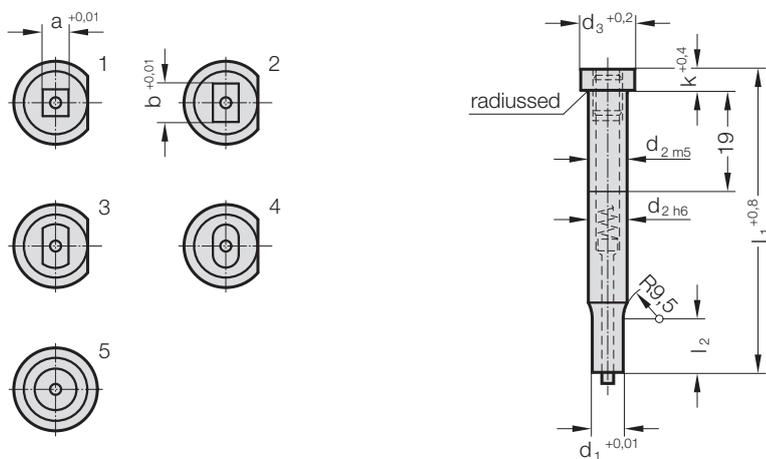


PUNCH WITH EJECTOR PIN, STEPPED, SHORT POINT

268.



Material:

HSS
Order No 268.3.
Hardness:
Shaft 64 ± 2 HRC
Head 52 ± 5 HRC

Description of FIBRO materials for tool and die components see at the beginning of Chapter E.

Execution:

Punch head hot upset-forged. Shaft and shoulder precision plunge-ground.

Key flats parallel with longest size of shape, unless otherwise specified.

Note:

With kerf ≤ 0.04 mm, FIBRO rounds off sharp edges for shape 1 and shape 2 if the punch and piercing die bushing are ordered together. This reduces the fitting time and the risk of an edge break during operation.

268.

Punch with ejector pin, stepped, short point

d_1	d_2	d_3	k	l_2	a_{min}	l_1	60	71	80	90	100
1.6 - 4.9	5	8	5	7	1.6		●	●	●	●	●
2.3 - 5.9	6	9	5	7	2.3		●	●	●	●	●
3.2 - 7.9	8	11	5	13	3.2		●	●	●	●	●
4.8 - 9.9	10	13	5	13	4.8		●	●	●	●	●
4.8 - 12.9	13	16	5	13	4.8		●	●	●	●	●
5.5 - 15.9	16	19	6.4	13	5.5		●	●	●	●	●
5.5 - 19.9	20	23	6.4	13	5.5		●	●	●	●	●
6.5 - 24.9	25	28	6.4	13	6.5		●	●	●	●	●

Ordering Code (example):

Punch with ejector pin, stepped, short point	=	268.3.
Shaft diameter d_2	13 mm =	1300.
Length l_1	60 mm =	060.
Cutting form FORM	square =	1.
Cutting form width a	4.8 mm =	0480.
Cutting form length b	4.8 mm =	0480
Order No	=	268.3. 1300.060. 1. 0480. 0480