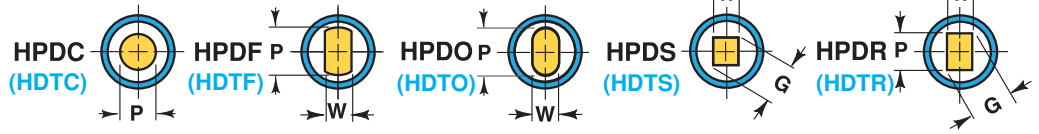
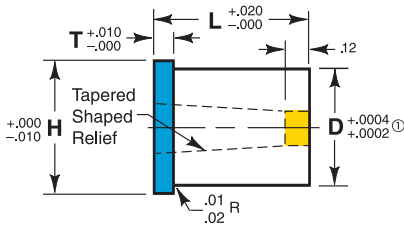
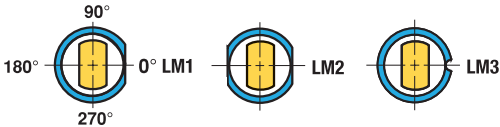


## Ultra Precision Headed Die Button (HPD-)



### Ordering Example:

Qty Steel Type D L P  
6 PM4 HPDC 75 x 1.25 x .380



Optional Locating Methods See Page 38 for details and options.

Steel: M2 Rc 60-63  
PM4, Rc 63-65

### TOLERANCES

$D \leq 1.50$  P,W  $^{+.0002}_{-.0000}$   $\text{M} \text{ } .0003$  P,W to D

$D > 1.50$  P,W  $^{+.0004}_{-.0000}$   $\text{M} \text{ } .0004$  P,W to D

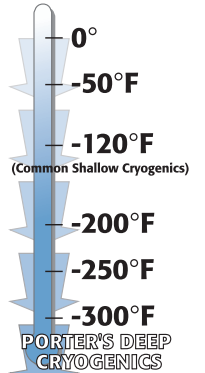
Manufactured to ANSI and NAPMA Standards where applicable.

① D Tol =  $^{+.0006}_{+.0002}$

0.5 Degree taper relief per side

Porter also offers **HDT** and **DT** style die buttons to standard precision tolerances. Any Diameter can be furnished with P  $^{+.0005}_{-.0000}$  and TIR of .0005 in round configurations. Any Shaped ID can be furnished with P,W of  $^{+.001}_{-.000}$  and TIR of .001. These standard tolerance items are furnished with a slug relief of 1 degree taper per side.

Shank		Head		Lengths L										Round ID	Shape ID	
D**	Code No.	H	T	.500	.625	.750	.875	.9375	1.000	1.125	1.250	1.375	1.500	Range P	Min W	Max P/G
.1875	18	.312	.125	●	●	●	●	●	●	●				.050 - .130	.050	.130
.2500	25	.375	.188	●	●	●	●	●	●	●	●			.050 - .170	.050	.170
.3125	31	.437	.188	●	●	●	●	●	●	●				.062 - .212	.050	.212
.3750	37	.500	.188	●	●	●	●	●	●	●	●			.075 - .255	.050	.255
.4375	43	.562	.188		●	●	●	●	●	●	●	●		.130 - .297	.075	.297
.5000	50	.625	.188	●	●	●	●	●	●	●	●	●	●	.150 - .344	.075	.344
.6250	62	.750	.188		●	●	●	●	●	●	●	●	●	.188 - .425	.075	.425
.7500	75	.875	.188		●	●	●	●	●	●	●	●	●	.225 - .510	.075	.510
.8750	87	1.000	.188		●	●	●	●	●	●	●	●	●	.300 - .595	.075	.595
1.0000	100	1.125	.188		●	●	●	●	●	●	●	●	●	.400 - .680	.135	.680
1.2500	125	1.375	.188		●	●	●	●	●	●	●	●	●	.500 - .850	.135	.850
1.5000	150	1.625	.188		●	●	●	●	●	●	●	●	●	.600 - 1.050	.135	1.050
1.7500	175 ①	1.875	.188		●	●	●	●	●	●	●	●	●	.750 - 1.400	.135	1.400
2.0000	200 ①	2.125	.188		●	●	●	●	●	●	●	●	●	.875 - 1.600	.135	1.600
2.2500	225 ①	2.375	.188		●	●	●	●	●	●	●	●	●	1.000 - 1.800	.135	1.800
2.5000	250 ①	2.625	.188		●	●	●	●	●	●	●	●	●	1.125 - 2.000	.135	2.000
2.7500	275 ①	2.875	.188		●	●	●	●	●	●	●	●	●	1.250 - 2.200	.135	2.200
3.0000	300 ①	3.125	.188		●	●	●	●	●	●	●	●	●	1.375 - 2.450	.135	2.450

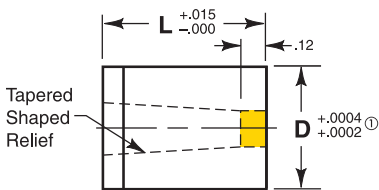


### THEN TEMPERED!

All Porter Ultra Precision die buttons are "Deep Cryogenically" treated for  
1. Wear  
2. Toughness  
3. Dimensional Stability  
See page 42 for more details.

\*\*D > 1.500 M2 (HSS) Steel only. NOTE--Standard .125 thick land is supplied, alternate lands are available, call out "AB" and land desired (Ex "AB-.062").

## Ultra Precision Headless Die Button (PD-)



### Ordering Example:

Qty Steel Type D L W P Locate  
3 PM4 PDO 43 x 1 x .097 x .191 LM1



Optional Locating Methods See Page 38 for details and options.

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

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