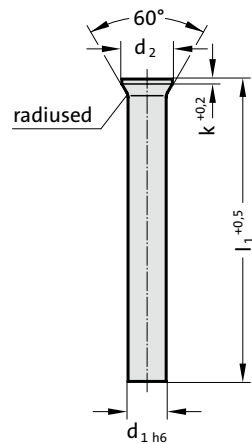


PUNCH DIN 9861 SHAPE D / ISO 6752

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:

Head hot upset-forged and tempered. Shaft and head subsequently precision plunge-ground for perfect concentricity and full interchangeability with replacement punches.

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

223. Punch DIN 9861 Shape D / ISO 6752

Gradation							
d ₁	d ₁	d ₂	k	l ₁	71	80	100
0,5	0.05	0.9	0.2		●	●	●
0,55	0.05	1	0.2		●	●	●
0,6	0.05	1.1	0.2		●	●	●
0,65	0.05	1.2	0.2		●	●	●
0,7	0.05	1.3	0.2		●	●	●
0,8	0.05	1.4	0.4		●	●	●
0,9	0.05	1.6	0.4		●	●	●
1	0.1	1.8	0.5		●	●	●
1,2	0.1	2	0.5		●	●	●
1,4	0.1	2.2	0.5		●	●	●
1,6	0.1	2.5	0.5		●	●	●
1,8	0.1	2.8	0.5		●	●	●
2	0.1	3	0.5		●	●	●
2,1	0.1	3.2	0.5		●	●	●
2,3	0.1	3.5	0.5		●	●	●
2,6	0.1	4	0.5		●	●	●
3	0.1	4.5	0.5		●	●	●
3,5	0.1	5	0.5		●	●	●
4	0.1	5.5	0.5		●	●	●
4,5	0.1	6	0.5		●	●	●
5	0.1	6.5	0.5		●	●	●
5,5	0.1	7	0.5		●	●	●
6	0.1	8	0.5		●	●	●
6,5	0.5	9	1		●	●	●
7,5	0.5	10	1		●	●	●
8,5	0.5	11	1		●	●	●
9,5	0.5	12	1		●	●	●
10,5	0.5	13	1		●	●	●
11,5	0.5	14	1		●	●	●
12,5	0.5	15	1		●	●	●
13,5	0.5	16	1.5		●	●	●
14,5	0.5	17	1.5		●	●	●
15,5	0.5	18	1.5		●	●	●
16,5	0.5	19	1.5		●	●	●
17,5	0.5	20	1.5		●	●	●
18,5	0.5	21	1.5		●	●	●
19,5	0.5	22	1.5		●	●	●

Ordering Code (example):

Punch DIN 9861 Shape D / ISO 6752	=	223.
Material MAT	HSS	= 3.
Shaft diameter d ₁	4 mm	= 0400.
Length l ₁	71 mm	= 071
Order No		= 223.3.0400. 071