


SCRAP RETENTION REVERSE TAPER BUTTON DIE

Patent pending

PRODUCTS DATA

P.1619

—Headed type—



RoHS

M H

D

Equivalent to SKD11 60~63HRC

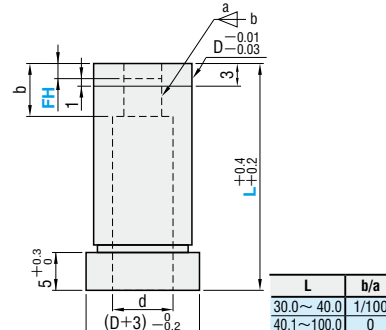
Catalog No.

D6~56

A SRTS—MHD
D SRTS—HDD
R SRTS—HDR
E SRTS—HDE
G SRTS—HDG

D10~56

A SRTS—MHDS
D SRTS—HDDS
R SRTS—HDRS
E SRTS—HDES
G SRTS—HDGS



L b/a

30.0~40.0	1/100
40.1~100.0	0

Ⓢ P dimension will change if regrinding is applied. Note that the change amount varies with the taper width (max.0.5mm on one side) and taper depth & regrinding amount.

Tip shape

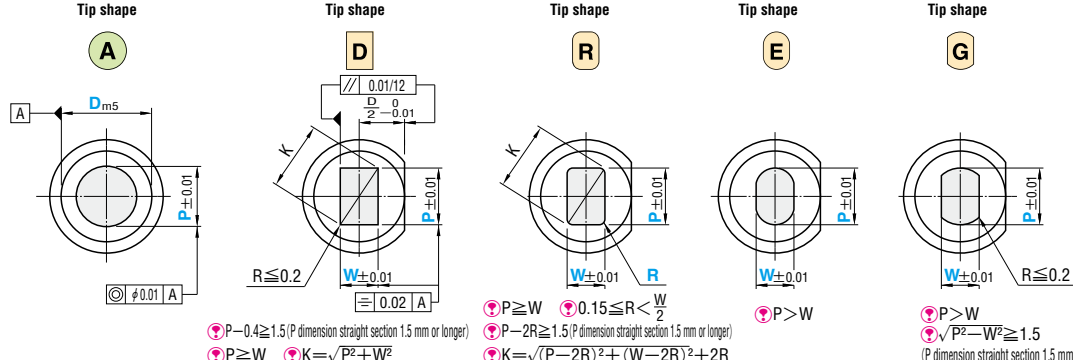
A

D

R

E


G



Ⓢ $P-0.4 \geq 1.5$ (P dimension straight section 1.5 mm or longer)
Ⓢ $P \geq W$ Ⓢ $K = \sqrt{P^2 + W^2}$

Ⓢ $P-2R \geq 1.5$ (P dimension straight section 1.5 mm or longer)
Ⓢ $P \geq W$ Ⓢ $0.15 \leq R < \frac{W}{2}$
Ⓢ $K = \sqrt{(P-2R)^2 + (W-2R)^2} + 2R$

—Straight type—



RoHS

M H

D

Equivalent to SKD11 60~63HRC

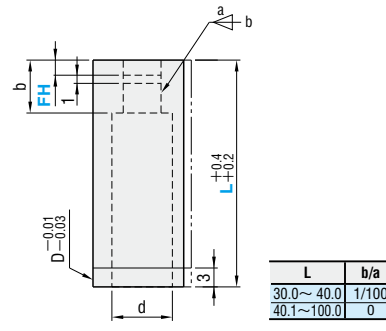
Catalog No.

D6~56

A SRTS—MSD
D SRTS—SDD
R SRTS—SDR
E SRTS—SDE
G SRTS—SDG

D8~56

A SRTS—MSDS
D SRTS—SDDS
R SRTS—SDRS
E SRTS—SDES
G SRTS—SDGS



L b/a

30.0~40.0	1/100
40.1~100.0	0

Ⓢ P dimension will change if regrinding is applied. Note that the change amount varies with the taper width (max.0.5mm on one side) and taper depth & regrinding amount.

