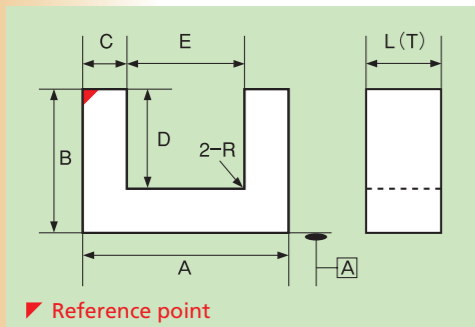
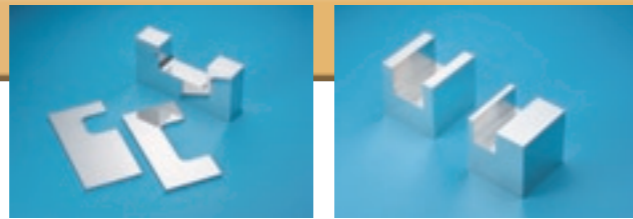


Blanking

Concave blanking for aluminum



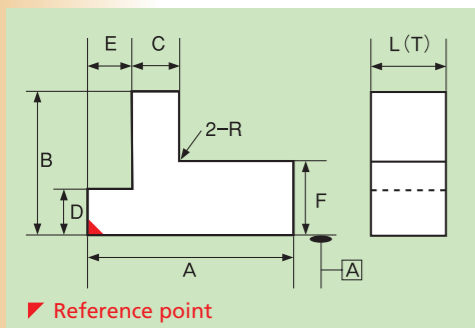
Blanking dimension tolerance (C to E) (mm)

Dimension	~ 6	~ 100	~ 500	~ 1000	More than 1,000
N (medium class)	±0.1	±0.2	±0.3	±0.4	±0.5
S (precision grade)	±0.05	±0.05	±0.1	±0.2	±0.3

Class N will apply unless otherwise instructed at the time of ordering.

Processing dimensions (mm)

Category	Processing dimensions							Processed plane (to plane A)	
	L (T)	A	B	C	D	E	R	Parallelism	Squareness
Plate type	5 ~ 30	200 ~ 1400	100 ~ 650	30 or more	5 ~ (B-30)	10.2 ~ (A-60)	5 or more	0.05 / 100mm	0.1 / 100mm
	30.01 ~ 40				10 ~ (B-30)	20.2 ~ (A-60)			
	40.01 ~ 80				15 ~ (B-50)	30.2 ~ (A-100)			
Block type	10 ~ 1400	30 ~ 300	20 ~ 150	5 or more	1 ~ 30	10.2 ~ (A-10)	1 or less	0.05 / 100mm	0.1 / 100mm
	1400	300	150		30.01 ~ 40	20.2 ~ (A-10)			
					40.01 ~ 80	30.2 ~ (A-10)			



Blanking dimension tolerance (C to F) (mm)

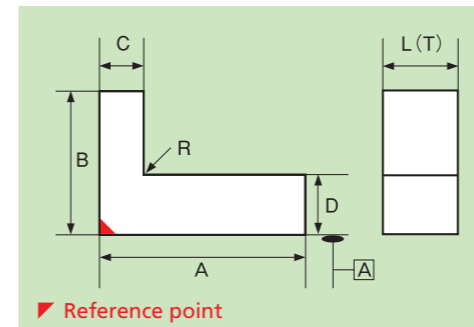
Dimension	~ 6	~ 100	~ 500	~ 1000	More than 1,000
N (medium class)	±0.1	±0.2	±0.3	±0.4	±0.5
S (precision grade)	±0.05	±0.05	±0.1	±0.2	±0.3

Class N will apply unless otherwise instructed at the time of ordering.

Processing dimensions (mm)

Category	Processing dimensions							Processed plane (to plane A)		
	L (T)	A	B	C	D, F	E	R	Parallelism	Squareness	
Plate type	5 ~ 30	200 ~ 1400	100 ~ 650	30 or more	30 ~ (B-5)	5 ~ (A-35)	5 or more	0.05 / 100mm	0.1 / 100mm	
	30.01 ~ 40				30 ~ (B-10)	10 ~ (A-40)				
	40.01 ~ 80				50 ~ (B-15)	15 ~ (A-65)				
Block type	10 ~ 1400	30 ~ 300	20 ~ 150	5 or more	5 ~ (B-1)	1 ~ (A-6)	1 or less	0.05 / 100mm	0.1 / 100mm	
	1400	300	150		5 or more	Additionally subject to the following conditions: Equivalent to or more than (B-30) and Equivalent to or more than (A-C) x 5				

L-shaped blanking for aluminum



Blanking dimension tolerance (C and D) (mm)

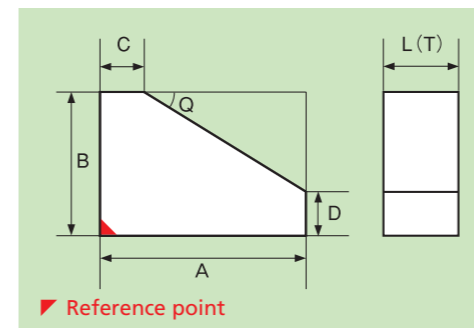
Dimension	~ 6	~ 100	~ 500	~ 1000	More than 1,000
N (medium class)	±0.1	±0.2	±0.3	±0.4	±0.5
S (precision grade)	±0.05	±0.05	±0.1	±0.2	±0.3

Class N will apply unless otherwise instructed at the time of ordering.

