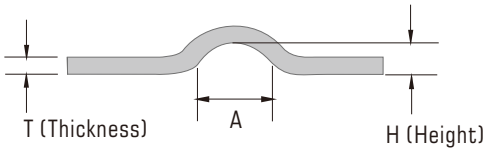
FORMING TOOLS FOR THICK TURRET

FORMING TOOLS

WHEEL TOOLS

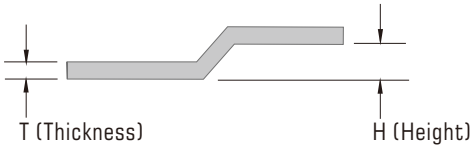
WHEEL RIB

1. High speed forming,equal to table moving
2. Make any shape in auto index station
3. No any nibbling marks
4. Any location of sheet start or end
5. Make Mini Radius on sheet: 16mm
6. For thickness : Mini. thickness:0.8mm
   Max:1.5mm SS,2.0mm MS,2.5mm AL



WHEEL OFFSET

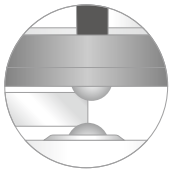
1. High speed forming,equal to table moving
2. Make any shape in auto index station
3. No any nibbling marks
4. Any location of sheet start or end
5. Make Mini Radius on sheet: 25mm
6. For thickness : Mini. thickness:0.8mm
   Max:1.5mm SS,2.0mm MS,2.0mm AL



WHEEL DEBURRING

1. High speed forming,equal to table moving
2. Remove burrs in auto index station
3. Deburring on top and bottom of holes
4. Any location of sheet start or end
5. Designed for thick turret machine
   with hydraulic or servo programmable rams

Mini Holes : Round 3.0mm
Mini slot width: 2.0mm
Max.Thickness: 5.0mm
Min,Thickness: 0.8mm



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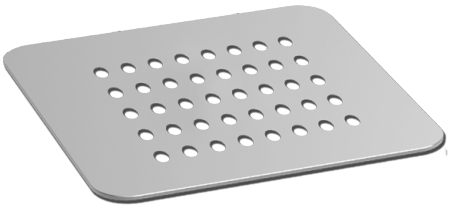
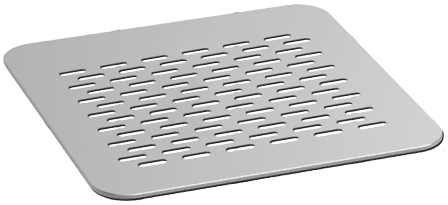
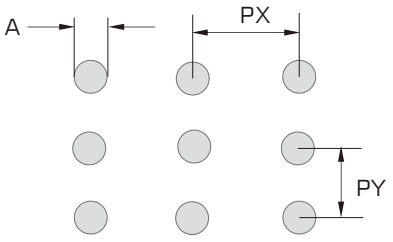
CLUSTER







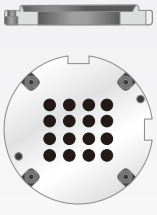
A _____ PX _____ PY _____ T _____
(Thickness)

Fully guided cluster Recommand in Diameter/Width < 3.0mm

Fully guided guide ass'y

Punch ass'y

Cluster die

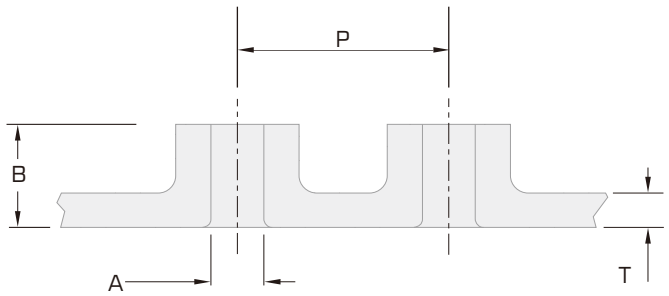


Fully guided stripper

A.Longer support for punch tip by stripper
B.Accurate close clearance between punch and stripper
C.More fixed stripper tightened by 4 screws
D.TICN punch available
E.Quick adjust guide assembly Optional

