

# JECTOR BLOCK PUNCHES

—WPC® TREATMENT—



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

—WPC® treatment—

**Tip machining limit**

Tip shape: **D** (Square), **R** (Rounded), **E** (Chamfered), **G** (Beveled)

W ≤ P, W ≤ R, W ≤ P, W < P

W ≤ P, 0.15 ≤ R < W/2, 0.01mm increments

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

The tip edges are very slightly rounded.

**Tapped**

Tip shape: **D**, **R**, **E**, **G**

Equivalent to SKD11 60~63HRC: **W-HJM** (Tip shape D, Tip length S)

Equivalent to SKH51 61~64HRC: **W-HSJM** (Tip shape R, Tip length L)

Powdered high-speed steel 64~67HRC: **W-PHJM** (Tip shape G, Tip length L > S)

**With key groove**

Tip shape: **D**, **R**, **E**, **G**

Equivalent to SKD11 60~63HRC: **W-HJK** (Tip shape D, Tip length S)

Equivalent to SKH51 61~64HRC: **W-HSJK** (Tip shape R, Tip length L)

Powdered high-speed steel 64~67HRC: **W-PHJK** (Tip shape G, Tip length L > S)

**Single flange**

Tip shape: **D**, **R**, **E**, **G**

Equivalent to SKD11 60~63HRC: **W-HJF** (Tip shape D, Tip length S)

Equivalent to SKH51 61~64HRC: **W-HSJF** (Tip shape R, Tip length L)

Powdered high-speed steel 64~67HRC: **W-PHJF** (Tip shape G, Tip length L > S)

**Double flanges**

Tip shape: **D**, **R**, **E**, **G**

Equivalent to SKD11 60~63HRC: **W-HJW** (Tip shape D, Tip length S)

Equivalent to SKH51 61~64HRC: **W-HSJW** (Tip shape R, Tip length L)

Powdered high-speed steel 64~67HRC: **W-PHJW** (Tip shape G, Tip length L > S)

Catalog No.	Type	Tip shape	Tip length	H	W min.	V												L	0.1mm	B			M	ℓ	U
						6	8	10	13	16	20	22	25	28	30	12.0	12.0			T	S	L			
Tapped	W-HJM, W-HSJM, W-PHJM	D	S	6	2.0	○	○	○	○	○	○	○	○	○	○	○	○	(40)	8	13	4	5	1.0		
				8	2.5	○	○	○	○	○	○	○	○	○	○	○	○	○	(50)	13	19	6	6	1.5	
With key groove	W-HJK, W-HSJK, W-PHJK	R	L	10	3.0	○	○	○	○	○	○	○	○	○	○	○	○	(40)	13	19	6	6	1.5		
				13	4.0	○	○	○	○	○	○	○	○	○	○	○	○	○	(50)	19	25	8	8	1.5	
Single flange	W-HJF, W-HSJF, W-PHJF	E	L	16	5.0	○	○	○	○	○	○	○	○	○	○	○	○	60	19	25	8	8	1.5		
				20	6.0	○	○	○	○	○	○	○	○	○	○	○	○	○	70	19	25	8	8	1.5	
Double flanges	W-HJW, W-HSJW, W-PHJW	G	L	22	6.0	○	○	○	○	○	○	○	○	○	○	○	○	80	19	25	8	8	1.5		
				25	6.0	○	○	○	○	○	○	○	○	○	○	○	○	○	80	19	25	8	8	1.5	

L(40) → B=6 If full length is (40), tip length is 6mm in all cases.  
 L(50) → H10~25 → B=13(10) If full length is (50) and H dimension is 10~25, tip length is 13mm in all cases. (For types with key grooves, the tip length is 10mm.)

**Order**

**Key groove position and flange position change**

With key groove: **K0**, **K90**, **K180**, **K270**

Single flange: **F0**, **F90**, **F180**, **F270**

Double flanges: **WF0**, **WF90**

(1) If tip is at center of shank

0.01mm increments: **P** - **W** - **R** (R only) - **K·F·WF**

0.1mm increments: **T ≥ 20**

W-HSJMRL	20	10	70	P16.00	W 9.00	R0.15	T25.5	K0	F90	WF90
W-PHJKES	08	06	60	P 7.00	W 5.00					
W-HSJFDL	16	13	60	P15.00	W12.00					
W-HSJWEL	13	10	40	P 8.00	W 5.00					

(2) If tip is not at center of shank

0.01mm increments: **P** - **W** - **R** (R only) - **K·F·WF** - **X·Y**

0.1mm increments: **T ≥ 20**

W-HSJFDL	16	13	50	P15.00	W12.00			F90	X0.00	Y0.55
----------	----	----	----	--------	--------	--	--	-----	-------	-------

H Zmin. table:  
 H: 6-8, 10-13, 16~25  
 Zmin.: 1.0, 1.5, 2.0

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

**Days to Ship** **Quotation**

**Alterations** **Price** **Quotation**

Alterations: **W-HSJMDS** 20 08 - 60 - P18.00 - W3.50

Price: **K·F·WF** - **X·Y** - (BC-HC-TC, etc.) - **LKC**

Alteration	Code	Spec.	1Code
Tip	BC	Tip length change (shorter than standard) 2 ≤ BC ≤ B, 0.1mm increments	
Alterations to full length	LC	Full length change LC < L, 0.1mm increments (if combined with LKC, 0.01mm increments can be selected.) Tip length B is shortened by (L-LC).	
	LKC	Full length tolerance change L +0.2 -0.05 → +0.05 0	
Key groove	TKC	Key groove position tolerance change T -0.05 → -0.02 0	
	RTC	Key groove position tolerance change T -0.05 → +0.05 0	
Key groove	UK	Key groove depth change 0.5 ≤ UK ≤ U + 0.2, 0.1mm increments. Can be used for key groove types. Can be used for H ≥ 10 (K0, K180), V ≥ 10 (K90, K270).	
	HC	Flange width change 0 ≤ HC < 1.5, 0.1mm increments	
Alterations to flange	TC	Flange thickness change 3.5 ≤ TC < 5, 0.1mm increments (if combined with TKC, 0.01mm increments can be selected.) Full length L is shortened by (5-TC). If combined with LC, full length is equal to LC.	
	TKC	Flange thickness tolerance change T +0.2 -0.05 → +0.02 0	
Alterations to flange	TKM	Flange thickness tolerance change T +0.2 -0.05 → -0.02 0	
	FK	Relief chamfering to flange top edge. Flange edge is chamfered to prevent flange breakage.	
Shape	JVC	Change of spring to reinforced type. 8 ≤ H ≤ 25 → Can be used for L ≥ 60. Cannot be used for H6.	

Alteration	Code	Spec.	1Code
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.	
	AC	AIR. 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.	
Alterations to shape	NC	The jector pin is removed. Cannot be combined with AC.	
	CCP	Chamfering to one corner of shank (for error prevention). One corner of shank is chamfered to C1.0. Can be used if distances a and b from tip corners to shank meet the following conditions. Selection of chamfering position. Can be used for tapped types only.	
Alterations to shape	VKC	Shank tolerance change V+H +0.01 -0.005 0	
	VKM	Shank tolerance change V+H +0.01 -0.005 0	
	VHM	Shank tolerance change V+H +0.01 -0.01 0	
	VHZ	Shank tolerance change V+H +0.01 ±0.005 0	
Alterations to shape	DC	Addition of press-in lead. Press-in lead of 3mm (V·H -0.01 -0.03) is added. Can be used for tapped types and key groove types.	