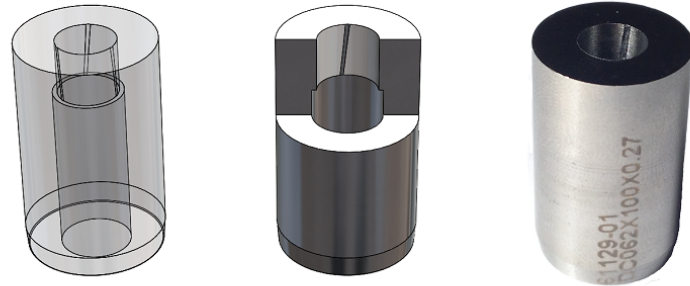
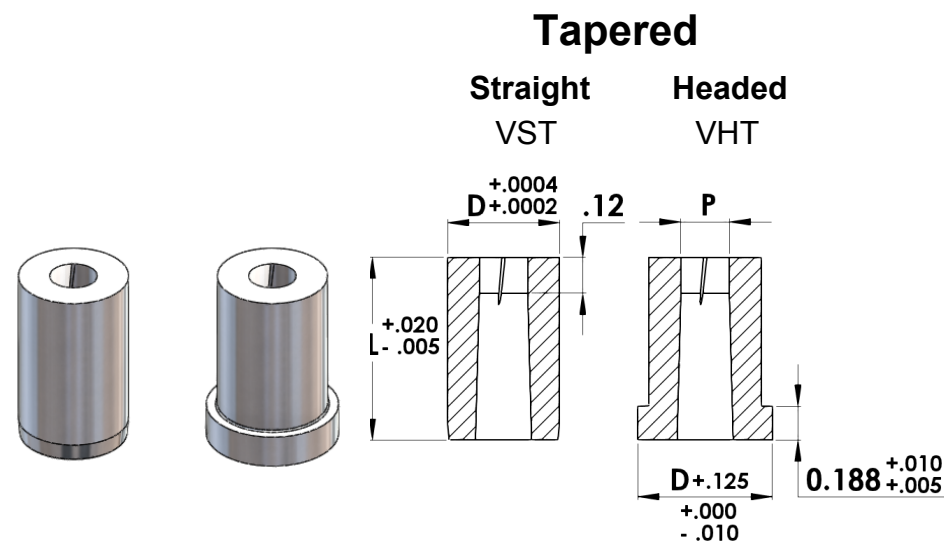


Die Buttons with SlugRetention



VorTool SlugRetention is available for all type of existing or old die buttons regardless of their origin.

We also offer "made to order" die buttons that include the slug control grooves.



CUSTOM

DIAMETER	L DIMENSIONS - OVER ALL LENGTH								CI		RE		LL		OB		CUS	
	.625	.750	.875	1.000	1.125	1.25	1.375	1.500	Min.P	Max.P	Min.W	Max.P	Min.W	Max.P	Min.W	Max.P	Min.W	Max.P
.250	62	75	87	100	112	NA	NA	NA	.062	.170	.062	.120	.062	.120	.062	.120	.062	.120
.3125	62	75	87	100	112	125	NA	NA	.062	.212	.062	.150	.062	.150	.062	.150	.062	.150
.375	62	75	87	100	112	125	137	150	.075	.255	.062	.180	.062	.180	.062	.180	.062	.180
.4375	62	75	87	100	112	125	137	150	.130	.297	.075	.210	.075	.210	.075	.210	.075	.210
.500	62	75	87	100	112	125	137	150	.150	.344	.075	.243	.075	.243	.075	.243	.075	.243
.625	62	75	87	100	112	125	137	150	.188	.425	.075	.300	.075	.300	.075	.300	.075	.300
.750	62	75	87	100	112	125	137	150	.225	.510	.075	.360	.075	.360	.075	.360	.075	.360
.875	62	75	87	100	112	125	137	150	.300	.595	.075	.420	.075	.420	.075	.420	.075	.420
1.000	62	75	87	100	112	125	137	150	.400	.680	.075	.480	.075	.480	.075	.480	.075	.480
1.250	62	75	87	100	112	125	137	150	.500	.850	.075	.601	.075	.601	.075	.601	.075	.601
1.500	62	75	87	100	112	125	137	150	.600	1.050	.075	.742	.075	.742	.075	.742	.075	.742

