

# SCRAP RETENTION REVERSE ANGULAR BUTTON DIES

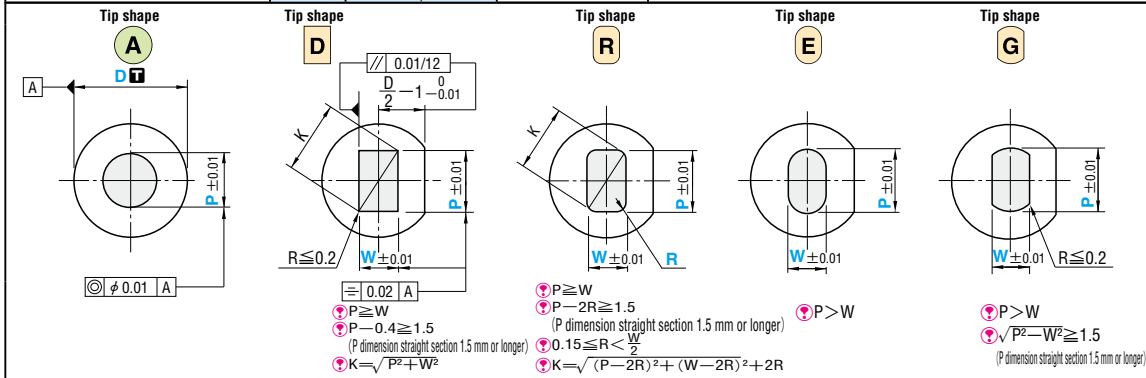
—STRAIGHT TYPE—

Patent pending



Straight type	Shank diameter D tolerance	M H	D dimension	Catalog No.	The hole shape can be selected from A D R E G below.
	Dn5	Equivalent to SKH51 61~64HRC Equivalent to SKD11 60~63HRC Equivalent to SKD11 60~63HRC	D5	SRT-ASD	
			D6~25	SRT-ASD	
			D8~25	SRT-ASD	
			D4~25	SRT-PASD	
			D8~25	SRT-PASD	
	D+0.005/0	Equivalent to SKH51 61~64HRC Equivalent to SKD11 60~63HRC Equivalent to SKD11 60~63HRC	D5	SRTA-ASD	
			D6~16	SRTA-ASD	
			D8~16	SRTA-ASD	
			D5~16	SRTA-PASD	
			D8~16	SRTA-PASD	

For shank diameter tolerance D tolerance, select either n5 or +0.005/0.



D	Shank diameter D tolerance		Catalog No.	L	0.01mm increments				MT	C	Select	FH
	n5	+0.005/0			Type	D	A	D R E G				
5	+0.013	+0.008	(Equivalent to SKH51) (Dn5) (D+0.005)	5	16 20 22 25 30	2.00~ 2.50	—	—	C >= 0.060 (But C >= 0.050 if the clearance is 10% or below C >= 0.050) Clearance 	Select the level of tensile strength Level tensile strength (N/mm²) H 800~ M 600~ L ~599	1.0~3.0	
6			(Equivalent to SKD11) (Dn5) (D+0.005)	6	16 20 22 25 30 35	2.00~ 3.00	—	—				
8	+0.016	+0.01		8	16 20 22 25 30 35	2.00~ 4.00	4.00	2.00				
10	+0.02			10	16 20 22 25 30 35	2.00~ 6.00	6.00	2.00				
13	+0.012			13	16 20 22 25 30 35	3.00~ 8.00	8.00	2.00				
16	+0.012			16	16 20 22 25 30 35	5.00~ 10.00	10.00	2.00				
(20)	+0.024	+0.005/0		(20)	16 20 22 25 30 35	7.00~ 12.00	12.00	3.00				
(25)	+0.015			(25)	16 20 22 25 30 35	10.00~ 16.00	16.00	3.00				
5	+0.013	+0.008	(Powdered high-speed steel) (Dn5) (D+0.005)	5	16 20 22 25 30	2.00~ 2.50	—	—				
6				6	16 20 22 25 30 35	2.00~ 3.00	—	—				
8	+0.016	+0.01		8	16 20 22 25 30 35	2.00~ 4.00	4.00	2.00				
10	+0.02			10	16 20 22 25 30 35	2.00~ 6.00	6.00	2.00				
13	+0.012			13	16 20 22 25 30 35	3.00~ 8.00	8.00	2.00				
16	+0.012			16	16 20 22 25 30 35	5.00~ 10.00	10.00	2.00				
(20)	+0.024			(20)	16 20 22 25 30 35	7.00~ 12.00	12.00	3.00				
(25)	+0.015			(25)	16 20 22 25 30 35	10.00~ 16.00	16.00	3.00				

