

# CARBIDE PILOT PUNCHES FOR FIXING TO STRIPPER PLATES

—TIP R AND TAPER COMBINED TYPE · MINUS HEAD TOLERANCE · NORMAL · LAPPING · TiCN COATING—

PRODUCTS DATA


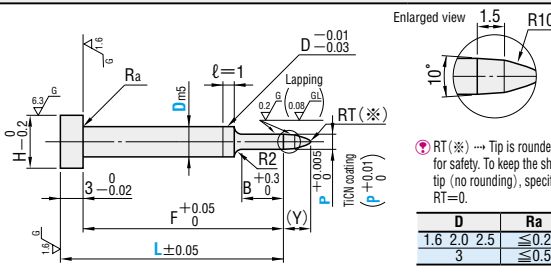
P.1604


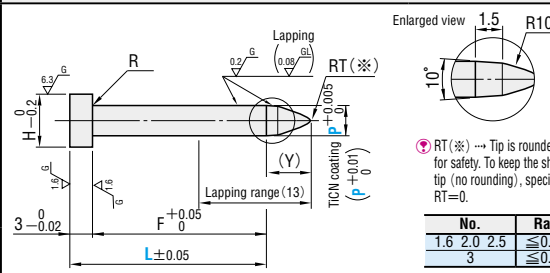
# CARBIDE STRAIGHT PILOT PUNCHES FOR FIXING TO STRIPPER PLATES

—TIP R AND TAPER COMBINED TYPE, MINUS HEAD TOLERANCE, NORMAL · LAPPING · TiCN COATING—

PRODUCTS DATA

P.1604

Type	M H	Catalog No.			Shape						
		Normal	Lapping	TiCN coating Surface hardness 3000HV							
					 <p>Enlarged view 1.5 R10</p> <p>RT (※) → Tip is rounded for safety. To keep the sharp tip (no rounding), specify RT=0.</p> <table border="1"> <tr> <th>D</th> <th>Ra</th> </tr> <tr> <td>1.6 2.0 2.5</td> <td>≤0.2</td> </tr> <tr> <td>3</td> <td>≤0.5</td> </tr> </table> <p>Ⓢ Although the marks of processing may remain in the center of a Shank end face, it is satisfactory on a function.</p>	D	Ra	1.6 2.0 2.5	≤0.2	3	≤0.5
D	Ra										
1.6 2.0 2.5	≤0.2										
3	≤0.5										
V30 (HIP) 88~89HRA	WSPTPF	L-WSPTPF	H-WSPTPF								

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V30 (HIP) 88~89HRA	WSPTF	L-WSPTF	H-WSPTF								

Catalog No.			0.1mm increments	0.001mm increments (With coating, 0.01mm increments)		B	H
Type	D	L	min.	P	max.		
Normal WSPTPF	1.6	10.0 ~ 32.0	0.800 (1.00) ~ 1.599	4	2.6		
Lapping L-WSPTPF	2.0						
TiCN coating H-WSPTPF	2.5						
	3						
		10.0 ~ 40.0	2.000 ~ 2.999		5		

Catalog No.			0.1mm increments	0.001mm increments (With coating, 0.01mm increments)		H
Type	No.	L	min.	P	max.	
Normal WSPTF	1.6	10.0 ~ 32.0	0.800 (1.00) ~ 1.600	2.6		
Lapping L-WSPTF	2.0					
TiCN coating H-WSPTF	2.5					
	3					
		10.0 ~ 40.0	2.000 ~ 3.000		5	

Ⓢ P > D - 0.03 → ℓ = 0 If P > D - 0.03, D = 0.01 (press-in lead) is not included. Ⓢ (Y) → Tip Y length = 0.6 + √(P - 0.2) (39.8 - P) / 4  
 Ⓢ The coating process also forms an extremely thin coating layer on the shank. Ⓢ P (1.00) → For TiCN coating is Pmin 1.00.

Ⓢ (Y) → Tip Y length = 0.6 + √(P - 0.2) (39.8 - P) / 4 Ⓢ P (1.00) → For TiCN coating is Pmin 1.00.

**Order** Catalog No. — L — P — (RT=0)  
 WSPTPF 2.0 — 28.0 — P1.900 — RTO  
 H-WSPTPF 2.5 — 30.0 — P2.20

Ⓢ [RT=0] only can be selected. (However, lapping cannot be used.)

