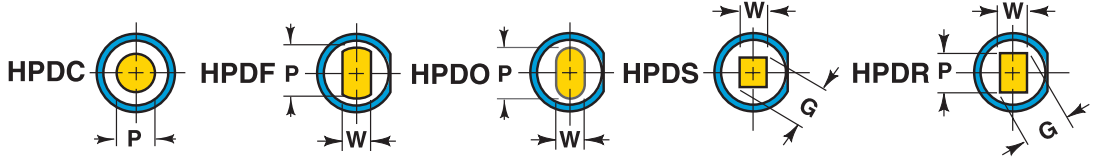
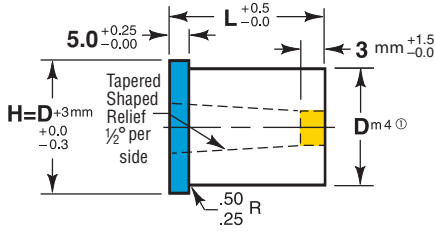
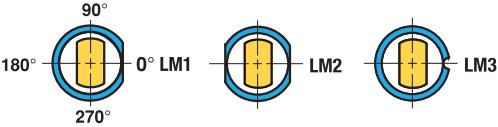


# PORTER Ultra Precision Headed Die Button (HPD-)



### Ordering Example:

Qty Steel Type Code L P  
6 M2 HPDC 016 x 25 x9.00



Optional Locating Methods See Page 38 for details and options.

Steel: M2 Rc 60-63

### TOLERANCES

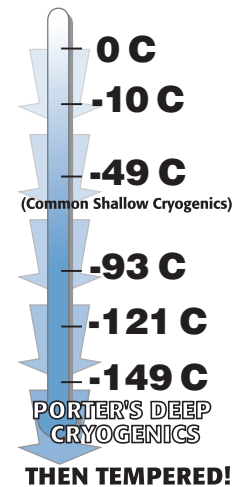
$\varnothing D \leq 38.0$  P,W  $+0.005$   $-0.000$   $\text{M}$  .008 P,W to D

$\varnothing D > 38.0$  P,W  $+0.01$   $-0.00$   $\text{M}$  .012 P,W to D

①  $\varnothing D > 40$  Tol D = m5

Manufactured to ISO and NAPMA standards where applicable.

Body D	Code No.	Lengths L										Range P	Min W	Max P/G
		13	16	19	20	22	25	28	30	32	35			
5.0	005	•	•	•	•	•	•	•	•	•	•	1.60 – 3.20	1.30	3.20
6.0	006	•	•	•	•	•	•	•	•	•	•	1.60 – 3.90	1.30	3.90
8.0	008	•	•	•	•	•	•	•	•	•	•	2.40 – 5.40	1.30	5.40
10.0	010	•	•	•	•	•	•	•	•	•	•	3.20 – 6.80	1.30	6.80
13.0	013	•	•	•	•	•	•	•	•	•	•	5.40 – 8.80	1.90	8.80
16.0	016			•	•	•	•	•	•	•	•	7.40 – 10.80	1.90	10.80
20.0	020			•	•	•	•	•	•	•	•	9.50 – 13.60	1.90	13.60
22.0	022			•	•	•	•	•	•	•	•	10.50 – 15.00	1.90	15.00
25.0	025			•	•	•	•	•	•	•	•	12.00 – 17.00	1.90	17.00
32.0	032			•	•	•	•	•	•	•	•	16.00 – 22.00	4.00	22.00
38.0	038			•	•	•	•	•	•	•	•	18.00 – 27.00	4.00	27.00
40.0	040			•	•	•	•	•	•	•	•	18.00 – 27.00	4.00	27.00
45.0	045					P	P	P	P	P	P	18.00 – 35.00	4.00	35.00
50.0	050					P	P	P	P	P	P	18.00 – 40.00	4.00	40.00
56.0	056					P	P	P	P	P	P	18.00 – 45.00	4.00	45.00
63.0	063					P	P	P	P	P	P	18.00 – 50.00	4.00	50.00
71.0	071					P	P	P	P	P	P	18.00 – 56.00	4.00	56.00
76.0	076					P	P	P	P	P	P	25.00 – 60.00	5.60	60.00



**THEN TEMPERED!**

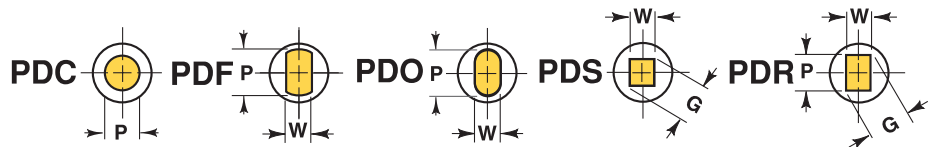
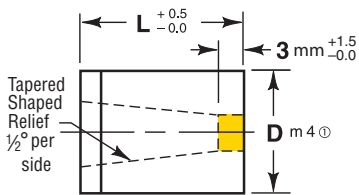
All Porter Ultra Precision die buttons are "Deep Cryogenically" treated for  
1. Wear  
2. Toughness  
3. Dimensional Stability  
See page 42 for more details.

P = Available PD (Headless) only

\*Standard 3mm thick land is supplied, alternate lands are available, call out "AB" and land desired (Ex "AB-5").

For perforating stock thickness less than 1 mm thick, the land should be shortened to minimize slug jamming in the die land.

# PORTER Ultra Precision Headless Die Button (PD-)



### Ordering Example:

Qty Steel Type Code L W P Locate  
6 M2 PDO 025 x 25 x 6.50 x 12.00 LM1



Optional Locating Methods See Page 38 for details and options.

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