EXTRUSION TAPPING

EXTRUSION TAPPING



A _____ P _____

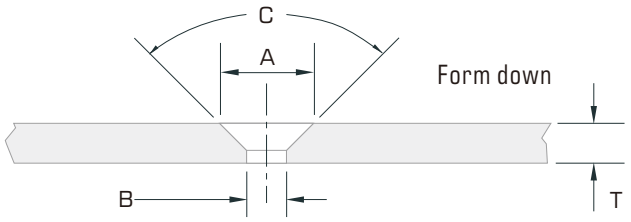
B _____ T _____

CHART FOR PREPUNCH SIZE

Material	Tapping size	Thickness / I.D. C size	0.8	1.0	1.2	1.6	2.0	2.3
Aluminum Mild steel	M2.6	2.21	1.3	1.3	1.3	1.6	N/A	N/A
	M3	2.57	1.3	1.3	1.6	1.6	N/A	N/A
	M4	3.40	2.0	2.0	2.0	2.3	2.3	2.5
	M5	4.30	N/A	2.3	2.3	2.8	2.8	3.0
	M6	5.20	N/A	N/A	N/A	3.0	3.8	3.8
Stainless steel	M2.6	2.21	1.3	1.3	N/A	N/A	N/A	N/A
	M3	2.57	1.3	1.6	1.8	N/A	N/A	N/A
	M4	3.40	2.0	2.0	2.0	N/A	N/A	N/A
	M5	4.30	N/A	2.3	2.3	N/A	N/A	N/A
	M6	5.20	N/A	3.0	3.0	N/A	N/A	N/A

