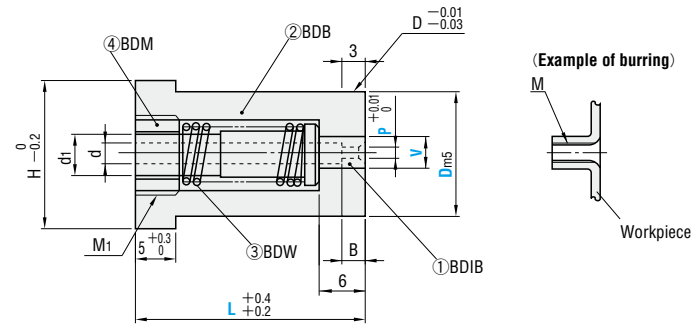


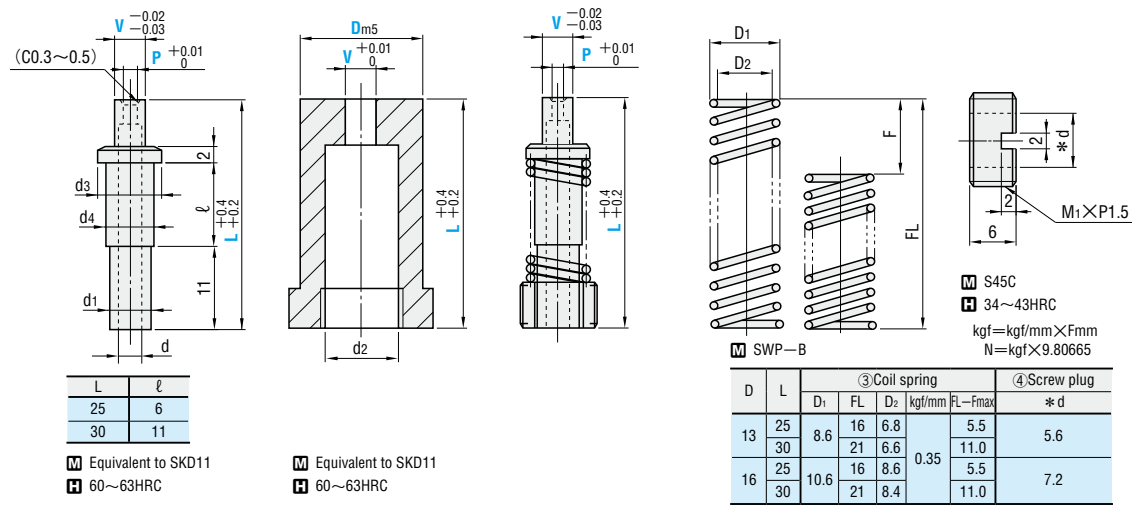
# BURRING DIE UNITS

RoHS

BDU (Unit)



①BDIB (Inner bushing)    ②BDB (Outer bushing)    BDIS (①③④)    ③BDW (Coil spring)    ④BDM (Screw plug)



D	M	B	d	d1	M1	H	d2	d3	d4	Catalog No.		L	0.01mm increments		M
										Type	D		min. V max.	min. P max.	
13	2.6	2.5	2.0	5.5	10	16	8.7	8.5	6.3	(Unit) BDU	13	25	3.05~3.90	1.55~1.75	2.6
	① BDIB	3	2.5							3.45~4.70			1.95~2.20	3	
16	2.6	2.5	2.0	7.1	12	19	10.7	10.5	7.9	② BDB	16	30	3.05~3.90	1.55~1.75	2.6
	③ BDIS	3	2.5							3.45~4.70			1.95~2.20	3	
	④ BDW	4	3.1							4.15~6.20			2.45~2.75	4	
	BDM	5	3.7							5.75~7.80			2.85~3.30	5	

Order

Catalog No.	L	V	P
(Unit) BDU 13	25	V3.75	P1.70
① BDIB 13	25	V3.75	P1.70
② BDB 13	25	V3.75	
①③④ BDIS 13	25	V3.75	P1.70
③ BDW 13	25		
④ BDM 13			

Days to Ship **Quotation**

Alterations Catalog No. — L — V — P — (LKC·TKC, etc.)  
BDU 13 — 25 — V3.75 — P1.70 — LKC

Alteration	Code	Spec.	1Code
BDU L	LKC	L dimension tolerance change L +0.4 → +0.05 +0.2 0	<b>Quotation</b>
BDB L	LKC	L dimension tolerance change L +0.4 → +0.05 +0.2 0	

Alteration	Code	Spec.	1Code
BDU BDB T	TKC	Head thickness tolerance change 5 +0.3 → +0.02 0 0	<b>Quotation</b>
BDU BDB V	VKC	V dimension tolerance change V +0.01 → +0.005 0 0	
BDU BDIS P	PKC	P dimension tolerance change P +0.01 → +0.005 0 0	

Price **Quotation**

## Features

1. Punched scraps are pushed into the inner bushing and held there, for an effective scrap retention.
2. It also knocks out the burring part at the same time. (Refer to the spring constant for the knockout force.)
3. The unit construction makes mounting and machining easier.
4. Because each component can be purchased separately, the die can be used even when there is no space to install the outer bushing.

## Notes for use

- Stroke Smax.=5mm
- Normal S=2~3mm
- However, use a stroke of S≥3mm in the following cases.

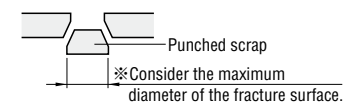
- ①Soft workpiece
- ②Thick workpiece

### Function of inner bushing chamfering

The chamfering prevents dents from being left on the formed surface during burring, and allows punched scraps to be easily pushed into the inner bushing. Slightly larger chamfering is performed for new units before delivery in order to provide a margin for assembly adjustment.

### Setting of P dimension for the inner bushing

The scrap which is generated varies depending on the machining conditions. Set dimension P so that the performance of this function is optimized.



### Spring for lifting the inner bushing

The spring is intended to lift the inner bushing. It is not intended to absorb shearing force. (Refer to the spring constant.)

