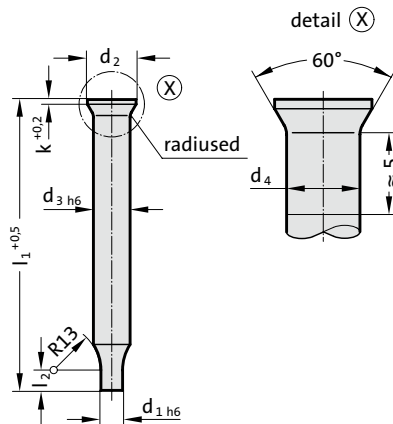


PUNCH SIMILAR TO DIN 9861 SHAPE CA



274.



274. Punch similar to DIN 9861 Shape CA

Gradation										
d_1	d_1	d_2	d_3	d_4	l_2	k	l_1	71	80	100
1 - 3,9	0.05	5.5	4	4.03	5 - 20	0.5		●	●	●
1,5 - 4,9	0.05	6.5	5	5.03	5 - 20	0.5		●	●	●
1,6 - 5,9	0.05	8	6	6.03	5 - 20	0.5		●	●	●
2,5 - 7,9	0.05	10	8	8.03	5 - 20	1		●	●	●
4 - 9,9	0.05	12	10	10.03	5 - 20	1		●	●	●
5 - 12,9	0.05	15	13	13.03	5 - 20	1		●	●	●
8 - 15,9	0.05	18	16	16.03	5 - 20	1.5		●	●	●

Description:

DIN 9861 restricts the range of stepped punches with conical head to shanks of 3 mm max. diameter and points of 2,95 mm max. diameter. Stepped punches of larger size are, however, quite popular owing to their rigidity and ability to sustain considerable stripping forces. In accommodation of this demand we supply larger sizes which are ground from stock sizes of the 222.-series.

Please select from those ranges and complete your order in accordance with the example on the right.

Material:

HSS

Order No 274.3.

Hardness:

Shaft 64 ± 2 HRC

Head 52 ± 3 HRC

HST

Order No 274.4.

Hardness:

Surface ≥ 950 HV 0,3

Head 52 ± 3 HRC

HZ - TIN (HSS)

Order No 274.0.

Hardness:

Surface 2300 HV 0,05

Head 52 ± 3 HRC

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

Execution:

Shaft precision ground. Head subsequently hot upset-forged and tempered; residual upset-buge below head normally much smaller than permissible acc. to DIN 9861.

Stock lengths: 71, 80, 100 mm.

other lengths and diameters on request!

Ordering Code (example):

Punch similar to DIN 9861 Shape CA	= 274.
Material MAT	HSS = 3.
Shaft diameter d_3	8 mm = 0800.
Length l_1	71 mm = 071.
Cutting diameter d_1	2.5 mm = 0250.
Cutting length l_2	5 mm = 05
Order No	= 274. 3.0800. 071.0250. 05