COUNTERSINK

COUNTERSINK



A _____

B _____

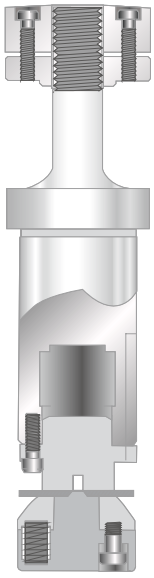
C _____

T _____

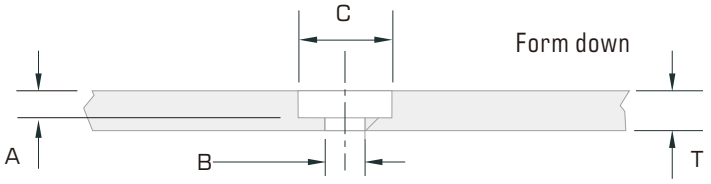
Material Type _____

Machine Type _____

Tooling Station _____



COUNTERSINK



A _____

B _____

C _____

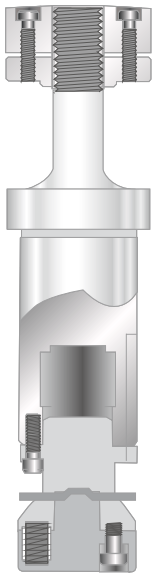
T _____

Material Type _____

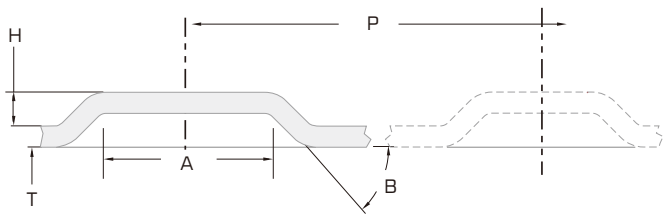
Machine Type _____

Tooling Station _____

EMBOSS/COUNTINOUS BEAD

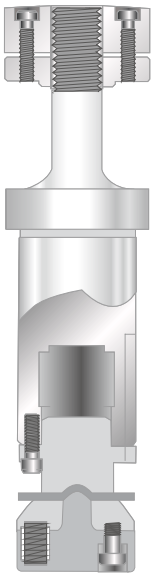


EMBOSS

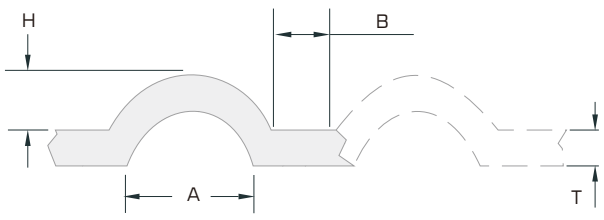


A _____ H _____

B _____ T _____ P _____



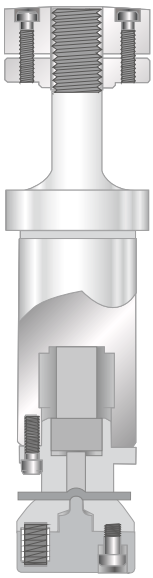
COUNTINUOUS BEAD



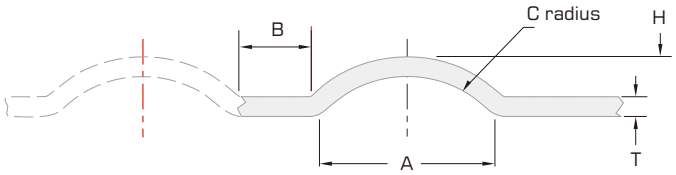
A _____ H _____

B _____ T _____

DIMPLE/EMBOSS COUNTERSINK



DIMPLE

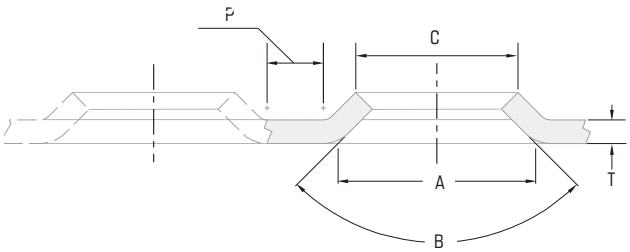


A _____

B _____ H _____

C _____ T _____

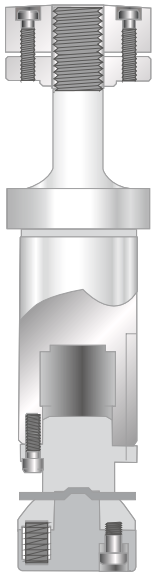
EMBOSS COUNTERSINK



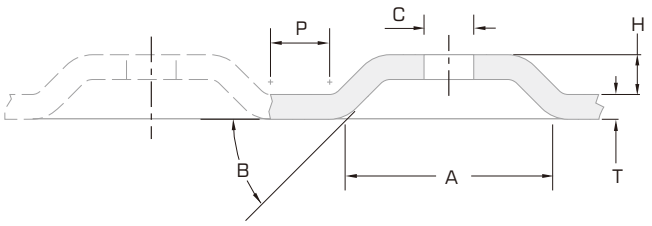
A _____ C _____ P _____

B _____ H _____ T _____

EMBOSS EXTRUSION



EMBOSS EXTRUSION



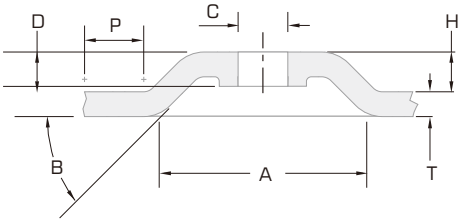
A _____ H _____

B _____ P _____

C _____ T _____

Note: The tooling need prepunch

EMBOSS EXTRUSION



A _____

B _____ D _____ P _____

C _____ H _____ T _____

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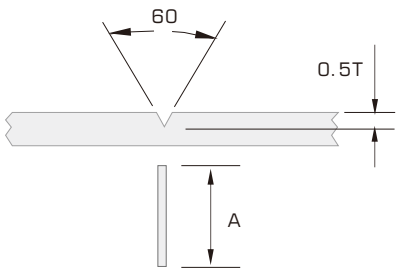
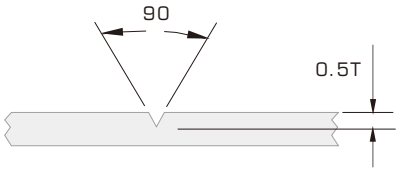
FORMING TOOLS

