

CARBIDE BUTTON DIES

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Name	CARBIDE BUTTON DIES	SCRAP RETENTION CARBIDE BUTTON DIES	CARBIDE BUTTON DIES FOR PREVENTING CLOGGING OF SCRAP
Catalog No.	(3)-(5)(B)	(3)-(5)(B)	(3)
Delivery	443	445	447
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Name	CARBIDE ANGULAR BUTTON DIES	SCRAP RETENTION CARBIDE ANGULAR BUTTON DIES	CARBIDE ANGULAR BUTTON DIES FOR PREVENTING CLOGGING OF SCRAP
Catalog No.	(3)-(5)(B)-(B)	(3)-(5)(B)	(3)
Delivery	449	451	453
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SPACER FOR BUTTON DIE
—For angular button die—

(3)(A)

456



SPACER FOR BUTTON DIE
—For straight button die drain hole—

(1)

456

Name	CARBIDE BUTTON DIE BLANKS	SPACER FOR BUTTON DIE —For angular button die—	SPACER FOR BUTTON DIE —For straight button die drain hole—
Catalog No.	(3)(A)	(3)(A)	(1)
Delivery	455	456	456
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CARBIDE BUTTON DIES

—GUIDE—

These products are manufactured and sold exclusively in Japan by MISUMI with the technical tie-up with KRANSKI GmbH in Germany.

Type	Material	Shank dimension tolerance	Normal		page	For scrap retention		For preventing crogging of scrap		
			Round	Shaped		Round	Shaped	Round	page	
Carbide head type	V40(HIP)	Dm5 D ^{+0.005} ₀	WHD	WHD□	P.443	SR—WHD	SR—WHD□	P.445	SV—WHD	P.447
			A—WHD	A—WHD□		SRA—WHD	SRA—WHD□		SVA—WHD	
Carbide straight	V40(HIP)	Dn5 D ^{+0.005} ₀	WSD	WSD□	P.443	SR—WSD	SR—WSD□	P.445	SV—WSD	P.447
			A—WSD	A—WSD□		SRA—WSD	SRA—WSD□		SVA—WSD	
Carbide angular head type	V40(HIP)	Dm5 D ^{+0.005} ₀	WAHD	WAHD□	P.449	SR—WAHD	SR—WAHD□	P.451	SV—WAHD	P.453
			A—WAHD	A—WAHD□		SRA—WAHD	SRA—WAHD□		SVA—WAHD	
Carbide angular straight type	V40(HIP)	Dn5 D ^{+0.005} ₀	WASD	WASD□	P.449	SR—WASD	SR—WASD□	P.451	SV—WASD	P.453
			A—WASD	A—WASD□		SRA—WASD	SRA—WASD□		SVA—WASD	

Scrap retention button dies (Products Data P.1137)

Available range

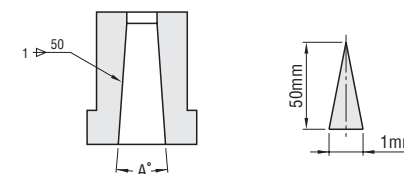
- Hole diameter..... $\phi 1.0 \sim \phi 16$
- Workpiece material..... With tensile strength up to 1177N/mm² (120Kgf/mm²)
- Thickness of machining materials..... 0.15mm or greater
- The scrap retention effect cannot be expected when the clearance (C) of either side is larger than the workpiece thickness (MT) by 20%. Therefore, keep the difference to 20% or less when using this type.

Either side of clearance (C) < workpiece thickness (MT) × 20%

The scrap retention button dies prevent a slug from being pulled up by forming small protrusions on the slug. Therefore, this type is not appropriate when precision holes are required or punched-out slugs are sold as a product.

Scrap retention button dies (Products Data P.1139)

Notation for dimensions of button die relief angle



1/50 indicates a taper having a length of 50mm with 1mm of broadened end.

Taper	1/50	1/100	1/150
Angle (A°)	1.146°	0.573°	0.382°