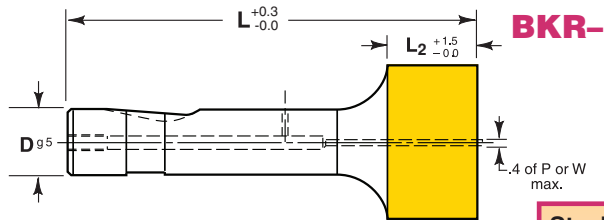


PORTER Light Duty Knob Style Punches



Ordering Example:

Qty Steel Type Code L P
15 M2 BRKC 013 80 25.20

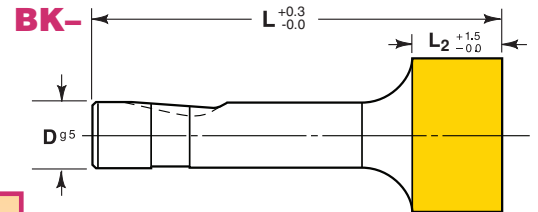
Steel: M2 Rc 60-63

TOLERANCES

Round P $\begin{matrix} +0.01 \\ -0.00 \end{matrix}$ ⊙ 0.01 P to D

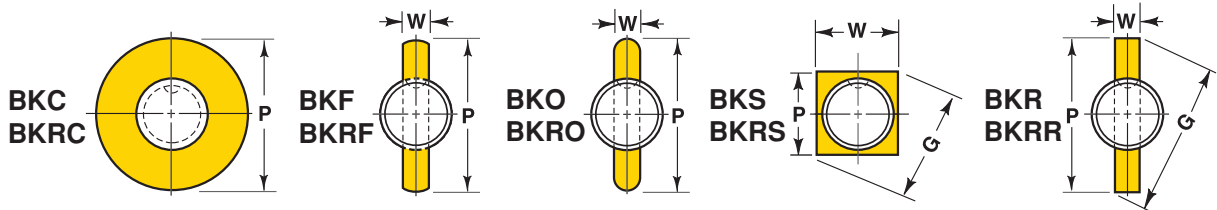
Shape P, W ± 0.01 ⊙ 0.02 P,W to D

Manufactured to ISO and NAPMA standards where applicable.
Back Draft 0.1/100mm L₂ max.



Ordering Example:

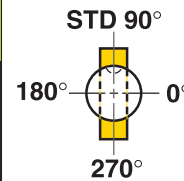
Qty Steel Type Code L W P
4 M2 BKS 020 100 23.00 x 23.00



Shank D	Code No.	Point Length L ₂	Lengths L				Point		Replacement Retrakto Kit*
			71	80	90	100	Round Range P	Shape Min W Max P/G	
13	013	20	●	●	●	●	13.10 – 32.00	5.00 32.00	K6M
16	016	25	●	●	●	●	16.10 – 38.00	6.00 38.00	K6M
20	020	25	●	●	●	●	20.10 – 40.00	8.00 40.00	K9M
25	025	25	●	●	●	●	25.10 – 44.00	10.00 44.00	K9M
32	032	32		●	●	●	32.10 – 50.00	11.50 50.00	K12M

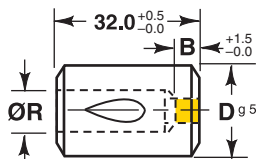
*Retrakto Kits available see page 36 for details.

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



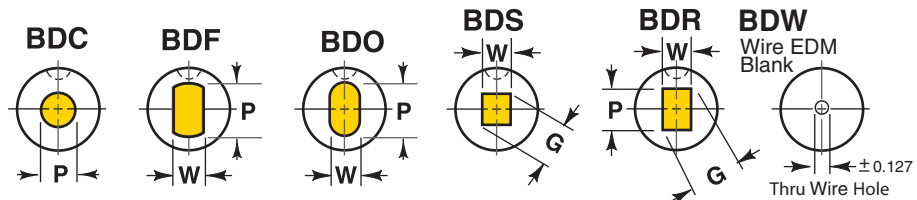
Standard ball seat location is at 90° using reflected view for punches. Alternate locations of 0°, 180° and 270° are available at no extra charge. Custom ball seat locations can be specified as number of degrees counterclockwise from 0°.

PORTER Bal-Lok Die Buttons (BD-)



Ordering Example:

Qty Steel Type Code P
25 M2 BDC 016 x 5.65



*SPECIAL NOTE: Small quantities of Bal-Lok die buttons may be substituted with a taper relief of 1 degree per side.

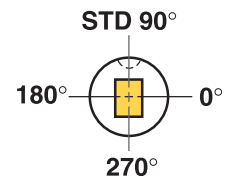
Body		Min. B	Max. R	Length L	Round I.D. Range P	Shape I.D.	
Code	D					Min. W	Max. P/G
013	13.0	4	6.00	32.0	1.50 – 5.20	1.50	5.20
016	16.0	4	8.00	32.0	3.20 – 7.20	2.00	7.20
020	20.0	4	12.00	32.0	4.00 – 11.00	2.40	11.00
025	25.0	5	16.00	32.0	8.00 – 15.00	4.00	15.00
032	32.0	6	20.00	32.0	11.00 – 19.00	4.80	19.00
038	38.0	6	27.00	32.0	16.50 – 26.00	6.40	26.00

Steel: D2, M2, Rc 60-63

TOLERANCES

Round P $\begin{matrix} +0.01 \\ -0.00 \end{matrix}$ ⊙ 0.01 P to D

Shape P,W $\begin{matrix} +0.02 \\ -0.00 \end{matrix}$ ⊙ 0.02 P,W to D



Standard Ball Seat location is at 90°, alternate locations of 0°, 180° and 270° are available at no extra charge. See pages 32 and 33 for additional standard I.D. forms.

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