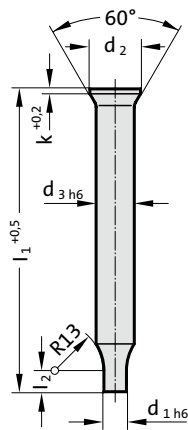


PUNCH SIMILAR TO DIN 9861 SHAPE C

275.



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

Material:

HSS
Order No 275.3.
Hardness: Shaft 64 ± 2 HRC; Head 52 ± 3 HRC

HST
Order No 275.4.
Hardness: Surface ≥ 950 HV 0,3; Head 52 ± 3 HRC

HZ - TIN (HSS)
Order No 275.0.
Hardness: Surface 2300 HV 0,05; Head 52 ± 3 HRC

ASP 23 - ASP 2023
Order No 275.6.
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!

275. Punch similar to DIN 9861 Shape C

Gradation									
d ₁	d ₁	d ₂	d ₃	l ₂	k	l ₁	71	80	100
1 - 3,9	0.05	5.5	4	5 - 20	0.5		●	●	●
1,5 - 4,9	0.05	6.5	5	5 - 20	0.5		●	●	●
1,6 - 5,9	0.05	8	6	5 - 20	0.5		●	●	●
2,5 - 7,9	0.05	10	8	5 - 20	1		●	●	●
4 - 9,9	0.05	12	10	5 - 20	1		●	●	●
5 - 12,9	0.05	15	13	5 - 20	1		●	●	●
8 - 15,9	0.05	18	16	5 - 20	1.5		●	●	●

Ordering Code (example):

Punch similar to DIN 9861 Shape C	=	275.
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	= 275.3.0800. 071.0250. 05	