

# JECTOR BLOCK PUNCHES

—TiCN COATING—

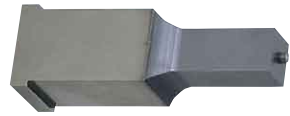
PRODUCTS DATA

P.1604

Details of jector hole, refer to JECTOR BLOCK PUNCH BLANK P.461

—TiCN coating—

**TiCN**  
**3000HV**  
Although the effective range of the coating is part B, an extremely thin coating film is formed also on the shank up to a length of approximately 10mm.



### Tip machining limit



W ≤ P      W ≤ P  
R=0 can be selected.      0.15 ≤ R < W/2  
0.01mm increments

Even when P=V and W=H, the tip tolerance is determined by the P and W tolerances.  
The tip end is ground before the coating is applied.

| Material                           | Catalog No. |           | Tapped     |            | Tip shape | Tip shape | Tip shape | Tip shape |
|------------------------------------|-------------|-----------|------------|------------|-----------|-----------|-----------|-----------|
|                                    | Type        | Tip shape | Tip length | Tip length |           |           |           |           |
| Equivalent to SKH51 61~64HRC       | H-HSJM      | D         | S          |            | D         | R         | E         | G         |
| Powdered high-speed steel 64~67HRC | H-PHJM      | E         | L          |            | D         | R         | E         | G         |
| Equivalent to SKH51 61~64HRC       | H-HSJK      | D         | S          |            | D         | R         | E         | G         |
| Powdered high-speed steel 64~67HRC | H-PHJK      | E         | L          |            | D         | R         | E <td G   |           |
| Equivalent to SKH51 61~64HRC       | H-HSJF      | D         | S          |            | D         | R         | E         | G         |
| Powdered high-speed steel 64~67HRC | H-PHJF      | E         | L          |            | D         | R         | E         | G         |
| Equivalent to SKH51 61~64HRC       | H-HSJW      | D         | S          |            | D         | R         | E         | G         |
| Powdered high-speed steel 64~67HRC | H-PHJW      | E         | L          |            | D         | R         | E         | G         |

| Catalog No.     | Type   | Tip shape | Tip length | H  | W   | P | V   |     |     |     |     |     |     |      |      |      |        | L  | 0.1mm | B | M   | ℓ   | U |
|-----------------|--------|-----------|------------|----|-----|---|-----|-----|-----|-----|-----|-----|-----|------|------|------|--------|----|-------|---|-----|-----|---|
|                 |        |           |            |    |     |   | 6   | 8   | 10  | 13  | 16  | 20  | 22  | 25   | 28   | 30   |        |    |       |   |     |     |   |
| Tapped          | H-HSJM | D         | S          | 6  | 2.0 |   | 3.0 | 3.0 | 4.0 | 5.0 | 7.0 | 8.0 | 9.0 | 10.0 | 12.0 | 12.0 | (40)   | 8  | 13    | 4 | 5   | 1.0 |   |
| With key groove | H-HSJK | R         | S          | 10 | 3.0 |   |     |     |     |     |     |     |     |      |      | (50) | 13     | 19 | 6     |   | 1.5 |     |   |
| Single flange   | H-HSJF | E         | L          | 13 | 4.0 |   |     |     |     |     |     |     |     |      |      | 60   | T ≥ 20 |    |       |   |     |     |   |
| Double flanges  | H-PHJF | G         | L          | 16 | 5.0 |   |     |     |     |     |     |     |     |      |      | 70   |        | 19 | 25    | 8 |     |     |   |
|                 | H-HSJW |           |            | 20 | 6.0 |   |     |     |     |     |     |     |     |      |      |      | 80     |    |       |   |     |     |   |
|                 |        |           |            | 22 | 6.0 |   |     |     |     |     |     |     |     |      |      |      |        |    |       |   |     |     |   |
|                 |        |           |            | 25 | 6.0 |   |     |     |     |     |     |     |     |      |      |      |        |    |       |   |     |     |   |

L (40) → B=6 If full length is (40), tip length is 6mm in all cases.  
L (50) → H10~25 → B=13 (10) If full length is (50) and H dimension is 10~25, tip length is 13mm in all cases. (For types with key grooves, the tip length is 10mm.)

