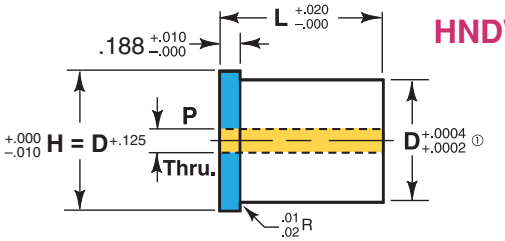
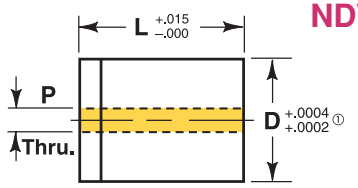
PORTER Wire EDM Die Blanks-I.D. thru no relief



HNDW

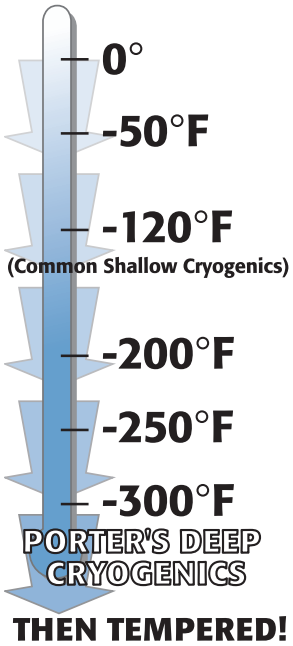
Steel: M2 Rc 60-63
PM4 Rc 63-65
TOLERANCES
ØP ±.005 | ◎ | .005 | P to D
① Ø D TOLERANCE +.0006 +.0002



NDW

Ordering Example: Qty 4, Steel M2, Type HNDW, D 75, L x 1.25

Ordering Example: Qty 6, Steel PM4, Type NDW, D 50, L x 1.00



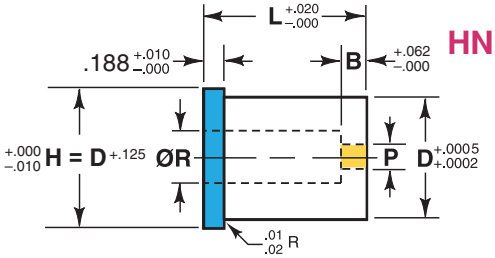
All Porter Wire Blanks are "Deep Cryogenically" treated for
1. Wear
2. Toughness
3. Dimensional Stability

See page 42 for more details.

Body		Lengths L										Thru Hole Size P
Code	D	.50	.62	.75	.87	.93	1.00	1.125	1.250	1.375	1.500	
*18	.1875	●	●	●	●	●	●	●	●			.043
25	.2500	●	●	●	●	●	●	●	●			.043
31	.3125	●	●	●	●	●	●	●	●			.043
37	.3750	●	●	●	●	●	●	●	●	●	●	.043 or .093
43	.4375	●	●	●	●	●	●	●	●	●	●	.043 or .093
50	.5000	●	●	●	●	●	●	●	●	●	●	.043 or .093
62	.6250			●	●	●	●	●	●	●	●	.043 or .125
75	.7500			●	●	●	●	●	●	●	●	.043 or .125
87	.8750			●	●	●	●	●	●	●	●	.043 or .125
100	1.0000			●	●	●	●	●	●	●	●	.125
125	1.2500			●	●	●	●	●	●	●	●	.125
150	1.5000			●	●	●	●	●	●	●	●	.125
175	1.7500①						●		●		●	.125
200	2.0000①						●		●		●	125
225	2.2250①						●		●		●	.125
250	2.5000①						●		●		●	.125
275	2.7500①						●		●		●	.125
300	3.0000①						●		●		●	.125

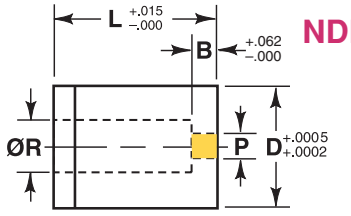
*Head thickness .125 =These sizes available in M2 (HSS) only. ● Available HNDW & NDW

PORTER EDM Die Blanks-I.D. Flush hole, round step relief



HNDE

Steel: M2 Rc 60-63
TOLERANCES
ØP ±.005 | ◎ | .005 | P to D



NDE

Ordering Example: Qty 4, Steel M2, Type HNDE, D 75, L x 1.25

Ordering Example: Qty 6, Steel M2, Type NDE, D 50, L x 1.00

Body		Lengths L								Flush Hole		Relief R
Code	D	.75	.875	.937	1.00	1.125	1.250	1.375	1.500	P	B	
37	.3750	●	●	N	●	●	●	N	●	.043	.156	.228
50	.5000	●	●	N	●	●	●	N	●	.043	.156	.312
62	.6250	●	●	N	●	●	●	N	●	.078	.187	.391
75	.7500	●	●	N	●	●	●	N	●	.093	.250	.468
87	.8750	●	●	N	●	●	●	N	●	.093	.250	.578
100	1.0000	●	●	N	●	●	●	N	●	.125	.250	.703
125	1.2500	●	●	N	●	●	●	N	●	.125	.250	.828
150	1.5000	●	●	N	●	●	●	N	●	.125	.312	1.094

N = NDE only. ● Available HNDE & NDE

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