LOGO STAMPING/MARKING TOOL

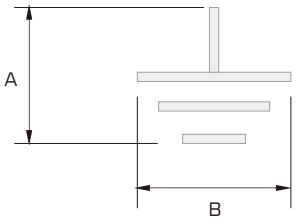
V LINE MARKING



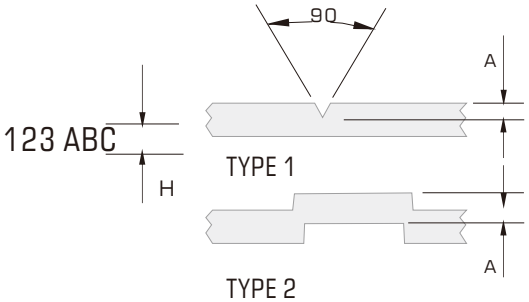
CENTER POINT



EARTH GROUND

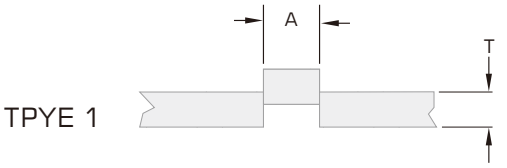


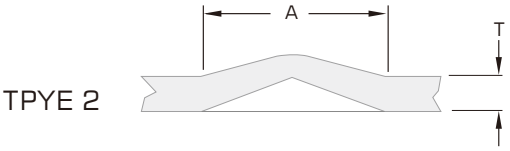
LOGO MARKING



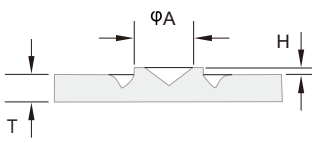
SHEAR BUTTON/LOCATOR TOOL

SHEAR BUTTON





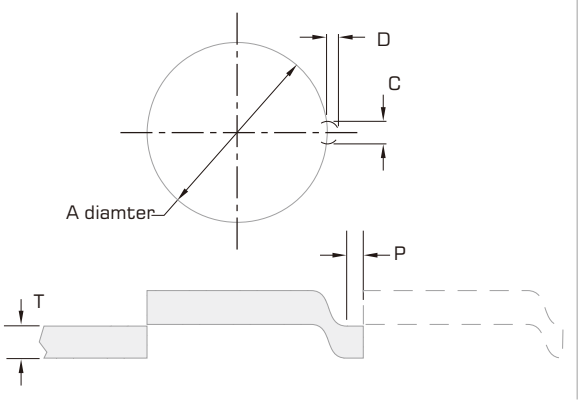
LOCATOR TOOL



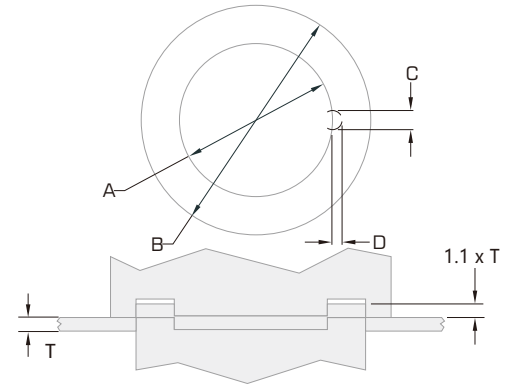
1.Tool can not be used for SUS304
2. ±0.02mm deformation appears of reverse side
3.More than 2.0mm thick material may swell around the formed area
4.FAB spring pack can not be used for this tool

