

BLOCK PUNCHES LIST

GUIDE

■BLOCK PUNCHES

Type	Material	Standard	TiCN coating type	Free size type
Normal	SKD11	HP	P.275	FHP
	SKH51	HSP		P.303
	Powdered high-speed steel	PHP		P.299
With tapping	SKD11	HM	P.277	FHM
	SKH51	HSM		P.303
	Powdered high-speed steel	PHM		P.299
Jector With tapping	SKD11	HJM	P.279	
	SKH51	HSJM		P.307
	Powdered high-speed steel	PHJM		
With key groove	SKD11	HK	P.281	FHK
	SKH51	HSK		P.303
	Powdered high-speed steel	PHK		P.299
Jector With key groove	SKD11	HJK	P.283	
	SKH51	HSJK		P.307
	Powdered high-speed steel	PHJK		
Single flange	SKD11	HF	P.285	FHF
	SKH51	HSF		P.303
	Powdered high-speed steel	PHF		P.299
Jector Single flange	SKD11	HJF	P.287	
	SKH51	HSJF		P.307
	Powdered high-speed steel	PHJF		
Double flange	SKD11	HW	P.289	FHW
	SKH51	HSW		P.303
	Powdered high-speed steel	PHW		P.299
Jector Double flange	SKD11	HJW	P.291	
	SKH51	HSJW		P.307
	Powdered high-speed steel	PHJW		
Flange thickness 10mm Single flange	SKD11	AHF	P.293	
	SKH51	AHSF		P.311
	Powdered high-speed steel	APHF		
Flange thickness 10mm Double flange	SKD11	AHW	P.295	
	SKH51	AHSW		P.311
	Powdered high-speed steel	APHW		
Stopper-flange type	SKD11	HT	P.297	
	SKH51	HST		
	Powdered high-speed steel	PHT		
Straight	SKD11	HPC	P.313	
	SKH51	HSPC		P.321
	Powdered high-speed steel	PHPC		
Straight With tapping	SKD11	HMC	P.313	
	SKH51	HSMC		P.321
	Powdered high-speed steel	PHMC		
Jector Straight With tapping	SKD11	HJMC	P.317	
	SKH51	HSJMC		P.323
	Powdered high-speed steel	PHJMC		
Straight With key groove	SKD11	HKC	P.313	
	SKH51	HSKC		P.321
	Powdered high-speed steel	PHKC		
Jector Straight With key groove	SKD11	HJKC	P.317	
	SKH51	HSJKC		P.323
	Powdered high-speed steel	PHJKC		
Straight Single flange	SKD11	HF	P.313	
	SKH51	HSF		
	Powdered high-speed steel	PHF		
Jector Straight Single flange	SKD11	HJF	P.317	
	SKH51	HSJF		
	Powdered high-speed steel	PHJF		
Straight Double flange	SKD11	HW	P.313	
	SKH51	HSW		
	Powdered high-speed steel	PHW		
Jector Straight Double flange	SKD11	HJW	P.317	
	SKH51	HSJW		
	Powdered high-speed steel	PHJW		
Short Straight with Tapping	SKD11	HMCDS	P.325	
	Powdered high-speed steel	PHMCDS		
Short Straight with Single Flange	SKD11	HFCDS	P.325	
	Powdered high-speed steel	PHFCDS		
Short Straight with Double Flanges	SKD11	HWCDS	P.325	
	Powdered high-speed steel	PHWCDS		

■BLOCK PUNCH BLANKS

Type	Material	Standard
Normal	SKD11	HPB (H6~30)
	SKH51	HPB (H3~5)
	Powdered high-speed steel	PHPB
With tapping	SKD11	HMB (H6~30)
	SKH51	HMB (H5)
	Powdered high-speed steel	PHMB
Jector With tapping	SKD11	HJMB
	SKH51	
	Powdered high-speed steel	
With key groove	SKD11	HKB (H6~30)
	SKH51	HKB (H3~5)
	Powdered high-speed steel	PHKB
Jector With key groove	SKD11	HJKB
	SKH51	
	Powdered high-speed steel	
Single flange	SKD11	HFB (H6~30)
	SKH51	HFB (H3~5)
	Powdered high-speed steel	PHFB
Jector Single flange	SKD11	HJFB
	SKH51	
	Powdered high-speed steel	

Type	Material	Standard
Double flange	SKD11	HWB (H6~30)
	SKH51	HWB (H3~5)
	Powdered high-speed steel	PHWB
Jector Double flange	SKD11	HJWB
	SKH51	
	Powdered high-speed steel	
Stopper-flange type	SKD11	HTB (H6~30)
	SKH51	HTB (H3~5)
	Powdered high-speed steel	PHTB
Short with tapping	SKD11	HMB
	SKH51	
	Powdered high-speed steel	
Short with Single Flange	SKD11	HFBS
	SKH51	
	Powdered high-speed steel	PHFBS
Short with Double Flanges	SKD11	HWBS
	SKH51	
	Powdered high-speed steel	PHWBS

■Example of selecting Catalog No.

M	Catalog No.			Shape	Point length	Diagram	Shape	Shape	Shape	Shape
	Type	Shape	Point length							
(H3~5) SKH51 61~64HRC	HP	D	S	D	S		D	R	E	G
SKH51 61~64HRC	HSP (H6~30)	R	L	R	L					
PM high speed steel 64~67HRC	PHP	G		G						

Ⓞ W ≤ P ≤ W × 20 Ⓞ W ≤ P ≤ W × 20 Ⓞ W ≤ P ≤ W × 20 Ⓞ W < P ≤ W × 20
 Ⓞ R = 0 : Also available Ⓞ 0.15 ≤ R < W/2 Ⓞ 0.01mm increments
 Ⓞ In the case of P=W and W=H, the tip tolerance uses P and W tolerances.

(Example)

- Select powdered high-speed steel. ⇨ Type **PHP**
- Select shape : **D** ⇨ Shape **D**
- Select short point length : **S** ⇨ Point length **S** ※Catalog No. is **PHPDS**

■Basis of tolerance for block punch

BASIS OF TOLERANCE	Standard	For VKC alteration
Perpendicularity	 $H \leq 10 \cdots a \leq 0.005$ $10 < H \leq 30 \cdots a \leq 0.01$	$a \leq 0.005$ (V, H only)
Parallelism	 $b \leq 0.01$	$b \leq 0.005$ (V, H only)
Warpage	 $c \leq 0.01$	$c \leq 0.005$ (H only)
Camber of point	 $d \leq 0.01$	$d \leq 0.01$
Perpendicularity of the head	 $e \leq 0.01$	$e \leq 0.01$