Tip shape

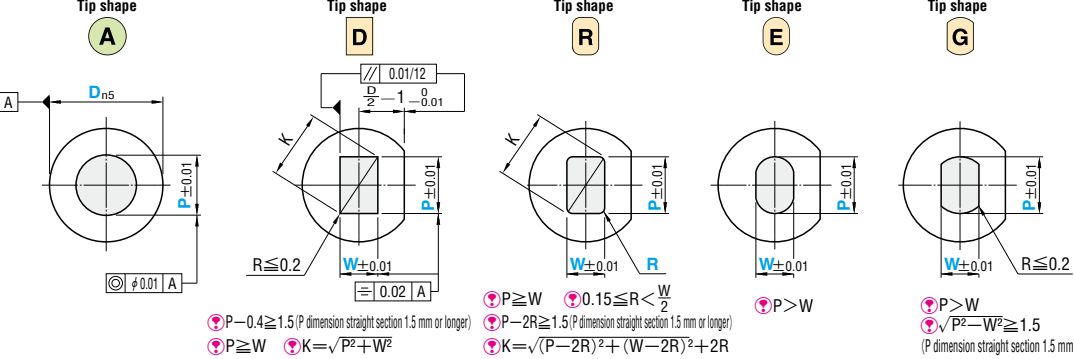
A

D

R

E

G



Ⓢ $P-0.4 \geq 1.5$ (P dimension straight section 1.5 mm or longer)
Ⓢ $P \geq W$ Ⓢ $K = \sqrt{P^2 + W^2}$

Ⓢ $P-2R \geq 1.5$ (P dimension straight section 1.5 mm or longer)
Ⓢ $P \geq W$ Ⓢ $0.15 \leq R < \frac{W}{2}$
Ⓢ $K = \sqrt{(P-2R)^2 + (W-2R)^2} + 2R$

D tolerance			Catalog No.		D	0.1 mm increments L	0.01mm increments					MT (workpiece material thickness)	C (clearance)	Select TS (Tensile strength (N/mm ²))	FH (Taper depth)	b	d
D	m5	n5	Type	Type			A	D	R	E	G						
6	+0.009 +0.004	+0.013 +0.008		Headed type (D _{m5})	Straight type (D _{n5})	6	2.00~3.00	3.00	2.00						1.0~2.0	3	3.4
8	+0.012 +0.006	+0.016 +0.010				8	2.00~4.00	4.00	2.00						1.0~3.0	4	4.4
10	+0.015 +0.007	+0.020 +0.012		A SRTS—MHD	SRTS—MSD	10	2.00~6.00	6.00	2.00						1.0~5.0	6	6.4
13	+0.017 +0.008	+0.024 +0.015		D SRTS—HDD	SRTS—SDD	13	3.00~8.00	8.00	2.00								8.4
16	+0.017 +0.008	+0.024 +0.015		R SRTS—HDR	SRTS—SDR	16	5.00~10.00	10.00	2.00								10.6
20	+0.020 +0.009	+0.028 +0.017		E SRTS—HDE	SRTS—SDE	20	7.00~12.00	12.00	3.00								12.6
25	+0.020 +0.009	+0.028 +0.017		G SRTS—HDG	SRTS—SDG	25	10.00~16.00	16.00	3.00								16.6
32	+0.024 +0.011	+0.033 +0.020				32	15.00~20.00	20.00	4.00								20.6
38	+0.024 +0.011	+0.033 +0.020				38	19.00~26.00	26.00	5.00								26.6
45	+0.024 +0.011	+0.033 +0.020				45	25.00~35.00	35.00	6.00								36.0
50	+0.024 +0.011	+0.033 +0.020				50	33.00~40.00	40.00	7.00								41.0
56	+0.024 +0.011	+0.033 +0.020				56	38.00~45.00	45.00	8.00								46.0
10	+0.012 +0.006	+0.016 +0.010		Headed type (D _{m5})	Straight type (D _{n5})	10	2.00~6.00	6.00	2.00						1.0~5.0	6	6.4
13	+0.015 +0.007	+0.020 +0.012		A SRTS—MHDS	SRTS—MSDS	13	3.00~8.00	8.00	2.00								8.4
16	+0.017 +0.008	+0.024 +0.015		D SRTS—HDDS	SRTS—SDDS	16	5.00~10.00	10.00	2.00								10.6
20	+0.017 +0.008	+0.024 +0.015		R SRTS—HDRS	SRTS—SDRS	20	7.00~12.00	12.00	3.00								12.6
25	+0.020 +0.009	+0.028 +0.017		E SRTS—HDES	SRTS—SDES	25	10.00~16.00	16.00	3.00								16.6
32	+0.020 +0.009	+0.028 +0.017		G SRTS—HDGS	SRTS—SDGS	32	15.00~20.00	20.00	4.00								20.6
38	+0.024 +0.011	+0.033 +0.020				38	19.00~26.00	26.00	5.00								26.6
45	+0.024 +0.011	+0.033 +0.020				45	25.00~35.00	35.00	6.00								36.0
50	+0.024 +0.011	+0.033 +0.020				50	33.00~40.00	40.00	7.00								41.0
56	+0.024 +0.011	+0.033 +0.020				56	38.00~45.00	45.00	8.00								46.0

