

# CONIC SPECIAL TOOL USERS MANUAL

Thank you very much for purchasing Conic special tools. Please read this manual carefully and use Conic tools safely.

 Use special tool safely.

◆ Please use tools as suitable conditions.

Other than specified material or thickness tools maybe destroyed.

◆ Please adjust shut height before use.

- Make sure each punchpress shut height.
- **Conic set the shut height shorter for safety reason when ship out our tools.**

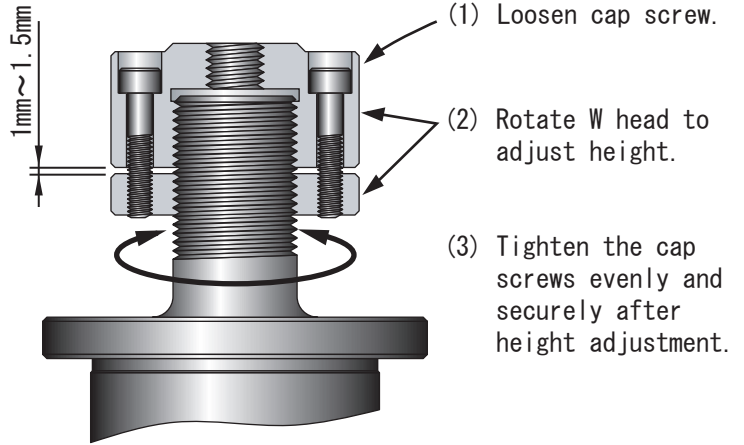
Please use this manual for setting the shut height.

◆ If process is multi process type tool:

- Please make sure pre-hole size.
- Please make sure center position of the tools when make punching program.

## How to adjust forming up tool height.

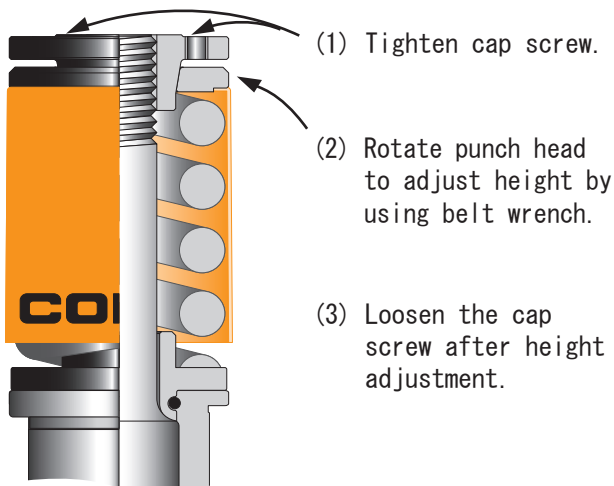
(W head style)



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	

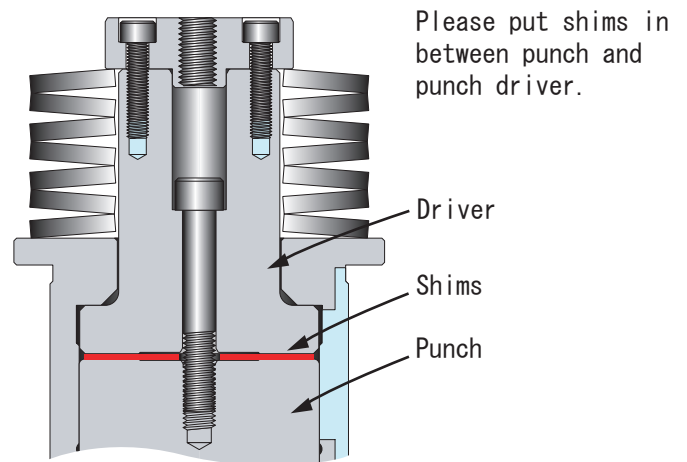
## How to adjust forming down tool height.

(small size tools are adjustment of head)



## How to adjust forming down tool height.

(Large size tool need to adjust by shims)



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

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