ROUND CORE PINS FOR BOSS

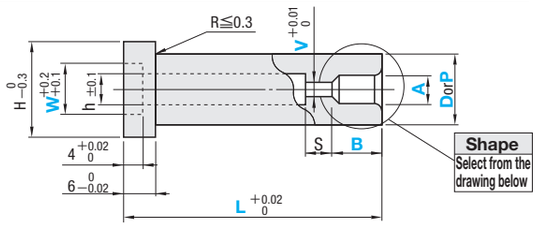
—GAS RELEASE HOLE TYPE—

Refer to "Core Sleeves" in P.529 · P.531 for the shape of boss height 4mm or more.

Non JIS material definition is listed on P.1351 - 1352

RoHS

Type		M	H	T		
Shaft diameter (D) selection type	Shaft diameter (P) designation type		HRC	DorP	A	B
GV—BCHS—□□	GV—BCHBS—□□	SKH51 equivalent	~	—	—	±
GV—BCVS—□□	GV—BCVBS—□□				—	



■Counterbore Hole Diameters

W dimension is determined depending on V dimension.

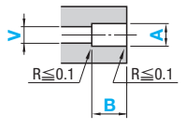
W	V
3	0.80~1.50
4	1.51~2.00
5	2.01~2.50
6	2.51~3.00
7	3.01~4.00

h=V+(0.2~0.4)

Concave part is applied with electric discharge finishing. (0.4▽)

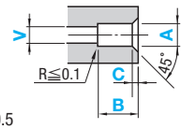
Shape

SS



V≦A—0.5

CS

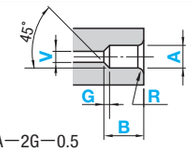


V≦A—0.5

0.2≦C≦0.5

C≦{(DorP)—A—0.2}/2

RG

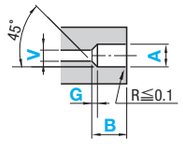


V≦A—2G—0.5

0.3≦R≦0.5

0.25≦G≦1.0 A≧2G+0.5

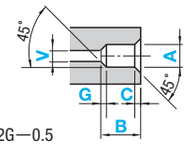
SG



V≦A—2G—0.5

0.25≦G≦1.0 A≧2G+0.5

CG



V≦A—2G—0.5

0.2≦C≦0.5 0.25≦G≦1.0

C≦{(DorP)—A—0.2}/2 A≧2G+0.5

■Unit of designation

T	Unit of designation
C±0.1	0.05mm increments
R±0.1	
G±0.1	
B±0.02	0.01mm increments

■Shaft Diameter (D) Selection Type

H	S	Part Number			0.01mm increments			
		Type	Shape	D	L	A	B	V
6	5	GV—BCHS— GV—BCVS—	SS SG CS CG RG	3	10.00~60.00	1.50≦A≦D—1	0.50≦B≦4.00 and B≦3×A	Shape SS・CS 0.80≦ V≦A—0.5
7				3.5				
				4				
8				4.5				Shape SG・CG・RG 0.80≦ V≦A—2G—0.5
				5		1.50≦A≦D—1.5		
9				5.5				
				6				

■Shaft Diameter (P) Designation (0.01mm increments) Type

H	S	Part Number			0.01mm increments				
		Type	Shape	No.	L	P	A	B	V
6	5	GV—BCHBS— GV—BCVBS—	SS SG CS CG RG	3*	10.00~60.00	2.50~2.99	1.50≦A≦P—1	0.50≦B≦4.00 and B≦3×A	Shape SS・CS 0.80≦ V≦A—0.5
7				3.5		3.00~3.49			
				4		3.50~3.99			
8				4.5		4.00~4.49			Shape SG・CG・RG 0.80≦ V≦A—2G—0.5
				5		4.50~4.99	1.50≦A≦P—1.5		
9				5.5		5.00~5.49			
				6		5.50~5.99			

*No.3 is applicable only to Shape SS・CS.

Order

Part Number	L	P	A	B	V	C・R・G
(Shaft diameter (D) selection type) GV—BCVS— CG4	38.00		A2.50	B2.50	V1.50	C0.5—G0.25
(Shaft diameter (P) designation type) GV—BCHBS—SG3	50.00	P2.80	A1.80	B3.00	V0.80	G0.25

Days to Ship: Quotation

Price: Quotation

Alterations

Part Number	L	P	A	B	V	Tip size (C・R・G)	(KC・WKC…etc.)
GV—BCVS— CG4	38.00		A3.00	B2.50	V1.50	C0.3 —G0.3	RKC3.0
GV—BCHBS—CG6	50.00	P5.70	A4.00	B3.00	V2.50	G0.5	TRN

Alteration details P.495

Alterations	Code	Spec.	1Code
KC 0 −0.01	KC	Single flat cutting (DorP)/2≦KC＜H/2	Quotation
WKC 0 −0.01	WKC	Two flats cutting (DorP)/2≦WKC＜H/2	
KAC KBC 0 −0.01	KAC KBC	Varied width parallel flats cutting (DorP)/2≦KAC＜H/2 KBC=0.1mm increments only KAC＜KBC＜H/2	
RKC RKC 0 −0.01	RKC	Two flats (right angled) cutting (DorP)/2≦RKC＜H/2	
DKC DKC 0 −0.01	DKC	Three flats cutting (DorP)/2≦DKC＜H/2	
SKC SKC 0 −0.01	SKC	Four flats cutting (DorP)/2≦SKC＜H/2	
AG° ±0.5 0° KGC 0 −0.01 KGC	KGC	Two flats (angled) cutting (DorP)/2≦KGC＜H/2 AG=1° increments 0＜AG＜360	
120° 120° 120° KTC 0 −0.01	KTC	Three flats cutting at 120° (DorP)/2≦KTC＜H/2	

About Designation Unit for Key Flat Cutting

(1)To align the key flat with the shaft diameter

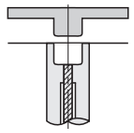
Unit of designation
- Shaft diameter (D) selection type 0.05mm increments possible
- Shaft diameter (P) designation type 0.005mm increments possible

(2)To designate arbitrary key flat dimensions

Unit of designation 0.1mm

Alterations	Code	Spec.	1Code
L T	LKC	Changes L dimension tolerance L +0.02 0 …→ L +0.01 0	Quotation
H HC 0 −0.3	HC	Head diameter change HC=0.1mm increments (DorP)≦HC＜H,W+1.2≦HC In relation to the diameter tolerance, alteration may create a straight piece with little diameter difference between the head and shaft.	
H HCC 0 −0.02	HCC	Head diameter change (precision) HCC=0.1mm increments (DorP)+0.5≦HCC＜H—0.3	
	TRN	Relief under the head (Makes plate chamfering unnecessary)	

Note that finished products may not release if the core pin's A／B ratio, material, molding conditions, etc. are inappropriate.



Characteristics

This core pin is appropriate for precisely processing the positioning boss of molding products.

The diameter tolerance of the boss is set to $-\frac{0}{0.02}$ ／ $-\frac{0}{0.01}$ and a minus side. Then the assembly of the molding product and the alignment adjustment can be simply done.

Short shot and gas bake in molding can be surely prevented, because gas relief hole is designed on the boss tip. Decreases the cavity filling pressure of resin.

* Due to the filling pressure decreasing, break and burr of pins and residual distortion of molding products are reduced.

Example