

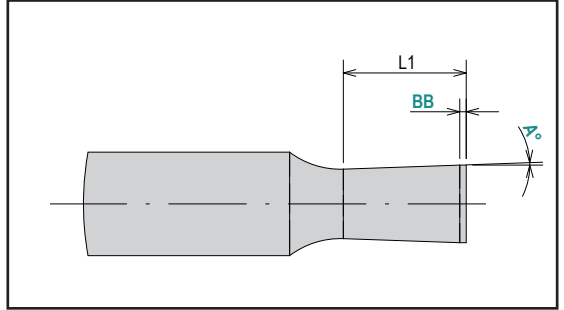
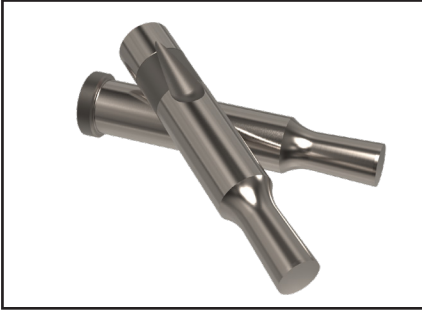


# XAR/XAV-ALTERATION THE SOLUTION FOR ADHESIVE WEAR



punching NE-metals  
without flakes\*

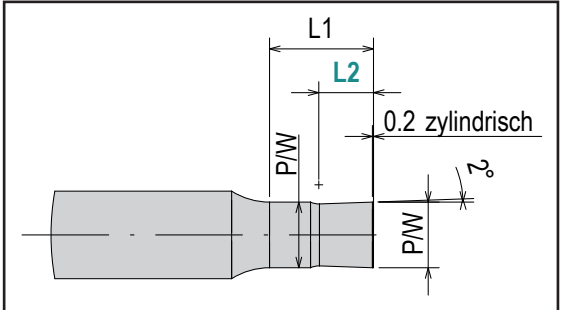
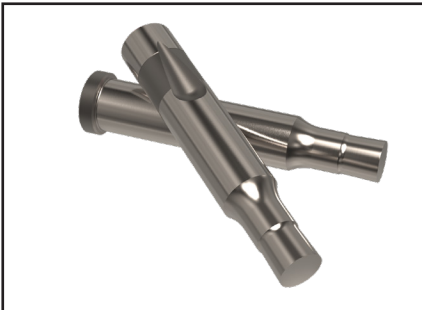
## XAR-Alteration



- “A” is limited to 0,029° to 10°
- Valid for all shapes.

**Example:** BJO 13 1990 P12,00 W8,00 XAR1° BB0,5

## XAV-Alteration



- L1 is the catalog point length and L2 is the variable alteration length.
- The alteration „XBR“ will not affect L2 length.

**Example:** BJO 13 1990 P12,00 W8,00 XAV10

When punching non-ferrous metals (NF metals) such as aluminum, aluminum alloy, copper, or brass, material sticks to the punch. This leads to the formation of a built-up edge and later to flakes, when the punch dives into the die.

**The solution: Attachment of a relief grinding**

This reduces the pressure on the cutting edge and counteracts wear.

At DAYTON PROGRESS, you can get the relief grinding through the addition of ‚XAV‘ or ‚XAR‘.

**Example:**

BJX 13 19100 M2 P10 XAV

BJX 13 19100 M2 P10 XAR (plus degree specification)

**Your advantages**

- XAR and XAV alterations are available for all DAYTON cutting punches
- Longer tool life with cutting tough materials
- Coatings can further enhance the positive effect

**The difference**  
**XAR** - angle and length are freely configurable  
**XAV** - according to VW standard angle always 2°

Please contact our staff for exact specifications.

\*A slight formation of flakes cannot be completely ruled out!



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