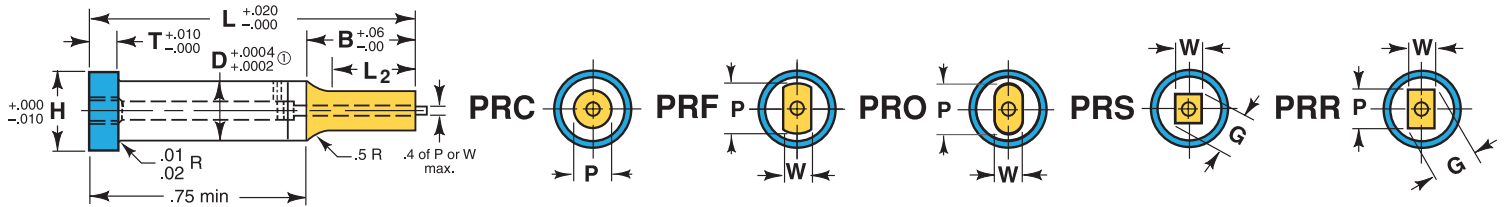
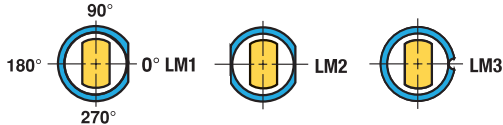


PORTER Ultra Precision Headed Retracto Punch (PR-)



Ordering Example: Qty Steel Type D B L P
6 PM4 PRC 50 C x 3.00 x .470

Reflected View



Optional Locating Methods See Page 38 for details and options.

**Steel: A2, M2 Rc 60-63
PM4, Rc 63-65**
D Ø > 1.000 M2 (HSS) Steel only
Heads Rc 40-55 (1" Ø and smaller and L ≥ 2")
TOLERANCES

$D \leq 1.50$ P,W $\begin{matrix} +.0002 \\ -.0000 \end{matrix}$ $\text{Ⓞ} .0003$ P,W to D

$D > 1.50$ P,W $\begin{matrix} +.0004 \\ -.0000 \end{matrix}$ $\text{Ⓞ} .0004$ P,W to D

① D Tol = $\begin{matrix} +.0006 \\ +.0002 \end{matrix}$

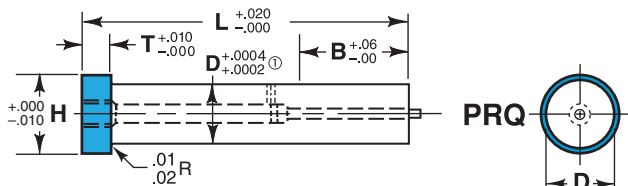
Manufactured to ANSI and NAPMA Standards where applicable.

Shank		Head		Point Length B					Lengths L in .25" Increments	Point			Replacement Retracto Kit*
D	Code No.	H	T	A(.50)	B(.75)	C(1.0)	D(1.25)	E(1.5)		Round	Shape		
										Range P	Min W	Max P/G	
.1875	18	.312	.125	•	•	•			1.25 thru 3.00	.062 - .1874	.093	.1875	K2I
.2500	25	.375	.188	•	•	•	•		1.25 thru 3.00	.093 - .2499	.093	.2500	K3I
.3125	31	.437	.188	•	•	•	•	•	1.25 thru 4.00	.125 - .3124	.125	.3125	K4I
.3750	37	.500	.188	•	•	•	•	•	1.25 thru 4.00	.187 - .3749	.187	.3750	K6I
.4375	43	.562	.188		•	•	•	•	1.50 thru 4.00	.187 - .4374	.187	.4375	K6I
.5000	50	.625	.188		•	•	•	•	1.50 thru 4.00	.225 - .4999	.250	.5000	K6I
.6250	62	.750	.188		•	•	•	•	1.50 thru 4.00	.310 - .6249	.282	.6250	K9I
.7500	75	.875	.188		•	•	•	•	1.50 thru 4.00	.390 - .7499	.312	.7500	K9I
1.0000	100	1.125	.188		•	•	•	•	2.25 thru 3.25	.485 - .9999	.375	1.0000	K9I
1.2500	125 ①	1.375	.188				•	•	2.25 thru 3.25	.625 - 1.2499	.375	1.2500	K12I
1.5000	150 ①	1.625	.188				•	•	2.25 thru 3.25	.750 - 1.4999	.375	1.5000	K12I
1.7500	175 ①	1.875	.188				•	•	2.25 thru 3.25	1.000 - 1.7499	.375	1.7500	K12I
2.0000	200 ①	2.125	.188				•	•	2.25 thru 3.25	1.188 - 1.9999	.425	2.0000	K12I

*Retracto Kits available see page 36 for details.
Retracto Punches .1875 and 1.25 and larger = No side hole.

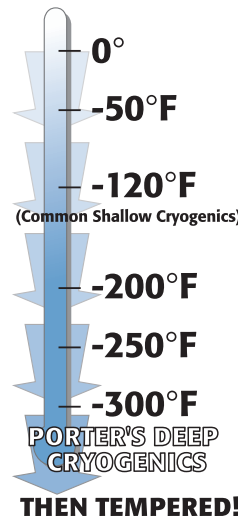
All Lengths in Light Blue Panel have Hot Forged Heads for added strength and toughness.

PORTER Ultra Precision Headed Retracto Punch Blank (PRQ)



Ordering Example: Qty Steel Type D L
7 PM4 PRQ 37 x 3.00

Standard Alterations are changes that are beyond the ranges listed in the catalog that can be altered for a minimal charge. See page 37.



All Porter Ultra Precision Punches up to 1" Dia. are "Deep Cryogenically" treated for

1. Wear
2. Toughness
3. Dimensional Stability

See page 42 for more details.

For additional standard forms and configurations see pages 32 and 33.