Processing dimensions (mm)

Category	Processing dimensions						Processed plane (to plane A)	
	L (T)	A	B	C	D	R	Parallelism	Squareness
Plate type	5 ~ 30	200 ~ 1400	100 ~ 650	30 ~ (A-5)	30 ~ (B-5)	5 or more	0.05 / 100mm	0.1 / 100mm
	30.01 ~ 40			30 ~ (A-10)	30 ~ (B-10)			
	40.01 ~ 80			50 ~ (A-15)	50 ~ (B-15)			
Block type	10 ~ 1400	30 ~ 300	20 ~ 150	5 ~ (A-1)	5 ~ (B-1)	1 or less	0.05 / 100mm	0.1 / 100mm
	1400	300	150	Additionally subject to the following conditions: Equivalent to or more than (B-80) and Equivalent to or more than B-(5 x C)				

Tilt blanking for aluminum



Blanking dimension tolerance (C and D, for the plate type) (mm)

Dimension	~ 6	~ 100	~ 500	~ 1000	More than 1,000
N (medium class)	±0.1	±0.2	±0.3	±0.4	±0.5
S (precision grade)	±0.05	±0.05	±0.1	±0.2	±0.3

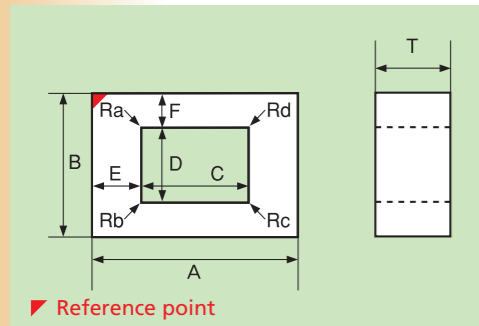
Class N will apply unless otherwise instructed at the time of ordering.
For the block type, tolerance Q is +/- 0.3°.

Processing dimensions (mm)

Category	Processing dimensions					
	L (T)	A	B	C	D	Q
Plate type	5 ~ 80	200 ~ 1400	100 ~ 650	1 or more	1 or more	1° ~ 89°
Block type	10 ~ 50 50.01 ~ 200	30 ~ 250 L/2 ~ 250	20 ~ 99.99 20 ~ 125	5 or more	5 or more	1° ~ 89°

Blanking

Rectangular hollow blanking for aluminum



Blanking dimension tolerance (C to F) (mm)

Dimension	~ 6	~ 100	~ 500	~ 1000	More than 1,000
N (medium class)	±0.1	±0.2	±0.3	±0.4	±0.5
S (precision grade)	±0.05	±0.05	±0.1	±0.2	±0.3

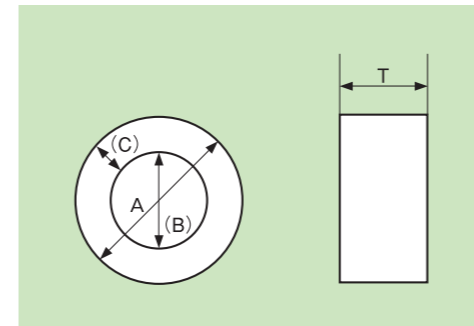
Class N will apply unless otherwise instructed at the time of ordering.

Processing dimensions (mm)

Category	Processing dimensions					
	T	A	B	C · D	E · F	Ra ~ Rd
Plate type	5 ~ 30	50 ~ 1400	50 ~ 650	20 or more	20 or more	5 or more
	30.01 ~ 40			30 or more		10 or more
	40.01 ~ 80			40 or more		15 or more

* The minimum distance between the hollow and the end face is 20 mm.

Circle blanking and ring blanking for aluminum



Blanking dimension tolerance (A to C) (mm)

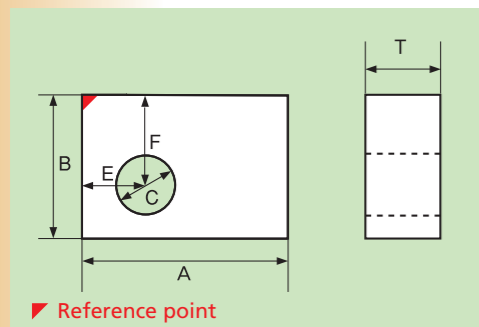
Dimension	~ 100	~ 450
N (medium class)	±0.2	±0.3

Processing dimensions (mm)

Category	Processing dimensions			
	T	A	B	C
Circle	5 ~ 50	160 ~ 450	—	—
Ring	5 ~ 50	160 ~ 450	30 ~ (A - 60)	30 or more

* The plate thickness plane may be milled depending on the material and the plate thickness. Please contact us for details.

