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

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

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



PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

STANDARDSISO.COM : Click to view the full PDF of ISO 11900-2:2008



COPYRIGHT PROTECTED DOCUMENT

© ISO 2008

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

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 1302:2002.¹⁾

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

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

STANDARDSISO.COM : Click to view the full PDF of ISO 11900-2:2008

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

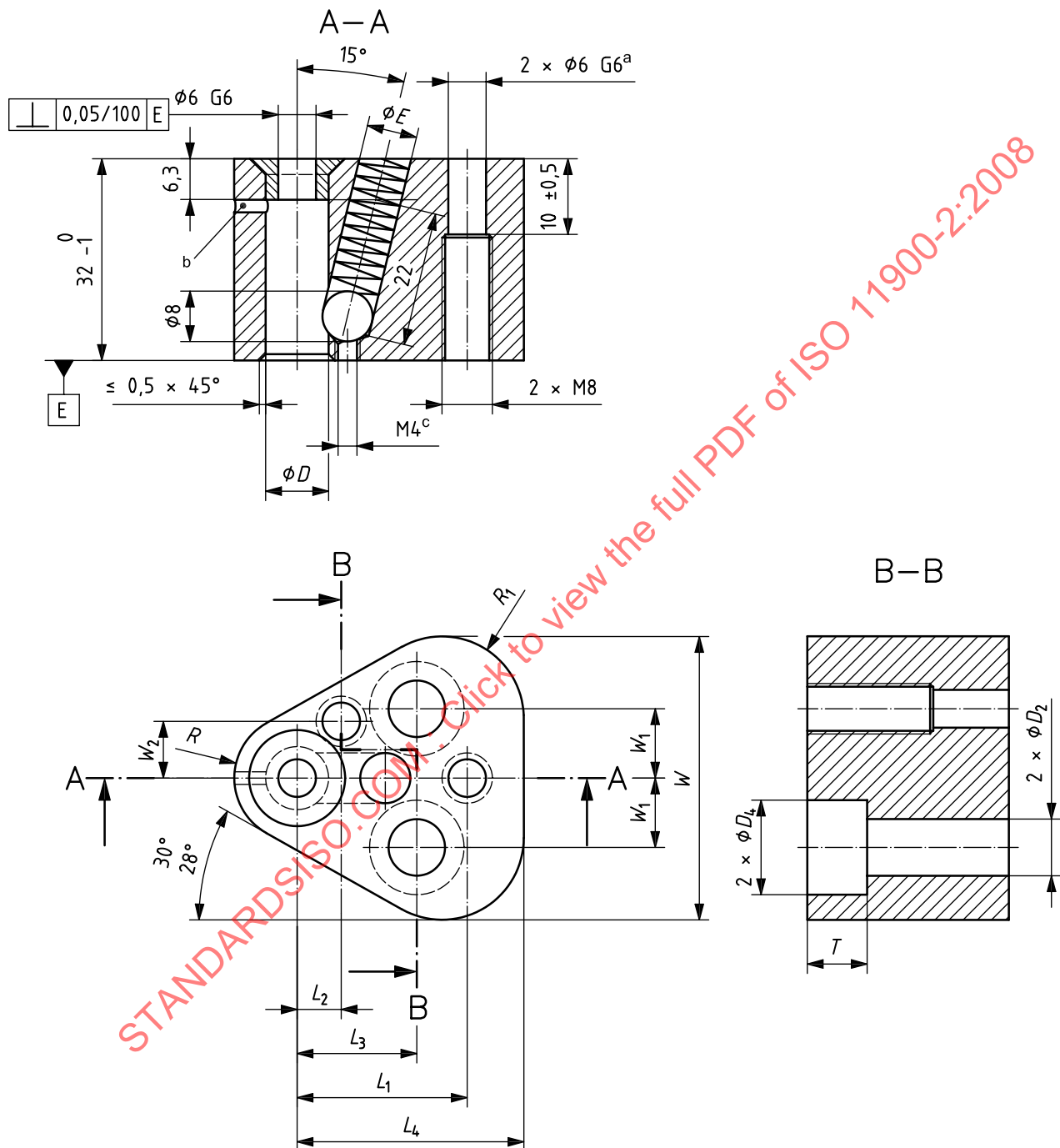
3.1 General tolerance

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

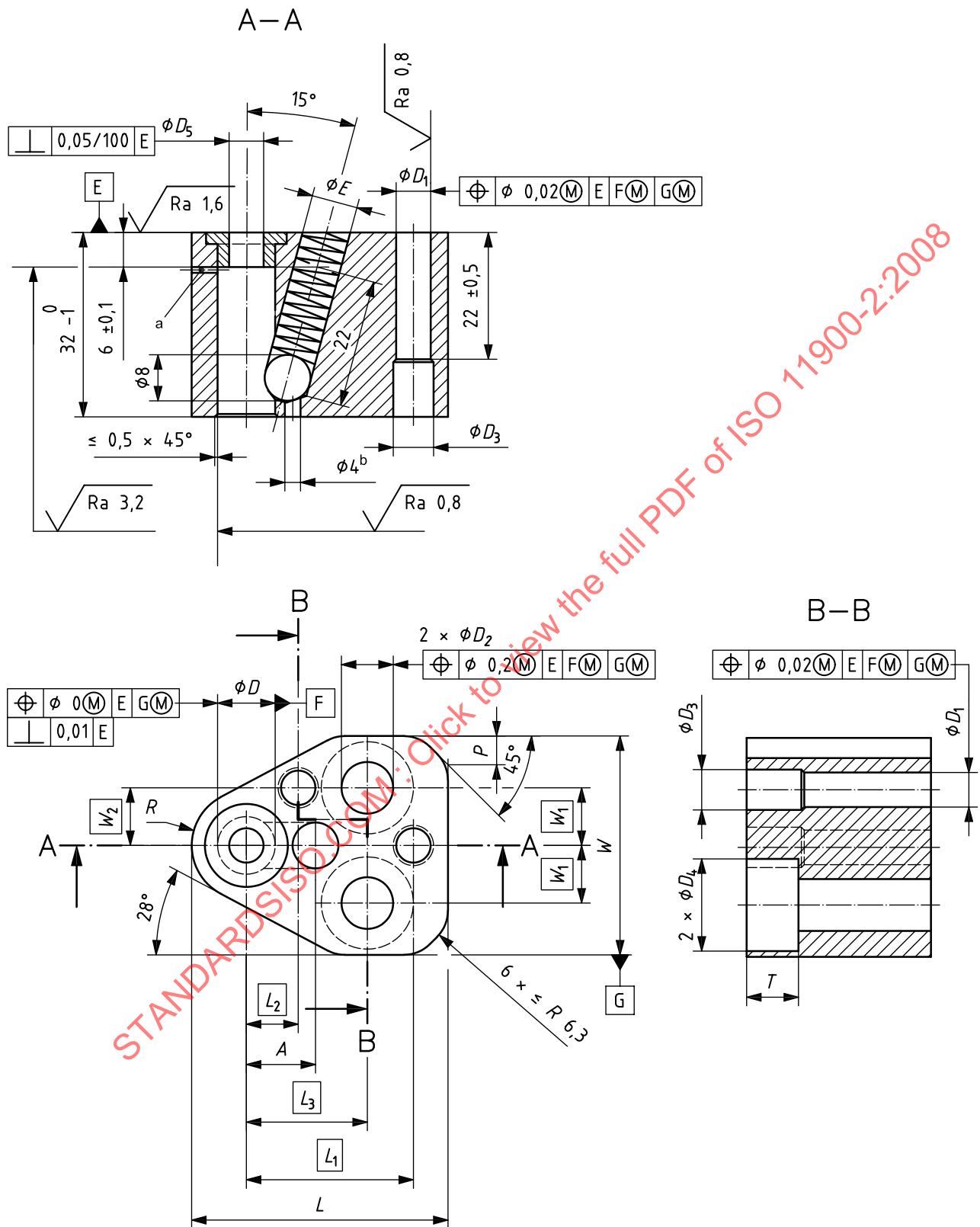
D H6	W 0 -5	D_2^a $\pm 0,3$	D_4 $\pm 0,3$	L_1 $\pm 0,01$	L_2 $\pm 0,01$	L_3 $\pm 0,1$	L_4 0 -2	W_1 $\pm 0,13$	W_2 $\pm 0,01$	T $\pm 0,3$	E $\pm 0,02$	R max.	R_1 max.	Screw
10	45	9	15	26,92	7,5	19	36	11,1	9	9,5	8,05	10	13	M8
13	51			29,97	6,5		39	14,3	12			13	16	
16	54			31,75	6,5		41	15,9	13,5			15	17	
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

^a 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.

Dimensions in millimetres
Surface roughness values in micrometres



a Venting hole.

b Optional.

Figure 2 — Type D reduced ball-lock punch retainer