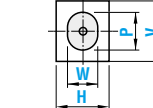


### Key groove position - flange position change

| With key groove | K0 | K90 | K180 | K270 | Single flange | F0 | F90 | F180 | F270 | Double flanges | WF0 | WF90 |
|-----------------|----|-----|------|------|---------------|----|-----|------|------|----------------|-----|------|
|                 |    |     |      |      |               |    |     |      |      |                |     |      |

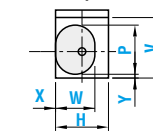
(1) If tip is at center of shank

| Catalog No. | V  | H  | L  | P      | W      | R (R only) | T ≥ 20 | K · F · WF |
|-------------|----|----|----|--------|--------|------------|--------|------------|
| H-HSJMRL    | 20 | 10 | 70 | P16.00 | W9.00  | R0.15      |        |            |
| H-PHJKES    | 08 | 06 | 60 | P7.00  | W5.00  |            |        | T25.5 - K0 |
| H-HSJFDL    | 16 | 13 | 60 | P15.00 | W12.00 |            |        | F90        |
| H-HSJWEL    | 13 | 10 | 40 | P8.00  | W5.00  |            |        | WF90       |



(2) If tip is not at center of shank

| Catalog No. | V  | H  | L  | P      | W      | R (R only) | T ≥ 20 | K · F · WF | X - Y         |
|-------------|----|----|----|--------|--------|------------|--------|------------|---------------|
| H-HSJFDL    | 16 | 13 | 50 | P15.00 | W12.00 |            |        | F90        | X0.00 - Y0.55 |



X and Y must be set either to 0 or to 0.02 or more. Tolerance ±0.01. If X and Y are 0, an additional coating layer of 3~5 μm is added.

| 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



Price



Alterations Catalog No. V H L(LC) P-W-R T K·F·WF X-Y (BC·HC·TC, etc.)  
H-HSJMDS 20 08 - 60 - P18.00 - W3.50 - LKC

| Alteration                 | Code | Spec.   | 1Code     |
|----------------------------|------|---|-----------|
| Tip                        | BC   | Tip length change (shorter than standard) 2 ≤ BC ≤ B 0.1mm increments   |           |
| Alterations to full length | LC   | Full length change LC < L 0.1mm increments (if combined with LKC, 0.01mm increments can be selected.) Tip length B is shortened by (L-LC).  |           |
| Key groove                 | LKC  | Full length tolerance change L +0.2 / 0 → +0.05 / 0   |           |
|                            | TKC  | Key groove position tolerance change T -0.05 / -0.02 → -0.05 / +0.05  |           |
| Alterations to flange      | RTC  | Key groove position tolerance change T -0.05 / +0.05  |           |
|                            | UK   | Key groove depth change 0.5 ≤ UK ≤ U + 0.2 0.1mm increments Can be used for H ≥ 10 (K0, K180) V ≥ 10 (K90, K270).   |           |
| Alterations to shape       | HC   | Flange width change 0 ≤ HC < 1.5 0.1mm increments   |           |
|                            | 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. | Quotation |
|                            | TKC  | Flange thickness tolerance change T +0.2 / 0 → +0.02 / 0  |           |
|                            | TKM  | Flange thickness tolerance change T +0.2 / 0 → -0.02 / 0  |           |
| Shape                      | FK   | Relief chamfering to flange top edge Flange edge is chamfered to prevent flange breakage.   |           |
|                            | JVC  | Change of spring to reinforced type 8 ≤ H ≤ 25 → Can be used for L ≥ 60 Cannot be used for H6.  |           |

| Alteration           | Code | Spec.  | 1Code     |
|----------------------|------|--|-----------|
| 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.   |           |
| Alterations to shape | AC   | AIR 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.   |           |
| Alterations to shape | CCP  | Chamfering to one corner of shank (for error prevention) One corner of shank is chamfered to C1.0. Can be used if distances a and b from tip corners to shank meet the following conditions. a + b ≥ 1.3 | Quotation |
|                      | VKC  | Shank tolerance change V · H +0.01 / 0 → +0.005 / 0  |           |
|                      | VKM  | Shank tolerance change V · H +0.01 / 0 → -0.005 / 0  |           |
|                      | VHM  | Shank tolerance change V · H +0.01 / 0 → -0.01 / 0   |           |
| Alterations to shape | VHZ  | Shank tolerance change V · H +0.01 / 0 → ±0.005  |           |
|                      | DC   | Addition of press-in lead Press-in lead of 3mm (V · H - 0.03) is added. Can be used for tapped types and key groove types.   |           |