

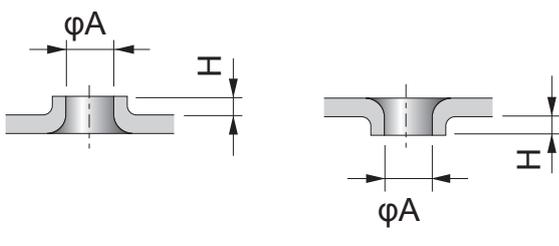
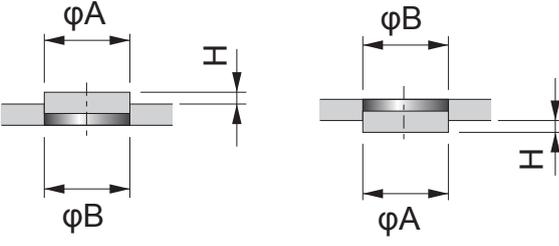
## SHAPE INSTRUCTION FOR FORMING TOOLS

We summarized the shape / dimension instructions and precautions when ordering tools.

When ordering forming tools, please specify the following in addition to the shape instructions.

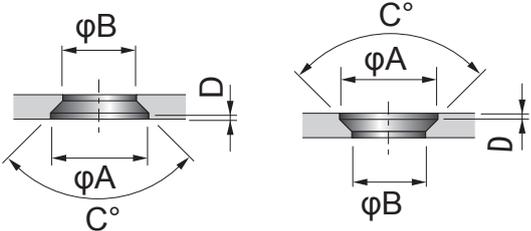
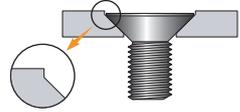
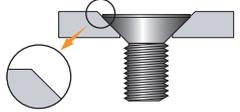
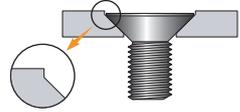
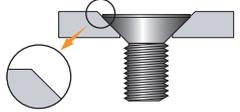
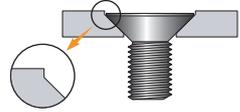
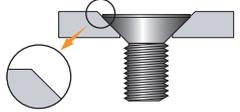
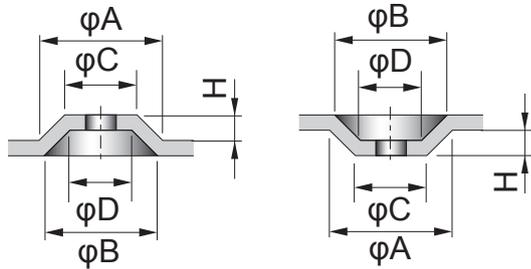
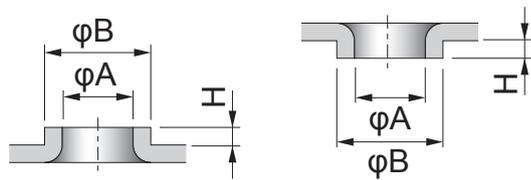
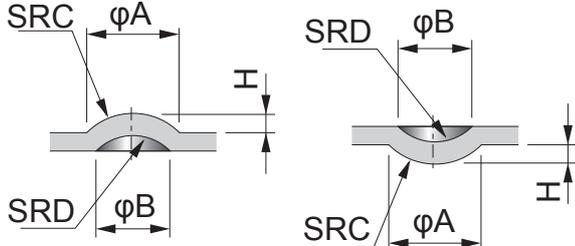
- Thickness of material, Kind of material
- Forming Up or Forming Down
- Processing pitch, presence of other tools that may interfere with the forming tools.