**Features**

- These pilot punches for fixing to stripper plates were developed for use with press dies that are used with thin workpieces.
- The under-head dimension F is highly accurate and the tip is smoothly rounded.

**Order** Catalog No. — L — P — (RT=0)  
 WSPTF2.0 — 28.0 — P1.900 — RTO  
 L-WSPTF2.5 — 30.0 — P2.205

Ⓢ [RT=0] only can be selected. (However, lapping cannot be used.)

**Features**

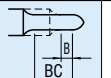
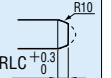

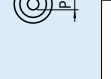
- These pilot punches for fixing to stripper plates were developed for use with press dies that are used with thin workpieces.
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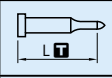
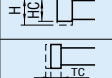
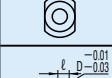

**Days to Ship** **Quotation**

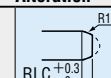
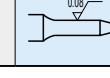
**Days to Ship** **Quotation**


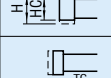


**Alterations** Catalog No. — L — P — (RT=0) — (BC·HC·TC, etc.)  
 WSPTPF3 — 28.0 — P2.500 — RTO — HC4.0

**Alterations** Catalog No. — L — P — (RT=0) — (RSC·HC·TC...etc.)  
 WSPTF 3 — 28.0 — P2.480 — RTO — HC4.0 — PKC

Alteration	Code	Spec.	1Code
	BC	Tip length change 2 ≤ BC ≤ Bmax. 0.1mm increments Ⓢ Full length L must be at least 8mm longer than tip length BC.	Quotation
	RLC	Tip R is cut flat. 3 ≤ RLC < Ymax. 0.1mm increments	
	PKC	Tip diameter tolerance change • Normal P +0.005 ⇨ +0.003 • Lapping P +0.01 ⇨ +0.005 • TiCN coating P +0.01 ⇨ +0.005 Ⓢ P dimension can be selected in 0.001mm increments.	
	PKV	Tip diameter tolerance change • Normal P +0.005 ⇨ ±0.002 • Lapping P +0.01 ⇨ ±0.005 • TiCN coating P +0.01 ⇨ ±0.005 Ⓢ P dimension increment remains the same.	
	SC	Tip roughness change 0.2 G ⇨ 0.08 GL The base material is finished before the coating is applied. Ⓢ Can be used for coating types only. Ⓢ RT=0 and R=0 cannot be selected.	

Alteration	Code	Spec.	1Code
	LKC	Full length tolerance change L ±0.05 ⇨ +0.05 Ⓢ F dimension tolerance F +0.05 ⇨ ±0.05	Quotation
	HC	Head diameter change D + 0.1 ≤ HC < H 0.1mm increments	
	TC	Head thickness change 2 ≤ TC < 3 0.1mm increments Ⓢ The full length remains as specified.	
	KC	Addition of single key flat to head	
	WKC	Addition of double key flats in parallel	
	NDC	No press-in lead ℓ ≥ 1 ⇨ ℓ = 0	

Alteration	Code	Spec.	1Code
	RLC	Tip R is cut flat. 3 ≤ RLC < Ymax. 0.1mm increments	Quotation
	PKC	PKC	
PKV		Tip diameter tolerance change • Normal P +0.005 ⇨ ±0.002 • Lapping P +0.01 ⇨ ±0.005 • TiCN coating P +0.01 ⇨ ±0.005 Ⓢ P dimension increment remains the same.	
	SC	Tip roughness change 0.2 G ⇨ 0.08 GL The base material is finished before the coating is applied. Ⓢ Can be used for coating types only. Ⓢ RT=0 and R=0 cannot be selected.	

Alteration	Code	Spec.	1Code
	LKC	Full length tolerance change L ±0.05 ⇨ +0.05 Ⓢ F dimension tolerance F +0.05 ⇨ ±0.05	Quotation
	HC	Head diameter change 2.6 ≤ P + 0.1 ≤ HC < H 0.1mm increments	
	TC	Head thickness change 2 ≤ TC < 3 0.1mm increments Ⓢ The full length remains as specified. Ⓢ Cannot be used with TiCN coating.	
	KC	Addition of single key flat to head	
	WKC	Addition of double key flats in parallel	

**Price** **Quotation**

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