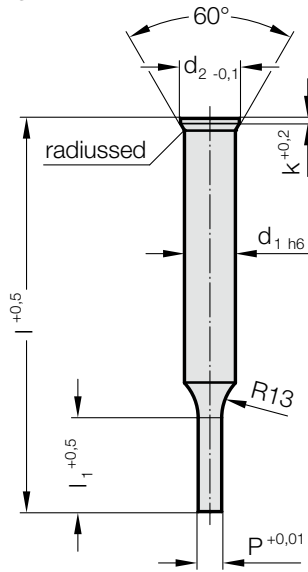


# PUNCH, STEPPED, ROUND, ~DIN 9861



2219.



2219. Punch, stepped, round, ~DIN 9861

d <sub>1</sub> / Order No	d <sub>2</sub>	P	l <sub>1</sub> / Order No	k	l (Order Code character)	71 (D)	80 (E)	100 (G)	120 (J)
3 / (1)	4.5	0,8 - 2,9	8 (1) 10 (2)	0.5		●	●	●	●
4 / (2)	5.5	1 - 3,9	8 (1) 13 (3)	0.5		●	●	●	●
5 / (3)	6.5	1,5 - 4,9	13 (3) 19 (4)	0.5		●	●	●	●
6 / (4)	8	1,6 - 5,9	13 (3) 19 (4)	0.5		●	●	●	●
8 / (5)	10	2,5 - 7,9	19 (4) 25 (5)	1		●	●	●	●
10 / (6)	12	4 - 9,9	19 (4) 25 (5)	1		●	●	●	●
13 / (7)	15	5 - 12,9	19 (4) 25 (5)	1		●	●	●	●
16 / (8)	18	8 - 15,9	19 (4) 25 (5)	1.5		●	●	●	●
20 / (9)	22	12 - 19,9	19 (4) 25 (5)	1.5		●	●	●	●

**Material:**

HSS  
 Order No 2219.3.  
 ASP 2023  
 Order No 2219.6

**Hardness:**

Shaft 64 ± 2 HRC  
 Head 52 ± 5 HRC

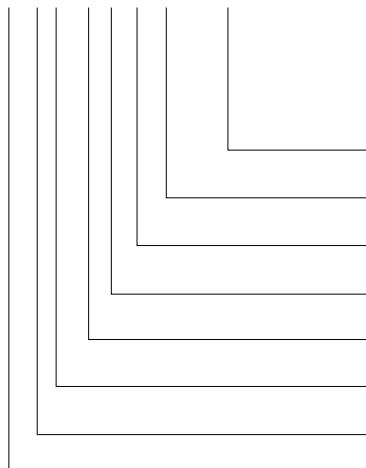
Description of FIBRO materials for tool and die components see at the beginning of Chapter E.

**Execution:**

Stamp shank and punch head are precision ground after the heat compression and tempering of the punch head using the plunge process.

**Ordering Code (example):**

**2219.37G.4.0720**



**Shape: round**  
 P = ø 7,2 mm  
**Punch cutting length l<sub>1</sub>**  
 19 mm  
**Length: l**  
 100 mm  
**Diameter: d<sub>1</sub>**  
 13 mm  
**Material:**  
 HSS  
**Type:**  
 DIN 9861  
**Execution: Order No**  
 round  
**Punch:**  
 without ejector pin

**Order No**  
 = 0720  
**Order No**  
 = (4)  
**Order Code character**  
 = (G)  
**Order No**  
 = (7)  
**Order No**  
 = (3)  
**Order No**  
 = (9)  
 = (1)  
 = 22