

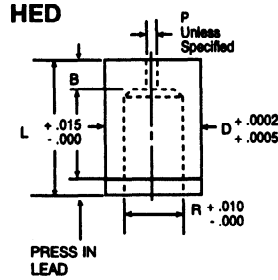


PIVOT PUNCH CORPORATION / BASIC SERIES

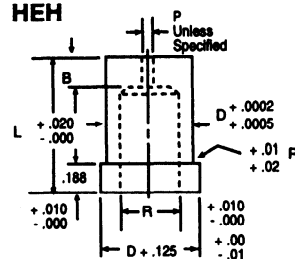
STEEL: M2 R/C 60-62

## WIRE & CONVENTIONAL EDM DIE BUTTONS

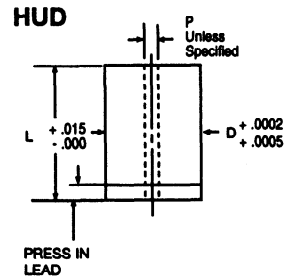
HED



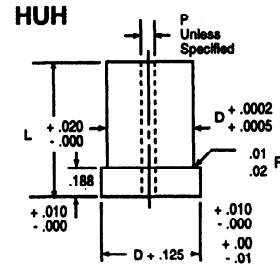
HEH



HUD



HUH



**NOTE: WE STOCK CPM-M4 HEADLESS BLANKS IN .750, .875 AND 1.00 DIAMETERS.**

Round P, ± .005



UNIVERSAL CODE: 104111 & 104211 (SEE PAGE 175)

Body		HUD/HUH	HED/HEH			Overall Length L							
D	Code	P	P	Max. B	R	3/4	7/8	15/16**	1	1 1/8	1 1/4	1 3/8	1 1/2
.2500	2	.031	-	-	-	X	X	X	X	X	X	X	X
.3750	3	.031	.032	.25	.228	X	X	X	X	X	X	X	X
.5000	4	.062	.032	.25	.312	X	X	X	X	X	X	X	X
.6250	5	.062	.093	.25	.391	X	X	X	X	X	X	X	X
.7500	6	.062	.093	.31	.468	X	X	X	X	X	X	X	X
.8750	7	.062	.093	.31	.578	X	X	X	X	X	X	X	X
1.0000	8	.062	.093	.31	.703	X	X	X	X	X	X	X	X
1.2500	9	.062	.125	.37	.828	X	X	X	X	X	X	X	X
1.5000	10	.062	.125	.37	1.094	X	X	X	X	X	X	X	X

\*\*HEADLESS ONLY

### HOW TO ORDER

TYPE D L  
**HUD 4 1**

**HUD  
HUH**

These blanks are provided with small straight through hole. They are commonly used for wire and vertical EDM operations. There are basically two advantages to this type of blank:

1. In wire cutting, a taper relief can be cut instead of a round straight relief.
2. In conventional EDM applications you can "tailor" the size of the relief to the shape you are cutting.

**HED  
HEH**

These blanks are used with conventional type EDM machines. The "P" hole is used for flushing away particles of steel. Relief hole (R) provides clearance for slug removal.