

FORMING TOOL

Not only punching but also various forming processes are possible with the NC turret punch press.

TYPICAL FORMING PROCESS

■ BURRING FOR THREAD FORM

Forming process for making tubes of threading for screw.

[Forming up]



[Forming down]



There are two types of tools.

Pre-hole one process type

Die which performs pre-hole processing and burring at the same time.

Pre-hole two process type

Die for burring after pre-hole processing

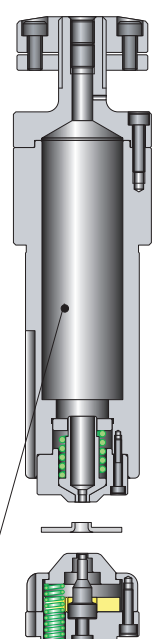
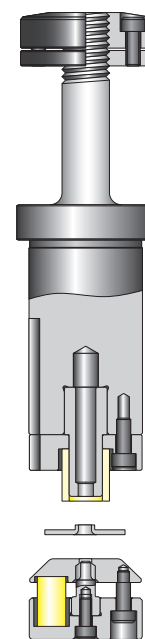
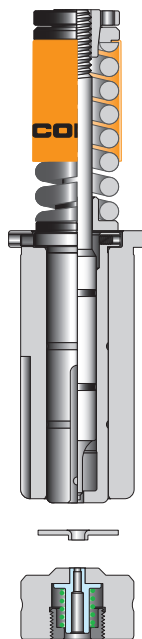
Our standard dimension table (other than upward & downward hole one process type)

Screw size	Pin diameter	Pre-hole
M 2 . 5	φ 2 . 1	φ 1 . 2
M 3	φ 2 . 6	φ 1 . 5
M 4	φ 3 . 4	φ 2 . 0
M 5	φ 4 . 3	φ 2 . 4
M 6	φ 5 . 1	φ 2 . 8

※TiN coating is applied to the upward burring pin of standard dimension.

※In the case of non-standard dimensions, please indicate the pin diameter.

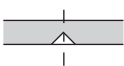
FORMING DOWN (Pre-piercing and forming) FORMING UP (Forming after Pre-piercing) FORMING UP (Pre-piercing and forming)



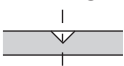
Slug accumulates in the upper tank.

■ CENTER POINT

[Forming up]



[Forming down]



• The standard is a height adjustment free type. (a die that required punch length adjustment for each plate thickness.)

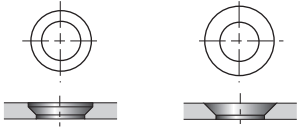
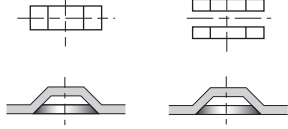
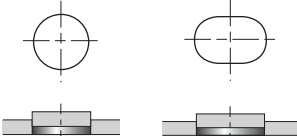
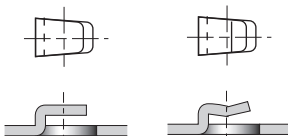
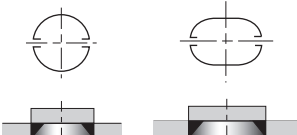
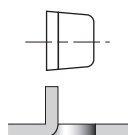
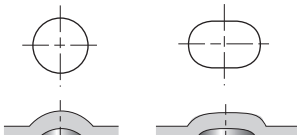
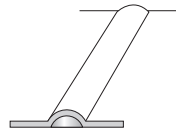
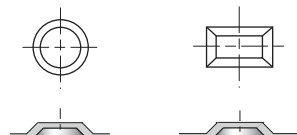
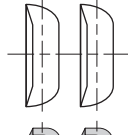
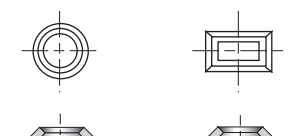
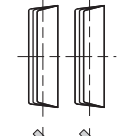
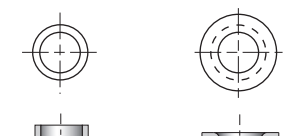
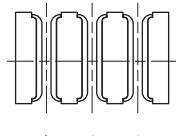
• Standard center punch angle is 90 degree. Please specify if an angle other than 90 degree is desired.

• The depth of the center point is optionally adjustable.

※We also produce a type that adjusts and fixes the punch length for each material thickness.

FORMING TOOL

Examples of other major forming

NAME	PRINCIPAL USE · SPECIAL NOTES	NAME	PRINCIPAL USE · SPECIAL NOTES
COUNTERSINK FOR COUNTERSUNK SCREW 	<ul style="list-style-type: none"> • Sink the head of the countersunk screw, rivets in the material. • Take the corner after the punching process. • Guide for tapping. 	BRIDGE, DOUBLE BRIDGE 	<ul style="list-style-type: none"> • Used for the seat of products. • Insert the circuit board. • Positioning.
HALF SHEAR 	<ul style="list-style-type: none"> • positioning, stoppers, etc. • The projection height is desirably 60% or less of the plate thickness. 	LANCE (Z-BENDING) 	<ul style="list-style-type: none"> • Used for hooks, positioning, stoppers, etc.
KNOCKOUT 	<ul style="list-style-type: none"> • Retain the scraps to the base material and remove it with a screwdriver etc. when using. • Positioning, stoppers, etc. 	LANCE (L-BENDING) 	<ul style="list-style-type: none"> • Used for positioning, stoppers, etc.
EMBOSS (DIMPLE) 	<ul style="list-style-type: none"> • Used for positioning etc. 	BEADING 	<ul style="list-style-type: none"> • Plate reinforcement.
EMBOSS 	<ul style="list-style-type: none"> • Used for the seat of products and the seat of bolts etc. • Stick the nameplate, seal etc. 	LOUVER FOR AIR FLOW 	<ul style="list-style-type: none"> • Air flow for ventilation. • Mini louvers are also used for positioning and stoppers.
COUNTERSINK 	<ul style="list-style-type: none"> • Sink the head of the countersunk screw. • Non-slip. 	LANCE FOR AIR FLOW 	<ul style="list-style-type: none"> • Air flow for ventilation.
BURRING · CURLING 	<ul style="list-style-type: none"> • Guidance and protection of pipes and cables. • Water drainage, air flow for ventilation. 	CARD GUIDE 	<ul style="list-style-type: none"> • Insert the circuit board.

There are various other forming tools.
Please also see the information and images on our website.

For More information,
please contact
CONIC tool sales desk.

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