Circular hollow blanking for aluminum



Blanking dimension tolerance (C to F) (mm)

Dimension	~ 6	~ 100	~ 500	~ 1000	More than 1,000
N (medium class)	±0.1	±0.2	±0.3	±0.4	±0.5
S (precision grade)	±0.05	±0.05	±0.1	±0.2	±0.3

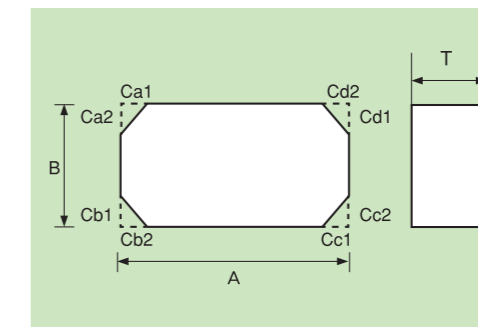
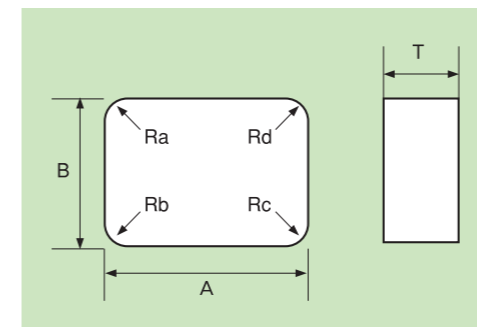
Class N will apply unless otherwise instructed at the time of ordering.

Processing dimensions (mm)

Category	Processing dimensions				
	T	A	B	C	E · F
Plate type	5 ~ 30	50 ~ 1400	50 ~ 650	20 or more	20 or more
	30.01 ~ 40			30 or more	25 or more
	40.01 ~ 80			40 or more	30 or more

* The minimum distance between the hollow and the end face is 10 mm.

Corner blanking for aluminum



Processing dimensions (mm)

Category	Processing dimensions				
	T	A	B	Ra ~ Rd	Ca1 · Ca2 ~ Cd1 · Cd2
Corner rounding	5 ~ 80	200 ~ 1400	100 ~ 650	1 or more	—
Corner cutting	5 ~ 80	200 ~ 1400	100 ~ 650	—	1 or more

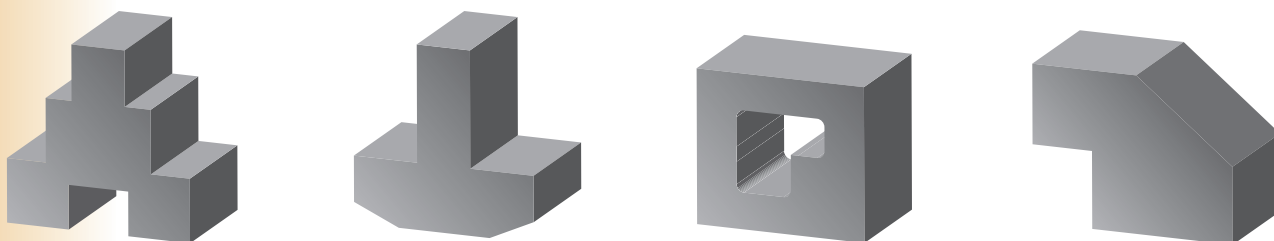
* Corner rounding may leave some unevenness where a linear portion meets a rounded curve.

Blanking

Combined processing



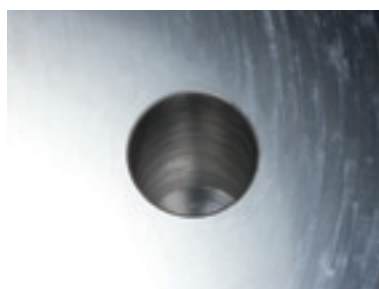
Examples of results



Processing dimensions (mm)

Category	Processing dimensions (mm)									
	L (T)	B	A	C	D	E	F	G	H	R
Plate type	5 ~ 50	100 ~ 650	200 ~ 1400	Whether or not to perform the blanking is determined on a case-by-case basis.						

Other processing (hole blanking, tapping, etc.)



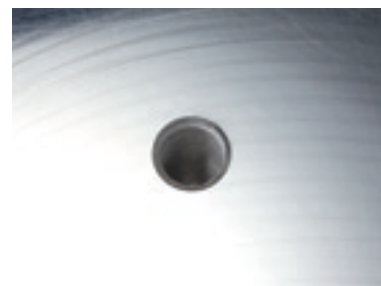
Drill hole



Countersink



Counterbore



Tapped hole

Category	Processing dimensions (mm)
Drill hole	ϕ 2.5 ~ ϕ 14.0
Counterbore	ϕ 5 ~
Tapped hole	M3 ~ M16

* Hole depth: Not exceeding five times the hole diameter