

JECTOR PUNCHES WITH KEY GROOVES

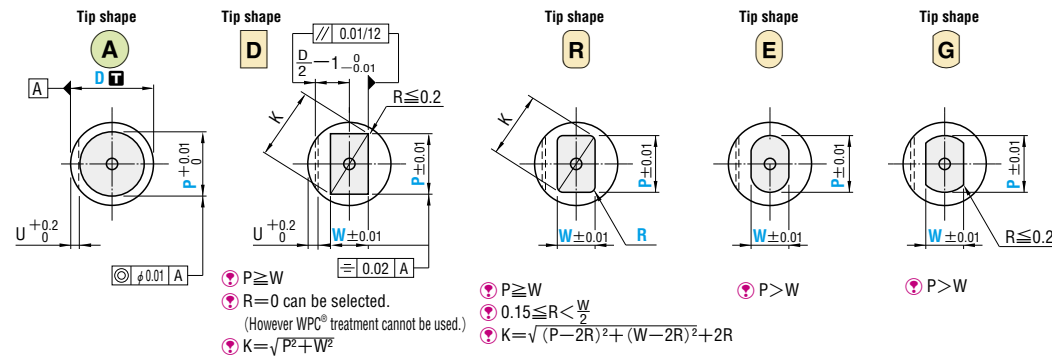
—NORMAL • WPC® TREATMENT—



Calculating the projection length of the jector pin (reference value) P.241

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	
—Normal— 	Dm5		SKJ	A	S	<p>The tip edge of a WPC® treatment punch is very slightly rounded.</p>
—WPC® treatment— 	D+0.005 0	Equivalent to SKD11 60~63HRC —WPC® treatment— Surface 1000~1100HV	WPC® treatment W—SKJ	D	L	
			A—SKJ	E	L	
			WPC® treatment AW—SKJ	G	L	



Type	Tip shape	B Tip length	D	L							0.01mm increments				T	B	U key groove depth	M	
											A	D	R	E					G
											min. P max.	P·Kmax.	P·Wmin.	R					R
(Dm5) SKJ	A	S	6	(40)	50	60	70	80	2.00~5.99	5.97	2.00	0.15 ≤ R < 1/2 (R only)	T > 5.0	8	1.0	3			
			8	(40)	50	60	70	80	90	100	3.00~7.99			7.97	3.00	13	1.5	4	
			10	(40)	50	60	70	80	90	100	3.00~9.99			9.97	3.00	19	1.5	5	
			13	(40)	50	60	70	80	90	100	6.00~12.99			12.97	6.00	19	1.5	6	
—WPC® treatment— W—SKJ	D	L	6		50	60	70	80	2.00~5.99	5.97	2.00	0.15 ≤ R < 1/2 (R only)	T > 5.0	8	1.0	3			
			8		50	60	70	80	90	100	3.00~7.99			7.97	3.00	13	1.5	4	
			10		50	60	70	80	90	100	3.00~9.99			9.97	3.00	19	1.5	5	
			13		50	60	70	80	90	100	6.00~12.99			12.97	6.00	19	1.5	6	
(D+0.005) A—SKJ	R	L	6		50	60	70	80	2.00~5.99	5.97	2.00	0.15 ≤ R < 1/2 (R only)	T > 5.0	8	1.0	3			
			8		50	60	70	80	90	100	3.00~7.99			7.97	3.00	13	1.5	4	
			10		50	60	70	80	90	100	3.00~9.99			9.97	3.00	19	1.5	5	
			13		50	60	70	80	90	100	6.00~12.99			12.97	6.00	19	1.5	6	
—WPC® treatment— AW—SKJ	G	L	6		50	60	70	80	2.00~5.99	5.97	2.00	0.15 ≤ R < 1/2 (R only)	T > 5.0	8	1.0	3			
			8		50	60	70	80	90	100	3.00~7.99			7.97	3.00	13	1.5	4	
			10		50	60	70	80	90	100	3.00~9.99			9.97	3.00	19	1.5	5	
			13		50	60	70	80	90	100	6.00~12.99			12.97	6.00	19	1.5	6	

L(40)→B=6 If full length is (40), tip length is 6mm in all cases.
L(50)→B=13 If full length is (50), tip length is 13 mm in all cases.
If no key groove is required, select T dimension that is the same as the full length L.

Order Catalog No. — L — P — W — R (R only) — T
A—SKJAS 13 — 80 — P8.24 — T20.0

Days to Ship Quotation

Alterations Catalog No. — L(LC-LCT) — P(PC) — W(WC) — R — T — (BC-KC-NKC, etc.)
A—SKJAL 13 — 80 — P8.24 — T20.0 — LKC

Alteration	Code	A	D	R	E	G	1Code
Alterations to tip	PC WC	Tip dimension change PC ≥ PCmin. 0.01 mm increments (If combined with PKC, 0.001 mm increments can be selected.)	Tip dimension change PC·WC ≥ PC·WCmin. 0.01 mm increments				
	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. R=0 cannot be selected for tip shape D corners. Cannot be used with WPC treatment.					
	PRC	Rounding of tip side edge 0.3 ≤ PRC ≤ 1 0.1 mm increments PRC ≤ (P-d)·0.5/2 d, dimension P.238 Cannot be combined with PCC. For WPC treatment, the tolerance is PRC ± 0.1.					
	PCC	Chamfering to tip side edge 0.3 ≤ PCC ≤ 1 0.1 mm increments PCC ≤ (P-d)·0.5/2 d, dimension P.238 Cannot be combined with PRC. For WPC treatment, the tolerance is PCC ± 0.1.					
PKC	Tip tolerance change P+0.01 → +0.005 0 (P dimension can be selected in 0.001 mm increments.)	Tip tolerance change P·W ± 0.01 → +0.01 0					

Price Quotation

Alteration	Code	A	D	R	E	G	1Code
Alterations to full length	LC	Full length change LC < L (reduction in tip length) 0.1 mm increments (If combined with LKC-LKZ, 0.01 mm increments can be selected.) Tip length B is shortened by (L-LC). The projection length of the jector pin is 2 mm.					
	LCT	T dimension tolerance and full length changes are processed using a single code. The allowable range of change, increment, ordering process, and notes (P) are the same as for LC.	TKC	LC	Full length tolerance change L+0.3 → +0.1 0		
	LKC	Full length tolerance change L+0.3 → +0.05 0					
	LKZ	Full length tolerance change L+0.3 → +0.01 0 Cannot be used with WPC treatment.					
Others	KC	Key flat position 90° change 1° increments					
	NKC	No key flat					
	KD	Key groove 90°/180° position change 1° increments					
	WKD	Addition of double key grooves in parallel Double key grooves in parallel. Can be combined with KD.					
	TKC	T dimension tolerance change T+0.05 → 0 0 → -0.02					
	SKC	Single key flat on shank D/2-0.5 → 0 -0.01 D6 P ≤ D-1.2 W ≤ D-1.2 (Machining width 0.5) D8 P ≤ D-2.2 W ≤ D-2.2 (Machining width 1) Cannot be combined with KC-KD-WKD. Cannot be used with WPC treatment.					
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.						

