

JECTOR PUNCHES

—DICOAT® TREATMENT—



Calculating the projection length of the jector pin (reference value) P.185

For details of jector holes, refer to Jector Punch Blanks. P.180
For details of jector pins, refer to Jector Pin Sets. P.185

| Type | Shank diameter D | M H | Catalog No. | | The tip shape can be selected from Tip shape A~G in the figure below. | |
|-----------------------------|--------------------------------|---|-----------------|-----------------------|---|--|
| | | | Type | Tip shape | Tip length | |
| —Dicoat® treatment— RoHS | D _{m5} (D4~25) | Equivalent to SKD11 60~63HRC Surface 3000HV | T-SJ T-SJV | A D R E G | S L | |
| | | | T-PJ T-PJV | | | |
| | D ^{+0.005} (D4~13) | Equivalent to SKD11 60~63HRC Surface 3000HV | AT-SJ AT-SJV | | | |
| | | Powdered high-speed steel 62~64HRC Surface 3000HV | AT-PJ AT-PJV | | | |

For shank diameter tolerance D, select either m5 or ^{+0.005}0.

Tip shape A

Tip shape D

Tip shape R

Tip shape E

Tip shape G

| Type | Tip shape | Tip length | D | L | | | | | | | 0.01 mm increments | | | B | H | | |
|--|-----------|-----------------------|----|------|-----|-----|-----|-----|-----|--------|--------------------|---------|---------|-------|------|------|----|
| | | | | (4) | (5) | (6) | (7) | (8) | (9) | (10) | min. P max. | P·Kmax. | P·Wmin. | | | | |
| (D _{m5}) T-SJ T-PJ Spring reinforced type (D8~25) | S | A D R E G | 13 | (4) | 40 | 50 | 60 | 70 | 80 | | 1.00~ | 3.99 | 3.97 | 1.00 | 8 | 7 | |
| | | | | (5) | 40 | 50 | 60 | 70 | 80 | | 2.00~ | 4.99 | 4.97 | 2.00 | | 8 | |
| | | | | (6) | 40 | 50 | 60 | 70 | 80 | | 2.00~ | 5.99 | 5.97 | 2.00 | | 9 | |
| | | | | (8) | 40 | 50 | 60 | 70 | 80 | 90 | 100 | 3.00~ | 7.99 | 7.97 | | 3.00 | 11 |
| | | | | (10) | 40 | 50 | 60 | 70 | 80 | 90 | 100 | 3.00~ | 9.99 | 9.97 | | 3.00 | 13 |
| | | | | (13) | 40 | 50 | 60 | 70 | 80 | 90 | 100 | 6.00~ | 12.99 | 12.97 | | 6.00 | 16 |
| (D ^{+0.005}) (D4~13) AT-SJ AT-PJ Spring reinforced type (D8~13) | L | A D R E G | 13 | (4) | 50 | 60 | 70 | 80 | | 1.00~ | 3.99 | 3.97 | 2.00 | 19 | 7 | | |
| | | | | (5) | 50 | 60 | 70 | 80 | | 2.00~ | 4.99 | 4.97 | 2.00 | | 8 | | |
| | | | | (6) | 50 | 60 | 70 | 80 | | 2.00~ | 5.99 | 5.97 | 2.00 | | 9 | | |
| | | | | (8) | 50 | 60 | 70 | 80 | 90 | 100 | 3.00~ | 7.99 | 7.97 | | 3.00 | 11 | |
| | | | | (10) | 50 | 60 | 70 | 80 | 90 | 100 | 3.00~ | 9.99 | 9.97 | | 3.00 | 13 | |
| | | | | (13) | 50 | 60 | 70 | 80 | 90 | 100 | 6.00~ | 12.99 | 12.97 | | 6.00 | 16 | |
| | | | | (16) | 60 | 70 | 80 | 90 | 100 | 10.00~ | 15.99 | 15.97 | 6.00 | 19 | | | |
| | | | | (20) | 60 | 70 | 80 | 90 | 100 | 13.00~ | 19.99 | 19.97 | 6.00 | 23 | | | |
| | | | | (25) | 60 | 70 | 80 | 90 | 100 | 18.00~ | 24.99 | 24.97 | 6.00 | 28 | | | |

