PRECISION CARBIDE BLOCK PUNCHES WITH AIR HOLES

RoHS

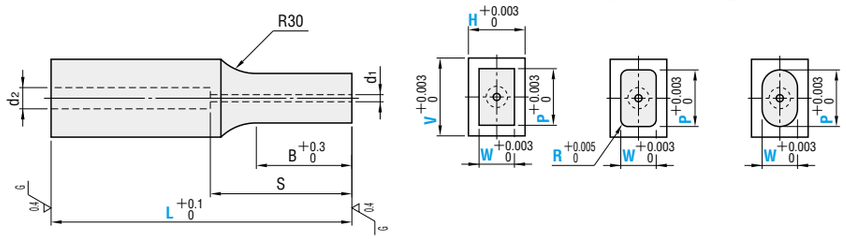
•Tip machining limit

Tip shape D	Tip shape R	Tip shape E
P≧W	P≧W 0.15≦R<$\frac{W}{2}$	P>W

M H	Shank dimensions V·H
V30(HIP) 88～89HRA	V·H 4～20

—Normal—

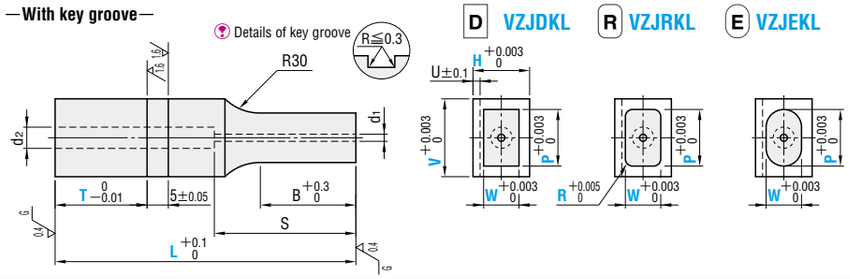
D VZJDBL R VZJRBL E VZJEBL



M H	Shank dimensions V·H
V30(HIP) 88～89HRA	V·H 4～20

—With key groove—

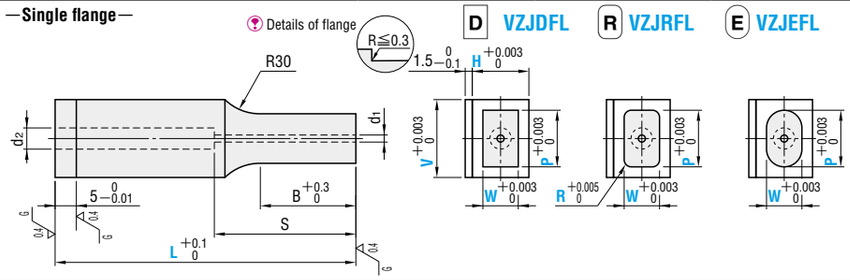
D VZJDKL R VZJRKL E VZJEKL



M H	Shank dimensions V·H
V30(HIP) 88～89HRA	V·H 4～16 Cannot be used for products marked with ● in the specification table.

—Single flange—

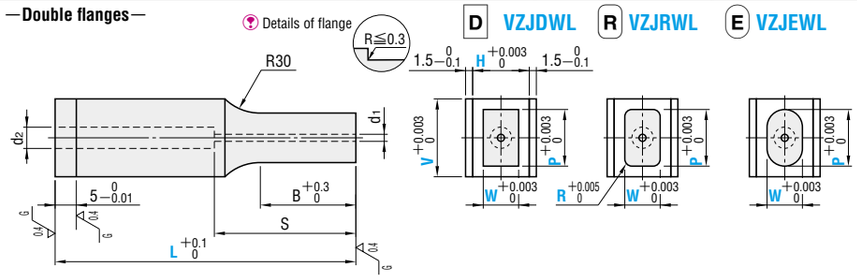
D VZJDFL R VZJRFL E VZJEFL



M H	Shank dimensions V·H
V30(HIP) 88～89HRA	V·H 4～16 Cannot be used for products marked with ● in the specification table.

