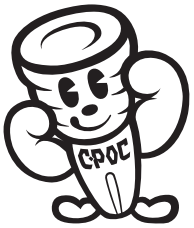
SHAPE INSTRUCTION FOR FORMING TOOLS

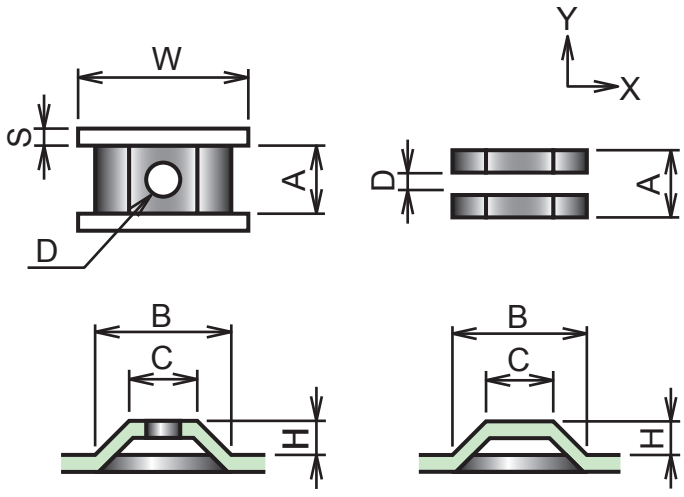
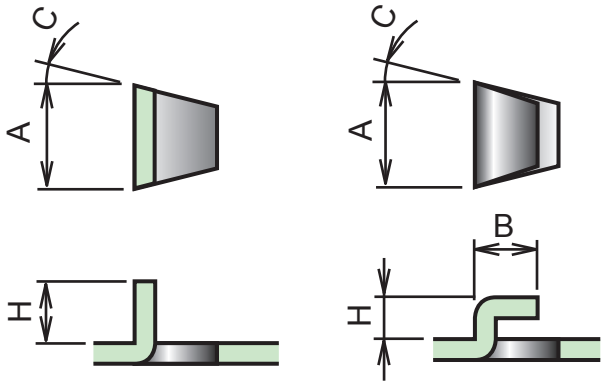
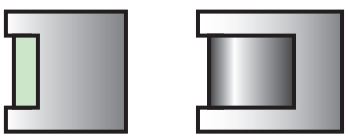
We summarized the shape / dimension instructions and precautions when ordering tools.

- 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
■ Bridge, Double bridge  [SINGLE BRIDGE] [DOUBLE BRIDGE]	1. Please let us know when forming after slitting. 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.) 3. Please let us know if there is a tolerance in the inner width (D) in the case of a double bridge.
■ Lance  [L-BENDING] [Z-BENDING]	1. An angle (C) of 5 ° or more is recommended. (To prevent strip errors) 2. Please inform us when cutting up after slitting. [When there is a slit]  ※In the case of forming after slitting, the tool life is extended.

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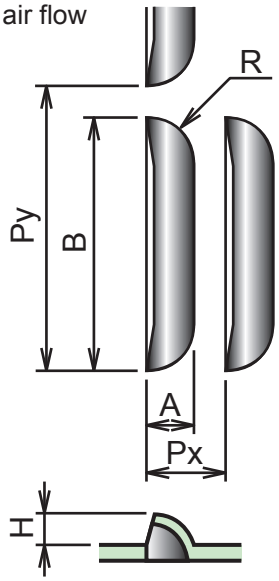
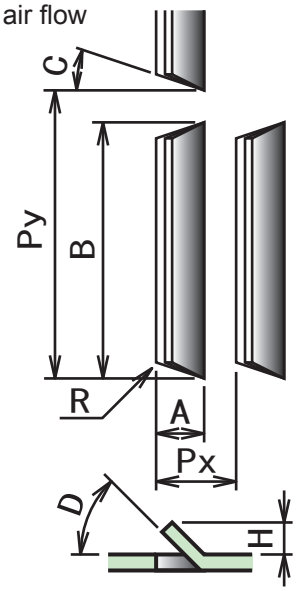
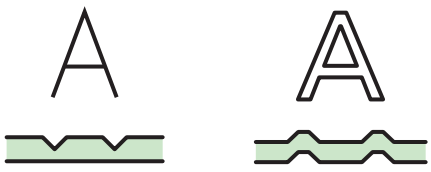
FORMING SHAPES	INSTRUCTIONS
■ Louver for air flow 	1. Punching condition (only as a guide) Material thickness ≦ 2.3 mm Width (A) ≧ Height (H) x 2 Forming pitch Px ≧ Width (A) + 5 mm Py ≧ Length (B) + 5 mm (Material thickness ≦ 1.6 mm) Py ≧ Lengh (B) + 8 mm (Material thickness ＞ 1.6 mm) Please contact us if the above processing conditions are not met. 2. Dimension "R" and "A" would be same dimension unless otherwise instructed.
■ Lance for air flow 	1. Punching condition (only as a guide) Material thickness ≦ 2.3 mm Material thickness + Height (H) ＜ 10 mm Forming pitch Px ≧ Width (A) Px ≧ Length (B) + 5 mm ・The recommended width (A) is at least 5 times the material thickness. ・The recommended angle (C) is 5 ° or more and 20 ° or less. ・A rise angle (D) of 45 ° or less is recommended to maintain tool strength. Please consult us if the above punching conditions are not met.
■ Marking (Stamping Emboss)  [Stamping] [Emboss]	1. There are two types of engravings: “stamping” that creates a dent in the workpiece (material) and “embossing” that creates a concavity and convexity. 2. In the case of a embossing, please indicate whether you want to be able to read from the concave side or the convex side. 3. There is also a replaceable blade type stamp that can replace only the stamped part.

For More information, please contact CONIC tool sales desk.

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