

CONIC SPECIAL TOOL USERS MANUAL (Murata type)

Thank you very much for purchasing Conic special tools. Please read this manual carefully and use Conic tools safely.



Use special tool safely.

- Please use tools as suitable conditions.
 Other than specified material or thickness tools maybe destroyed.
- ◆ Please adjust shut height before use.
 - Make sure each punchpress shut height.
 - Conic set the shut height shorter for safety reason when ship out our tools.

Please use this manual to put shims in to adjust shut height.

- ◆ If process is multi process type tool;
 - Please make sure pre-hole size.
 - Please make sure center position of the tools when make punching program.

- How to adjust shut height for forming tools.
- 1) Height adjustment of forming tool is done by shims.
- 2) There are two ways to adjust height, one is using punch shims another is using die shims.
- 3) First punch without any shims then find the difference and required amount of shims.

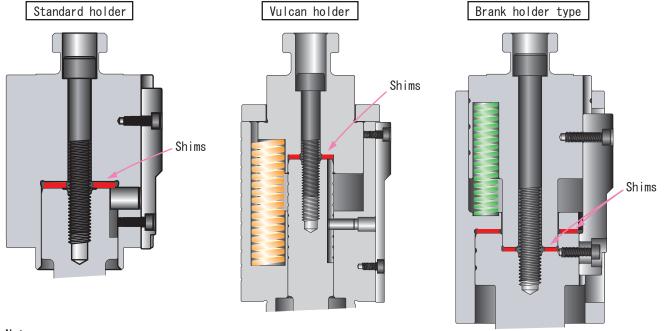
Note 1:

Please make sure to take out shims after punching.

Note 2:

Add the grinding amount of shims after grind the tools.

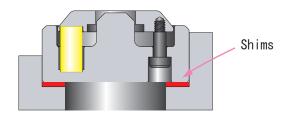
■How to adjust punch shims. (put shims between punch and punch holder)



Note:

In case use blank holder type guide, please be careful, there are two positions to put same thickness shims in one is between punch and driver, another is punch and holder.

■How to adjust die shims. (put shims between die and die holder)



Special forming shim set(sells separately) has 5 pieces shims. Thickness is t=0.4, 0.5, 0.6, 0.7, 0.8mm It can be adjusted by those combination from 0.4mm to 2.6mm 0.1mm step.

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