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**Tools for pressing — Ball-lock punch  
retainers —**

Part 2:  
**Types C and D, reduced for light duty**

*Outillage de presse — Porte-poinçons pour poinçons à bille —  
Partie 2: Types C et D, réduits pour tôles minces*



Reference number  
ISO 11900-2:2008(E)

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## Foreword

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International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 11900-2 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 8, *Tools for pressing and moulding*.

This second edition cancels and replaces the first edition (ISO 11900-2:2001), of which it constitutes a minor revision. In particular, the references given in Clause 2 have been updated, and the indication of surface textures has been updated in accordance with ISO 1302:2002.<sup>1)</sup>

ISO 11900 consists of the following parts, under the general title *Tools for pressing — Ball-lock punch retainers*:

- *Part 1: Types A and B, rectangular and square for light duty*
- *Part 2: Types C and D, reduced for light duty*
- *Part 3: Type E, reduced for heavy duty*

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1) ISO 1302:2002, *Geometrical Product Specifications (GPS) — Indication of surface texture in technical product documentation*.

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# Tools for pressing — Ball-lock punch retainers —

## Part 2: Types C and D, reduced for light duty

### 1 Scope

This part of ISO 11900 specifies the dimensions and tolerances, in millimetres, of reduced ball-lock punch retainers, type C and type D, for light duty, and of their backing plug, the main use of which is the retention of ball-lock punches in accordance with ISO 10071-1, when punching holes in steel sheets.

It also gives material guidelines and specifies the hardness and designation of ball-lock punch retainers that are in accordance with its specifications.

### 2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 273, *Fasteners — Clearance holes for bolts and screws*

ISO 4762, *Hexagon socket head cap screws*

ISO 8735, *Parallel pins with internal thread, of hardened steel and martensitic stainless steel*

ISO 10071-1, *Tools for pressing — Ball-lock punches — Part 1: Ball-lock punches for light duty*

