
दबा कर कार्य करने वाले डाई सेट
(प्लेन टाइप) — विशिष्टि

भाग 1 सेंटर पोस्ट आयाताकार डाई सेट
(पहला पुनरीक्षण)

**Press Working Die Sets
(Plain Type) — Specification**

Part 1 Centre Post Rectangular Die Sets

(*First Revision*)

ICS 25.120.10

© BIS 2018



भारतीय मानक ब्यूरो

BUREAU OF INDIAN STANDARDS

मानक भवन, 9 बहादुरशाह ज़फर मार्ग, नई दिल्ली-110002

MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG

NEW DELHI-110002

www.bis.org.in www.standardsbis.in

FOREWORD

This Indian Standard (Part 1) (First Revision) was adopted by the Bureau of Indian Standards after the draft finalized by the Metal Forming Machines Sectional Committee had been approved by the Production and General Engineering Division Council.

This standard was first published in 1982. The experience gained in implementation of this standard has necessitated this revision. This standard is issued in six parts. Other parts of this Indian Standard are:

- Part 2 Centre post square die sets
- Part 3 Centre post round die sets
- Part 4 Rear post rectangular die sets
- Part 5 Rear post square die sets
- Part 6 Rear post round die sets

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'.

Indian Standard
**PRESS WORKING DIE SETS (PLAIN TYPE) —
 SPECIFICATION**

PART 1 CENTRE POST RECTANGULAR DIE SETS

(First Revision)

1 SCOPE

This standard covers dimensions and other requirements for (plain type) rectangular die set with two guide posts in central axis.

2 REFERENCES

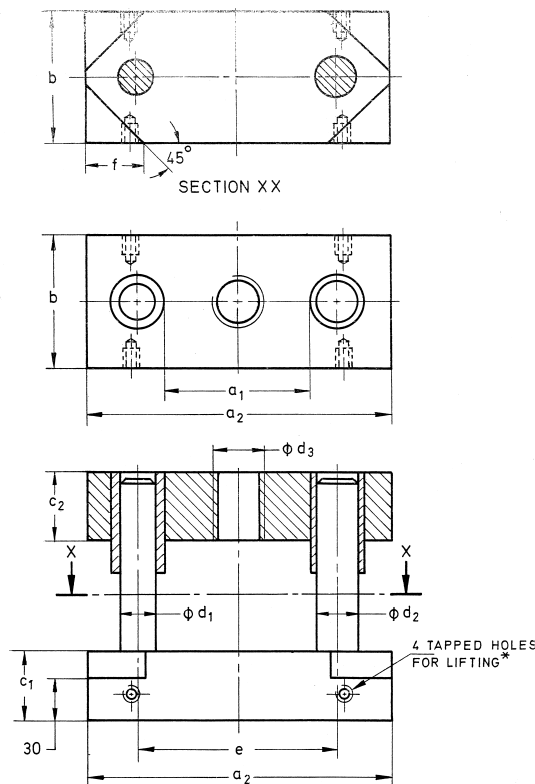
The following standards contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below.

<i>IS No.</i>	<i>Title</i>
210 : 2009	Grey iron castings — Specification (<i>fifth revision</i>)
1030 : 1998	Carbon steel castings for general engineering purposes — Specification (<i>fifth revision</i>)
2062 : 2011	Hot rolled medium and high tensile structural steel — Specification (<i>seventh revision</i>)
8127 : 2005	Guide bushes for press tool die sets — Specification (<i>second revision</i>)
11742 : 1986	Test chart for die sets

3 DIMENSIONS

The dimensions shall be as given in Table 1.

Table 1 Dimensions for Press Working Die Sets (Centre Post Rectangular Die Sets)
(Clause 3)



All dimensions in millimetres.

