

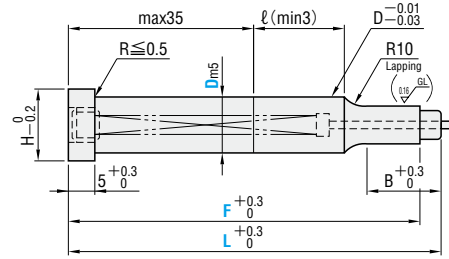
JECTOR DRAWING PUNCHES

—NORMAL · LAPPING—

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	M	H	Shank diameter D	Catalog No.
Regular type	Equivalent to SKH51	61~64HRC	4~6	SJ Lapping L—SJ
	Equivalent to SKD11	60~63HRC	8~25	
	Powdered high-speed steel	64~67HRC	4~25	PJ Lapping L—PJ
Punch with locating dowel hole	Equivalent to SKD11	60~63HRC	10~25	SJ—C Lapping L—SJ—C



SJ—C→T=5^{+0.03}/₀^{+0.01}
 Lapping is applied to the area from the punch tip up to B dimension. (However end face is not lapped.)

Shape **P.673**

B	H	Catalog No.		D	L	0.01mm increments		dmin.
		Type	Shape			min. P max.*	Vmin.	
8	7	Regular type	Lapping	4	40 50 60 70 80	2.00~	3.99	1.00
	8		L—SJ	5		2.00~	4.99	2.00
	9		L—PJ	6		2.00~	5.99	2.00
13	11	With locating dowel hole	2A~4A	8	(40) (50) 60 70 80 90 100	3.00~	7.99	3.00
	13		2B	10		3.00~	9.99	3.00
	16		2C~8C	13		6.00~	12.99	6.00
19	19	(D10~25) (L60~100)	3D~7D	16		10.00~	15.99	6.00
	23		9D	20		13.00~	19.99	6.00
	28			25		18.00~	24.99	6.00

- Lapping cannot be used for shapes 2A·2C·3C·4C·6C·3D·4D·5D·9D.
- L (40)→B=6 If full length L is (40), tip length B is 6mm in all cases.
- L (50)→B=13 If full length L is (50), tip length B is 13mm in all cases.
- SJ—C→D≥10, L≥60 For SJ—C, D is 10~25 and full length L is 60 or more.
- SJ—C L=60→B=13 If full length L is (60) for SJ—C, tip length B is 13mm in all cases.
- P>D—0.03→ℓ=0 If P>D—0.03, D_{-0.03}^{-0.01} (press-in lead) is not included.
- P can be the same value as D. P=D→P m5·ℓ=0 * If P=D, tolerance of P is m5 and D_{-0.03}^{-0.01} (press-in lead) is not included.
- For the shapes with dimension d, pay special attention to dmin.

Order **Catalog No.** — **L** — **P·E·V·R·Q·A·K·F·S**
SJ2C 16 — **70** — **P12.00—V10.00—A30—F65.0—S3**

Days to Ship **Quotation**

Alterations **Catalog No.** — **L(LC)** — **P·E·V·R·Q·A·K·F·S** — (HC·TC, etc.)
SJ2C 16 — **LC75.0** — **P12.00—V10.00—A30—F65.0—S3** — **LKC—FKC**

Alteration	Code	Spec.	1Code
	HC	Head diameter change D≤HC<H 0.1mm increments	
	TC	Head thickness change 3.5≤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≤TCC≤(H-D)/2 If H≤5, then TCC is 0.5. Cannot be combined with SRC.	
	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 -0.04~0 relative to the retainer surface.	
	TKC	Head thickness tolerance change 5 ^{+0.3} / ₀ → +0.02 Cannot be used for punches with locating dowel holes.	
	TKM	Head thickness tolerance change 5 ^{+0.3} / ₀ → -0.02 Cannot be used for punches with locating dowel holes.	

P Price **Quotation**

Alteration	Code	Spec.	1Code
	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 → +0.05	
	PKC	P dimension tolerance change P ^{+0.01} / ₀ → +0.005 Cannot be used with lapping.	
	AKC	Angle A tolerance change A±30° → ±10° Cannot be used with lapping.	
	KKC	Angle K tolerance change K±30° → ±10° Cannot be used with lapping.	Quotation
RKC	R dimension tolerance R±0.5 → ±0.05 Cannot be used with lapping. Can be used for 0.1≤R≤10.		
	QKC	Q dimension tolerance change Q±0.5 → ±0.05 Cannot be used with lapping. Can be used for 0.1≤Q≤10.	
	NDC	No press-in lead ℓ≥3→ℓ=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 → +0.05	

PUNCHES & DIES FOR FORMING