SCRAP RETENTION CARBIDE BLOCK DIES

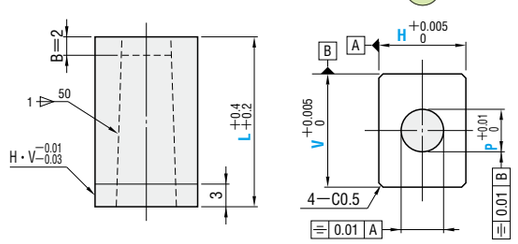
—STRAIGHT TYPE / SINGLE FLANGE TYPE—

PRODUCTS DATA P.1619

—Straight— RoHS

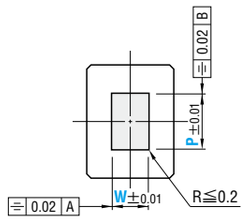
M H	Catalog No.
V40(HIP) 87～88HRA	Ⓐ SR—WBLD Ⓓ SR—WBLDD Ⓡ SR—WBLDR Ⓔ SR—WBLDE Ⓖ SR—WBLDG

Hole shape Ⓐ



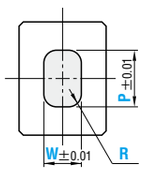
Ⓟ P⋯→ min. W max.
P dimension must be within the range of W dimension.

Hole shape Ⓓ



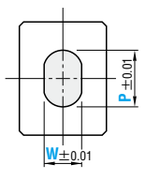
Ⓟ P≧W
Ⓟ P−0.4≧1.5
(P dimension straight section 1.5 mm or longer)

Hole shape Ⓡ



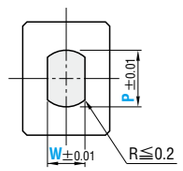
Ⓟ P≧W Ⓟ 0.15≦R＜$\frac{W}{2}$
Ⓟ P−2R≧1.5
(P dimension straight section 1.5 mm or longer)

Hole shape Ⓔ



Ⓟ P＞W

Hole shape Ⓖ

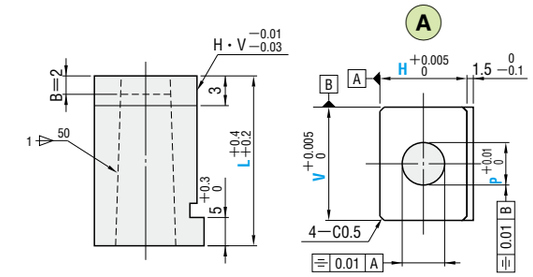


Ⓟ P＞W
Ⓟ $\sqrt{P^2-W^2}$≧1.5
(P dimension straight section 1.5 mm or longer)

—Single flange— RoHS

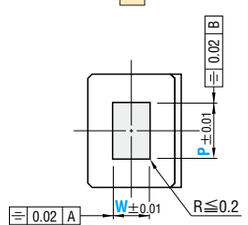
M H	Catalog No.
V40(HIP) 87～88HRA	Ⓐ SR—WBLDF Ⓓ SR—WBLDDF Ⓡ SR—WBLDRF Ⓔ SR—WBLDEF Ⓖ SR—WBLDGF

Hole shape Ⓐ



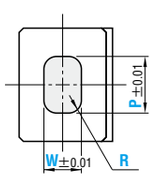
Ⓟ P⋯→ min. W max.
P dimension must be within the range of W dimension.

Hole shape Ⓓ



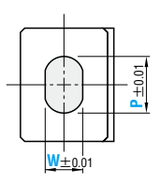
Ⓟ P≧W
Ⓟ P−0.4≧1.5
(P dimension straight section 1.5 mm or longer)

Hole shape Ⓡ



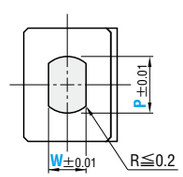
Ⓟ P≧W Ⓟ 0.15≦R＜$\frac{W}{2}$
Ⓟ P−2R≧1.5
(P dimension straight section 1.5 mm or longer)

Hole shape Ⓔ



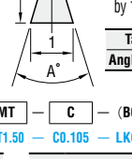
Ⓟ P＞W

Hole shape Ⓖ



Ⓟ P＞W
Ⓟ $\sqrt{P^2-W^2}$≧1.5
(P dimension straight section 1.5 mm or longer)

