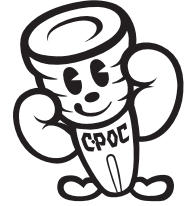


THE ORDERING GUIDE 3



ANGLE INDICATION OF ANGLED TOOL

Please refer to the table below when ordering angled tool.

Instruction drawing of the special angle setting ($K=0^\circ$ Viewing from the top of die)

SQ	RE	OB	SD	DD

Angled tool dimension example (Die viewed from above)

Please indicate the direction of the arrow at the desired angle,

with the direction of the arrow in the above reference diagram set to 0° .

(Counterclockwise is “+” and clockwise is “-”.)

<table border="0"> <tr> <td>OB</td> <td>6 x 20</td> <td>K=45°</td> </tr> <tr> <td>(shapes)</td> <td>(dimension)</td> <td>(angle)</td> </tr> </table>	OB	6 x 20	K=45°	(shapes)	(dimension)	(angle)	<table border="0"> <tr> <td>OB</td> <td>6 x 20</td> <td>K=-60°</td> </tr> <tr> <td>(shapes)</td> <td>(dimension)</td> <td>(angle)</td> </tr> </table>	OB	6 x 20	K=-60°	(shapes)	(dimension)	(angle)	<table border="0"> <tr> <td>SD</td> <td>φ16x14</td> <td>K=180°</td> </tr> <tr> <td>(shapes)</td> <td>(dimension)</td> <td>(angle)</td> </tr> </table>	SD	φ16x14	K=180°	(shapes)	(dimension)	(angle)
OB	6 x 20	K=45°																		
(shapes)	(dimension)	(angle)																		
OB	6 x 20	K=-60°																		
(shapes)	(dimension)	(angle)																		
SD	φ16x14	K=180°																		
(shapes)	(dimension)	(angle)																		

[NOTE]

- For the standard cutting edge angle with respect to the reference key direction, see “Technical Information Vol.31”. Please indicate in the above method **only when it is different from the standard edge angle**.
- Please note that the direction of CONIC reference key may differ from the standard of other machine brand.

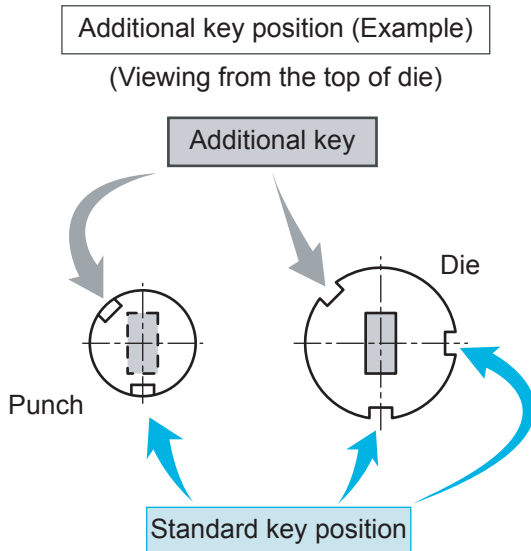


THE ORDERING GUIDE 3

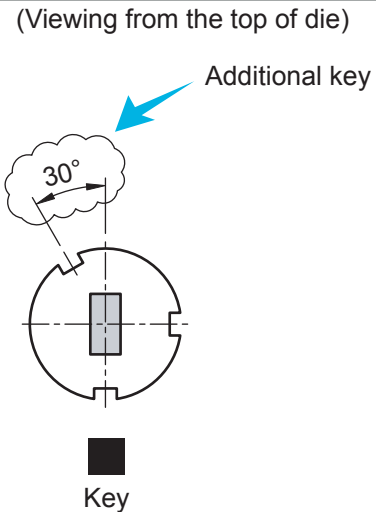
ADDITIONAL KEY SPECIFICATIONS

(Below is an example of Thick turret type of C station.)

An angled key can be added in addition to the standard key position. (Additional key specification)
However, depending on the model and station size, additional key may not be available.
For additional key instructions, write the key position to be added to the top view of the die.



The way to instruct the additional key position



4-WAY KEY POSITION

“4-way key specification” tools that can be used in four directions of 0°, 90°, 180° and 270° can also be manufactured. Please instruct us when ordering a directional forming tool or special shape.

ADVICE ON ONE POINT

About turret key,

The turret key attached to the turret will be worn out if used for a long time, and it may cause beard burr and galling of the tool during punching, so it is recommended to replace it regularly.

In that case, it is also recommended to center the turret.
We also sell “Centering jig”. Please contact Conic tool sales desk.

Perform regular maintenance.



For More information,
please contact
CONIC tool sales desk.

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