

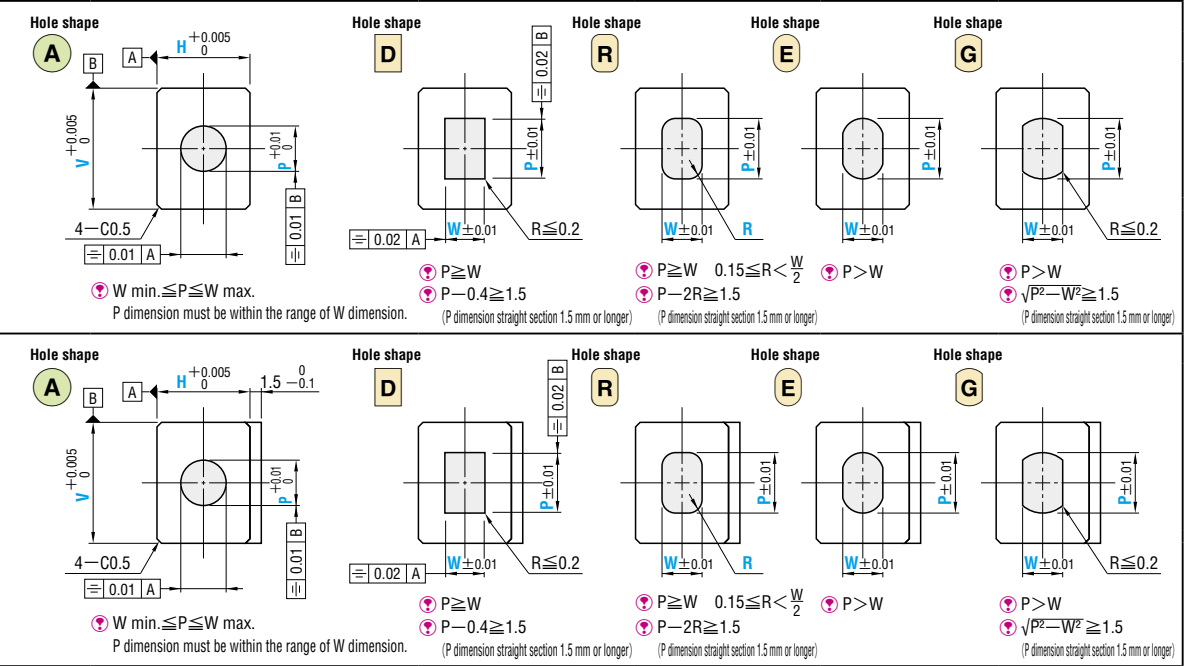
# SCRAP RETENTION BLOCK DIES



—Straight—	RoHS	M H	Catalog No.		Diagram
			A	D R E G	
	Equivalent to SKD11 60 ~ 63HRC	SR-BLD	SR-BLDD	SR-BLDR	
			SR-BLDE	SR-BLDG	
Powdered high-speed steel 64 ~ 67HRC	SR-PBLD	SR-PBLDD	SR-PBLDR	SR-PBLDE	SR-PBLDG
—Single flange—	RoHS	M H	Catalog No.		Diagram
	Equivalent to SKD11 60 ~ 63HRC	SR-BLDF	SR-BLDDF	SR-BLDRF	
			SR-BLDEF	SR-BLDGF	
Powdered high-speed steel 64 ~ 67HRC	SR-PBLDF	SR-PBLDDF	SR-PBLDRF	SR-PBLDEF	SR-PBLDGF

Catalog No.	H	V	min. P max.								R	L	MT (workpiece material thickness) 0.01mm increments	C (clearance) 0.005mm increments
			6	8	10	13	16	20	25	30				
Straight	6	1.00 ~ 3.00	1.00	1.00	1.00	1.00	1.00	1.50	1.50	0.15 ≤ R < W/2 (R only)	16 20 22 25 30 35	MT ≥ 0.15 Select a workpiece material thickness of 0.15mm or more.	C ≥ 0.010 Select a clearance of 0.010mm or more.	
Single flange	8	1.00 ~ 4.00												
A SR-BLD	10	1.00 ~ 6.00												
D SR-BLDD	13	1.00 ~ 8.00												
R SR-BLDR	16	1.00 ~ 10.00												
E SR-BLDE	20	1.50 ~ 12.00												
G SR-BLDG	25	1.50 ~ 16.00												

P·W·R...0.01mm increments    Can be used only for workpiece materials with tensile strengths up to 1,177N/mm<sup>2</sup> (120kgf/mm<sup>2</sup>).  
 Workpiece material thickness and clearance are used as machining data for the scrap retention. Specify the shaped hole dimensions (P·W·R) when selecting the block die finishing dimensions.



**Order**

(1) If shaped hole is at center of shank

Catalog No. V H - L - P - W - R (R only) - MT - C

SR-PBLDRF 13 10 - 22 - P7.65 - W3.65 - R0.50 - MT1.50 - C0.105

(2) If shaped hole is not at center of shank (hole shapes A only)

Catalog No. V H - L - P - MT - C - X - Y

SR-PBLDF 13 10 - 22 - P4.35 - MT1.50 - C0.105 - X4.85 - Y7.82

For the upper and lower limit values for X and Y, refer to P.467.  
 X, Y tolerance: ±0.005  
 Be aware that the shaped hole position and X/Y values are determined differently for block punches.

**Alterations**

Catalog No. V H - L(LC) - P - W - R - MT - C - (BC-HC, etc.)

SR-BLDF 08 06 - LC21 - P2.25 - MT1.50 - C0.105 - LKC - ANF1.2

**P** Price **Quotation**

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

Alteration	Code	A	D R E G	1Code
Alterations to shaped hole	BC	Shaped hole depth change 1 ≤ BC ≤ B max. 0.1mm increments	Shaped hole depth change 1 ≤ BC < 2 0.1mm increments	Quotation
	PKC	Shaped hole tolerance change P +0.01 ⇨ +0.005 0	Shaped hole tolerance change P·W ±0.01 ⇨ +0.01 0	
	HVC	H and V are reversed relative to shaped hole. P dimension is machined in direction H and W dimension is machined in direction V. P ≤ W max. P dimension must be within the range of W dimension listed in the specification table.		
Alterations to flange	HC	Flange width change 0 ≤ HC < 1.5 0.1mm increments		
	TC	Flange thickness change 0.1mm increments (if combined with TKC·TKM, 0.01mm increments can be selected.) Full length is shortened by (S-TC). If combined with LC, full length is equal to LC.		
	TKC	Flange thickness tolerance change	T +0.3 ⇨ +0.02 0	
	TKM	Flange thickness tolerance change	T +0.3 ⇨ 0 0 -0.02	

Alteration	Code	A	D R E G	1Code
Alterations to full length	LC	Full length change 10 ≤ LC < L 0.1mm increments (If combined with LKC-LKZ, 0.01mm increments can be selected.) For single flange types, if LC ≤ 12 then press-in lead is not included.		
	LKC	Full length tolerance change	L +0.4 ⇨ +0.05 +0.2 0	
	LKZ	Full length tolerance change	L +0.4 ⇨ +0.01 +0.2 0	
Others	VHM	Shape tolerance change	H·V +0.005 ⇨ 0 -0.005	
	ANF	Angular angle change 0 ≤ ANF ≤ 1.2 0.2° increments d ≤ dmax. d = P + 2((L-B) tan(ANF°)) P - Btan(ANF°) ≥ 0.6 W - Btan(ANF°) ≥ 0.6 Cannot be used if shaped hole is not at center of shank.	 Taper 1/50 Angle (one side) 0.573°	