Catalog No.		H	V min. W max. / min. P max.	6	8	10	13	16	20	25	R	L	MT (workpiece material thickness)	C (clearance)
				1.00～3.00	1.00～4.00	1.00～6.00	1.00～8.00	1.00～10.00	1.50～12.00	1.50～16.00	R		0.01mm increments	0.005mm increments
Straight	Single flange													
Ⓐ SR—WBLD	SR—WBLDF	6	1.00～3.00	○	○	○	○	○	○	○	0.15≦R＜$\frac{W}{2}$ (Ⓡ only)	16	MT≧0.15 Select a workpiece material thickness of 0.15mm or more.	C≧0.010 Select a clearance of 0.010mm or more.
Ⓓ SR—WBLDD	SR—WBLDDF	8	1.00～4.00		○	○	○	○	○	○		20		
Ⓡ SR—WBLDR	SR—WBLDRF	10	1.00～6.00			○	○	○	○	○		22		
Ⓔ SR—WBLDE	SR—WBLDEF	13	1.00～8.00				○	○	○	○		25		
Ⓖ SR—WBLDG	SR—WBLDGF	16	1.00～10.00					○	○	○		30		
		20	1.50～12.00						○	○		35		
		25	1.50～16.00							○				



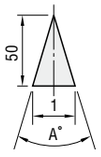
Ⓟ P・W・R⋯→0.01mm increments Ⓟ Can be used only for workpiece materials with tensile strengths up to 1177N/mm² (120kgf/mm²).
Ⓟ Workpiece material thickness and clearance are used as machining data for the scrap retention. Specify the shaped hole dimensions (P・W・R) when selecting the die finishing dimensions.

Ⓟ Price Quotation

Order

Catalog No.	V	H	—	L	—	0.01mm increments P	W	R (Ⓡ only)	—	MT	—	C
SR—WBLDRF	13	10	—	22	—	P7.65	W4.65	R0.50	—	MT1.50	—	C0.105

Days to Ship Quotation



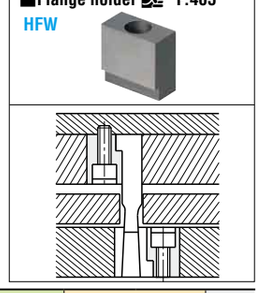
• 1 50 indicates a taper in which the diameter increases by 1mm over 50mm of length.

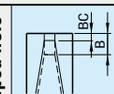
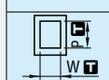
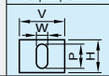
Taper	1/50
Angle (A°)	1.146°

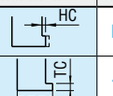
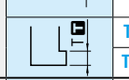
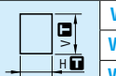
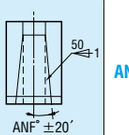
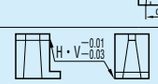
Alterations

Catalog No.	V	H	—	L(LC)	—	P—W—R	—	MT	—	C	— (BC・LKC, etc.)
SR—WBLDF	08	06	—	20	—	P2.25	—	MT1.50	—	C0.105	— LKC—ANF1.2

■Flange holder P.465
HFW



Alteration		Code	Ⓐ	ⒹⓇⒺⒼ	1Code
Alterations to shaped hole		BC	Shaped hole depth change 1≦BC＜Bmax. 0.1mm increments P: 1.00～1.99 Bmax. 3; 2.00～ Bmax. 4	Shaped hole depth change 1≦BC＜2 0.1mm increments	Quotation
		PKC	Shaped hole tolerance change $P^{+0.01}_{0}$ ⇨ $^{+0.005}_{0}$	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→min. W max.	
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 $L^{+0.4}_{+0.2}$ ⇨ $^{+0.05}_{0}$		
		LKZ	Full length tolerance change $L^{+0.4}_{+0.2}$ ⇨ $^{+0.01}_{0}$		

Alteration		Code	Ⓐ	ⒹⓇⒺⒼ	1Code
Alterations to flange		HC	Flange width change 0≦HC＜1.5 0.1mm increments		Quotation
		TC	Flange thickness change 2≦TC＜5 0.1mm increments (If combined with TKC・TKM, 0.01mm increments can be selected.) Ⓟ Full length is shortened by (5—TC). If combined with LC, full length is equal to LC.		
		TKC	Flange thickness tolerance change $T^{+0.3}_{0}$ ⇨ $^{+0.02}_{0}$		
		TKM	Flange thickness tolerance change $T^{+0.3}_{0}$ ⇨ $^{0}_{-0.02}$		
Others		VKC	Shape tolerance change $H・V^{+0.005}_{0}$ ⇨ $^{+0.003}_{0}$		
		VKM	Shape tolerance change $H・V^{+0.005}_{0}$ ⇨ $^{0}_{-0.003}$		
		VHM	Shape tolerance change $H・V^{+0.005}_{0}$ ⇨ $^{0}_{-0.005}$		
		ANF	Angular angle change 0≦ANF≦1.2 0.2° increments Ⓟ d≦dmax. Ⓟ d=P+2{(L—B)tan(ANF°)} P—B tan(ANF°)≧0.6 W—B tan(ANF°)≧0.6	V / d max.: 6 3.4; 8 4.4; 10 6.4; 13 8.4; 16 10.6; 20 12.6; 25 14.6 Taper 1/50; Angle (one side) 0.573°	
		NDC	 ⇨No press-in lead		