KNOCKOUT-EKO TOOL

SINGLE EKO



DOUBLE EKO



A _____ D _____

B _____ P _____

C _____ T _____

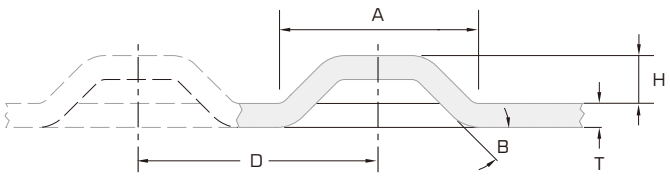
Material Type _____

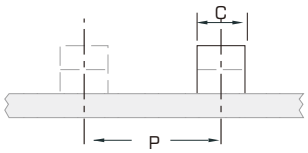
Machine Type _____

Tooling Station _____

BRIDGE TOOL

BRIDGE-FLAT TOP





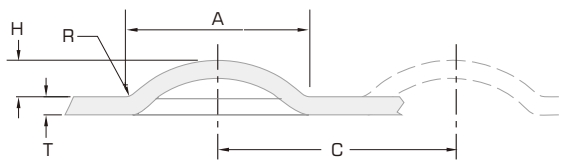
A _____ H _____

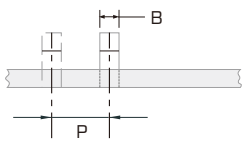
B _____ P _____

C _____ T _____

D _____

BRIDGE-RADIUS TOP





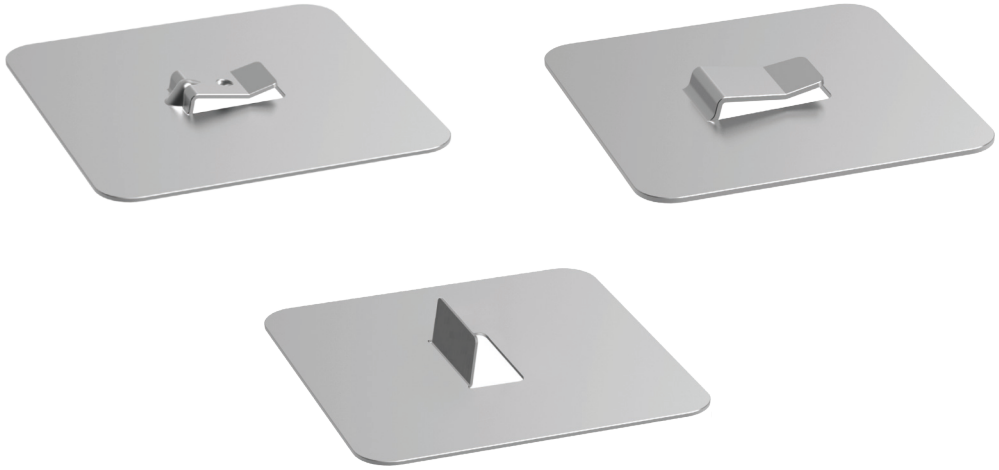
H _____

A _____ R _____

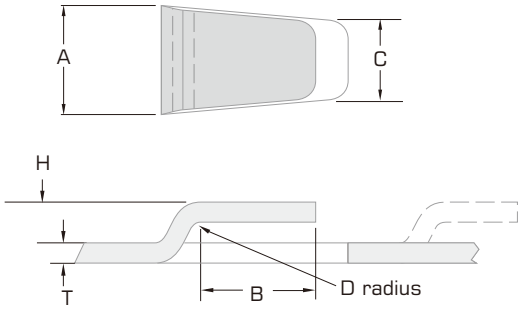
B _____ T _____

C _____ P _____

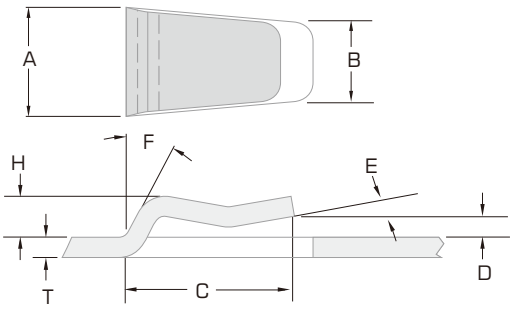
LANCE AND FORM



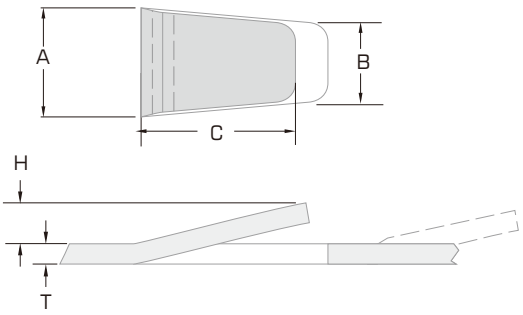
LANCE AND FORM — SELF CLIP



LANCE AND FORM — SPRING CLIP



LANCE AND FORM — TAB



A _____

