

JECTOR PUNCHES

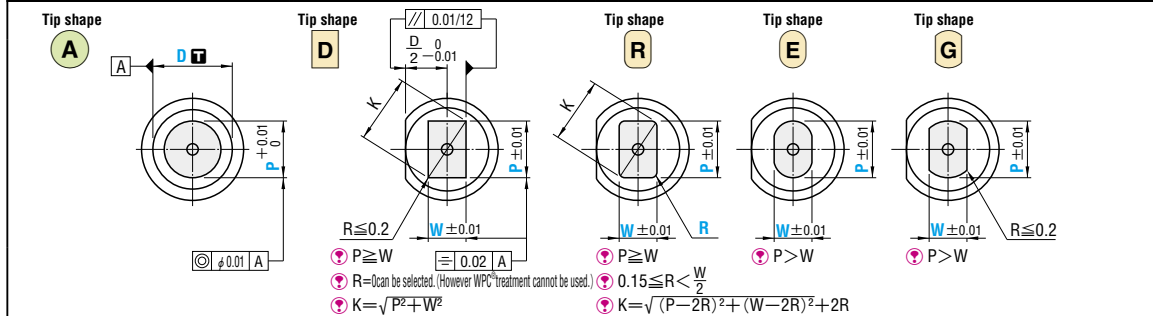
—CONFIGURABLE FULL LENGTH, FIXED B TYPE, NORMAL·WPC® TREATMENT·SPRING REINFORCED TYPE—



- ※ Jector punch which maintains the same tip length B even when L is changed.
- Ⓜ Projection length of the jector pin is 2mm.

- For details of jector holes, refer to Jector Punch Blanks. P.236
- 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	
 —WPC® treatment—	Dm5	D5~6 Equivalent to SKH51 61~64HRC	LFSJ LFSJV	A D R E G	S L	
			WPC® treatment W-LFSJ W-LFSJV			
	D ⁺ 0.005 0	D8~25 Equivalent to SKD11 60~63HRC	A-LFSJ A-LFSJV			For a WPC® type punch, the tip end is ground before the coating is applied. The tip edge of a WPC® treatment punch is very slightly rounded.
		—WPC® treatment— Surface 1000~1100HV	WPC® treatment AW-LFSJ AW-LFSJV			



Type	Tip shape	B Tip length	D	L					B	H
				0.1mm increments						
				0.01mm increments						
Spring reinforced type (D8~25)	A, D, R, E, G	S	(5)	40.0~80.0	2.00~4.99	4.97	2.00	0.15 ≤ R < W (R only)	8	8
			(6)	40.0~80.0	2.00~5.99	5.97	2.00		9	9
			8	60.0~100.0	3.00~7.99	7.97	3.00		11	11
			10	60.0~100.0	3.00~9.99	9.97	3.00		13	13
			13	60.0~100.0	6.00~12.99	12.97	6.00		16	16
	E, G	L	(5)	40.0~80.0	2.00~4.99	4.97	2.00		19	19
			(6)	40.0~80.0	2.00~5.99	5.97	2.00		23	23
			8	50.0~100.0	3.00~7.99	7.97	3.00		13	8
			10	50.0~100.0	3.00~9.99	9.97	3.00		11	9
			13	50.0~100.0	6.00~12.99	12.97	6.00		19	13
Spring reinforced type (D8~25)	A, D, R, E, G	L	16	50.0~100.0	6.00~12.99	12.97	6.00	16	16	
			19	50.0~100.0	10.00~15.99	15.97	6.00	19	19	
			20	50.0~100.0	13.00~19.99	19.97	6.00	23	23	
			25	50.0~100.0	18.00~24.99	24.97	6.00	28	28	
			25	60.0~100.0	18.00~24.99	24.97	6.00	25	23	

- Ⓜ The spring constants of LFSJV, W-LFSJV, A-LFSJV, and AW-LFSJV are twice those of LFSJ, W-LFSJ, A-LFSJ and AW-LFSJ respectively.
- Ⓜ Jector holes are based on the jector punch blanks. P.236
- Ⓜ If the tip shape is A, D, R, E, G and the difference between full length and tip length is 30mm or less, the tip length is adjusted to (Full length - 30mm).
- Ⓜ 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.
- Ⓜ D (5) and (6) are specifications available for LFSJ, W-LFSJ, A-LFSJ, and AW-LFSJ only. Spring reinforced types are available for D8~25 only.

