

# JECTOR BLOCK PUNCHES

—HW COATING—



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

—HW coating—

**Tip machining limit**

Tip shape	Tip shape	Tip shape	Tip shape
D	R	E	G

$W \leq P$       $W \leq P$       $W \leq P$       $W < P$   
 $0.15 \leq R < W/2$  (0.01mm increments)  
 $0.15 \leq R < W/2$  (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.

RoHS

**Tapped**

Tip shape	Tip shape	Tip shape	Tip shape
D	R	E	G

$H^{+0.01}_0$ ,  $V^{+0.01}_0$ ,  $W \pm 0.01$ ,  $R \leq 0.2$ ,  $P \pm 0.01$ ,  $B^{+0.3}_0$ ,  $L^{+0.2}_0$

**With key groove**

Tip shape	Tip shape	Tip shape	Tip shape
D	R	E	G

$H^{+0.01}_0$ ,  $V^{+0.01}_0$ ,  $W \pm 0.01$ ,  $R \leq 0.2$ ,  $P \pm 0.01$ ,  $B^{+0.3}_0$ ,  $L^{+0.2}_0$ ,  $T^{+0.05}_0$ ,  $U^{+0.1}_0$

**Single flange**

Tip shape	Tip shape	Tip shape	Tip shape
D	R	E	G

$H^{+0.01}_0$ ,  $V^{+0.01}_0$ ,  $W \pm 0.01$ ,  $R \leq 0.2$ ,  $P \pm 0.01$ ,  $B^{+0.3}_0$ ,  $L^{+0.2}_0$ ,  $T^{+0.05}_0$

**Double flanges**

Tip shape	Tip shape	Tip shape	Tip shape
D	R	E	G

$H^{+0.01}_0$ ,  $V^{+0.01}_0$ ,  $W \pm 0.01$ ,  $R \leq 0.2$ ,  $P \pm 0.01$ ,  $B^{+0.3}_0$ ,  $L^{+0.2}_0$ ,  $T^{+0.05}_0$

Catalog No.	Type	Tip shape	B Tip length	H	W	V	V												L	0.1mm T	B	M	ℓ	U
							6	8	10	13	16	20	22	25	28	30								
Tapped	HW-HSJM	D	S	6	2.0	2.0	3.0	3.0	4.0	5.0	7.0	8.0	9.0	10.0	12.0	12.0	(40)	8	13	4	5	12	1.0	
				8	2.5	2.5	3.0	3.0	4.0	5.0	7.0	8.0	9.0	10.0	12.0	12.0								
With key groove	HW-HSJK	R	S	10	3.0	3.0	3.0	3.0	4.0	5.0	7.0	8.0	9.0	10.0	12.0	12.0	(50)	13	19	6	6	12	1.5	
				13	4.0	4.0	4.0	4.0	5.0	7.0	8.0	9.0	10.0	12.0	12.0									
Single flange	HW-HSJF	E	L	16	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	5.0	60	19	25	8	8	8	1.5		
				20	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0								6.0	
Double flanges	HW-HSJW	G	L	22	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	70	19	25	8	8	8	1.5		
				25	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0								6.0	

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

**Order**

**Key groove position-flange position change**

With key groove	Single flange	Double flanges
KO, K90, K180, K270	F0, F90, F180, F270	WF0, WF90

(1) If tip is at center of shank

Catalog No. V H L ———— 0.01mm increments ———— 0.1mm increments ———— K · F · WF  
 P — W — R (R only) — T ≥ 20

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

(2) If tip is not at center of shank

Catalog No. V H L ———— 0.01mm increments ———— 0.1mm increments ———— K · F · WF ———— 0.01mm increments  
 P — W — R (R only) — T ≥ 20 — X-Y

HW-HSJFDL	16	13	50	P15.00	W12.00			F90	X0.00	Y0.55
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X and Y must be set either to 0 or to 0.02 or more. Tolerance ±0.01. If X and Y are 0, an additional coating layer of 3~5 μ is added.

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** **Price** **Quotation**

Alterations

Catalog No. V H L(LC) — P · W · R — T — K · F · WF — X-Y — (BC · HC · TC, etc.) — LC

Alteration	Code	Spec.	1Code
<b>Tip</b>	BC	Tip length change (shorter than standard) 2 ≤ BC ≤ B 0.1mm increments	
<b>Alterations to full length</b>	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	
<b>Key groove</b>	TKC	Key groove position tolerance change T -0.05 → -0.02	
	RTC	Key groove position tolerance change T -0.05 → +0.05	
<b>Alterations to flange</b>	UK	Key groove depth change 0.5 ≤ UK ≤ U + 0.2 0.1mm increments Can be used for H ≥ 10 (KO, K180) V ≥ 10 (K90, K270).	<b>Quotation</b>
	HC	Flange width change 0 ≤ HC < 1.5 0.1mm increments	
<b>Alterations to shape</b>	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.	
	TKM	Flange thickness tolerance change T +0.2 → -0.02	
<b>Alterations to shape</b>	FK	Relief chamfering to flange top edge Flange edge is chamfered to prevent flange breakage.	
	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
<b>Alterations to shape</b>	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.	
<b>Alterations to shape</b>	NC	<del>MANUFACTURE</del> 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. a + b ≥ 1.3	<b>Quotation</b>
<b>Alterations to shape</b>	VKM	Shank tolerance change V · H +0.01 → +0.005	
	VHM	Shank tolerance change V · H +0.01 → -0.005	
	VHZ	Shank tolerance change V · H +0.01 → ±0.005	
	DC	Addition of press-in lead Press-in lead of 3mm (V · H -0.03) is added. Can be used for tapped types and key groove types.	