
International Standard



6752

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Round punches with 60° conical head and straight shank

Poinçons à tête conique à 60° et corps cylindrique

First edition — 1984-08-01

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[ISO 6752:1984](https://standards.iteh.ai/catalog/standards/sist/311b6e8d-6eb3-4fb5-ab40-2aa12aa46395/iso-6752-1984)

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UDC 621.961.2

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Descriptors : tools, punches, dimensions, materials, hardness.

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been authorized 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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 6752 was developed by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in October 1982.

It has been approved by the member bodies of the following countries :

Belgium	Hungary	Romania
Bulgaria	India	South Africa, Rep. of
Egypt, Arab Rep. of	Israel	Sweden
Finland	Italy	Switzerland
France	Mexico	United Kingdom
Germany, F.R.	Poland	USA

No member body expressed disapproval of the document.

Round punches with 60° conical head and straight shank

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1 Scope and field of application

This International Standard specifies the basic dimensions in millimetres of round punches with 60° conical head and straight shank in the diameter range of 0,5 to 15 mm.

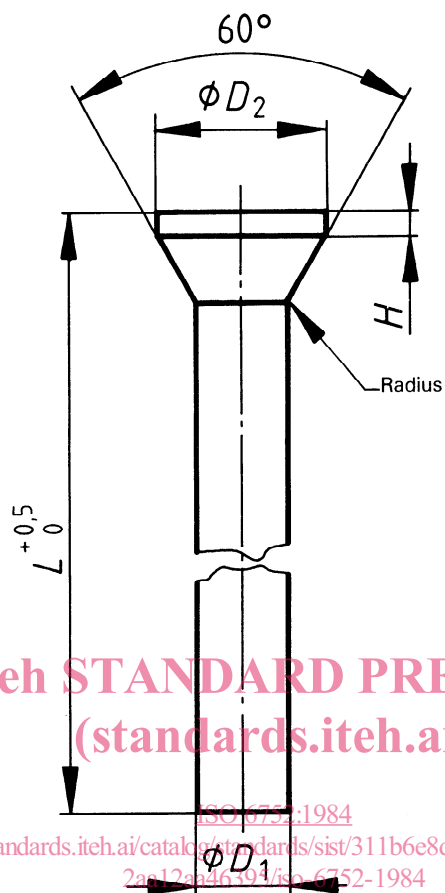
It gives as examples materials and hardness, and specifies designation of punches according to this International Standard.

The main use of punches as defined in this International Standard is for punching holes in steel sheet. They may also be used when punching holes in other materials.

2 References

- ISO/R 80, *Rockwell hardness test (B and C scales) for steel*.
ISO 4957, *Tool steel*.

3 Dimensions



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Dimensions in millimetres

D_1 h6	D_2	H $+0.2/0$
0,5	0,9	0,2
0,55	1	0,2
0,6	1,1	0,2
0,65	1,2	0,2
0,7	1,3	0,2
0,75	1,3	0,2
0,8	1,4	0,4
0,85	1,4	0,4
0,9	1,6	0,4
0,95	1,6	0,4
1	1,8	0,5
1,05	1,8	0,5
1,1	1,8	0,5
1,2	2	0,5
1,25	2	0,5
1,3	2	0,5
1,4	2,2	0,5
1,5	2,2	0,5
1,6	2,5	0,5
1,7	2,5	0,5
1,8	2,8	0,5

D_1 h6	D_2	H $+0.2/0$
1,9	2,8	0,5
2	3	0,5
2,1	3,2	0,5
2,2	3,2	0,5
2,4	3,5	0,5
2,5	3,5	0,5
2,6	4	0,5
2,8	4	0,5
3	4,5	0,5
3,2	4,5	0,5
3,4	4,5	0,5
3,6	5	0,5
3,8	5	0,5
4	5,5	0,5
4,2	5,5	0,5
4,5	6	0,5
4,8	6	0,5
5	6,5	0,5
5,3	6,5	0,5
5,6	7	0,5
6	8	0,5

D_1 h6	D_2	H $+0.2/0$
6,3	8	0,5
6,7	9	1
7,1	9	1
7,5	10	1
8	10	1
8,5	11	1
9	11	1
9,5	12	1
10	12	1
10,5	13	1
11	13	1
12	14	1
12,5	15	1
13	15	1
14	16	1,5
15	17	1,5
$L = 71 - 80 - 100$		

4 Material and hardness

The material is left to the manufacturer's discretion. The following hardness values are given as examples :

- a) Tool steel with 12 % Cr
point: HRC 62 ± 2
head: HRC 45 ± 5
- b) High speed steel
point: HRC 64 ± 2
head: HRC 52 ± 3

5 Designation

A punch in accordance with this International Standard shall be designated by

- a) a reference to this International Standard;
- b) its point diameter (D_1);
- c) its length (L).

Example :

Punch ISO 6752 - 6,3 × 80

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