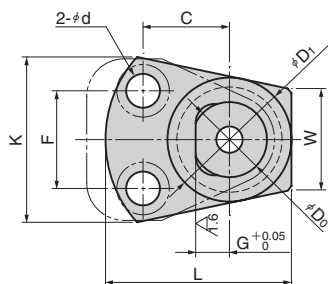
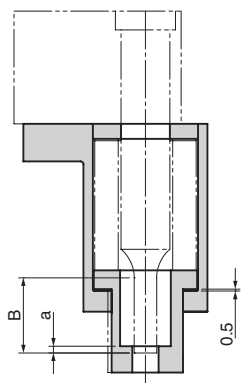
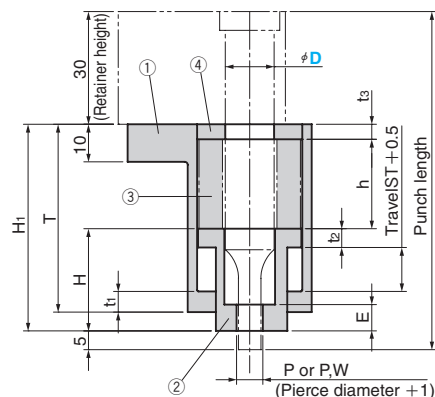


Punch Stripper Unit

COIL SPRING TYPE

CAD FILE

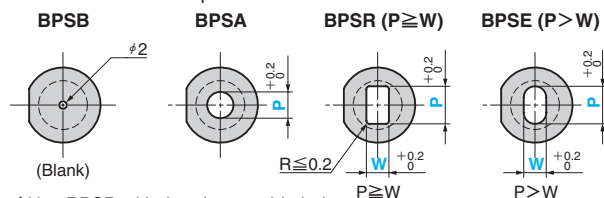
- BPSB** (Bushing blank type)
- BPSA** (Round hole)
- BPSR** (Square hole with radius)
- BPSE** (Oblong hole)



Material : ①Holder (SS400, Black Oxide)
 ②Steel bushing (S45C)
 ③Coil Spring
 ④Spacer (SS400)

Hole of Steel Bushing

Determine the hole size with the pierce diameter + 1 mm.



*Use BPSB with the pierce guide hole.
 *Set the entry of the pierce to 5mm or less.

D	Punch Length	T	t1	H	t2	H1	E	h	t3	C	F	G	D0	D1	K	L	W	d	B	a
10	80	44	4.5	23	5.0	45	9	18	4	21	20	9	20	33	44	49.5	27	9	13	1.5
	90	50	5.5	27.2		55	8	23.8												1.3
13	80	44	4.5	23	5.0	45	9	18	4	23	26	9	20	33	44	49.5	27	9	13	1.5
	90	50	5.5	27.2		55	8	23.8												1.3
16	90	53	5.0	28	4.5	55	13	24	3	26	24	13.5	30	41	50	60.5	36	11	19	1.5

D	Punch Length	Travel ST	Initial Load	Stripper Force N(kgf) Note 1	Maximum Return Force N(kgf)	Spring Constant N/mm(kgf/mm)	Spring Used	Accessory Mounting Bolt
10	80	12	0.0	572.6(58.1)	981.6(99.6)	81.8(8.3)	TL27-30	M8×60
	90	11.2		790.5(80.6)	1427.8(145.6)	127.5(13.0)	TM27-35	
13	80	12	0.0	572.6(58.1)	981.6(99.6)	81.8(8.3)	TL27-30	M8×60
	90	11.2		790.5(80.6)	1427.8(145.6)	127.5(13.0)	TM27-35	
16	90	16	0.0	1116.5(114.4)	1624.0(166.4)	101.5(10.4)	TL35-40	M10×60

*(Note 1): Pierce entry is set at 5 mm.

Catalog No.	D	Punch Length	Increments of 0.1 mm				
			BPSA		BPSR		BPSE
			P	P	W	P	W
BPSB	10	80	3.0~11.0	3.0~8.0	3.0~8.0	3.1~11.0	3.0~10.8
BPSA	10	90					
BPSR	13	80	3.0~14.0	3.0~10.1	3.0~10.1	3.1~14.0	3.0~13.8
BPSE	16	90	3.0~17.0	3.0~12.3	3.0~12.3	3.1~17.0	3.0~16.8



Catalog No.	D	Punch Length	P	W
BPSB	10	80		
BPSA	10	80	P8.2	
BPSR	13	90	P8.0	W6.0



Option Code	Specification
RA	Lock position of the irregular shape (square or oblong hole) bushing is changed (at increments of 1°).
PN	Dowel hole is machined. 2-φ6H7

See page 319 for option details.



Order **BPSR13-80-P 8.0-W 6.0-RA30**
BPSA10-80-P 8.2-PN

Spring Diagram