IS 10068 (Part 1) : 2018

Die Space $a_1 \times b$	a_2	c_1	c_2	d_1	d_2	d_3	e	f
80 × 63	197	40	30	19	20	M 20 × 1.5	127	30
100 × 63	217	45	30	19	20	M 20 × 1.5	147	30
125 × 63	242	45	30	19	20	M 20 × 1.5	172	30
160 × 63	288	50	32	24	25	M 20 × 1.5	212	30
200 × 63	328	50	32	24	25	M 20 × 1.5	252	30
100 × 80	228	50	32	24	25	M 20 × 1.5	152	35
125 × 80	253	50	32	24	25	M 20 × 1.5	177	35
160 × 80	288	50	32	24	25	M 20 × 1.5	212	35
200 × 80	328	50	32	24	25	M 20 × 1.5	252	35
250 × 80	378	50	32	24	25	M 20 × 1.5	302	35
125 × 100	253	56	40	24	25	M 24 × 1.5	177	40
160 × 100	288	56	40	24	25	M 24 × 1.5	212	40
200 × 100	346	56	40	30	32	M 24 × 1.5	260	40
250 × 100	396	56	40	30	32	M 24 × 1.5	310	40
315 × 100	461	56	40	30	32	M 24 × 1.5	375	40
160 × 125	306	56	40	30	32	M 24 × 1.5	220	50
200 × 125	346	56	40	30	32	M 24 × 1.5	260	50
250 × 125	396	56	40	30	32	M 24 × 1.5	310	50
315 × 125	461	56	40	30	32	M 24 × 1.5	375	50
200 × 160	346	63	50	30	32	M 30 × 2	260	40
250 × 160	396	63	50	30	32	M 30 × 2	310	50
315 × 160	485	63	50	38	40	M 30 × 2	385	50
400 × 160	570	63	50	38	40	M 30 × 2	470	50
250 × 200	420	63	50	38	40	M 30 × 2	320	50
315 × 200	485	63	50	38	40	M 30 × 2	385	50
400 × 200	570	63	50	38	40	M 30 × 2	470	50
500 × 200	670	63	50	38	40	M 30 × 2	570	50
315 × 230	485	63	50	38	40	M 30 × 2	385	50
400 × 250	570	63	50	38	40	M 30 × 2	470	50
500 × 250	670	63	50	38	40	M 30 × 2	570	50
400 × 315	594	75	63	48	50	M 42 × 3	480	50
500 × 315	694	75	63	48	50	M 42 × 3	580	50
500 × 400	694	75	63	48	50	M 42 × 3	580	50

* Tapped Size — M 8 × 20 for die sets up to 125 × 80 die space,
M 10 × 25 for die sets from 160 × 80 to 250 × 160 die space, and
M 12 × 35 for die sets of 315 × 160 die space and above.

4 DESIGNATION

4.1 A centre post rectangular die set of cast iron having a die space $a_1 \times b = 100 \text{ mm} \times 80 \text{ mm}$ with guide posts ‘Type A’ with round ends and having length = 200 mm, and with stepped solid (Type A) guide bushes of length 60 mm, shall be designated as:

Die Set C — 100 × 80 IS 10068 (Part 1) alongwith guide posts AR — 24/25 × 200 IS 7664 and guide bushes A — 24/25 × 60 IS 8127

4.2 A centre post rectangular die set of mild steel having a die space $a_1 \times b = 100 \text{ mm} \times 80 \text{ mm}$ with guide posts ‘Type B’ with tapered ends and having length = 200 mm, and with guide bushes ‘Type B’ of length 60 mm, shall be designated as:

Die Set MS — 100 × 80 IS 10068 (Part 1) alongwith guide posts BT — 24/25 × 200 IS 7664 and guide bushes B — 24/25 × 60 IS 8127

4.3 A centre post rectangular die set of welded or cast steel having a die space $a_1 \times b = 100 \text{ mm} \times 80 \text{ mm}$, with guide posts ‘Type B’ with tapered ends and having

length = 200 mm, and with guide bushes ‘Type B’ of length 60 mm, shall be designated as:

