

VARIOUS KINDS OF SPECIAL SHAPE

For punching with a turret punch press, various types of special shape tooling are used.

JOINT TOOLING

When processing a large number of products with one piece of material (sheet), a joint type is used to hold the products together.

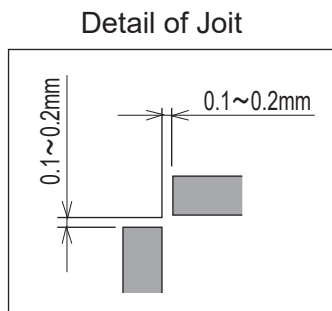
There are two types of joints: **MICRO JOINT** and **WIRE JOINT**.

MICRO JOINT

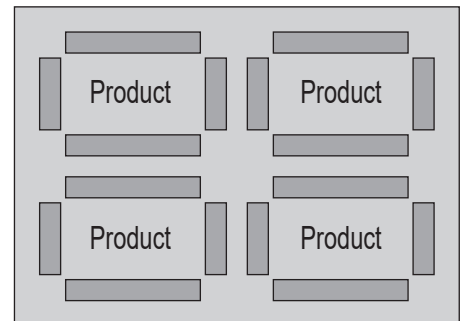
Fix the product to the base material with a small joint and give vibration to the workpiece after processing.

1. Joint of corner part

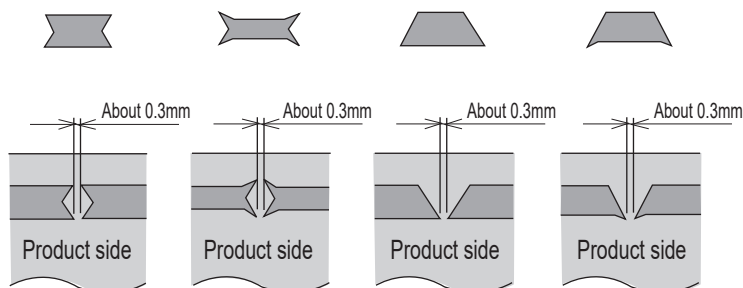
The outer periphery is removed at square or rectangle, and a part is connected without cutting off the corner as shown in the right figure.



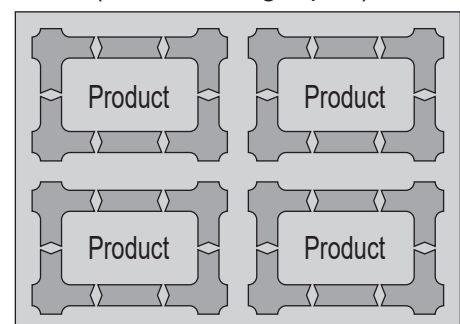
Cases of micro joint processing
(Joint of corner part)



2. Joint of straight part (When the corner is rounded.)



Cases of micro joint processing
(Joint of straight part)



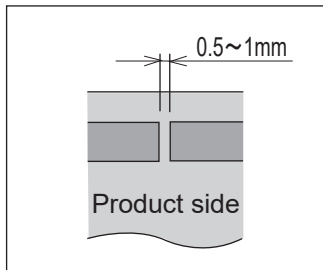
The number and width of micro joints vary depending on the thickness, material, shape and size of the workpiece. It is recommended to actually process and check with reference to the above dimensions.

VARIOUS KINDS OF SPECIAL SHAPE

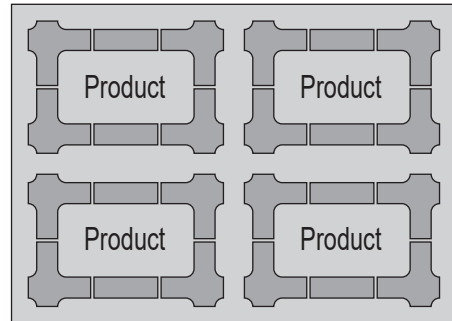
WIRE JOINT

Use a wire joint larger than a micro joint to hold large products together.

Detail of Joint



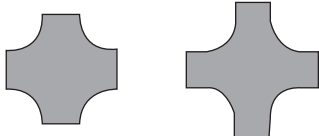
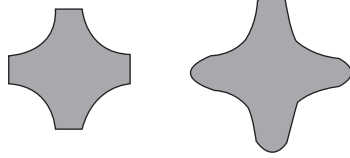
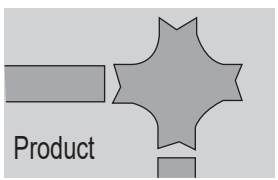
Cases of micro joint processing



CORNER RADIUS

Use the corner radius type (CR type) to Round the corners of the product.

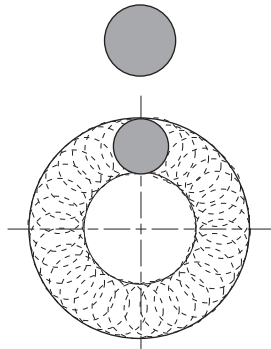
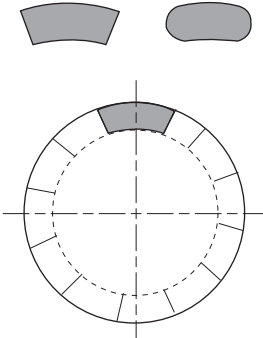
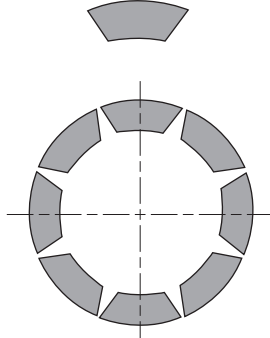
Typical corner radius types are as follows.

Standard Corner radius tool	Corner radius tool with tangent line	Corner radius with joint
		

NIBBRING RADIUS TOOLING

There are the following methods for removing holes larger than the size of the punching.

1. Slitting **processing by Round Nibbling Method**
2. Slitting **processing by Curved tool punching Method**

Round Nibbling Method	Curved tool punching Method	Radius tooling with Joint
		
The punched surface becomes wavy.	The central part pulls out with a round or square shape, and the outer periphery nibble with a rounded shape.	Provide a joint and remove the joint after processing.

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