

JECTOR PUNCHES FOR HEAVY LOAD

— FINISHED FOR RETAINERS · CONFIGURABLE FULL LENGTH · FIXED B TYPE · SPRING AND PIN REINFORCED TYPE · TiCN COATING —



※ Jector punch which maintains the same tip length B even when L is changed.
 ● For details of jector holes, refer to Jector Punch Blanks. P.238
 ● For details of jector pins, refer to Jector Pin Sets. P.241

Type	Shank diameter D Tolerance	M H	Catalog No.		The tip shape can be selected from [Tip shape] A~G in the figure below.
			Type	Tip shape B Tip length	
	Dm5		H—LFAPJ Spring and pin reinforced type H—LFAPJV		
For shank diameter tolerance D, select either m5 or $^{+0.005}_0$.					

Type	Tip shape	Tip length	D	L	0.01mm increments			B	H
					0.1mm increments	(A) min. P max.	D R E G P · Kmax. P · Wmin.		
(Dm5) H—LFAPJ —Spring and pin reinforced type— H—LFAPJV		8	8	60.0~130.0	4.00~ 7.99	7.97	4.00	13 15 18 21 25	13
		10	10	70.0~130.0	5.00~ 9.99	9.97	5.00		
		13	13	70.0~100.0	6.00~ 12.99	12.97	6.00		
		16	16	70.0~130.0	10.00~ 15.99	15.97	6.00		
		20	20	80.0~100.0	13.00~ 19.99	19.97	6.00		
(D $^{+0.005}_0$) AH—LFAPJ —Spring and pin reinforced type— AH—LFAPJV		8	8	70.0~130.0	4.00~ 7.99	7.97	4.00	19 21 25 30	19
		10	10	70.0~100.0	5.00~ 9.99	9.97	5.00		
		13	13	70.0~100.0	6.00~ 12.99	12.97	6.00		
		16	16	80.0~130.0	10.00~ 15.99	15.97	6.00		
		20	20	80.0~100.0	13.00~ 19.99	19.97	6.00		
		25	25	18.00~ 24.99	24.97	6.00			

● The spring constants of H—LFAPJV and AH—LFAPJV are twice those of H—LFAPJ and AH—LFAPJ respectively.
 ● A: P>D—0.03 → ℓ=0 If P>D—0.03 for a round punch, D $^{+0.01}_0$ (press-in lead) is not included.
 ● D R E G: P·K>D—0.05 → ℓ=0 If P·K>D—0.05 for a shaped punch, D $^{+0.01}_0$ (press-in lead) is not included.
 ● Jector holes are based on the jector punch blanks for heavy load. P.238

Order — — — —
 H—LFAPJAS 20 — 80 — P15.00

Effect of spring and pin reinforced type
 The spring constant is twice that of the standard type, resulting in improved scrap removal. In addition, the improved strength under the pin head prevents breakage below the head.

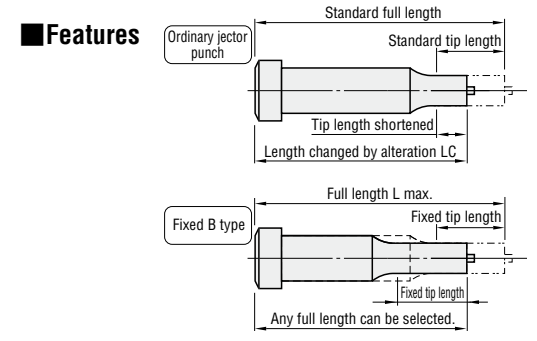
Days to Ship **Quotation**

Alterations — — — — — (BC·KC, etc.)
 H—LFAPJAS 20 — 79 — P15.00 — W6.00 — BC13

Alteration	Code	(A)	D R E G	1Code
Alterations to tip	BC	Tip length change (shorter than standard) 2 ≤ BC < B 0.1 mm increments		
	SC	Lapping of tip P dimension tolerance and increment are the same. The base material is finished before the coating is applied. R=0 cannot be selected for the tip shape D corners.		
	PRC	Rounding of tip side edge 0.3 ≤ PRC ≤ 1.0 mm increments P dimension tolerance and increment are the same. P dimension can be selected in 0.01 mm increments. Cannot be combined with PCC. Cannot be used for D > 13.		
	PCC	Chamfering to tip side edge 0.3 ≤ PCC ≤ 1.0 mm increments PCC ≤ (P - d) / 2 d, dimension P.238 Cannot be combined with PRC.		
	PKC	Tip tolerance change P + 0.01 → +0.005 W ± 0.01 → +0.01 P dimension can be selected in 0.01 mm increments. Cannot be used for D > 13.	Tip tolerance change P - W ± 0.01 → +0.01	
Alterations to full length	LKC	Full length tolerance change L + 0.3 → +0.05 0 → 0		

Alteration	Code	(A)	D R E G	1Code
Alterations to head	KC	Addition of single key flat to head	Key flat position change 1° increments	
	WKC	Addition of double key flats in parallel	Double key flats in parallel Can be combined with KC.	
	KFC	Double key flats at 0° and a selected angle 1° increments Cannot be combined with WKC.	Double key flats at 0° and a selected angle 1° increments Cannot be combined with KC·WKC.	
	NKC	No key flat		
Alterations to shank	SKC	Single key flat on shank P ≤ D - 2.2 W ≤ D - 2.2 (Machining width 1) Cannot be combined with KC·WKC·KFC.		
	NC	The jector pin is removed.		
	NDC	No press-in lead ℓ ≥ 3 → ℓ = 0		

Price **Quotation**



- Whereas the tip length B gets shortened when alteration LC is added to an ordinary jector punch, a fixed B type maintains the same tip length B for any L dimension.
- Because a fixed B type jector punch has no side hole on the shank, it can be used as an air blow punch simply by removing the jector pin.

PUNCHES