### 3 Dimensions

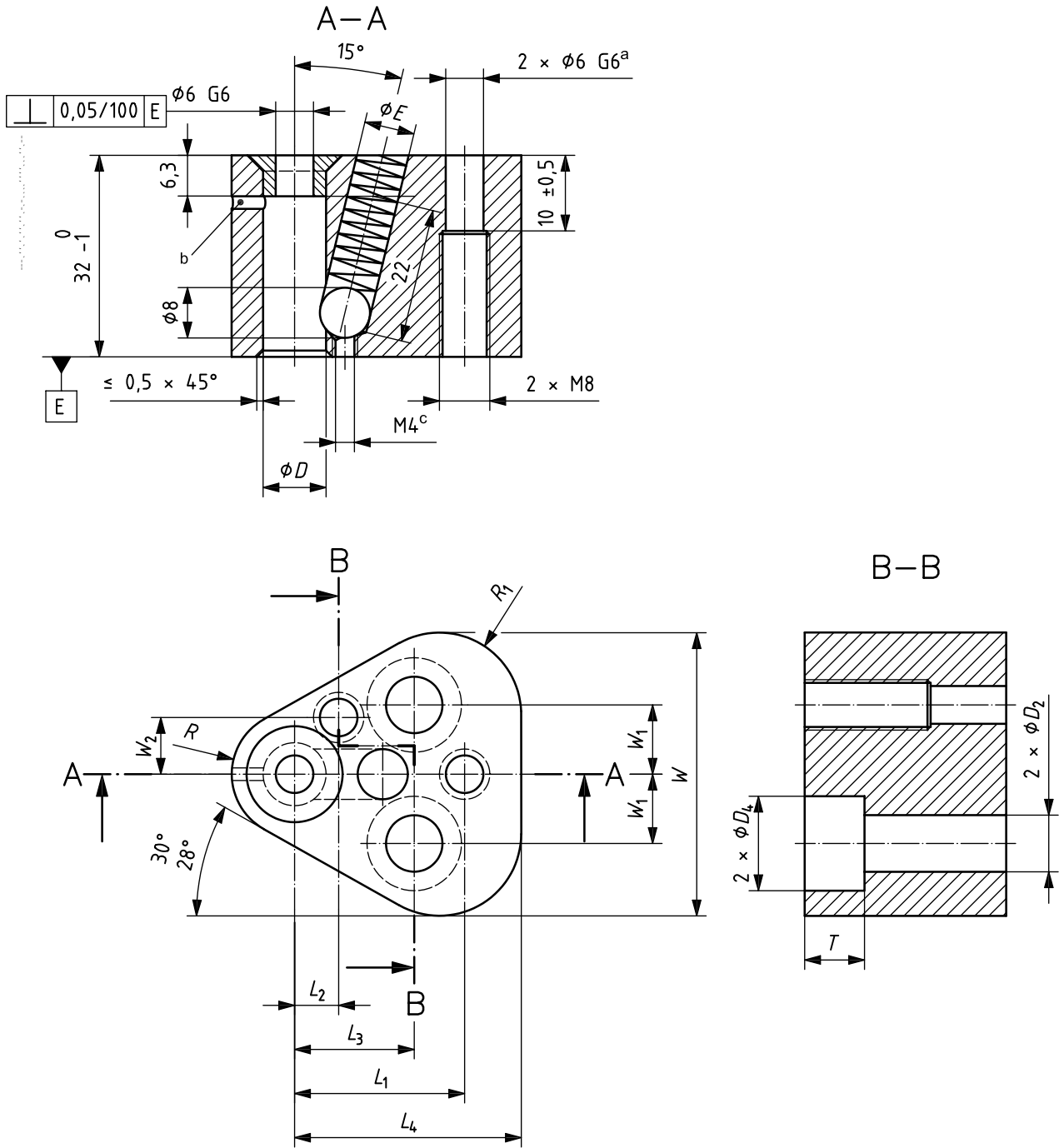
#### 3.1 General tolerance

The general tolerance for all dimensions not individually toleranced is  $\pm 0,25$  mm.

3.2 Type C reduced ball-lock punch retainer

The dimensions of type C reduced ball-lock punch retainers shall conform to the indications in Figure 1 and Table 1.

Dimensions in millimetres



- a Hole for parallel hardened pins (dowels pins) in accordance with ISO 8735.
- b Venting hole.
- c Optional.