Order	Catalog No.	L	P	W	R (R only)
	LFSJDS 6	60	P3.00	W2.80	
	A-LFSJEL 10	75.3	P8.50	W4.25	

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.

Days to Ship **Quotation**

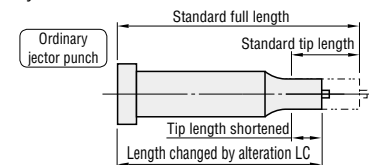
Alterations Catalog No. — L — P(PC) — W(WC) — R — (BC-HC-TC, etc.)
LFSJDS 6 — 58 — P3.00 — W2.80 — HC8-KFC225

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 PCC, 0.001 mm increments can be selected.)	Tip dimension change PC·WC ≥ PC·WCmin. 0.01 mm increments																																					
		<table border="1"> <tr><th>D</th><th>PCmin.</th></tr> <tr><td>5</td><td>1.800</td></tr> <tr><td>6</td><td>1.800</td></tr> <tr><td>8</td><td>2.500</td></tr> <tr><td>10</td><td>2.800</td></tr> <tr><td>13</td><td>5.000</td></tr> <tr><td>16</td><td>8.000</td></tr> <tr><td>20</td><td>9.000</td></tr> <tr><td>25</td><td>9.000</td></tr> </table>	D	PCmin.	5	1.800	6	1.800	8	2.500	10	2.800	13	5.000	16	8.000	20	9.000	25	9.000	<table border="1"> <tr><th>D</th><th>PC·WCmin.</th></tr> <tr><td>5</td><td>1.80</td></tr> <tr><td>6</td><td>1.80</td></tr> <tr><td>8</td><td>2.50</td></tr> <tr><td>10</td><td>2.80</td></tr> <tr><td>13</td><td>5.00</td></tr> <tr><td>16</td><td>5.00</td></tr> <tr><td>20</td><td>5.00</td></tr> <tr><td>25</td><td>5.00</td></tr> </table>	D	PC·WCmin.	5	1.80	6	1.80	8	2.50	10	2.80	13	5.00	16	5.00	20	5.00	25	5.00	
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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 the 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.236 Cannot be combined with PCC. For a 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.236 Cannot be combined with PRC. For a WPC® treatment, the tolerance is PCC ± 0.1.																																							
PKC	Tip tolerance change P + 0.01 ⇔ +0.005 0 ⇔ 0 (P dimension can be selected in 0.001 mm increments.)	Tip tolerance change P·W ± 0.01 ⇔ +0.01 0 ⇔ 0																																						
Alterations to full length	LKC	Full length tolerance change L + 0.3 ⇔ +0.05 0 ⇔ 0																																						
	LKZ	Full length tolerance change L + 0.3 ⇔ 0.01 0 ⇔ 0 Cannot be used with WPC® treatment.																																						

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	Double key flats at 0° and a selected angle 1° increments	
	NKC	—	No key flat	
	HC	Head diameter change D ≤ HC < H 0.1 mm increments		
	TC	Head thickness change 3.5 ≤ TC < 5 0.1 mm increments (If combined with TKC-TKM, 0.01mm increments can be selected.) The full length L remains as specified.		
	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.1611 0.1 mm increments 0.5 ≤ TCC ≤ (H - D) / 2 If H ≤ 5, TCC is 0.5.		
	RC	Head thickness is machined to a surface of -0.04~0 relative to the retainer tolerance. Cannot be used for D ⁺ 0.005 types.		
Alterations to shank	SKC	Single key flat on shank D/2 - 0.5~0.01 · 05~6 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.		
	NC	The jector pin is removed.		
	NDC	No press-in lead ℓ ≥ 3 ⇔ ℓ = 0		

Features

• 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.

P Price **Quotation**