### DIMENSION INSTRUCTION METHOD FOR VARIOUS KINDS OF FORMING TOOLS

FORMING SHAPES	INSTRUCTIONS												
<p>■ Center Point</p> <p>[ FORMING UP ] [ FORMING DOWN ]</p> 	<ol style="list-style-type: none"> <li>Our standard center punch tools are height adjustment free tool.</li> <li>The standard center punch angle (A) is 90°. Please let us know if you would like other than 90°.</li> </ol>												
<p>■ Burring for thread form</p> <p>[ FORMING UP ] [ FORMING DOWN ]</p> 	<ol style="list-style-type: none"> <li>Please specify the inner diameter (A). Our standard inner diameter dimensions are as shown in the table on the right. <table border="1" data-bbox="1308 1220 1460 1411"> <thead> <tr> <th>Size</th> <th>φA</th> </tr> </thead> <tbody> <tr> <td>M2.5</td> <td>φ2.1</td> </tr> <tr> <td>M3</td> <td>φ2.6</td> </tr> <tr> <td>M4</td> <td>φ3.4</td> </tr> <tr> <td>M5</td> <td>φ4.3</td> </tr> <tr> <td>M6</td> <td>φ5.1</td> </tr> </tbody> </table> </li> <li>The standard dimension upward burring pin is coated with TiN.</li> <li>For pre-hole processing, <ul style="list-style-type: none"> <li>• Two steps for upward processing.</li> <li>• For downward processing, one process is the standard, but we are also preparing a pre-hole in one hit type by upward forming.</li> </ul> </li> </ol>	Size	φA	M2.5	φ2.1	M3	φ2.6	M4	φ3.4	M5	φ4.3	M6	φ5.1
Size	φA												
M2.5	φ2.1												
M3	φ2.6												
M4	φ3.4												
M5	φ4.3												
M6	φ5.1												
<p>■ Half Shear</p> <p>[ FORMING UP ] [ FORMING DOWN ]</p> 	<ol style="list-style-type: none"> <li>Please specify A or B dimension. It is also possible to instruct both A and B.</li> <li>If the height (H) is not specified, it will be about half the plate thickness.</li> <li>Unless otherwise specified, the dimensional tolerance of dimension A is ± 0.02. Please specify if other dimensional tolerances are desired.</li> <li>Extrusion type is also available as requested. (φA &lt; φB)</li> </ol>												



# LIFE COUNTERMEASURE FOR TOOLING

FORMING SHAPES	INSTRUCTIONS						
<p>■ Countersink for countersunk screw (Chamfering)</p> <p>[ FORMING UP ]    [ FORMING DOWN ]</p> 	<p>1. Two types of chamfering are available.</p> <table border="1" data-bbox="810 344 1442 546"> <thead> <tr> <th>Type 1</th> <th>Type 2</th> </tr> </thead> <tbody> <tr> <td></td> <td></td> </tr> <tr> <td>Chamfer with a straight section</td> <td>Chamfer without a straight section</td> </tr> </tbody> </table> <p>2. When using countersunk screws, please specify the countersunk screw dimensions.</p>	Type 1	Type 2			Chamfer with a straight section	Chamfer without a straight section
Type 1	Type 2						
							
Chamfer with a straight section	Chamfer without a straight section						
<p>■ Emboss</p> <p>[ FORMING UP ]    [ FORMING DOWN ]</p> 	<p>1. Please specify either A or B and C or D dimensions.</p> <p>2. If there is a pre-hole (inner diameter hole), please specify the dimensions. Please also indicate the before or after forming of the pre-hole (inner diameter hole).</p>						
<p>■ Burring (Extrusion)</p> <p>[ FORMING UP ]    [ FORMING DOWN ]</p> 	<p>1. Please specify the inner diameter (A) or outer diameter (B).</p> <p>2. When processing stainless steel, we recommend die punch surface treatment (TiN treatment).</p> <p>3. For upward forming, an external spring type die with enhanced strip force is also available.</p> <p>4. When threading the inner diameter, please inform us of the screw dimensions.</p>						
<p>■ Emboss (Dimple)</p> <p>[ FORMING UP ]    [ FORMING DOWN ]</p> 	<p>1. Please indicate the dimensions of convex diameter (A), concave diameter (B), convex spherical radius (C), concave spherical radius (D).</p> <p>2. Please let us know if the depth of the recess is required.</p>						

For More information,  
please contact  
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