JECTOR BLOCK PUNCHES
—DOUBLE FLANGES—

RoHS

M H	Catalog No.		
	Type	Tip shape	B Tip length
Equivalent to SKD11 60~63HRC	HJW	D R E G	S / L
Equivalent to SKH51 61~64HRC	HSJW		
Powdered high-speed steel 64~67HRC	PHJW		Tip length (B) L>S

Tip shape D
Tip shape R
Tip shape E
Tip shape G

$1.5 \, ^{0}_{-0.1}$ $H \, ^{+0.01}_{0}$ $1.5 \, ^{0}_{-0.1}$

$V \, ^{+0.01}_{0}$ $P \pm 0.01$

$W \pm 0.01$ $R \le 0.2$ (D)
$W \pm 0.01$ R (R)
$W \pm 0.01$ (E)
$W \pm 0.01$ $R \le 0.2$ (G)

R10
ℓ
M
$5 \, ^{+0.2}_{0}$ $B \, ^{+0.3}_{0}$ $L \, ^{+0.2}_{0}$

Details of flange $R \le 0.3$

- W≦P (D) R=0 can be selected.
- W≦P (R) 0.15≦R<W/2 0.01mm increments
- W≦P (E)
- W<P≦W×20 (G)

Even when P=V and W=H, the tip tolerance is determined by the P and W tolerances.

Catalog No.				V P min.	6	8	10	13	16	20	22	25	28	30	L	B		M	ℓ
Type	Tip shape	B Tip length	H W min.		3.0	3.0	4.0	5.0	7.0	8.0	9.0	10.0	12.0	12.0		S / L			
HJW HSJW PHJW	D R E G	S	6	2.0	○	○	○	○	○	○	○	○	○	○	(40)	8	13	4	
			8	2.5		○	○	○	○	○	○	○	○	○	(40)			5	
			10	3.0			○	○	○	○	○	○	○	○	(50)	13	19	6	12
			13	4.0				○	○	○	○	○	○	○	(50)				
		L	16	5.0					○	○	○	○	○	○	60				
			20	6.0						○	○	○	○	○	70	19	25	8	
			22	6.0							○	○	○	○	80				
			25	6.0								○	○	○	80				

- L(40) ⋯B=6 If full length is (40), tip length is 6mm in all cases.
- L(50)・H10~25⋯B=13 If full length is (50) and H dimension is 10~25, tip length is 13mm in all cases.

Order

■Flange position: WF specification

WF0
WF90

(1) If tip is at center of shank

Catalog No. V H L — P — W — R(R only) WF
HJWES 08 06 — 60 — P6.00 — W5.00 — WF0

(2) If tip is not at center of shank

Catalog No. V H L — P — W — R(R only) WF X—Y
HJWES 13 10 — 60 — P10.00 — W8.00 — WF90 — X0.00 — Y0.10

X and Y must be set either to 0 or to 0.02 or more. Tolerance ±0.01

H	Zmin.
6・8	1.0
10・13	1.5
16~25	2.0

When the tip position is changed, the jector hole must be located at least Zmin. away from the tip edges.
The jector hole position cannot be changed.

Days to Ship Quotation

Alterations

Catalog No. V H (L/LC) — P—W—R WF X—Y — (BC-PKC, etc.)
HJWES 10 10 — 60 — P8.00 — W7.80 — WF0 — BC10.5

Price Quotation

Alteration		Code	Spec.	1Code
Alterations to tip		BC	Tip length change (shorter than standard) 2≦BC<B 0.1mm increments	
		SC	Lapping of tip W≧2.00 P dimension tolerance and increment remain the same. R=0 cannot be selected for the tip D corner.	
		PKC	Tip tolerance change $P \cdot W \pm 0.01 \Rightarrow \, ^{+0.01}_{0}$	
		PKV	Tip tolerance change $P \cdot W \pm 0.01 \Rightarrow \pm 0.005$	
Alterations to full length		LC	Full length change LC<L 0.1mm increments (If combined with LKC・LKZ, 0.01mm increments can be selected.) Tip length B is shortened by (L—LC).	
		LKC	Full length tolerance change $L \, ^{+0.2}_{0} \Rightarrow \, ^{+0.05}_{0}$	
		LKZ	Full length tolerance change $L \, ^{+0.2}_{0} \Rightarrow \, ^{+0.01}_{0}$	
Alterations to flange		HC	Flange width change 0≦HC<1.5 0.1mm increments	Quotation
		TC	Flange thickness change 3.5≦TC<5 0.1mm increments (If combined with TKC, 0.01mm increments can be selected.) Full length L is shortened by (5—TC). If combined with LC, full length is equal to LC.	
		TKC	Flange thickness tolerance change $T \, ^{+0.2}_{0} \Rightarrow \, ^{+0.02}_{0}$	
		TKM	Flange thickness tolerance change $T \, ^{+0.2}_{0} \Rightarrow \, ^{0}_{-0.02}$	
		FK	Relief chamfering to flange top edge Flange edge is chamfered to prevent flange breakage.	
Alterations to shape		CC	Chamfering to four corners of shank The four corners of shank are chamfered to C0.5. The distance between shank corners and the tip must be 0.5mm or more.	
		JVC	Change of spring to reinforced type 8≦H≦25⋯Can be used with L≧60. Cannot be used for H6.	
		AC	The jector pin is removed to create an air path and the side vent hole is plugged from the inside by inserting a resin (ABS) ring.	
		NC	The jector pin is removed. Cannot be combined with AC.	
		VKC	Shank tolerance change $V \cdot H \, ^{+0.01}_{0} \Rightarrow \, ^{+0.005}_{0}$	
		VKM	Shank tolerance change $V \cdot H \, ^{+0.01}_{0} \Rightarrow \, ^{0}_{-0.005}$	
		VHM	Shank tolerance change $V \cdot H \, ^{+0.01}_{0} \Rightarrow \, ^{0}_{-0.01}$	
		VHZ	Shank tolerance change $V \cdot H \, ^{+0.01}_{0} \Rightarrow \pm 0.005$	

■Flange holder ▷ P.465

HFW

BLOCK PUNCHES