—Double flanges—

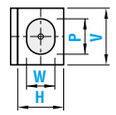
D VZJDWL R VZJRWL E VZJEWL



Catalog No. Type	Tip shape	Type	Shank and tip dimensions (mm) H	W min.	V / P min. 4 / 2.0	5 / 2.5	6 / 3.0	8 / 3.0	10 / 4.0	13 / 5.0	16 / 7.0	20 / 8.0	L	0.1mm T	B L 40	B L 50	B L 60·70	d1×S L 40	d1×S L 50	d1×S L 60·70	d2	U
VZJ	D R E	BL KL FL WL	4	1.5	○	○	○	○	○	○	○	●	40 50 60 70	T≧2	13	13	13	0.5×17			1.2	1.0
			5	2.0		○	○	○	○	○	○	●						0.8×17	0.8×20		2.1	
			6	2.0			○	○	○	○	○	●									2.6	
			8	2.5				○	○	○	○	●				19	19	1.2×17	1.2×27		3.4	1.5
			10	3.0					○	○	○	●						1.6×17	1.6×28		4.4	
			13	3.0						○	○	●						1.9×17	1.9×28			
			16	4.0							○	●					25	2.9×17	2.9×24	2.9×36		
			20	5.0								●										

Order

(1) If tip is at center of shank

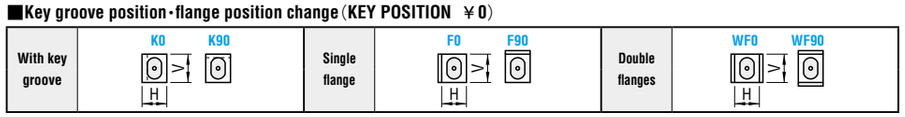


Catalog No.	V	H	L	P (0.001mm increments)	W	R (R only)	T (0.1mm increments)	K·F·WF
VZJEBL	20	08	60	P18.000	W 4.000			
VZJEKL	10	06	60	P 8.000	W 5.000		T25.5	K0
VZJEFL	16	13	60	P15.000	W12.000			F90
VZJEWL	13	10	40	P 8.000	W 5.000			WF90

(2) **If tip is not at center of shank:** Cannot be changed. (Cannot be manufactured.)

■Key groove position·flange position change (KEY POSITION ¥0)

With key groove	Single flange	Double flanges
K0 K90	F0 F90	WF0 WF90

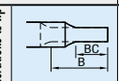
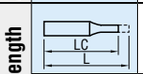
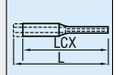


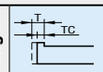
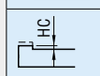
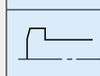
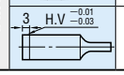
Days to Ship Quotation

Price Quotation

Alterations

Catalog No.	V	H	L (LC·LCX)	P·W·R	T	K·F·WF	(BC·HC·TC, etc.)
VZJEBL	20	08	60.0	P18.000—W3.000			LKC—DC

	Alteration	Code	Spec.	1Code
Alterations to tip		BC	Tip length change 2≦BC<B 0.1mm increments	Quotation
Alterations to full length		LC	Full length change LC<L 0.1mm increments (If combined with LKC, 0.01mm increments can be selected.) Tip length B is shortened by (L−LC).	
		LCX	Full length change with the same tip length B 30+B(BC)≦LCX<L 0.1mm increments If difference between full length and tip length is 30mm or less, tip length is adjusted to (Full length − 30mm). If combined with LKC, 0.01mm increments can be selected. Cannot be used for flanged types.	
		LKC	Full length tolerance change L +0.1 0 ⇨ +0.01 0	
Alteration to key groove		UK	Key groove depth change 0.5≦UK≦U+0.2 0.1mm increments H(V)−(UK+d2)≧2 Can be used for types with key grooves.	

	Alteration	Code	Spec.	1Code
Alterations to flange		TC	Flange thickness change 2≦TC<5 0.1mm increments Full length L is shortened by (5−TC). If combined with LC, full length is equal to LC.	Quotation
		HC	Flange width change 0≦HC<1.5 0.1mm increments	
		FK	Relief chamfering to flange top edge Flange edge is chamfered to prevent flange breakage. Cannot be used for normal types and types with key grooves.	
Others		VHM	Shank tolerance change V·H +0.003 0 ⇨ 0 −0.003	
		DC	Addition of press-in lead Press-in lead 3mm (H.V −0.01 −0.03) is added. Cannot be used for flanged types.	

PRECISION PUNCHES & DIES