The spring constants of T-SJ, T-PJ, AT-SJ, and AT-PJ are twice those of T-SJ, T-PJ, AT-SJ, and AT-PJ respectively.
 A: P>D-0.03→ℓ=0 If P>D-0.03 for a round punch, D-0.01 (press-in lead) is not included.
 R E G: P·K>D-0.05→ℓ=0 If P·K>D-0.05 for a shaped punch, D-0.01 (press-in lead) is not included.
 L(4)→B=6 If full length is (4), tip length is 6 mm in all cases.
 L(5)→B=13 If full length is (5), tip length is 13 mm in all cases.
 D(4), (5), and (6) are specifications available for T-SJ, T-PJ, AT-SJ, and AT-PJ only. T-SJV and T-PJV are available for D8~25 only. AT-SJV and AT-PJV are available for D8~13 only.

Order Catalog No. — L — P — W — R (R only)
 T-SJES 6 — 50 — P5.48 — W3.20

Effect of spring reinforced type
 The spring constant is twice that of a standard type jector punch. The large spring load results in more effective scrap removal.

Alterations Catalog No. — L(LC·LCT·LMT) — P — W — R — (BC·HC·TC, etc.)
 T-SJES 6 — 50 — P5.48 — W3.20 — HC8.0-TC4.0

| 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 | | |
| | PRC | Rounding of tip side edge 0.3≤PRC≤1 0.1 mm increments PRC≤(P-d,-0.5)/2 d, dimension P.180 | | |
| Alterations to full length | LC | Full length change (reduction in tip length) LC<L 0.1 mm increments (If combined with LKC, 0.01 mm increments can be selected.) Tip length B is shortened by (L-LC). Projection length of the jector pin is 2 mm. | | |
| | LCT | Changes to head thickness tolerance and full length are processed using a single code. The allowable range of change, increment, ordering process, and notes are the same as for LC. | TKC Head thickness tolerance change T+0.3 → +0.02 0 → 0 | LC Full length tolerance change L+0.3 → +0.1 0 → 0 |
| | LMT | Changes to head thickness tolerance and full length are processed using a single code. The allowable range of change, increment, ordering process, and notes are the same as for LC. | TKM Head thickness tolerance change T+0.3 → -0.02 0 → 0 | LC Full length tolerance change L+0.3 → +0.1 0 → 0 |
| | LKC | Full length tolerance change L+0.3 → +0.05 0 → 0 | | |
| Alterations to head | KC | Addition of single key flat to head | Key flat 90° 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 | Double key flats at 0° and a selected angle 1° increments | |
| | NKC | No key flat | | |

| Alteration | Code | A | D R E G | 1Code |
|----------------------|------|--|----------|-------|
| Alterations to head | HC | Head diameter change D≤HC<H 0.1 mm increments | | |
| | TC | Head thickness change 0.1 mm increments (If combined with TKC·TKM·LCT·LMT, 0.01 mm increments can be selected.) Full length L is shortened by (5-TC). If combined with LC·LCT·LMT, full length remains as specified. | 3.5≤TC<5 | |
| | TKC | Head thickness tolerance change T+0.3 → +0.02 0 → 0 | | |
| | TKM | Head thickness tolerance change T+0.3 → 0 0 → -0.02 | | |
| | TCC | Chamfering of head This improves the strength of the punch head P.1097 0.1 mm increments 0.5≤TCC≤(H-D)/2 If H≤5, then TCC is 0.5. Cannot be combined with SRC. | | |
| | RC | Head thickness is machined to a tolerance of -0.04~0 relative to the retainer surface. Cannot be used for D ^{+0.005} 0 types. | | |
| Alterations to shank | SRC | Modification of head for use with select retainers (SLS) For details, refer to P.629. Can be used for D10~25. Cannot be used for D ^{+0.005} 0 types. | | |
| | SKC | Single key flat on shank D4~6 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·WKC·KFC. | | |
| | 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. | | |
| | NC | The jector pin is removed. Cannot be combined with AC. | | |
| | NDC | No press-in lead ℓ≥3 → ℓ=0 | | |

Price Quotation