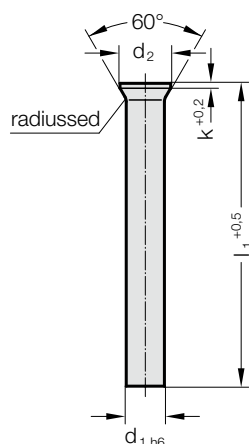


PUNCH DIN 9861 SHAPE D / ISO 6752

223.



Material:

HSS
Order No 223.3.
Hardness:
Shaft 64 ± 2 HRC
Head 52 ± 3 HRC

HST
Order No 223.4.
Hardness:
Surface ≥ 950 HV 0,3
Head 52 ± 3 HRC

HZ - TIN (HSS)
Order No 223.0.
Hardness:
Surface 2300 HV 0,05
Head 52 ± 3 HRC

ASP 23 - ASP 2023
Order No 223.6.
Hardness:
Shaft 64 ± 2 HRC
Head 52 ± 3 HRC

Description of FIBRO materials for tool and die components see at the beginning of Chapter E.

Execution:

Stamp shank and punch head are precision ground after the heat compression and tempering of the punch head using the plunge process.

Stock lengths: 71, 80, 100 mm.
other lengths and diameters on request!

223. Punch DIN 9861 Shape D / ISO 6752

Gradation		d ₂	k	l ₁	71	80	100
d ₁	d ₁						
0.5	-	0.9	0.2		●	●	●
0.55	-	1	0.2		●	●	●
0.6	-	1.1	0.2		●	●	●
0.65	-	1.2	0.2		●	●	●
0.7 - 0.75	0.05	1.3	0.2		●	●	●
0.8 - 0.85	0.05	1.4	0.4		●	●	●
0.9 - 0.95	0.05	1.6	0.4		●	●	●
1 - 1.1	0.1	1.8	0.5		●	●	●
1.2 - 1.3	0.1	2	0.5		●	●	●
1.4 - 1.5	0.1	2.2	0.5		●	●	●
1.6 - 1.7	0.1	2.5	0.5		●	●	●
1.8 - 1.9	0.1	2.8	0.5		●	●	●
2	0.1	3	0.5		●	●	●
2.1 - 2.2	0.1	3.2	0.5		●	●	●
2.3 - 2.5	0.1	3.5	0.5		●	●	●
2.6 - 2.9	0.1	4	0.5		●	●	●
3.1 - 3.4	0.1	4.5	0.5		●	●	●
3.5 - 3.9	0.1	5	0.5		●	●	●
4.1 - 4.4	0.1	5.5	0.5		●	●	●
4.5 - 4.9	0.1	6	0.5		●	●	●
5.1 - 5.4	0.1	6.5	0.5		●	●	●
5.5 - 5.9	0.1	7	0.5		●	●	●
6.1 - 6.4	0.1	8	0.5		●	●	●
6.5 - 7	0.5	9	1		●	●	●
7.5	-	10	1		●	●	●
8.5 - 9	0.5	11	1		●	●	●
9.5	-	12	1		●	●	●
10.5 - 11	0.5	13	1		●	●	●
11.5 - 12	0.5	14	1		●	●	●
12.5	-	15	1		●	●	●
13.5 - 14	0.5	16	1.5		●	●	●
14.5 - 15	0.5	17	1.5		●	●	●
15.5	-	18	1.5		●	●	●
16.5 - 17	0.5	19	1.5		●	●	●
17.5 - 18	0.5	20	1.5		●	●	●
18.5 - 19	0.5	21	1.5		●	●	●
19.5	-	22	1.5		●	●	●

* For d₁ = 3, 4, 5, 6, 8, 10, 13, 16 and 20 mm
see 2209. Cutting punches, Blank, DIN 9861, Form D

Ordering Code (example):

Punch DIN 9861 Shape D / ISO 6752	=	223.
Material MAT	HSS	= 3.
Shaft diameter d ₁	4,1 mm	= 0410.
Length l ₁	71 mm	= 071
Order No	=	223.3.0410. 071