

NON-CLOGGING CARBIDE BUTTON DIES

— HEADED TYPE · STRAIGHT TYPE —



Type	Shank diameter D tolerance	Catalog No.	Shape
—Headed— RoHS	D _{m5}	SV—WHD	
	D +0.005/0	SVA—WHD	
—Straight— RoHS	D _{n5}	SV—WSD	
	D +0.005/0	SVA—WSD	

For shank diameter tolerance D, select either m5 or n5 or +0.005/0.

For shank diameter tolerance D, select either n5 or +0.005/0.

D tolerance			Catalog No.		L	0.01mm increments min. P max.	V	G	d	H	T
D	m5	n5	Type	D							
3	+0.006 +0.002	+0.008 +0.004	Headed (D _{m5}) SV—WHD	Straight (D _{n5}) SV—WSD	3	0.50~1.00	0.4	0.2	1.4	4	3
4	+0.009 +0.004	+0.013 +0.008	SV—WHD	SV—WSD	4	0.50~1.50			2.0	5	
5					5	0.50~2.50			3.0	6	
6	+0.012 +0.006	+0.016 +0.010	(D +0.005/0) SVA—WHD	(D +0.005/0) SVA—WSD	6	1.00~3.00	0.8	0.3	3.4	9	5
8					8	1.00~4.00			4.4	11	
10					10	2.00~6.00			6.4	13	

Order **Catalog No.** — L — P
SV—WHD10 — 25 — P4.50

Days to Ship **Quotation**

Price **Quotation**

Alterations **Catalog No.** — (L(LC·SLC)) — (P(PC)) — (HC·TC·CKC·MKC, etc.)
SV—WSD8 — LC18 — PC4.20 — LKC

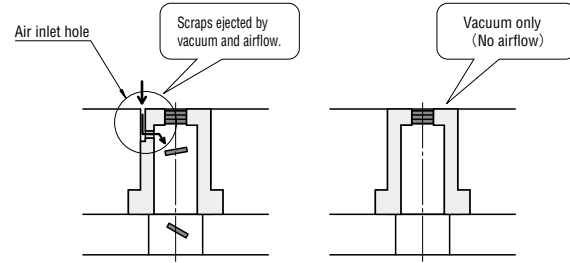
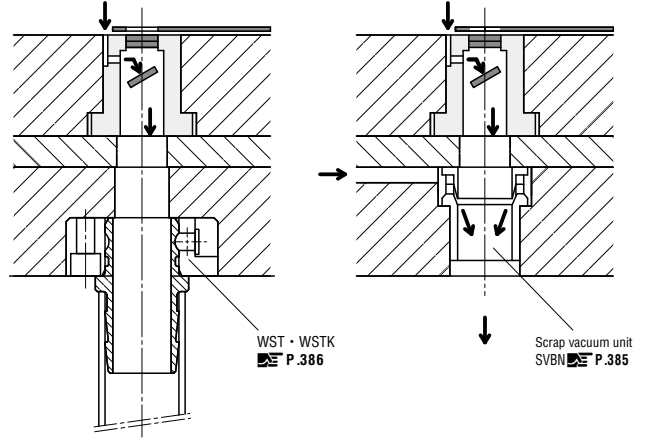
Alteration	Code	Spec.	1Code
Alterations to shaped hole	PC	Shaped hole diameter change min.: P > PC ≥ P _{min.} / 2 ≥ 1.00 0.01mm increments max.: P < PC ≤ P _{max.} + 0.2 0.01mm increments	
	LC	Full length change 8 ≤ LC < L 0.1mm increments (If combined with LKC·LKZ, 0.01mm increments can be selected.) Press-in lead is shortened by (L-LC). Cannot be used for headed types.	
Alterations to full length	LKC	Full length tolerance change L +0.4 → +0.05 0 → 0	Quotation
	LKZ	Full length tolerance change L +0.4 → +0.01 0 → 0	
	CKC	Changes to head thickness tolerance and full length tolerance are processed using a single code. For the machining limit, refer to the description of each alteration.	
	MKC	Changes to head thickness tolerance and full length tolerance are processed using a single code. The allowable range of change, increment, ordering process, and notes (⊙) are the same as for LC.	
Alterations to full length	SLC	Full length + Full length tolerance change L +0.4 → +0.05 +0.2 → 0	

Alteration	Code	Spec.	1Code
Alterations to head	KC	Addition of single key flat to head Cannot be used for D3~5.	
	WKC	Addition of double key flats in parallel Cannot be combined with KC·KFC. Cannot be used for straight types.	
	KFC	Double key flats at 0° and a selected angle 1° increments Cannot be used for straight types. Cannot be combined with KC·WKC.	
	HC	Head diameter change D ≤ HC < H 0.1mm increments	Quotation
	TC	Head thickness change 2 ≤ TC < T 0.1mm increments (If combined with TKC·TKM·CKC·MKC, 0.01mm increments can be selected.) Full length L is shortened by (T-TC). If combined with LC, full length is equal to LC.	
	TKC	Head thickness tolerance change T +0.3 → +0.02 0 → 0	
TKM	Head thickness tolerance change T +0.3 → -0.02 0 → 0		

Example

Features

- These non-clogging carbide button dies are intended to be used in combination with a vacuum device such as a vacuum pump.
- Because an air inlet hole is created near the shaped hole, when a vacuum device is used to provide suction, an air flow is produced inside the button die. As a result, the scrap removal effect is higher than in button dies without air inlet holes. (Figure 1)
- It is also possible to use products such as a scrap vacuum unit (P.385) or commercially available pail-mounted cleaner as the vacuum device in place of the vacuum pump. In these cases, the drive source is compressed air from a compressor or other machine. (Figure 2)
- Non-clogging button dies (Products data) P.1621



(Figure 1) Effect of air inlet hole

(Figure 2) Examples of Combinations with Various Vacuum Devices