

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.

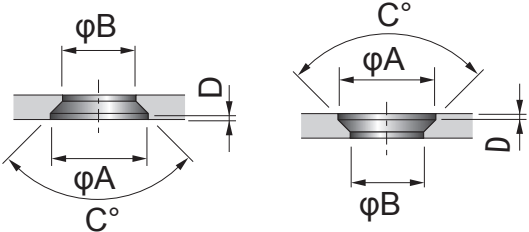
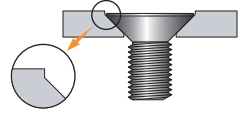
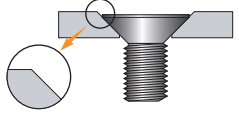
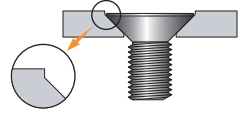
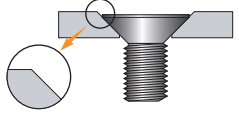
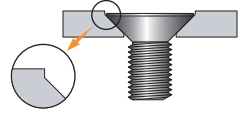
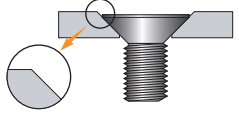
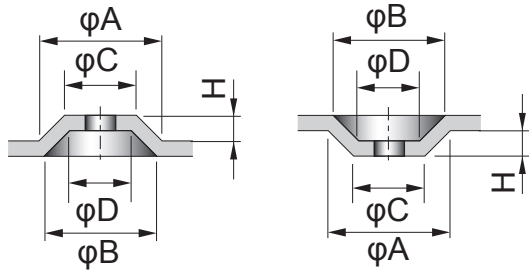
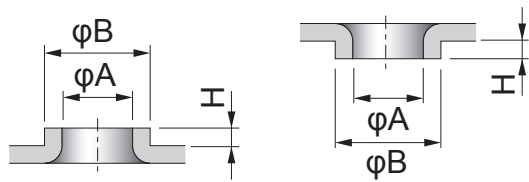
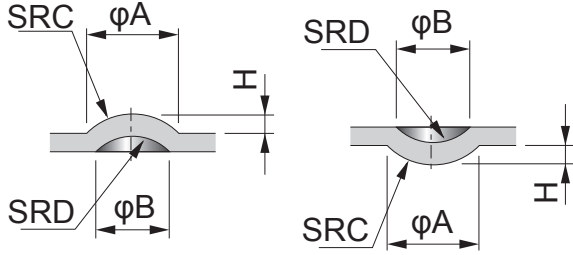
- Thickness of material, Kind of material
- Forming Up or Forming Down
- Processing pitch, presence of other tools that may interfere with the forming tools.

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"> Our standard center punch tools are height adjustment free tool. The standard center punch angle (A) is 90°. Please let us know if you would like other than 90°. 												
<p>■ Burring for thread form</p> <p>[FORMING UP] [FORMING DOWN]</p>	<ol style="list-style-type: none"> Please specify the inner diameter (A). Our standard inner diameter dimensions are as shown in the table on the right. <table border="1" style="float: right;"> <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> The standard dimension upward burring pin is coated with TiN. For pre-hole processing, <ul style="list-style-type: none"> • Two steps for upward processing. • For downward processing, one process is the standard, but we are also preparing a pre-hole in one hit type by upward forming. 	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"> Please specify A or B dimension. It is also possible to instruct both A and B. If the height (H) is not specified, it will be about half the plate thickness. Unless otherwise specified, the dimensional tolerance of dimension A is ± 0.02. Please specify if other dimensional tolerances are desired. Extrusion type is also available as requested. (φA < φB) 												



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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