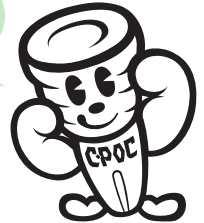


## SHAPE INSTRUCTION FOR FORMING TOOLS

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

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

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

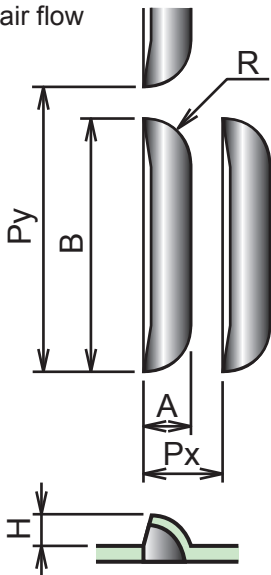
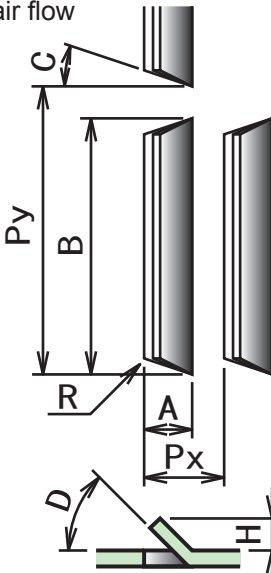
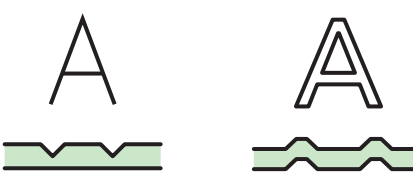


## DIMENSION INSTRUCTION METHOD FOR VARIOUS KINDS OF FORMING TOOLS

FORMING SHAPES	INSTRUCTIONS
<p>■ Bridge, Double bridge</p> <p>[SINGLE BRIDGE]      [DOUBLE BRIDGE]</p>	<ol style="list-style-type: none"> <li>1. Please let us know when forming after slitting.</li> <li>2. If there is a pre-hole (inner diameter hole D) with a single bridge, please specify the dimensions. Also, please indicate whether the pre-hole (D) is before or after forming. (In after forming, the pre-hole (D) is deformed.)</li> <li>3. Please let us know if there is a tolerance in the inner width (D) in the case of a double bridge.</li> </ol>
<p>■ Lance</p> <p>[ L-BENDING ]      [Z-BENDING]</p>	<ol style="list-style-type: none"> <li>1. An angle (C) of 5 ° or more is recommended. (To prevent strip errors)</li> <li>2. Please inform us when cutting up after slitting.</li> </ol> <p>[ When there is a slit ]</p> <p>※In the case of forming after slitting, the tool life is extended.</p>



# SHAPE INSTRUCTION FOR FORMING TOOLS

FORMING SHAPES	INSTRUCTIONS
<p>■ Louver for air flow</p> 	<ol style="list-style-type: none"> <li>Punching condition (only as a guide) <ul style="list-style-type: none"> <li>Material thickness <math>\leq 2.3</math> mm</li> <li>Width (A) <math>\geq</math> Height (H) x 2</li> <li>Forming pitch <math>P_x \geq</math> Width (A) + 5 mm</li> <li><math>P_y \geq</math> Length (B) + 5 mm (Material thickness <math>\leq 1.6</math> mm)</li> <li><math>P_y \geq</math> Length (B) + 8 mm (Material thickness <math>&gt; 1.6</math> mm)</li> </ul> </li> </ol> <p>Please contact us if the above processing conditions are not met.</p> <ol style="list-style-type: none"> <li>Dimension "R" and "A" would be same dimension unless otherwise instructed.</li> </ol>
<p>■ Lance for air flow</p> 	<ol style="list-style-type: none"> <li>Punching condition (only as a guide) <ul style="list-style-type: none"> <li>Material thickness <math>\leq 2.3</math> mm</li> <li>Material thickness + Height (H) <math>&lt; 10</math> mm</li> <li>Forming pitch <math>P_x \geq</math> Width (A)</li> <li><math>P_x \geq</math> Length (B) + 5 mm</li> </ul> </li> </ol> <ul style="list-style-type: none"> <li>The recommended width (A) is at least 5 times the material thickness.</li> <li>The recommended angle (C) is 5 ° or more and 20 ° or less.</li> <li>A rise angle (D) of 45 ° or less is recommended to maintain tool strength.</li> </ul> <p>Please consult us if the above punching conditions are not met.</p>
<p>■ Marking (Stamping Emboss)</p>  <p>[Stamping]                      [Emboss]</p>	<ol style="list-style-type: none"> <li>There are two types of engravings: "stamping" that creates a dent in the workpiece (material) and "embossing" that creates a concavity and convexity.</li> <li>In the case of a embossing, please indicate whether you want to be able to read from the concave side or the convex side.</li> <li>There is also a replaceable blade type stamp that can replace only the stamped part.</li> </ol>

For **More** information,  
please contact  
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