

## FORMING TOOL

Not only punching but also various forming processes are possible with the NC turret punch press.

### TYPICAL FORMING PROCESS

#### ■ BURRING FOR THREAD FORM

Forming process for making tubes of threading for screw.

[ Forming up ]



[ Forming down ]



There are two types of tools.

Pre-hole one process type

Die which performs pre-hole processing and burring at the same time.

Pre-hole two process type

Die for burring after pre-hole processing

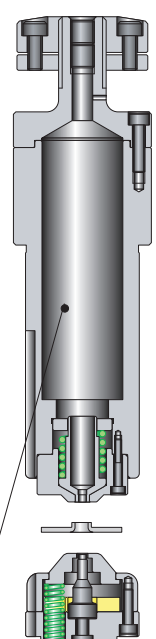
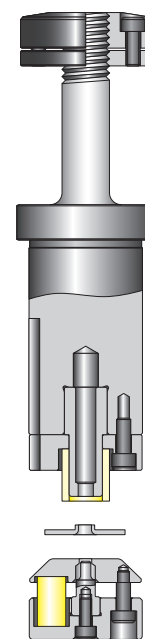
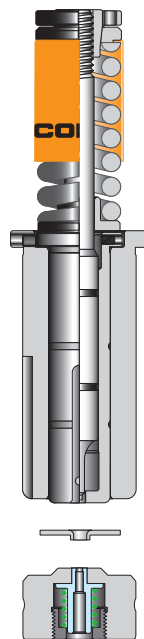
Our standard dimension table (other than upward & downward hole one process type)

Screw size	Pin diameter	Pre-hole
M 2 . 5	$\phi$ 2 . 1	$\phi$ 1 . 2
M 3	$\phi$ 2 . 6	$\phi$ 1 . 5
M 4	$\phi$ 3 . 4	$\phi$ 2 . 0
M 5	$\phi$ 4 . 3	$\phi$ 2 . 4
M 6	$\phi$ 5 . 1	$\phi$ 2 . 8

※TiN coating is applied to the upward burring pin of standard dimension.

※In the case of non-standard dimensions, please indicate the pin diameter.

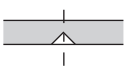
FORMING DOWN (Pre-piercing and forming)    FORMING UP (Forming after Pre-piercing)    FORMING UP (Pre-piercing and forming)



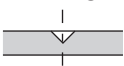
Slug accumulates in the upper tank.

#### ■ CENTER POINT

[ Forming up ]



[ Forming down ]



• The standard is a height adjustment free type. (a die that required punch length adjustment for each plate thickness.)

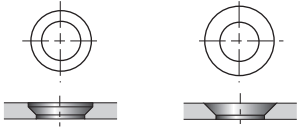
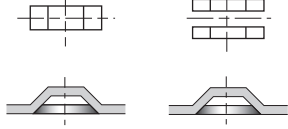
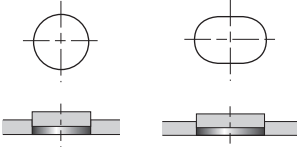
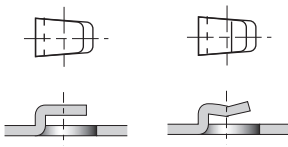
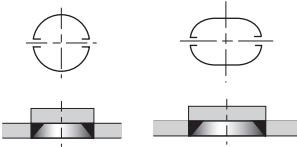
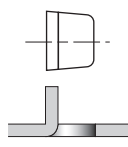
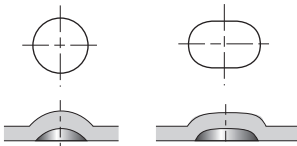
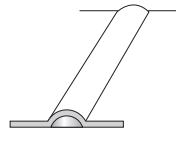
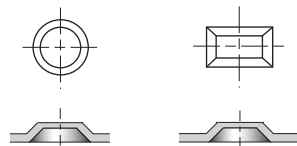
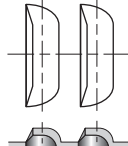
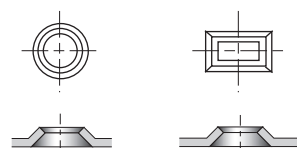
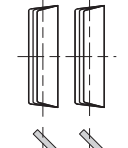
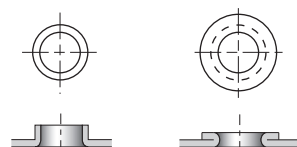
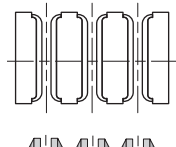
• Standard center punch angle is 90 degree. Please specify if an angle other than 90 degree is desired.

• The depth of the center point is optionally adjustable.

※We also produce a type that adjusts and fixes the punch length for each material thickness.

# FORMING TOOL

## Examples of other major forming

NAME	PRINCIPAL USE · SPECIAL NOTES	NAME	PRINCIPAL USE · SPECIAL NOTES
<b>COUNTERSINK FOR COUNTERSUNK SCREW</b> 	<ul style="list-style-type: none"> <li>• Sink the head of the countersunk screw, rivets in the material.</li> <li>• Take the corner after the punching process.</li> <li>• Guide for tapping.</li> </ul>	<b>BRIDGE, DOUBLE BRIDGE</b> 	<ul style="list-style-type: none"> <li>• Used for the seat of products.</li> <li>• Insert the circuit board.</li> <li>• Positioning.</li> </ul>
<b>HALF SHEAR</b> 	<ul style="list-style-type: none"> <li>• positioning, stoppers, etc.</li> <li>• The projection height is desirably 60% or less of the plate thickness.</li> </ul>	<b>LANCE (Z-BENDING)</b> 	<ul style="list-style-type: none"> <li>• Used for hooks, positioning, stoppers, etc.</li> </ul>
<b>KNOCKOUT</b> 	<ul style="list-style-type: none"> <li>• Retain the scraps to the base material and remove it with a screwdriver etc. when using.</li> <li>• Positioning, stoppers, etc.</li> </ul>	<b>LANCE (L-BENDING)</b> 	<ul style="list-style-type: none"> <li>• Used for positioning, stoppers, etc.</li> </ul>
<b>EMBOSS (DIMPLE)</b> 	<ul style="list-style-type: none"> <li>• Used for positioning etc.</li> </ul>	<b>BEADING</b> 	<ul style="list-style-type: none"> <li>• Plate reinforcement.</li> </ul>
<b>EMBOSS</b> 	<ul style="list-style-type: none"> <li>• Used for the seat of products and the seat of bolts etc.</li> <li>• Stick the nameplate, seal etc.</li> </ul>	<b>LOUVER FOR AIR FLOW</b> 	<ul style="list-style-type: none"> <li>• Air flow for ventilation.</li> <li>• Mini louvers are also used for positioning and stoppers.</li> </ul>
<b>COUNTERSINK</b> 	<ul style="list-style-type: none"> <li>• Sink the head of the countersunk screw.</li> <li>• Non-slip.</li> </ul>	<b>LANCE FOR AIR FLOW</b> 	<ul style="list-style-type: none"> <li>• Air flow for ventilation.</li> </ul>
<b>BURRING · CURLING</b> 	<ul style="list-style-type: none"> <li>• Guidance and protection of pipes and cables.</li> <li>• Water drainage, air flow for ventilation.</li> </ul>	<b>CARD GUIDE</b> 	<ul style="list-style-type: none"> <li>• Insert the circuit board.</li> </ul>

There are various other forming tools.  
Please also see the information and images on our website.

For More information,  
please contact  
CONIC tool sales desk.

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