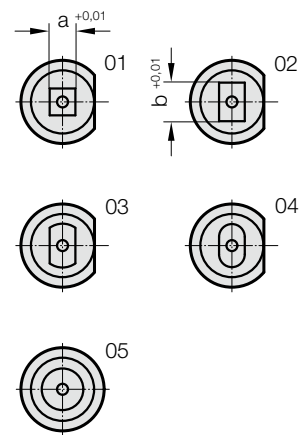
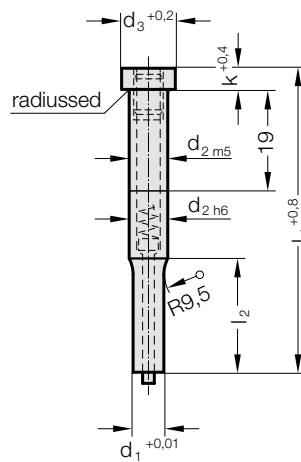


PUNCH WITH EJECTOR PIN, STEPPED, LONG POINT



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 01 and shape 02 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 =	01.
Cutting form width a	4.8 mm =	0480.
Cutting form length b	4.8 mm =	0480
Order No	=	269.3. 1300. 060. 01.0480. 0480