D=(20) (25) are specifications available for shank diameter tolerance of Dn5 only  
 Use with the clearance (C) less than 20% of the processed plate material thickness (MT), otherwise the effect will not be as expected. Clearance (C) <= Proceed plate material thickness (MT) x 20%  
 P dimension will change if regrinding is applied. Note that the change amount varies with the taper width (max.0.05mm on one side) and taper depth & regrinding amount.

Order **Catalog No.** — L — P — W — R (R only) — MT — C — TS — FH  
 SRT-ASDE 8 — 20 — P3.80 — W2.00 — MT1.50 — C0.105 — H — FH2.0

Days to Ship **Quotation**

Alterations **Catalog No.** — L(LC-SLC) — P(PC) — W(WC) — R — MT — C — TS — FH — (KC...etc.)  
 SRT-ASD 6 — 16 — P2.47 — MT1.50 — C0.105 — H — FH2.0 — LKZ

Alterations	Code	A	D R E G	1Code
Alterations to shaped hole	PC WC	Shaped hole diameter change min: $P > WC \geq \frac{P-W}{2} \geq 2.00$ 0.01 mm increments		Quotation
		max: $\frac{P}{WC} \leq P \cdot K_{max} + 0.2$ 0.01 mm increments		
Alterations to full length	LC	Full length change $10 \leq LC < L$ 0.1 mm increments (If combined with LKC-LKZ, 0.01 mm increments can be selected.) Press-in lead is shortened by (L-LC).		
	LKC	Full length tolerance change $L + 0.4 \Rightarrow +0.05$ $L + 0.2 \Rightarrow 0$		
	LKZ	Full length tolerance change $L + 0.4 \Rightarrow +0.01$ $L + 0.2 \Rightarrow 0$		

Alterations	Code	A	D R E G	1Code																			
Alterations to full length	SLC	Changes to full length and full length tolerance are processed using a single code. The allowable range of change, increment, ordering process, and notes (⊕) are the same as for LC. Full length change + Full length tolerance change $L + 0.4 \Rightarrow +0.05$ $L + 0.2 \Rightarrow 0$		Quotation																			
		⊕ 0.01 mm increments ⊗ Cannot be used for L(LC) < 10.																					
Others	KC	Addition of single key flat ⊕ Can be combined with KC for shapes D R E G. ⊗ Cannot be used for D5~6.	Key flat position change $270^\circ$ $180^\circ$ $90^\circ$ 1° increments																				
	WKC	Addition of double key flats in parallel ⊕ Can be combined with KC for shapes D R E G. ⊗ Cannot be used for L(LC) < 16. ⊗ Cannot be used for D5~6.																					
	ANF	Angular angle change $0.6 \leq ANF \leq 1.2$ 0.2° increments ⊕ d ≤ dmax. ⊕ $d = P + 2(L - B) \tan(ANF)$ ⊕ $P - B \tan(ANF) \geq 0.6$ ⊕ $W - B \tan(ANF) \geq 0.6$ ⊗ Cannot be used for P, W < 1.0.	<table border="1"> <tr> <th>D</th> <th>d max.</th> </tr> <tr> <td>4</td> <td>2.4</td> </tr> <tr> <td>5</td> <td>2.9</td> </tr> <tr> <td>6</td> <td>3.4</td> </tr> <tr> <td>8</td> <td>4.4</td> </tr> <tr> <td>10</td> <td>6.4</td> </tr> <tr> <td>13</td> <td>8.4</td> </tr> <tr> <td>16</td> <td>10.6</td> </tr> <tr> <td>20</td> <td>12.6</td> </tr> <tr> <td>25</td> <td>16.6</td> </tr> </table>	D	d max.	4	2.4	5	2.9	6	3.4	8	4.4	10	6.4	13	8.4	16	10.6	20	12.6	25	16.6
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Price **Quotation**

BUTTON DIES