

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.

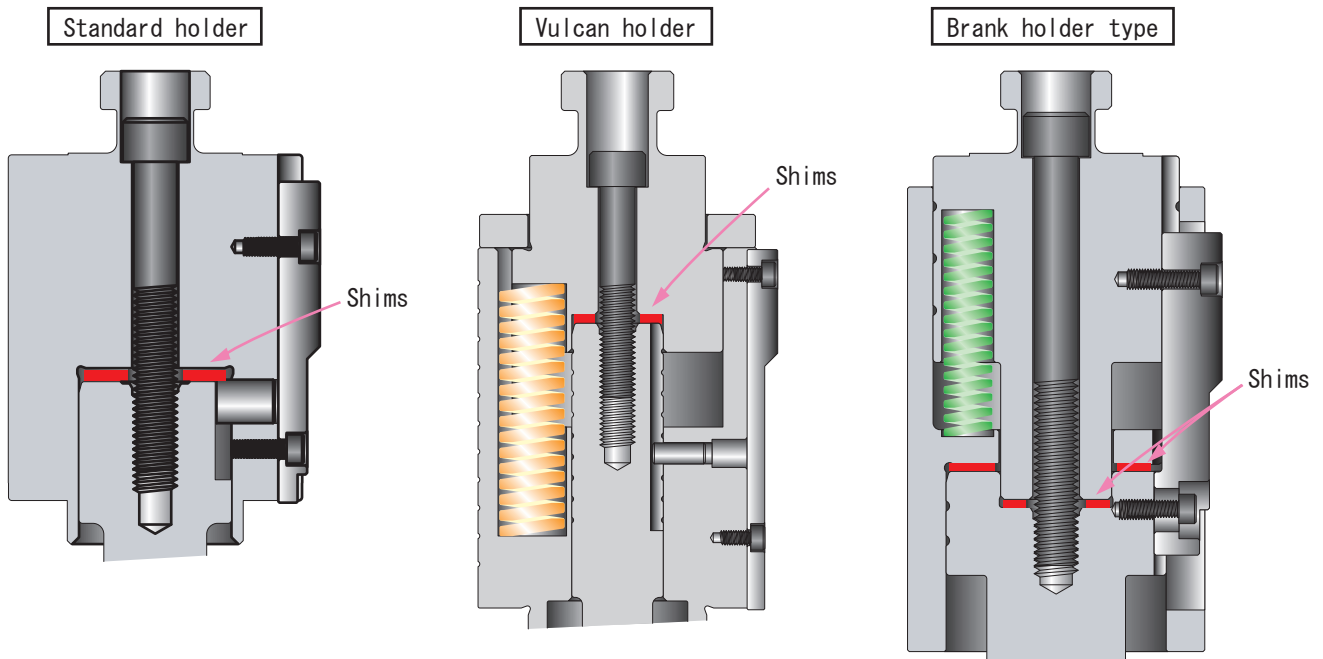
- Make sure each punchpress shut height.
- Conic set the shut height shorter for safety reason when ship out our tools.

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.

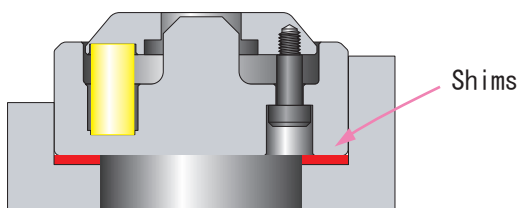
■ How to adjust punch shims. (put shims between punch and punch holder)



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)



■ 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.