SCRAP RETENTION REVERSE ANGULAR BUTTON DIES

—DOWEL SLOT TYPE—

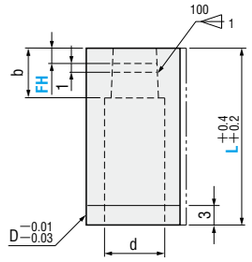
Patent pending

PRODUCTS DATA P.1404

RoHS

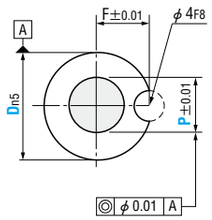
SRT—KSD
SRT—KD□

M Equivalent to SKD11
H 60～63HRC
A MS4—15



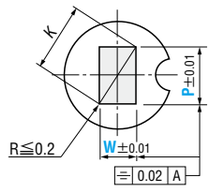
Select a push-in amount of punch greater than FH dimension. Pushing in until the straight part is effective against scrap retention and scrap clogging.

Tip shape A



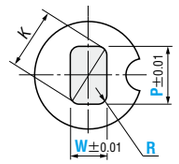
P≧W
K=√(P²+W²)
P−0.4≧1.5
(P dimension straight section 1.5mm or longer)

Tip shape D



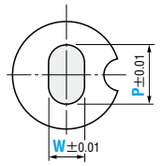
P≧W
0.15≦R＜W/2
K=√((P−2R)²+(W−2R)²+2R
P−2R≧1.5
(P dimension straight section 1.5mm or longer)

Tip shape R

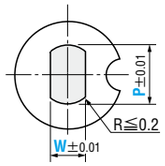


P＞W
√(P²−W²)≧1.5
(P dimension straight section 1.5mm or longer)

Tip shape E



Tip shape G



D tolerance		Catalog No.		L	0.01mm increments					0.005mm increments	Select	0.1mm increments	b	d	F
					Ⓐ	D R E G		R	MT (workpiece material thickness)	C (clearance)	TS (Tensile strength (N/mm²))	FH (Taper depth)			
D	n5	Type	D		min.P max.	P·Kmax.	P·Wmin.	R							
10	+0.016 +0.010	(Equivalent to SKD11) (Dn5)	10	16 20 22 25 28 30 32 35	2.00～ 6.00	6.00	2.00	0.15≦R＜W/2 (R only)	MT≧0.5	C≧0.060 (But C≧0.050 if the clearance is 10% or below C≧0.050)	Select the level of tensile strength	1.0～5.0	6	6.4	6.0
13	+0.020 +0.012	Ⓐ SRT—KSD	13	16 20 22 25 28 30 32 35	3.00～ 8.00	8.00	2.00					1.0～7.0	8	8.4	7.5
16		Ⓓ SRT—KDD	16	16 20 22 25 28 30 32 35	5.00～10.00	10.00	2.00							10.6	8.0
20		Ⓡ SRT—KDR	20	16 20 22 25 28 30 32 35	7.00～12.00	12.00	3.00							12.6	10.0
22	+0.024 +0.015	Ⓔ SRT—KDE	22	16 20 22 25 28 30 32 35	8.00～14.00	14.00	3.00							14.6	11.0
25		Ⓖ SRT—KDG	25	16 20 22 25 28 30 32 35	10.00～16.00	16.00	3.00							16.6	12.5

Level	Tensile strength (N/mm²)
H	800～
M	600～
L	～599

Punch shaped hole
Die shaped hole

Use with the clearance (C) less than 20% of the processed plate material thickness (MT), otherwise the effect will not be as expected. Clearance (C)≦Processed plate material thickness (MT)×20%
1/100 of relief taper length is as follows. Relief taper length=b−(FH+1)
P dimension will change if regrinding is applied. Note that the change amount varies with the taper width (max. 0.05mm on one side) and taper depth & regrinding amount.

Order

Catalog No.	L	P	W	R (Ⓡ only)	MT	C	TS	FH
SRT—KDD16	25	P9.20	W2.00		MT1.0	C0.1	M	FH2.0
SRT—KSD16	25	P9.2			MT1.0	C0.1	H	FH2.0

Days to Ship: Quotation Price: Quotation

Alterations

Catalog No.	L(LC)	P(PC)	W(WC)	R	MT	C	TS	FH	(KC···etc.)
SRT—KDD 16	25	P9.20	W2.00		MT1.00	C0.100	M	FH2.0	KC90

Alterations		Code	Ⓐ	D R E G
Alterations to tip		PC WC	Shaped hole diameter change min.: P/W＞PC/WC≧(P·Wmin./2)≧2.00 0.01mm increments max.: P/W＜PC/WC≦P·Kmax.+0.2 0.01mm increments	
Alterations to full length		LC	Full length change 10≦LC＜L 0.1mm increments (If combined with LKC·LKZ, 0.01 mm increments can be selected.) Press-in lead is shortened by (L—LC).	
		LKC	Full length tolerance change L +0.4 +0.2 ⇨ +0.05 0	
		LKZ	Full length tolerance change L +0.4 +0.2 ⇨ +0.01 0 ⊗ L＜16	
Others		KC	——	Key flat position change 1° increments