

SCRAP RETENTION BLOCK DIES

—CONFIGURABLE SIZE TYPE—



—Straight— RoHS

Equivalent to SKD11 60 ~ 63HRC	Catalog No.	
	A	D R E G
Powdered high-speed steel 64 ~ 67HRC	SR—FBLD	SR—FBLDD SR—FBLDR SR—FBLDE SR—FBLDG
	SR—FPBLD	SR—FPBLDD SR—FPBLDR SR—FPBLDE SR—FPBLDG

Hole shape **A** **D** **R** **E** **G**

$H = +0.005$
 $A = \pm 0.01$
 $4-C0.5$
 $P = +0.01$
 $V = +0.005$
 B
 $W \pm 0.01$
 $R \leq 0.2$
 $P \geq W$
 $P - 0.4 \geq 1.5$
 P dimension must be within the range of W dimension.

$P \geq W$
 $0.15 \leq R < \frac{W}{2}$
 $P - 2R \geq 1.5$
 (Straight portion of P dimension must be 1.5mm or longer.)

$P > W$
 $\sqrt{P^2 - W^2} \geq 1.5$
 (Straight portion of P dimension must be 1.5mm or longer.)

Catalog No.	H	V		R						R	L	MT (workpiece material thickness) 0.01mm increments	C (clearance) 0.005mm increments
		min. W max.	min. P max.	4	8.1	10.1	13.1	16.1	20.1				
(Equivalent to SKD11) (Powdered high-speed steel)	6.0 ~ 8.0	1.00 ~ 4.00	4	1.00	1.00	1.00	1.00	1.50	1.50	0.15 ≤ R < W/2 (R only)	16	MT ≥ 0.15	C ≥ 0.010
A SR—FBLD SR—FPBLD	8.1 ~ 10.0	1.00 ~ 6.00	4	1.00	1.00	1.00	1.00	1.50	1.50	0.15 ≤ R < W/2 (R only)	20	Select a workpiece material thickness of 0.15mm or more. Clearance	Select a clearance of 0.010mm or more. Clearance
D SR—FBLDD SR—FPBLDD	10.1 ~ 13.0	1.00 ~ 8.00	5								22		
R SR—FBLDR SR—FPBLDR	13.1 ~ 16.0	1.00 ~ 10.00	6								25		
E SR—FBLDE SR—FPBLDE	16.1 ~ 20.0	1.50 ~ 12.00	8								30		
G SR—FBLDG SR—FPBLDG	20.1 ~ 25.0	1.50 ~ 16.00	9								35		

- V—P=a H—W=b (For shape **A**, H—P=b)
- P·W·R→0.01mm increments V·H→0.1mm increments
- Can be used only for workpiece materials with tensile strengths up to 1,177N/mm² (120kgf/mm²).
- Workpiece material thickness and clearance are used as machining data for the scrap retention. Specify the shaped hole dimensions (P·W·R) when selecting the block die finishing dimensions.

Days to Ship Quotation

Alterations Catalog No. — V — H — L(LC) — P—W—R — MT — C — (BC·LKC, etc.)
SR—FBLDD — V12.5 — H9.5 — LC28 — P6.25—W4.75 — MT1.50 — C0.105 — LKC — ANF1.2

Alteration	Code	A	D R E G	1Code
Alterations to shaped hole	BC	Shaped hole depth change 1 ≤ BC ≤ B max. 0.1mm increments P/Bmax. 1.00 ~ 1.99 3 2.00 ~ 4	Shaped hole depth change 1 ≤ BC < 2 0.1mm increments	Quotation
	PKC	Shaped hole diameter tolerance change P +0.01 ⇄ +0.005 0	Shaped hole diameter tolerance change P·W ± 0.01 ⇄ +0.01 0	
	HVC	H and V are reversed relative to shaped hole. P dimension is machined in direction H and W dimension is machined in direction V. P ≤ W max. P dimension must be within the range of dimension W listed in the specification table.		
Alterations to full length	LC	Full length change 10 ≤ LC < L 0.1mm increments (If combined with LKC·LKZ, 0.01mm increments can be selected.)		
	LKC	Full length tolerance change L +0.4 ⇄ +0.05 +0.2 0		
	LKZ	Full length tolerance change L +0.4 ⇄ +0.01 +0.2 0		

Alteration	Code	A	D R E G	1Code														
Others	VHM	Shape tolerance change H·V +0.005 ⇄ 0 0 -0.005		Quotation														
	NDC	No press-in lead																
	ANF	Angular angle change 0 ≤ ANF ≤ 1.2 0.2° increments d ≤ dmax. d = P + 2((L - B) tan(ANF°)) P - B tan(ANF°) ≥ 0.6 W - B tan(ANF°) ≥ 0.6 Cannot be used if shaped hole is not at center of shank.	<table border="1"> <tr> <th>V</th> <th>d max.</th> </tr> <tr> <td>6.0 ~ 3.4</td> <td></td> </tr> <tr> <td>8.0 ~ 4.4</td> <td></td> </tr> <tr> <td>10.0 ~ 6.4</td> <td></td> </tr> <tr> <td>13.0 ~ 8.4</td> <td></td> </tr> <tr> <td>16.0 ~ 10.6</td> <td></td> </tr> <tr> <td>20.0 ~ 12.6</td> <td></td> </tr> <tr> <td>25.0 ~ 14.6</td> <td></td> </tr> </table> Taper 1/50 App. size 0.573°		V	d max.	6.0 ~ 3.4		8.0 ~ 4.4		10.0 ~ 6.4		13.0 ~ 8.4		16.0 ~ 10.6		20.0 ~ 12.6	
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(1) If shaped hole is at center of shank

Catalog No. — 0.1mm increments — V — H — L — 0.01mm increments — P — W — R (R only) — MT — C

SR—FBLDE — V15.8 — H12.8 — L22 — P7.27 — W5.25 — MT1.50 — C0.105

(2) If shaped hole is not at center of shank (hole shapes **A** only)

Catalog No. — 0.1mm increments — V — H — L — 0.01mm increments — P — MT — C — 0.01mm increments — X—Y

SR—FBLD — V15.8 — H12.8 — L22 — P5.25 — MT1.50 — C0.105 — X5.80 — Y6.35

- For the upper and lower limit values for X and Y, refer to P.467.
- X, Y tolerance: ±0.005
- Be aware that the shaped hole position and X/Y values are determined differently for block punches.

P Price Quotation