



To use forming tool safely.

◆ Use the tool under appropriate conditions.

Use at other than the specified plate thickness (material) may damage the tool.

◆ Use after adjusting the punch length.

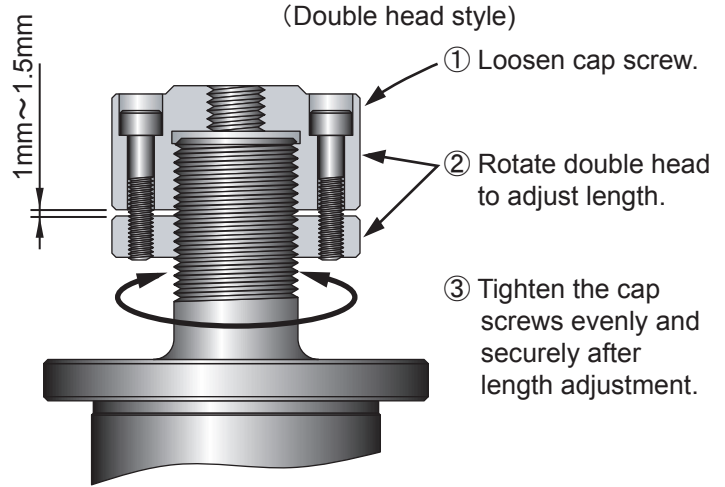
- Make sure the difference in shut height for each punch press.
- **At the time of shipment, Conic set the tool length shorter for safety.**

Please adjust the tool length with reference to this manual.

◆ If processing with a multi-process tool;

- Pre-hole size
 - Center position of the machine on the program
- Check these out.

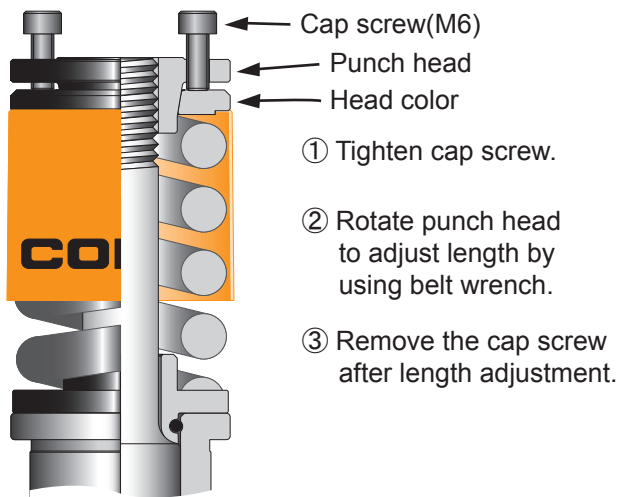
Height adjustment method for upward tool



Tool station	Screw Size	Adjustment amount
1/2"(A)	M12 P=1.25mm	1/4 turn makes 0.3mm adjustment
1-1/4"(B)	M20 P=1.5mm	1/5 turn makes 0.3mm adjustment
2"(C) 2-3/4" 3-1/2"(D)	M30 P=2mm	1/4 turn makes 0.5mm adjustment
4-1/2"(E)	M40 P=2mm	

Height adjustment method for downward tool

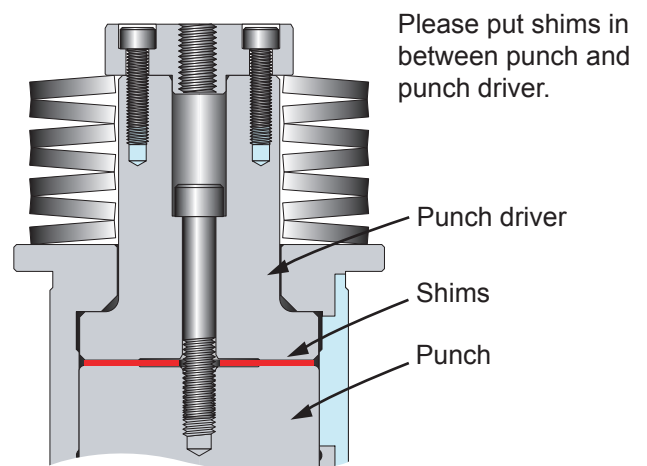
(The small-diameter tool is adjusted with the head)



Tool Station	Screw Size	Adjustment Amount
1/2"(A)	M12 P=1.25mm	1/4 turn makes 0.3mm adjustment
1-1/4"(B)	M20 P=1.5mm	1/5 turn makes 0.3mm adjustment

Height adjustment method for downward tool

(The large-diameter tool is adjusted with shims)



Special forming shim set(sells separately) has 5 pieces shims. Thickness is t=0.4 , 0.5 , 0.6 , 0.7 , 0.8 mm. It can be adjusted by those combination from 0.4 to 2.6mm 0.1mm step.

For More information, please contact CONIC tool sales desk.

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