

# JECTOR BLOCK PUNCHES

— WITH KEY GROOVE —

Details of jector hole, refer to JECTOR BLOCK PUNCH BLANK P.461

Equivalent to SKD11 60 ~ 63HRC  
Equivalent to SKH51 61 ~ 64HRC  
Powdered high-speed steel 64 ~ 67HRC

Tip shape: D, R, E, G

Tip length (B): L > S

Details of key groove: R ≤ 0.3

Even when P=V and W=H, the tip tolerance is determined by the P and W tolerances.

Type	Tip shape	Tip length	H	V	P min.	W min.	V												L	0.1mm T	B		M	ℓ	U
							6	8	10	13	16	20	22	25	28	30	8	13			4	5			
HJK	D	S	6	2.0	○	○	○	○	○	○	○	○	○	○	○	○	(40)	T ≥ 20	8	13	4	5	1.0		
			8	2.5	○	○	○	○	○	○	○	○	○	○	○	○			13	19	6	8			
HSJK	R	L	10	3.0												(50)	T ≥ 20	13	19	6	8	1.5			
			13	4.0														19	25	8	8				
PHJK	G	L	16	5.0												80	T ≥ 20	19	25	8	8	1.5			
			20	6.0																					
			22	6.0																					
			25	6.0																					

Ⓛ (40) → B=6 If full length is (40), tip length is 6mm in all cases.  
Ⓛ (50) · H10 ~ 25 → B=10 If full length is (50) and H dimension is 10 ~ 25, tip length is 10mm in all cases.

Order

Key groove position: K specification

(1) If tip is at center of shank

Catalog No. V H L P W R (R only) T ≥ 20 K

HJKES 08 06 - 60 - P8.00 - W5.20 - T22.5 - K0

(2) If tip is not at center of shank

Catalog No. V H L P W R (R only) T ≥ 20 K X-Y

HJKEL 20 16 - 60 - P14.00 - W10.00 - T25.5 - K180 - X0.00 - Y2.50

X and Y must be set either to 0 or to 0.02 or more. Tolerance ±0.01

H	Zmin.
6~8	1.0
10~13	1.5
16~25	2.0

When the tip position is changed, the jector hole must be located at least Zmin. away from the tip edges. The jector hole position cannot be changed.

Days to Ship **Quotation**

Alterations

Catalog No. V H L(LC) P-W-R T-K X-Y (BC-PKC, etc.)  
HJKDL 20 16 - LC5.5 - P14.00 - W10.00 - T25 - K0 - BC20.5

Price **Quotation**

Alteration	Code	Spec.	1Code
Alterations to tip	BC	Tip length change (shorter than standard) 2 ≤ BC < B 0.1mm increments	
	SC	Lapping of tip W ≥ 2.00 P dimension tolerance and increment remain the same. R=0 cannot be selected for the tip corner.	
	PKC	Tip tolerance change P·W ± 0.01 ⇨ +0.01 0	
	PKV	Tip tolerance change P·W ± 0.01 ⇨ ±0.005	
Alterations to full length	LC	Full length change LC < L 0.1mm increments (If combined with LKC-LKZ, 0.01mm increments can be selected.) Tip length B is shortened by (L-LC).	
	LKC	Full length tolerance change L +0.2 0 ⇨ +0.05 0	
	LKZ	Full length tolerance change L +0.2 0 ⇨ +0.01 0	
Alterations to shape	CC	Chamfering to four corners of shank The four corners of shank are chamfered to C0.5. The distance between shank corners and the tip must be 0.5mm or more.	
	JVC	Change of spring to reinforced type 8 ≤ H ≤ 25 → Can be used with L ≥ 60. Cannot be used for H6.	
	AC	The jector pin is removed to create an air path and the side vent hole is plugged from the inside by inserting a resin (ABS) ring.	
	NC	The jector pin is removed. Cannot be combined with AC.	
	TKC	Key groove position tolerance change T 0 -0.05 ⇨ 0 -0.02	
	RTC	Key groove position tolerance change T 0 -0.05 ⇨ +0.05 0	
	UK	Key groove depth change 0.5 ≤ UK ≤ U + 0.2 0.1mm increments Can be used for H ≥ 10 (K0, K180) V ≥ 10	
	VKC	Shank tolerance change V·H +0.01 0 ⇨ +0.005 0	
VKM	Shank tolerance change V·H +0.01 0 ⇨ 0 -0.005		
VHM	Shank tolerance change V·H +0.01 0 ⇨ 0 -0.01		
VHZ	Shank tolerance change V·H +0.01 0 ⇨ ±0.005		
DC	Addition of press-in lead Press-in lead of 3mm (V·H -0.01 -0.03) is added.		

Fixing keys for punches with key grooves P.245