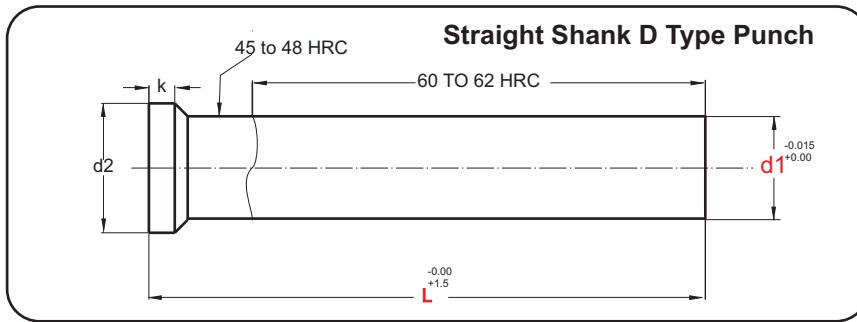


► Piercing Punches Type D

Reference Standard - IS 4296 / DIN 9861 Type D



Material :- High Speed Steel
(HSS) Grade M2 / HcHCr Grade
D2 (for sizes above 12mm)
Hardness :- 60 - 62 HRC
Head Hardness :- 45 - 48 HRC



d1 (-0.015)	d2 (-0.1)	L +1.5					K + 0.2
Increment of 0.1		50	70	80	90	100	
0.5	0.9	*	*				0.2
0.55	1.0	*	*				
0.6	1.1	*	*				
0.7	1.3	*	*				
0.8	1.4	*	*				
0.9	1.6	*	*				0.4
1.0-1.1	1.8	*	*	*			
1.2-1.3	2.0	*	*	*			0.5
1.4-1.5	2.2	*	*	*			
1.6-1.7	2.5	*	*	*	*		
1.8-1.9	2.8	*	*	*	*		
2	3.0	*	*	*	*	*	
2.1-2.2	3.2		*	*	*	*	
2.3-2.5	3.5		*	*	*	*	
2.6-2.9	4.0		*	*	*	*	
3.0-3.4	4.5		*	*	*	*	
3.5-3.9	5.0		*	*	*	*	
4.0-4.4	5.5		*	*	*	*	
4.5-4.9	6.0		*	*	*	*	
5.0-5.4	6.5		*	*	*	*	
5.5-5.9	7.0		*	*	*	*	
6.0-6.4	8.0		*	*	*	*	1
6.5-7.4	9.0		*	*	*	*	
7.5-8.4	10		*	*	*	*	
8.5-9.4	11		*	*	*	*	
9.5-10.4	12		*	*	*	*	
10.5-11.4	13		*	*	*	*	1.5
11.5-12.4	14		*	*	*	*	
12.5-13.4	15		*	*	*	*	
13.5-14.4	16		*	*	*	*	
14.5-15.4	17		*	*	*	*	
15.5-16.4	18		*	*	*	*	
16.5-17.4	19		*	*	*	*	
17.5-18.4	20		*	*	*	*	
18.5-19.4	21		*	*	*	*	
19.5-20.0	22		*	*	*	*	

Order Type :- Punch (Type) Dia (d1) X Length (L)

Example :- Punch (D) Dia 8 X 80