Figure 1 — Type C reduced ball-lock punch retainer

Table 1 — Dimensions of type C reduced ball-lock punch retainers

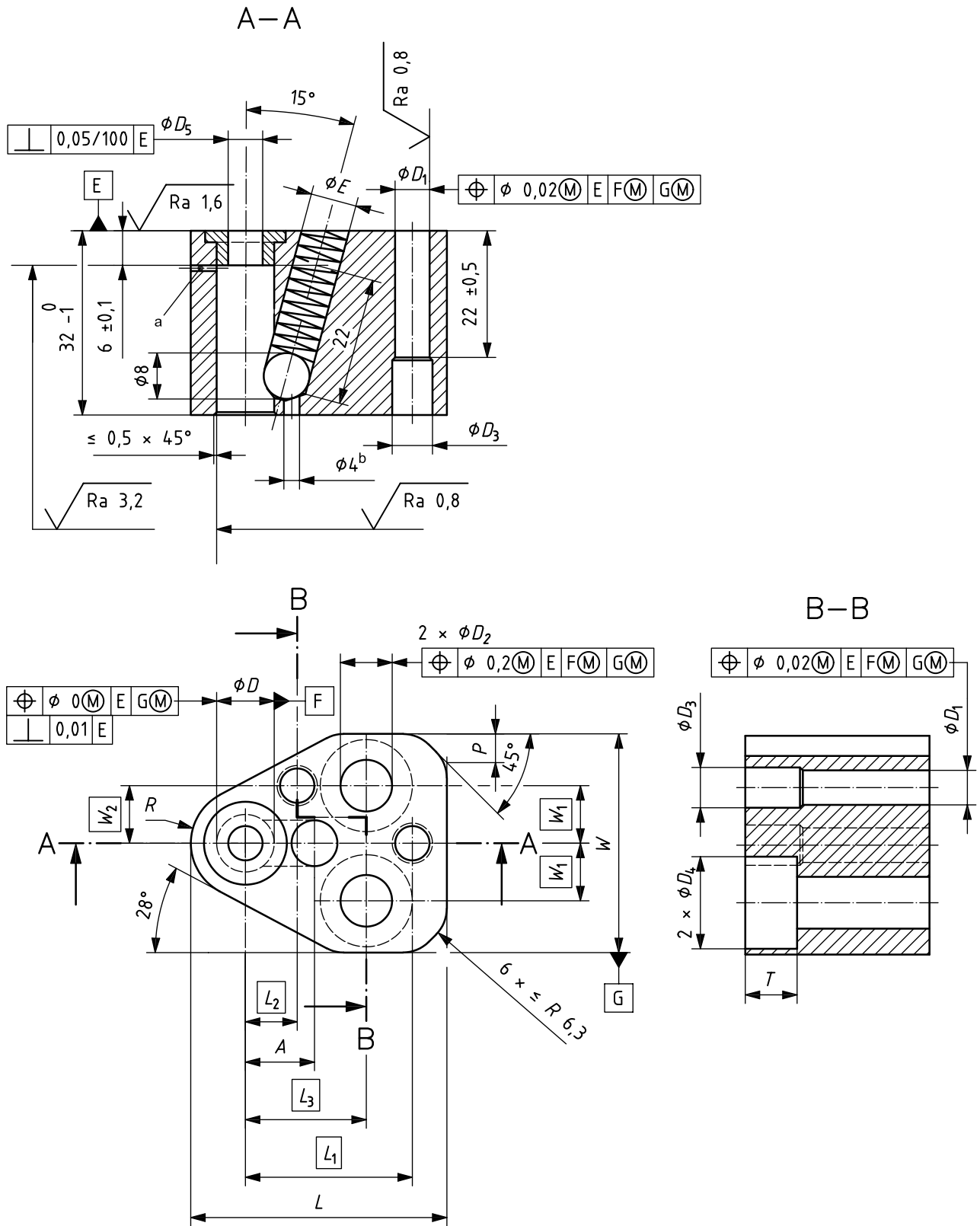
Dimensions in millimetres

$D$ H6	$W$ 0 -5	$D_2^a$ $\pm 0,3$	$D_4$ $\pm 0,3$	$L_1$ $\pm 0,01$	$L_2$ $\pm 0,01$	$L_3$ $\pm 0,1$	$L_4$ 0 -2	$W_1$ $\pm 0,13$	$W_2$ $\pm 0,01$	$T$ $\pm 0,3$	$E$ $\pm 0,02$	$R$ max.	$R_1$ max.	Screw
10	45	9	15	26,92	7,5	19	36	11,1	9	9,5	8,05	10	13	M8
13	51			29,97	6,5		39	14,3	12			13	16	
16	54			31,75	6,5		41	15,9	13,5			15	17	
20	61	11	18	33,53	5		44	17,5	16,5	11,5		18	21	M10
25	70	13,5	20	40,64	7	23,8	49	19,8	22	13,5		23	25	M12
32	70	13,5	20	40,64	7	23,8	49	19,8	22	13,5		23	25	M12

<sup>a</sup> Counterbore in accordance with ISO 273 and M8, M10 and M12 head cap screws in accordance with ISO 4762.

### 3.3 Type D reduced ball-lock punch retainer

The dimensions of type D reduced ball-lock punch retainers shall conform to the indications in Figure 2 and Table 2.



- a Venting hole.
- b Optional.

Figure 2 — Type D reduced ball-lock punch retainer



Table 2 — Dimensions of type D reduced ball-lock punch retainers

Dimensions in millimetres

$D$ H6	$L$	$W$	$D_1^a$ G6	$D_2^b$ H12	$L_1$	$L_2$	$L_3$	$W_1$	$W_2$	$T$	$D_3$	$D_4$	$A^c$	$E$ $\pm 0,02$	$P$	$R$	$D_5$ G6
10	44,5	38	6	9	29	9	21	10	10	9	7	16	12	8,05	5	9,5	6
13	50,5	47			32	11	23	13	13				13,5		6,5	12,5	
16	53,5	52	11	34	12	26	12	13	11	18	15	7	14				
20	60	55			11,5	27	14	17			17	8	17,5				
25	69,5	63	8	13	39	12	30	15	21	13	9	20	19,5		9	22	8
32	69,5	63			13	39	12	30	15	21		13	20		19,5	9	

a Hole for parallel hardened pins (dowel pins) in accordance with ISO 8735.

b Counterbore in accordance with ISO 273 and M8, M10 and M12 head cap screws in accordance with ISO 4762.

c Tolerance on this dimension is left to the manufacturer's discretion.

#### 4 Material and corresponding hardness

The choice of the material is left to the manufacturer's discretion. The hardness should be  $(46 \pm 3)$  HRC for ball-lock punch retainers and  $(55 \pm 5)$  HRC for backing plugs.

#### 5 Designation

Ball-lock punch retainers in accordance with this part of ISO 11900 shall be designated by the following:

- "Ball-lock retainer";
- reference to this part of ISO 11900, i.e. 11900-2;
- the type;
- the diameter  $D$ , in millimetres.

EXAMPLE A ball-lock punch retainer of type C with a diameter  $D = 10$  mm is designated as follows:

**Ball-lock retainer ISO 11900-2 - C - 10**

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**ICS 25.120.10**

Price based on 5 pages