Die Set S — 100 × 80 IS 10068 (Part 1) alongwith guide posts BT — 24/25 × 200 IS 7664 and guide bushes B — 24/25 × 60 IS 8127

4.4 A centre post rectangular die set of mild steel having a die space $a_1 \times b = 100 \text{ mm} \times 80 \text{ mm}$, with guide posts ‘Type A’ with round ends and having length = 200 mm, and with guide bushes ‘Type C’ shall be designated as:

Die Set MS — 100 × 80 IS 10068 (Part 1) along with guide posts AR — 24/25 × 100 IS 7664 and guide bushes C — 24/25 IS 8127

5 MATERIAL

The top and bottom tool holders shall be made of hot rolled medium and high tensile structural steel of IS 2062 or of cast iron of grade FG 260 of IS 210 or cast steel of grade 230-450W of IS 1030.

6 GENERAL REQUIREMENTS

The top and bottom tool holders shall be free from cracks, burrs and pits and shall satisfy for accuracy when tested in accordance with IS 11742.

7 MARKING

7.1 The designation and the manufacturer's identification or trademark shall appear at a prominent place on tool holders.

7.2 BIS Certification Marking

7.2.1 The press working die sets may also be marked with the Standard Mark.

7.2.2 The use of the Standard Mark is governed by the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations made thereunder. The details of conditions under which the licence for the use of the Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

Bureau of Indian Standards

BIS is a statutory institution established under the *Bureau of Indian Standards Act, 2016* to promote harmonious development of the activities of standardization, marking and quality certification of goods and attending to connected matters in the country.

Copyright

BIS has the copyright of all its publications. No part of these publications may be reproduced in any form without the prior permission in writing of BIS. This does not preclude the free use, in the course of implementing the standard, of necessary details, such as symbols and sizes, type or grade designations. Enquiries relating to copyright be addressed to the Director (Publications), BIS.

Review of Indian Standards

Amendments are issued to standards as the need arises on the basis of comments. Standards are also reviewed periodically; a standard along with amendments is reaffirmed when such review indicates that no changes are needed; if the review indicates that changes are needed, it is taken up for revision. Users of Indian Standards should ascertain that they are in possession of the latest amendments or edition by referring to the latest issue of 'BIS Catalogue' and 'Standards : Monthly Additions'.

This Indian Standard has been developed from Doc No.: PGD 04 (1550).

Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

BUREAU OF INDIAN STANDARDS

Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002

Telephones : 2323 0131, 2323 3375, 2323 9402 Website: www.bis.org.in

Regional Offices:

	Telephones
Central : Manak Bhavan, 9 Bahadur Shah Zafar Marg NEW DELHI 110002	{ 2323 7617 2323 3841
Eastern : 1/14 C.I.T. Scheme VII M, V. I. P. Road, Kankurgachi KOLKATA 700054	{ 2337 8499, 2337 8561 2337 8626, 2337 9120
Northern : Plot No. 4-A, Sector 27-B, Madhya Marg, CHANDIGARH 160019	{ 26 50206 265 0290
Southern : C.I.T. Campus, IV Cross Road, CHENNAI 600113	{ 2254 1216, 2254 1442 2254 2519, 2254 2315
Western : Manakalaya, E9 MIDC, Marol, Andheri (East) MUMBAI 400093	{ 2832 9295, 2832 7858 2832 7891, 2832 7892

Branches: AHMEDABAD. BENGALURU. BHOPAL. BHUBANESHWAR. COIMBATORE. DEHRADUN. DURGAPUR. FARIDABAD. GHAZIABAD. GUWAHATI. HYDERABAD. JAIPUR. JAMSHEDPUR. KOCHI. LUCKNOW. NAGPUR. PARWANOO. PATNA. PUNE. RAIPUR. RAJKOT. VISAKHAPATNAM.