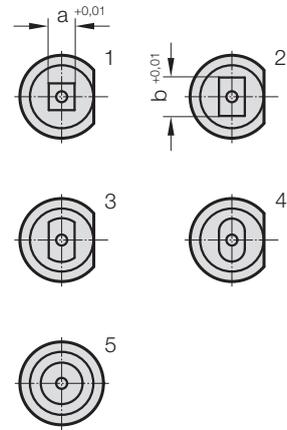
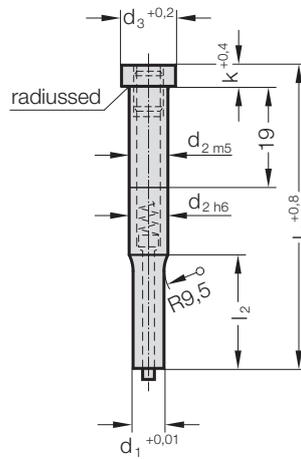


PUNCH WITH EJECTOR PIN, STEPPED, LONG POINT



269.



269. Punch with ejector pin, stepped, long point

d ₁	d ₂	d ₃	k	l ₂	a _{min}	l ₁	60	71	80	90	100
2,3 - 5,9	6	9	5	17,5	2,3		●	●	●	●	●
3,2 - 7,9	8	11	5	25	3,2		●	●	●	●	●
4,8 - 9,9	10	13	5	28	4,8		●	●	●	●	●
4,8 - 12,9	13	16	5	28	4,8		●	●	●	●	●
5,5 - 15,9	16	19	6,4	28	5,5		●	●	●	●	●
5,5 - 19,9	20	23	6,4	28	5,5		●	●	●	●	●
6,5 - 24,9	25	28	6,4	28	6,5		●	●	●	●	●

Material:

HSS
 Order No 269.3.
 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.

Ordering Code (example):

Punch with ejector pin, stepped, long point	=	269.3.
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	=	269.3. 1300.060. 1. 0480. 0480