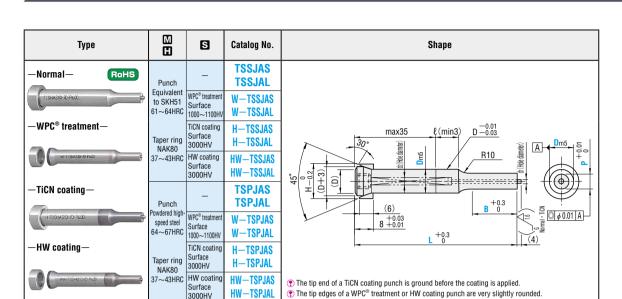
TAPERED HEAD JECTOR PUNCHES

-NORMAL·WPC® TREATMENT·TICN COATING·HW COATING-



Catalog No.			0.1 mm increments	0.01mm increments	В	н	d₁	d ₂
Туре		D	L	min. P max.			u ₁	uz
TSSJAS	-WPC® treatment -	8	50.0∼ 80.0	4.00∼ 7.99		13	1.5	3.4
TSPJAS	W—TSSJAS W—TSPJAS	10	55.0∼ 90.0	5.00∼ 9.99	13	15	1.8	
-TiCN coating-	-HW coating- HW-TSSJAS HW-TSPJAS	13	65.0∼ 100.0	6.00∼ 12.99		18	2.8	4.4
H—TSPJAS		16	05.0~ 100.0	10.00~ 15.99	19	21	2.0	
TSSJAL TSPJAL -TICN coating— H—TSSJAL H—TSPJAL	-WPC® treatment- W-TSSJAL W-TSPJAL -HW coating- HW-TSSJAL HW-TSPJAL	8	60.0~ 80.0	4.00~ 7.99		13	1.5	3.4
		10	60.0~ 90.0	5.00∼ 9.99	19	18	1.8	
		13	70.0~ 100.0	6.00∼ 12.99		15	2.8	4.4
		16	70.0 ~ 100.0	10.00~ 15.99	25	21	2.0	

The tip edges of a WPC® treatment or HW coating punch are very slightly rounded

HW-TSPJAL

 \P P>D-0.03···· ℓ =0 If P>D-0.03, D^{-0.01}_{-0.03} (press-in lead) is not included. Jector holes are based on the jector punch blanks for heavy load. F.238







Days to Ship Quotation



Quotation









Alteration		Code	Spec.	1Code	
	BCBC	ВС	Tip length change (shorter than standard) 2≦BC≦B 0.1 mm increments		
Alterations to tip	0.16 GL	SC	Lapping of tip P dimension tolerance and increment are the same. Cannot be used with TiCN coating, WPC® treatment and HW coating.	ation	
	PRC±0.05	PRC	Rounding of tip side edge 0.3≦PRC≦1 0.1 mm increments PRC≦(P-d,-0.5)/2 ⊗ Cannot be combined with PCC. For WPC®treatment or HW coating, the tolerance is PRC±0.1.	Quotation	
	PCC±0.05	PCC	Chamfering to tip side edge 0.3≦PCC≦1 0.1 mm increments PCC≦(P−d₁−0.5)/2 ⊗ Cannot be combined with PRC. For WPC® treatment or HW coating, the tolerance is PCC±0.1.		

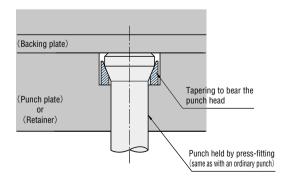
Alteration		Code	Spec.	1Code
Alterations to full length Alterations to tip		PKC	Tip dimension p+0.01 ⇒ +0.005 change p +0.01 ⇒ +0.005 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	
Alterations to full length		LKC	Full length tolerance change $L \stackrel{+0.3}{\underset{0}{\Leftrightarrow}} \rightleftharpoons \stackrel{+0.05}{\underset{0}{\Leftrightarrow}}$	ation
Shank		NC	The jector pin is removed.	Quotatic
NS .	€ D=8.83	NDC	No press-in lead $\ell{\ge}3{\Leftrightarrow}\ell{=}0$	



■ Features

- Tapered head jector punches are designed for punching of stainless steel, high-tensile steel, and for general heavy loads. The strength and convenience are superior to conventional heavy-load jector punches due to improvements to the following points.
- 1)There is no side hole on the shank. Such a hole can be a cause of punch breakage during punching for heavy loads.
- ②A problem with conventional jector punches is that the tip length B is shortened if an LC alteration is used. However tapered head jector punches are designed to maintain the same tip length B for any L dimension.
- When used with the accessory taper rings, the tapered head jector punches eliminate the need for machining of tapered holes in the punch plates and for machining to align the thickness of the plate and punch head.
- Guide to tapered head punches P.1611

- The head thickness tolerance of a tapered head punch, $8^{+0.03}_{+0.01}$, is achieved by machining a match between the actual individual punch and its taper ring. Be sure to use a taper ring that has the same ID mark as the punch.
- If the punch is combined with a tapered ring that has a different ID number, the head thickness may deviate from the tolerance listed in the catalog.
- When a punch is replaced, replace both punch and taper ring as a set. (The punch and taper ring are not sold individually.)



174 173