

SPECIAL TOOL USERS MANUAL (MURATA TYPE)

 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;

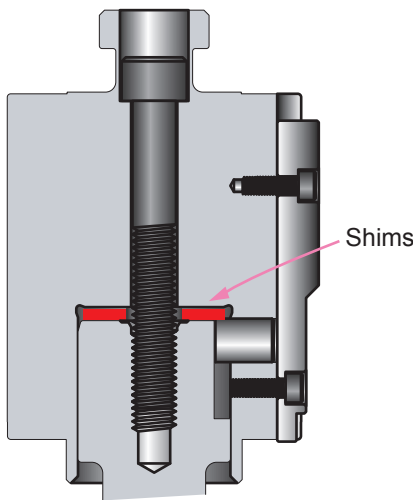
- Pre-hole size

- Center position of the machine on the program

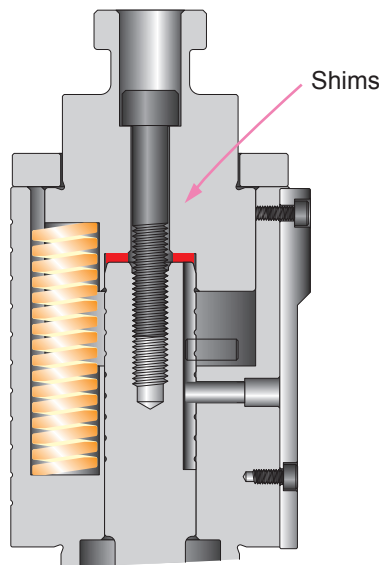
Check these out.

■ Height adjustment method by punch shims (Insert a shim between the punch and the punch holder.)

Style 114 holder



Vulcan holder



■ Height adjustment method for forming tools

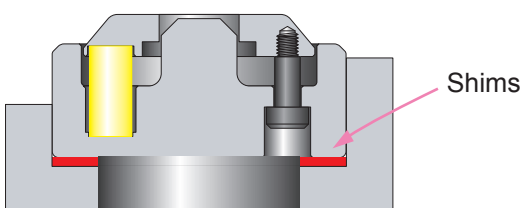
1) Adjustment of forming tool is done by shims.

2) There are two way to adjust length, one is using punch shims and the other is using die shims.

3) First punch without any shims then find the difference and required amount of shims.

Please be careful not to forget to remove the shim after punching.

■ Height adjustment method by die shims (Insert a shim between the die and the die holder.)



Special forming shim set(sells sepatately) 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 form 0.4mm to 2.6mm 0.1mm step.

For More information, please contact CONIC tool sales desk.

CONIC Co., Ltd.
 10-5 Taiheidai, Shoo-cho, Katsuta-gun, Okayama 709-4321 Japan
 Email: tools@conic.co.jp
<https://www.conic.co.jp>

CONIC PRECISION Co., Ltd.
 55/22 Moo 4, Buengkumphroy, Lumlukka, Phatumthani 12150 Thailand
 TEL: (662) 159-9870 FAX: (662) 159-9872
 Email: conic_thai@conic.co.jp