

MOVABLE CARBIDE PILOT PUNCHES



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Type	Shank diameter D tolerance	M	Catalog No.	Shape
Tip R type 	Dg6	V30 (HIP) 88~89HRA	WSUPT —Lapping— L—WSUPT —TiCN coating— H—WSUPT	 For the length of tip R, refer to the products data "Punch R length". P.1592 RT=0 with lapping cannot be selected. RT(*) → If R<8, tip is rounded for safety. To keep the sharp tip (no rounding), specify RT=0. P.1592 Although the marks of processing may remain in the center of a Shank end face, it is satisfactory on a function.
	D _{-0.005} -0.010		A—WSUPT —Lapping— AL—WSUPT —TiCN coating— AH—WSUPT	
Tapered tip type 	Dg6	V30 (HIP) 88~89HRA	WTUPT —Lapping— L—WTUPT —TiCN coating— H—WTUPT	 Although the marks of processing may remain in the center of a Shank end face, it is satisfactory on a function.
	D _{-0.005} -0.010		A—WTUPT —Lapping— AL—WTUPT —TiCN coating— AH—WTUPT	
Sharp tip angle type 	Dg6	V30 (HIP) 88~89HRA Surface 3000HV	WUPT —Lapping— L—WUPT —TiCN coating— H—WUPT	 Although the marks of processing may remain in the center of a Shank end face, it is satisfactory on a function.
	D _{-0.005} -0.010	A—WUPT —Lapping— AL—WUPT —TiCN coating— AH—WUPT		

Alteration	Code	Tip R type	Tapered tip and sharp tip angle types	1Code
Alterations to tip	PC	PC ≥ Pmin./2 0.01mm increments If PC is 0.500 ~ 0.999, Bmax. is 8mm. — Coating type— P ≥ Pmin./2 ≥ 1.00 0.01mm 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.		Quotation
	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.		
RLC	Tip R is cut flat. Allowable range of change 2 ≤ RLC < √P (10-P/4) 0.1mm increments			

Alteration	Code	Tip R type	Tapered tip and sharp tip angle types	1Code
Alterations to tip	BKC		Tip length tolerance change B +0.3 ⇔ +0.05	
	SC		Tip roughness change The base material is finished before the coating is applied. R=0 → R ≤ 0.2	
	GC		Tip angle change 15° < GC ≤ 45° 1° increments Cannot be used for tapered tip types.	Quotation
	YC		Tip taper length change - If YC < 2.0, 1 ≤ YC ≤ P × 2.83 - 0.3 - If P ≥ 2.0, 1 ≤ YC ≤ P × 1.86 - 0.3 ≤ 12 L (LC) + YC ≤ Lmax. + 8 0.1mm increments Cannot be used for sharp tip angle types.	
Alterations to full length	LC		Full length change B + 9 ≤ LC < L 0.1mm increments	

P Price **Quotation**

EX Example

Features

- No height adjustment is required after regrinding.
- Because it is possible to remove the pilot punch without disassembling the die, the number of steps required for regrinding can be reduced.
- Even if a misfeed occurs, because the pilot punches themselves are moveable, it is possible to prevent the punch from biting into the workpiece or being broken.

Catalog No.		0.1mm increments			0.001mm increments (With coating, 0.01mm increments)		0.1mm increments		Y
Type	D	L	L	L	min. P	max.	B		
(Dg6) (Tip R)	WSUPT	WTUPT	WUPT			1.000 ~ 2.500	5 ≤ B ≤ 23 TiCN coating 5 ≤ B ≤ L/2 ≤ 23	2	
(D _{-0.005} -0.010) (Tapered tip)	A—WSUPT	A—WTUPT	A—WUPT			1.500 ~ 3.500			
(Dg6) (Sharp tip angle)	L—WSUPT	L—WTUPT	L—WUPT			2.000 ~ 4.500		3	
(D _{-0.005} -0.010) (Lapping)	AL—WSUPT	AL—WTUPT	AL—WUPT			2.500 ~ 5.500			
(Dg6) (TiCN coating)	H—WSUPT	H—WTUPT	H—WUPT			3.000 ~ 7.500			
(D _{-0.005} -0.010) (TiCN coating)	AH—WSUPT	AH—WTUPT	AH—WUPT					5	

P dimension increment → If coated, 0.001mm increments can be selected for alteration PKC.

Order **Catalog No.** — L — P — B
WUPT 6 — 62 — P4.320 — B20

Days to Ship **Quotation**