QKC	Q dimension tolerance change $Q \pm 0.5 \rightarrow \pm 0.05$ Cannot be used for Dicoat® treatment punches. Can be used for $0.1 \leq Q \leq 10$.	
Others		NDC	No press-in lead $\ell \geq 3 \rightarrow \ell = 0$	
		AC	The jector pin is removed to create an air path and the side vent hole is plugged from the inside.	
		NC	The jector pin is removed. Cannot be combined with AC.	
		FKC	F dimension tolerance change $F_{+0.3}^0 \rightarrow +0.05$ Cannot be used for Dicoat® treatment punches.	



Price

Quotation



Order

Catalog No. —

L —

P·E·V·R·Q·A·K·F·S —

T-SJ2C 16 —

70 —

P12.00—V9.50—A30—F65.0—S3



Days to Ship

Quotation

PUNCHES & DIES FOR FORMING