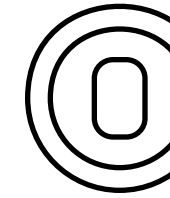
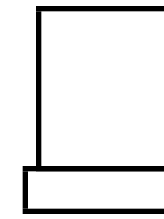
Order Sample (at the end of each code, state the Stock Thickness to be punched)

Tolerance on W and P dimensions: +.0002 / -.0000

VST - D.375 - L100 - CI.192 - M2 - 4 pcs - ST _____

VHT - D.750 - L100 - RE - W.255 - P.505 - A2 - 7 pcs - ST _____

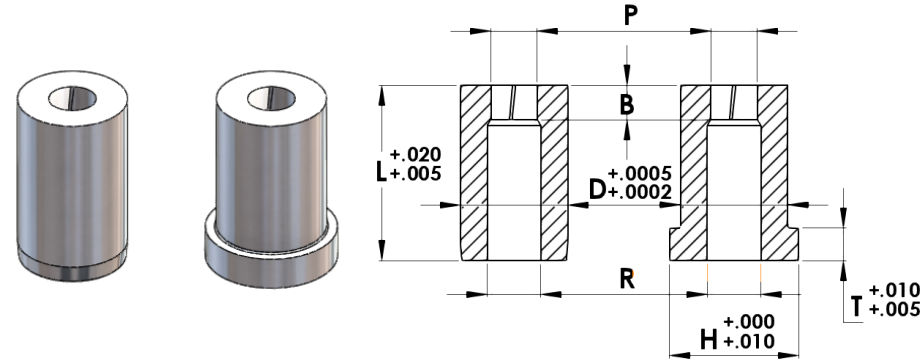
Locating Flat .0625 x .188



Counterbored

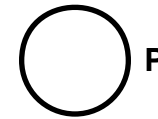
Straight
VSC

Headed
VHC



All die buttons over 0.090 hole diameter made with VorTool SlugRetention, using at least 3 slug control grooves.
Tapered slug relief 0.006 inch / side.
For counterbored slug relief refer to chart.
Material: M2 or A2, 60-62 RC.
Locating flat as shown above unless specified.
The slug retention alteration is guaranteed only when clearance does not exceed 10% per side.
Die buttons without SlugRetention are also available.
Please specify if not required.

If you have any doubt of generating a proper code for your order, simply send us a drawing, sketch or description of your needs. There is also an order form for your convenience that you may fill out and submit. You may refer to any other supplier's codes or specifications that we will be happy to cross reference to be used. Simply specify the maker.
If you are not familiar with the proper die hole clearances, please specify the hole diameter or dimensions to be punched, the stock thickness and its material type, e.g. 6061-T6.



CUSTOM

DIAMETER	FIXED		L DIMENSIONS - OVER ALL LENGTH								CI		RE		LL		OB		CUS	
D	B	R max	.625	.750	.875	1.000	1.125	1.25	1.375	1.500	Min.P	Max.P	Min.W	Max.P	Min.W	Max.P	Min.W	Max.P	Min.W	Max.P
.250	.156	.156	62	75	87	100	112	125	137	NA	.064	.135	NA	NA	NA	NA	NA	NA	NA	NA
.375	.156	.228	62	75	87	100	112	125	137	150	.064	.195	.062	.138	.062	.138	.062	.138	.062	.138
.500	.188	.312	62	75	87	100	112	125	137	150	.064	.285	.062	.201	.062	.201	.062	.201	.062	.201
.625	.188	.375	62	75	87	100	112	125	137	150	.136	.365	.095	.258	.095	.258	.095	.258	.095	.258
.750	.188	.468	62	75	87	100	112	125	137	150	.136	.435	.118	.307	.118	.307	.118	.307	.118	.307
.875	.250	.578	62	75	87	100	112	125	137	150	.276	.545	.127	.385	.127	.385	.127	.385	.127	.385
1.000	.250	.687	62	75	87	100	112	125	137	150	.356	.675	.158	.477	.158	.477	.158	.477	.158	.477
1.250	.312	.812	62	75	87	100	112	125	137	150	.500	.800	.189	.566	.189	.566	.189	.566	.189	.566
1.500	.312	1.062	62	75	87	100	112	125	137	150	.616	1.050	.252	.742	.252	.742	.252	.742	.252	.742

Order Sample (at the end of each code, state the Stock Thickness to be punched)

Tolerance on W and P dimensions: +.0002 / -.0000

VSC - D.500 - L100 - CI.280 - M2 - 7 pcs - ST _____

VHC - D1.000 - L100 - RE - W.380 - P.450 - A2 - 9 pcs - ST _____