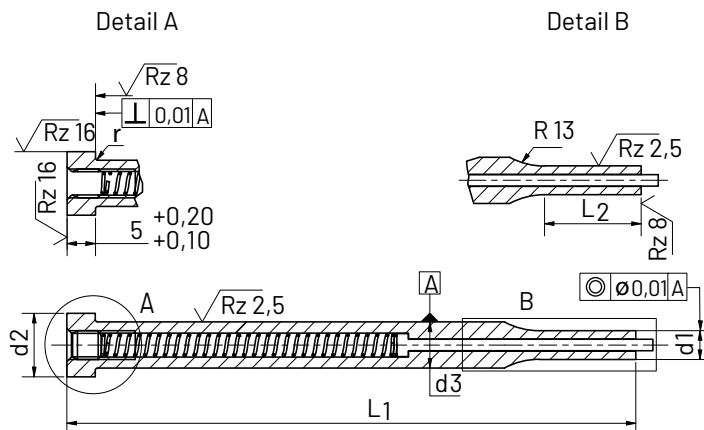


3 Prebijalna igla Cutting Punch

DIN ISO 8020 F



Precizna obdelava: z reducirnim rezilnim delom, cilindrično glavo, z odlepnikom ter brušeno.

Precision design: reduced cutting point, cylinder head, ejector, plunge cut ground.

Prebijalna igla s cilindrično glavo.

Cutting Punch with Cylindrical Head.

Obseg uporabe:

Za rezilna orodja za rezanje lukenj v jeklo. Posebej primerna za hiter izmet odrezkov iz matrice. Dimenzije so prikazane v tabeli.

Prileganje / Toleranca:

Premer reducirnega dela d_3

Ø	1,6-3	3-6	6-10	10-18	18-30	30-31,9
	+0,004	+0,006	+0,007	+0,008	+0,009	+0,011
J6	-0,002	-0,002	-0,002	-0,003	-0,004	-0,005

Premer stebra d_1

Ø	5+6	8+10	13+16	20+25	32
M5	+0,009	+0,012	+0,015	+0,017	+0,020
	+0,004	+0,006	+0,007	+0,008	+0,009

Dolžina: celotna L_{+1}

Reducirni del $L_{1+0,5}$

Material:

HSS (hitrorezno jeklo)
CPM 10 V

Na voljo tudi v drugih materialih. Poglejte tabelo materielov.

Lastnosti materiala:

HSS: z ekstremno močno trpežnostjo, za materiale, s katerimi se težko dela. Velika odpornost proti obrabi, visoka natezalna trdnost, visoka odpornost proti pregretju.

Range of application:

Cutting tools for cutting holes in steel. Especially suitable for fast ejection from the matrix. The dimensions are shown in the table.

Fit / Tolerance:

Diameter of the reducer part d_3

Shank diameter d_1

Ø	5+6	8+10	13+16	20+25	32
M5	+0,009	+0,012	+0,015	+0,017	+0,020
	+0,004	+0,006	+0,007	+0,008	+0,009

Length: total L_{+1}

Reduced point: $L_{1+0,5}$

Material:

HSS (High speed steels)
CPM 10 V

Other materials available on request, see material table.

Material properties:

HSS: with extremely strong durability for materials which are difficult to process. High abrasion resistance, high tear strength, high resistance to overheating.

Opomba | Note

V kompletu rezilne igle je posebna vzmet, vijak ter izmetač. Trdota vzmeti se nastavlja z vijakom na glavi.

These punch pins are fully supplied with special springs, screws and ejector. The Hardness: of the spring can be adjusted.



Različica

Brez navzkrižne luknje zatič z vzmetjo

Trdota:

Kaljeno, toplotno obdelano, kompletno sestavljeno

Steblo: HRC 62 - 66

Glava: HRC 45-55

Obdelava:

Kaljeno, popuščeno, cilindrična glava vroče kovana, po celotni dolžini naknadno brušeno steblo, vključno pod glavo - z radiusom, brušena površina glave.

Version

- without cross hole
- with spring loaded pin

Hardnes:

Hardened, tempered, shaft fine grinded, completely assembled

Shaft: HRC 62 - 66

Head: HRC 45- 55

Finish:

Hardened, tempered, cylinder head hot forged, subsequently ground over the entire length, including under the head radius, ground surface of the head.

HSS

Ø d3 j6	Stopnjevanje Gradation d3	Ø d2 0,25 -0,25	Ø d1 m5	r ±0,1 0,	L1 +0,5 0,	E	H+ 0,25	L+1				
								63	71	80	90	100
1,6 - 5,9	0,1	8	5	0,3	10	1,0	5	●	●	●	●	●
2,5 - 7,9		9	6		13			●	●	●	●	●
3,0 - 7,9		11	8					●	●	●	●	●
4,0 - 9,9		13,	10		17	1,4		●	●	●	●	●
5,0 - 12,9		16	13	0,4				●	●	●	●	●
8,0 - 18,9		19	16			2,1		●	●	●	●	●
12,0 - 19,5		23	20							●	●	●
16,5 - 24,9	0,5	28	25							●	●	●
20,0 - 31,9		35	32							●	●	●

CPM 10V

Ø d1 j6 [mm]	Stopnjevanje Gradation d1	d2 0 - 0,15 [mm]	d3 m5 [mm]	R 0 -0,2 [mm]	L2 +0,05 0 [mm]	L1 +0,05 +0,2			
						71	80	90	100
1,6 - 5,9	0,1	9	6	0,3	10	●	●	●	●
2,5 - 7,9	0,1	11	8		13	●	●	●	●
4,0 - 9,9		13	10		17	●	●	●	●
5,0 - 12,9		16	13	0,4		●	●	●	●
8,0 - 15,9		19	16			●	●	●	●
12,0 - 19,5	0,5	23	20			●	●	●	●
16,5 - 24,5		28	23			●	●	●	●