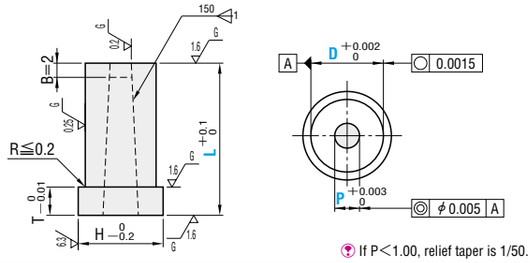
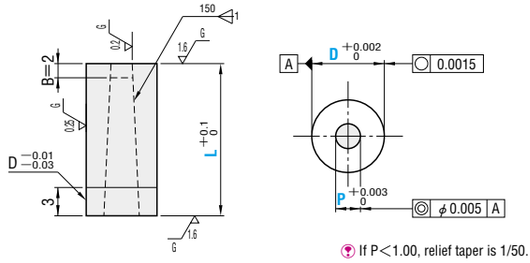
Type	M H	Catalog No.	Shape
—Headed— RoHS 	V40(HIP) 87～88HRA	SR—VAHD	 If P<1.00, relief taper is 1/50.
	Super fine grain (HIP) 90～92HRA	SR—VXAHD	
—Straight— RoHS 	V40(HIP) 87～88HRA	SR—VASD	 If P<1.00, relief taper is 1/50.
	Super fine grain (HIP) 90～92HRA	SR—VXASD	

Catalog No. Type	D	L	0.001mm increments min. P max.	MT (workpiece material thickness) 0.01mm increments	C (clearance) 0.001mm increments	H	T
Headed SR—VAHD SR—VXAHD / Straight SR—VASD SR—VXASD	3	13	0.800 ～ 1.000	MT≧0.10 Select a workpiece material thickness of 0.10mm or more.	C≧0.005 Select a clearance of 0.005mm or more. 	4	3
	4	16	0.800 ～ 1.500			5	
	5	20	0.800 ～ 2.500			6	
	6	22	1.000 ～ 3.000			9	5
	8		1.000 ～ 4.000			11	
	10	25	2.000 ～ 6.000			13	

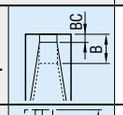
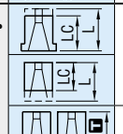
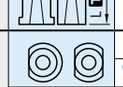
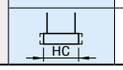
Can be used only for workpiece materials with tensile strengths up to 1177 N/mm² (120kgf/mm²).
Workpiece material thickness and clearance are used as machining data for the scrap retention.Specify the shaped hole dimension (P) when selecting the button die finishing dimensions.

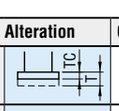
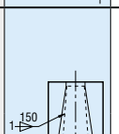
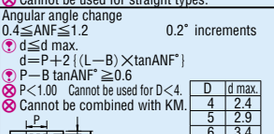
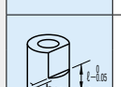
Order: Catalog No. — L — P — MT — C
SR—VAHD 6 — 20 — P2.500 — MT1.50 — C0.105

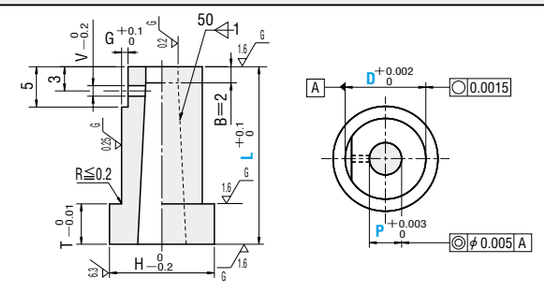
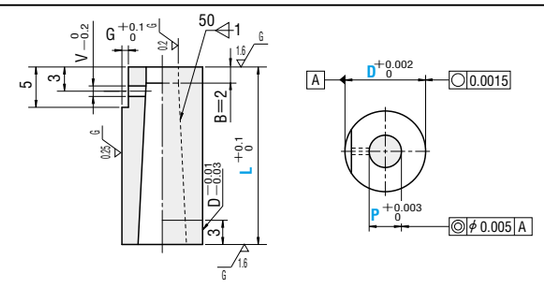
Price: Quotation

Days to Ship: Quotation

Alterations: Catalog No. — L(LC) — P — MT — C — (BC・HC・TC, etc.)
SR—VAHD 6 — LC18.5 — P2.500 — MT1.50 — C0.105 — LKC

Alteration	Code	Spec.	1Code
Shaped hole 	BC	Shaped hole depth change 1≦BC≦2 0.1mm increments	
Alterations to full length 	LC	Full length change for headed types 10≦LC<L 0.1mm increments (If combined with LKC, 0.01mm increments can be selected.)	Quotation
		Full length change for straight types 8≦LC<L 0.1mm increments (If combined with LKC, 0.01mm increments can be selected.)	
	LKC	Full length tolerance change L +0.1 0 ⇨ +0.01 0 ⊗ Cannot be used for L<16.	
Alterations to head 	KC	Addition of single key flat to head ⊗ Cannot be used for straight types ⊗ Cannot be combined with KFC.	
	WKC	Addition of double key flats in parallel ⊗ Cannot be used for straight types. ⊗ Cannot be combined with KFC.	
	KFC	270° 180° 90° 0° Double key flats at 0° and a selected angle1° increments ⊗ Cannot be combined with KC・WKC. ⊗ Cannot be used for L<16. ⊗ Cannot be used for straight types.	
	HC	Head diameter change D≦HC<H 0.1mm increments ⊗ Cannot be used for straight types.	

