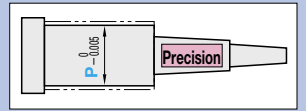


PRECISION TWO-STEP CORE PINS

—SHAFT DIAMETER (P) DESIGNATION (0.005mm INCREMENTS) TYPE—



Ⓜ Non JIS material definition is listed on P.1351 - 1352

RoHS	Part Number			
	Step 1	Material code	$\frac{M}{E}$	Step 2
CA CB CC CD CE	CA	ZB	SKD61 equivalent 48~52HRC	A
				B
				C
				D
				E
	VB	SKH51 equivalent 58~60HRC	B	
			C	
			D	
			E	
			E	

Step1 (shape for first step) select from CA~CE below

CA

Ⓜ $F+0.5 \leq Y$

CB

Ⓜ $F+0.7 \leq Y$

CC

Ⓜ $F + \frac{P-A}{2} + 0.5 \leq Y$

When AC code is used
 $F + \frac{P-A}{2 \tan AC} + 0.5 \leq Y$

CD

Ⓜ $C < \frac{P-A}{2}$

$C = \frac{P-A}{2}$ Ⓜ [Step1] CC

Ⓜ $C \leq 1.0$

Ⓜ $F+C+0.5 \leq Y$

Details of part ①

CE

Ⓜ $0.2 \leq R \leq \frac{P-A}{2}$

Ⓜ $F+R+0.5 \leq Y$

Details of part ②

Step2 (shape for second step)

A

(Designation of V=E possible)

Ⓜ $Y+0.5 \leq L$

B

Ⓜ $Y+0.7 \leq L$

C

Ⓜ $Y + \frac{V-J}{2} + 0.5 \leq L$

When AGC code is used
 $Y + \frac{V-J}{2 \tan AGC} + 0.5 \leq L$

Details of part ③

D

Ⓜ $Y+G+0.5 \leq L$

Details of part ④

H	Part Number		0.01mm increments		0.005mm increments		0.01mm increments					0.1mm increments				lmax.	
	Step1	Material	Step2	No.	min.	max.	F	Y	A	V	J	Emin.	C	R	G		Q
3				1.5								0.50					
4				2								0.70					
5				2.5	100.00							1.00					
6	CA	ZB	A	3								1.00					
7	CA	ZB	A	3.5								1.00					
8	CB	ZB	B	4	120.00							1.50					
9	CC	ZB	C	5								1.50					
10	CD	ZB	D	5.5	14.00							2.00					
11	CE	ZB	E	6								2.00					
15				10								2.50					
18				13								2.50					
21				16								2.50					
25				20	30.00							5.00					

Order **Part Number** - L - P - F - Y - A - V - J - E - C · R - G · Q

CBVBB6 - 62.10 - P5.555 - F42.00 - Y53.25 - A5.20 - V4.70 - J4.10 - E3.50

CDVBA8 - 70.00 - P7.255 - F43.50 - Y55.32 - A5.00 - V4.50 - E4.00 - C0.5

CEVBE6 - 55.75 - P5.980 - F43.50 - Y48.76 - A5.00 - V4.80 - J3.80 - E3.00 - R0.4 - Q0.4

Days to Ship **Quotation** Price **Quotation**

Alterations **Part Number** - L - P - F(FC) - Y - A - V - J - E - C · R - G · Q - (KC · WKC...etc.)

CEVBA5 - 56.50 - P4.800 - F48.00 - Y52.00 - A4.20 - V4.10 - E2.80 - R0.3 - RKC2.4

Alterations	Code	Spec.	1Code	Alterations	Code	Spec.	1Code
	KC	Single flat cutting P/2 ≤ KC < H/2			HC	Head diameter change HC=0.1mm increments P ≤ HC < H Ⓜ In relation to the diameter tolerance, alteration may create a straight piece with little diameter difference between the head and shaft.	
	WKC	Two flats cutting P/2 ≤ WKC < H/2			HCC	Head diameter change (precision) HCC=0.1mm increments P+0.5 ≤ HCC < H-0.3	
	KAC KBC	Varied width parallel flats cutting P/2 ≤ KAC < H/2 KBC=0.1mm increments only KAC < KBC < H/2			TC	Head thickness change TC=0.1mm increments 1.5 ≤ TC < 4 (Dimensions L, Y, and F remain unchanged) 4 - TC ≤ Lmax. - L	
	RKC	Two flats (right angled) cutting P/2 ≤ RKC < H/2			TRN	Relief under the head (No need for plate chamfering)	
	DKC	Three flats cutting P/2 ≤ DKC < H/2			NHC	Numbering on the head How to order Ⓜ P.442 Ⓜ Available when H ≥ 2 Ⓜ Combination with SKC not available.	
	SKC	Four flats cutting P/2 ≤ SKC < H/2			AC	Changes the standard angle (Ks=45°). AC=1° increments Ⓜ Available for [Step1] CC/CD Ⓜ 30 ≤ AC ≤ 60 Ⓜ When [Step1] CD : A+2(C×tanAC) < P	
	KGC	Two flats (angled) cutting P/2 ≤ KGC < H/2 0 < AG < 360 AG=1° increments			AGC	Changes the standard angle (Z=45°). AGC=1° increments Ⓜ Available for [Step2] C/D Ⓜ 30 ≤ AGC ≤ 60 Ⓜ When [Step2] D : J+2(G×tanAGC) < V	
	KTC	Three flats cutting at 120° P/2 ≤ KTC < H/2			FC	F dimension becomes shorter than Fmin. Makes L dimension shorter than L min. too. FC ≥ 5mm Ⓜ It can be designated up to Lmin.=6.5mm.	
					GVC	Gas vent machining GS · GB=1mm increments Ⓜ Available when P ≥ 2.00 Ⓜ 2 ≤ GS ≤ 10 GS+2 ≤ GB ≤ 30 Fmin. ≤ F-GB How to order Ⓜ P.442	

Ⓜ Refer to the [Step2] drawing for Y tolerance

Steps-Type
Round Core
Pins
Precision