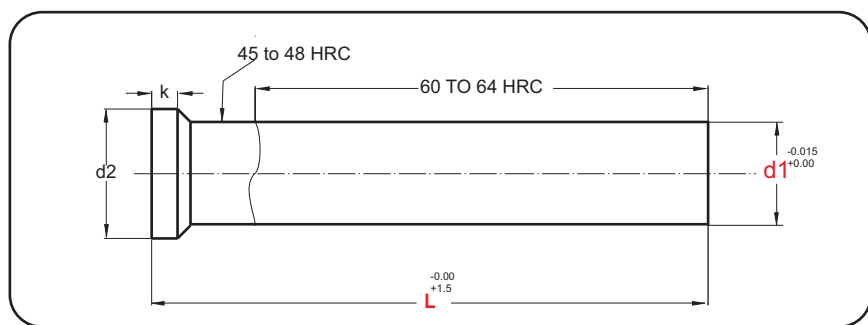


## ► Piercing Punches Heavy Duty (Type H)



**Material :-** High Speed Steel  
(HSS) Grade M2 / HcHCr Grade  
D2 (for sizes above 12mm)

**Hardness :-** 60 - 62 HRC

**Head Hardness :-** 45 - 48 HRC

Note : This punches are to be used where sheet thickness are higher.

d1 (-0.015)	d2 (-0.1)	L +1.5					K + 0.2
Increment of 0.1		50	70	80	90	100	
4.0-4.4	5.5		*	*			2.5
4.5-4.9	6.0		*	*			
5.0-5.4	6.5		*	*			
5.5-5.9	7.0		*	*			4
6.0-6.4	8.0		*	*			
6.5-7.4	9.0		*	*			
7.5-8.4	10		*	*	*	*	5
8.5-9.4	11		*	*	*	*	
9.5-10.4	12		*	*	*	*	
10.5-11.4	13		*	*	*	*	
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 (H) Dia 8 X 80