Ⓢ D (6) → The D=6 straight type is a specification available for shape(A) (round) only. It is not available for shapes (D, R, E, G).
 Ⓢ L (40.01) → When LKC-LKZ is selected, select an L dimension of 40.01 or larger.
 Ⓢ P dimension will change if regrinding is applied. Note that the change amount varies with the taper width (max.0.05mm on one side) and taper depth & regrinding amount.

Order **Catalog No.** — **L** — **P** — **W** — **R (R only)** — **MT** — **C** — **TS** — **FH**

SRTS—MHD 10 — 35.1 — P5.00 — MT1.5 — C0.105 — H — FH2.0
 SRTS—HDRS 20 — 65 — P8.00 — W8.00 — R0.40 — MT1.5 — C0.105 — H — FH2.0

Days to Ship **Quotation** **P** Price **Quotation**

P Price **Quotation**

Alterations **Catalog No.** — **L** — **P(PC)** — **W(WC)** — **R** — **MT** — **C** — **TS** — **FH** — (HC-TC...etc.)

SRTS—MHD 13 — 35 — PC8.02 — MT1.5 — C0.105 — H — FH2.0 — TC4.0

Alterations	Code	A	D R E G	1Code
Alterations to shaped hole	PC WC	Shaped hole diameter change min. $P > \frac{PC}{WC} \geq 2.00$ 0.01mm increments max. $P < \frac{PC}{WC} \leq P \cdot K_{max} + 0.2$ 0.01mm increments		Quotation
Full length	LKC LKZ	Full length tolerance change $L \pm 0.4 \rightarrow +0.05$ Full length tolerance change $L \pm 0.4 \rightarrow +0.01$		
Head	KC	Addition of single key flat to head	Key flat position change 1° increments	
		Addition of single key flat	Key flat position change 1° increments	

Alterations	Code	A	D R E G	1Code
Alterations to head	WKC	Addition of double key flats in parallel Ⓢ Can be combined with KC for shapes (D, R, E, G). Ⓢ Cannot be used for D6 straight type.		Quotation
	KFC	Double key flats at 0° and a selected angle 1° increments Ⓢ Cannot be combined with KC-WKC. Ⓢ Cannot be used for L (L<16 or L>25). Ⓢ Cannot be used for straight types.		
Others	HC	Head diameter change $D \leq HC < (D+3)$ 0.01mm increments		
	TC	Head thickness change 0.1mm increments (if combined with TKC-TKM, 0.01 mm increments can be selected). Full length remains as specified.	$2 \leq TC < 5$	
	TKC	Head thickness tolerance change	$T \pm 0.3 \rightarrow +0.02$ $0 \rightarrow -0.02$	
	TKM	Head thickness tolerance change	$T \pm 0.3 \rightarrow +0.02$ $0 \rightarrow -0.02$	
	RC	Can be used for headed types only. Head thickness is machined to a tolerance of -0.04 ~ 0 relative to the retainer surface.		
	SKC	Single key flat on shank Ⓢ Can be used for headed types only. Ⓢ Can be used for D ≥ 8. Ⓢ Cannot be combined with KC-WKC-KFC. Ⓢ Cannot be used for straight types.		