



PIVOT PUNCH CORPORATION / CATALOG INFORMATION

STANDARD ALTERATIONS

METRIC

Standard Alterations Solid Punch

Standard alterations are the ranges beyond those sizes listed in the catalog which can be manufactured for a slight additional charge.

Standard Alterations Ejector Punches

Standard alterations are the ranges beyond those sizes listed in the catalog which can be manufactured for a slight additional charge.

SP, SW P & W Dimensions Smaller than Standard
SB Point Length Longer than Standard

Point Length D	Min. P (Rounds)							Min. W (Shapes)					
	8	13	19	25	30	35	40	8	13	19	25	30	35
04	.8	1.1	1.3	1.9	2.5	-	-	1.3	1.6	1.6	2.4	2.8	-
05	1.0	1.3	1.3	1.9	2.5	-	-	1.3	1.6	1.6	2.4	3.0	-
06	1.3	1.6	1.6	2.0	2.5	-	-	1.3	1.6	1.6	2.4	3.0	-
08	1.6	1.6	1.6	2.4	2.5	3.2	-	1.6	2.4	2.4	2.4	3.2	4.0
10	1.6	1.6	1.6	2.5	3.2	3.2	6.0	2.0	2.4	2.8	3.2	3.2	4.0
13	-	3.2	3.2	3.2	3.2	4.0	6.0	-	3.2	3.2	3.2	3.6	4.5
16	-	6.0	6.0	6.0	6.0	6.0	6.0	-	6.0	6.0	6.0	6.0	6.0
20	-	6.0	6.0	6.0	7.6	7.6	7.6	-	6.0	6.0	6.0	6.0	6.0
25	-	8.0	8.0	8.0	10.0	10.0	10.0	-	6.0	6.0	6.0	6.0	6.0
32	-	10.0	10.0	10.0	10.0	10.0	10.0	-	6.0	6.0	6.0	6.0	6.0

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SB Point Length Longer than Standard

Point Length D	Min. P (Rounds)							Min. W (Shapes)					
	8	13	19	25	30	35	40	8	13	19	25	30	35
-	-	-	-	-	-	-	-	-	-	-	-	-	-
05	2.0	2.0	2.0	2.4	2.5	-	-	2.0	2.0	2.0	2.4	3.0	-
06	3.0	3.0	3.0	3.0	3.0	3.2	-	3.0	3.0	3.0	3.0	4.0	4.0
08	4.0	4.0	4.0	4.0	4.0	4.0	6.0	4.0	4.0	4.0	4.0	4.0	4.5
10	-	4.0	4.0	4.0	4.0	4.0	6.0	-	4.0	4.0	4.0	4.0	4.5
13	-	3.2	3.2	3.2	3.2	4.0	6.0	-	6.0	6.0	6.0	6.0	6.0
16	-	6.0	6.0	6.0	6.0	6.0	6.0	-	6.0	6.0	6.0	6.0	6.0
20	-	6.0	6.0	6.0	7.6	7.6	7.6	-	6.0	6.0	6.0	6.0	6.0
25	-	8.0	8.0	8.0	10.0	10.0	10.0	-	6.0	6.0	6.0	6.0	6.0
32	-	10.0	10.0	10.0	10.0	10.0	10.0	-	7.2	7.2	7.2	7.2	7.2

SD **Reduced Shank Diameter**
Head diameter does not change with body diameter.

Shank Dia.	4.0	5.0	6.0	8.0	10.0	13.0	16.0	20.0	25.0	32.0
Min. SD	2.5	3.5	4.5	6.5	8.5	11.5	14.5	18.5	23.5	30.5

SD **Reduced Shank Diameter**
Head diameter does not change with body diameter.

Shank Dia.	5.0	6.0	8.0	10.0	13.0	16.0	20.0	25.0	32.0
Min. SD	4.4	5.0	6.8	8.8	11.5	14.5	18.5	23.5	30.5

SL **Overall Length Shortened (25.4 min.)**
Stock removal from point end which shortens B length. To maintain "B" specify "SB"

SLL **Precision Overall Length**
Same as SL except overall length is held to ± 0.02 .

ST **Thinner Head than Standard**
Stock removal from head end which shortens overall length.

STT **Precision Head Thickness**
Same as ST except head thickness tolerance is held to ± 0.01 .

SH **Reduced Head Diameter**
Minimum head diameter equals $D + 0.00 - 0.03$

SL **Overall Length Shortened (25.4 min.)**
Stock removal from point end which shortens B length. To maintain "B" specify "SB"

SLL **Precision Overall Length**
Same as SL except overall length is held to ± 0.02 .

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SN **TONDRA**
A unique wear-resistant surface treatment for M-2 steel.

STN **Titanium Nitride**
coating for extra wear.
For M-2 steel.