Alteration	Code	Spec.	1Code
Head 	TC	Head thickness change 2≦TC<T 0.1mm increments ⓡ Full length is shortened by (T—TC). ⓡ If combined with LC, full length is equal to LC. ⊗ Cannot be used for straight types.	
Alterations to shank 	ANF	Angular angle change 0.4≦ANF≦1.2 0.2° increments ⓡ d≦d max. d=P+2{(L—B)×tanANF°} ⓡ P—B tanANF°≧0.6 ⊗ P<1.00 Cannot be used for D<4. ⊗ Cannot be combined with KM.  D / d max.: 4 / 2.4; 5 / 2.9; 6 / 3.4; 8 / 4.4; 10 / 6.4. Taper 1/150, Angle (one side) 0.191°	Quotation
	KM	Addition of key groove to prevent lifting ⊗ Cannot be used for D<6. ⊗ Cannot be used for headed types. D / h / ℓ: 6 / 1 / 5≦ℓ<L; 8, 10 / 1.5 / 0.1mm increments. ⊗ Cannot be combined with ANF.	

Type	M H	Catalog No.	Shape
—Headed— RoHS 	V40(HIP) 87～88HRA	SV—VAHD	
	Super fine grain (HIP) 90～92HRA	SV—VXAHD	
—Straight— RoHS 	V40(HIP) 87～88HRA	SV—VASD	
	Super fine grain (HIP) 90～92HRA	SV—VXASD	

Catalog No. Type	D	L	0.001mm increments min. P max.	V	G	H	T	Base unit price 1～4 pieces SV—VAHD	SV—VXAHD	SV—VASD	SV—VXASD
Headed SV—VAHD SV—VXAHD / Straight SV—VASD SV—VXASD	3	13	0.500 ～ 1.000	0.4	0.2	4	3	Quotation			
	4	16	0.500 ～ 1.500			5					
	5	20	0.500 ～ 2.500			6					
	6	22	1.000 ～ 3.000	0.8	0.3	9	5				
	8		1.000 ～ 4.000			11					
	10	25	2.000 ～ 6.000			13					

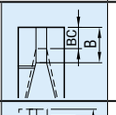
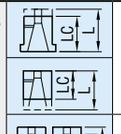
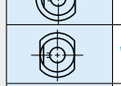
Order: Catalog No. — L — P
SV—VAHD 6 — 20 — P2.500

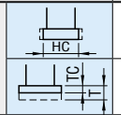
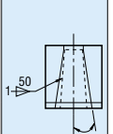
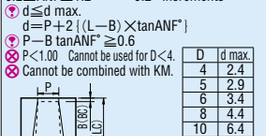
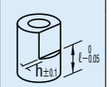
Price: Quotation

Days to Ship: Quotation

Alterations: Catalog No. — L(LC) — P — (BC・HC・TC, etc.)
SV—VASD 6 — LC18 — P2.500 — LKC

■Features
- These non-clogging button dies are intended to be used in combination with a vacuum device such as a vacuum pump. A scrap vacuum unit (P.299) can be used as the vacuum device.
- When the vacuum device is operating, the air inlet hole near the shaped hole creates an airflow inside the button die. As a result, the scrap removal effect is higher than in button dies without air inlet holes.
- Non-clogging button dies [Products Data] P.1621

Alteration	Code	Spec.	1Code
Shaped hole 	BC	Shaped hole depth change 1≦BC<2 0.1mm increments	
Alterations to full length 	LC	Full length change for headed types 13≦LC<L 0.1mm increments (If combined with LKC, 0.01mm increments can be selected.)	Quotation
		Full length change for straight types 8≦LC<L 0.1mm increments (If combined with LKC, 0.01mm increments can be selected.)	
	LKC	Full length tolerance change L +0.1 0 ⇨ +0.01 0 ⊗ Cannot be used for L<16.	
Alterations to head 	KC	Addition of single key flat to head ⊗ Cannot be used for straight types ⊗ Cannot be combined with KFC.	
	WKC	Addition of double key flats in parallel ⊗ Cannot be used for straight types. ⊗ Cannot be combined with KFC.	
	KFC	270° 180° 90° 0° Double key flats at 0° and a selected angle1° increments ⊗ Cannot be combined with KC・WKC. ⊗ Cannot be used for L<16. ⊗ Cannot be used for straight types.	

Alteration	Code	Spec.	1Code
Head 	HC	Head diameter change D≦HC<H 0.1mm increments	
	TC	Head thickness change 2≦TC<T 0.1mm increments ⓡ Full length is shortened by (T—TC). ⓡ If combined with LC, full length is equal to LC.	
Alterations to shank 	ANF	Angular angle change 0.2≦ANF≦1.2 0.2° increments ⓡ d≦d max. d=P+2{(L—B)×tanANF°} ⓡ P—B tanANF°≧0.6 ⊗ P<1.00 Cannot be used for D<4. ⊗ Cannot be combined with KM.  D / d max.: 4 / 2.4; 5 / 2.9; 6 / 3.4; 8 / 4.4; 10 / 6.4. Taper 1/50, Angle (one side) 0.573°	Quotation
	KM	Addition of key groove to prevent lifting ⊗ Cannot be used for D<6. ⊗ Cannot be used for headed types. D / h / ℓ: 6 / 1 / 5≦ℓ<L; 8, 10 / 1.5 / 0.1mm increments. ⓡ KM is machined in a position symmetrically opposite to the air inlet. ⊗ Cannot be combined with ANF.	