

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

Caution when start to use Conic tools

Please use Conic punching tools as of when you get it from factory.

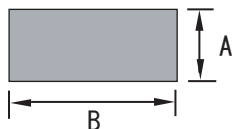
- Please use Conic tools as of when you get it from factory. Because, we apply special lubricant grease (MoS₂ with graphite) on slide area which is punch body and inside of guide. It is necessary to apply certain lubrication frequently while machine is running.
- When you get punch body as the tooling parts, we recommend to apply some lubricant grease (MoS₂ with graphite) to slide area of punch body and inside of guide before using that tool.

Conic recommend to use MoS₂ with graphite for tool slide area. Customer may purchase that from Conic tool order desk or distributors.

- Please clean not only tools but also turret tool holder and die holder when install tools to the machine. Sometimes metal dust may stay in the die holder and cause by incline set up of the die.
- When tools are not used in the turret, please take out and store in the tool cabinet to avoid getting rust and dust.
- If tool is dull and not make good performance, please regrind punch and die to use wet type grinder. After regrind clean the punch body slide area and apply good lubrication oil or grease to there.
- Please do not modify or apply additional machining to the punching tools by customer.
- If you have any other questions please contact tool order desk.

Regarding Urethane Kicker

Most of the time, Conic put urethane kicker to the bottom area of punch body to avoid slug comes up depend on size and shape.



- Round shape; standard on size more than 4mm
- Shape type; standard on short size(A) is more than 6mm
(We can put urethane kicker if (A) is more than 6mm if customer request.)
- Special shape; depend on actual size and shape.

When use tools as blanking shapes

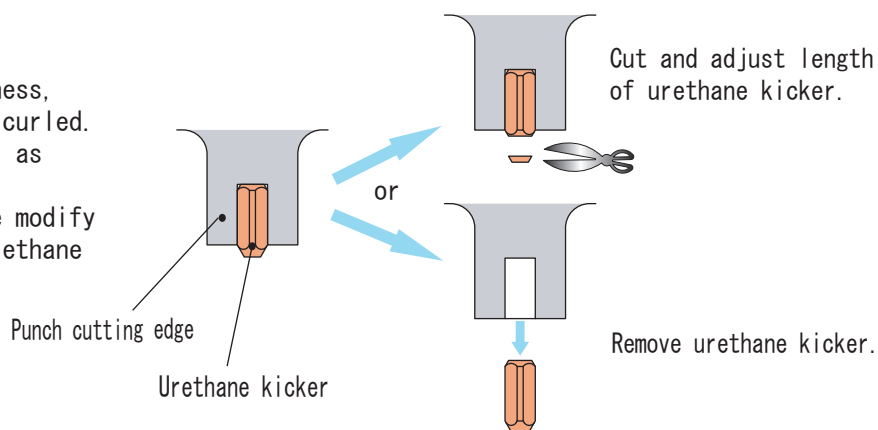
If punched blank is going to parts please read followings:

[Specification]

We sometimes put urethane kicker even customer may use that tools as blanking shapes. Please make sure punching edges of the tools.

[Note]

Depend upon material or material thickness, sometimes punched shape has damaged or curled. In such cases please test same material as production and check the result. Then, if result is not satisfied, please modify to cut the urethane kicker or remove urethane kicker itself.



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.

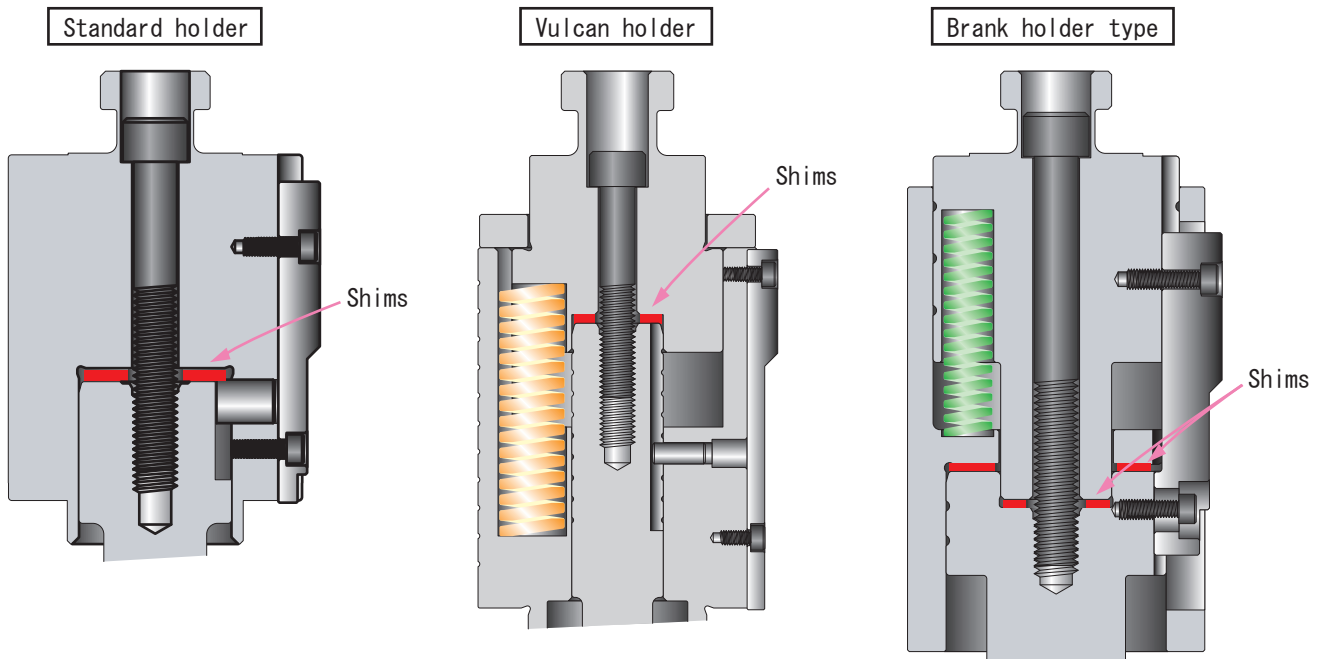
- Make sure each punchpress shut height.
- Conic set the shut height shorter for safety reason when ship out our tools.

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.

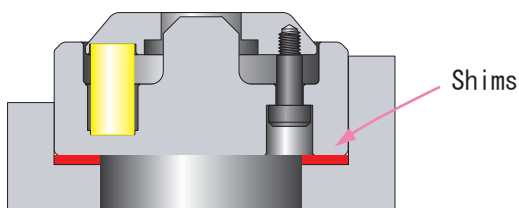
■ How to adjust punch shims. (put shims between punch and punch holder)



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.