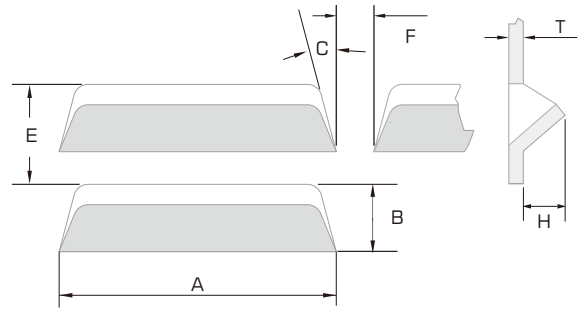
B _____ E _____

C _____ F _____ P _____

D _____ H _____ T _____

LOUVER TOOL

OPEN STRAIGHT LOUVER



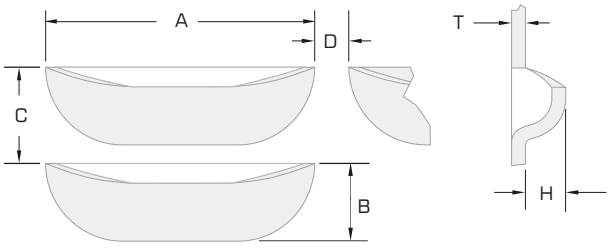
A _____ E _____

B _____ F _____

C _____ H _____

T _____

CLOSE RADIUS LOUVER

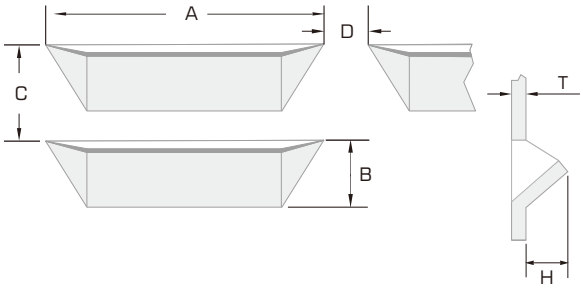


A _____ D _____

B _____ H _____

C _____ T _____

CLOSE STRAIGHT LOUVER



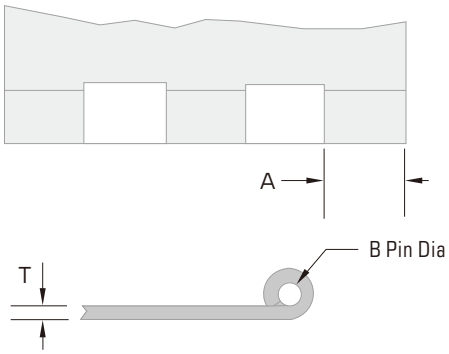
A _____ D _____

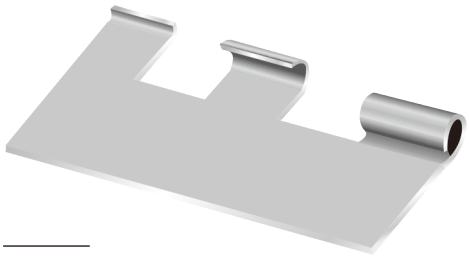
B _____ H _____

C _____ T _____

HINGLE TOOL/CARD GUIDE

HINGLE TOOL



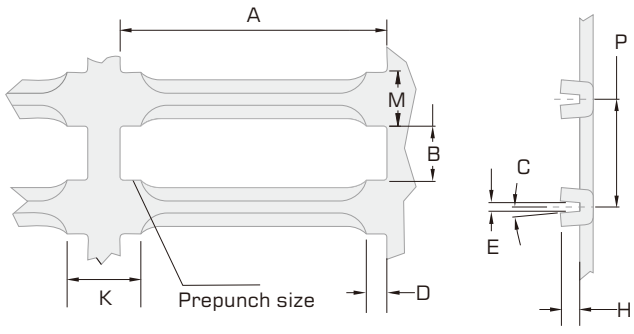


A _____

B _____

T _____

CARD GUIDE

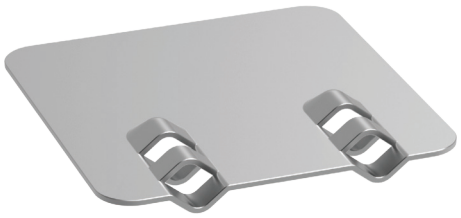


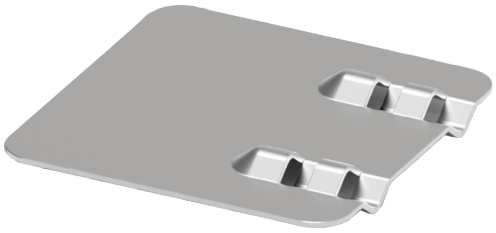
A _____ D _____ K _____

B _____ E _____ P _____

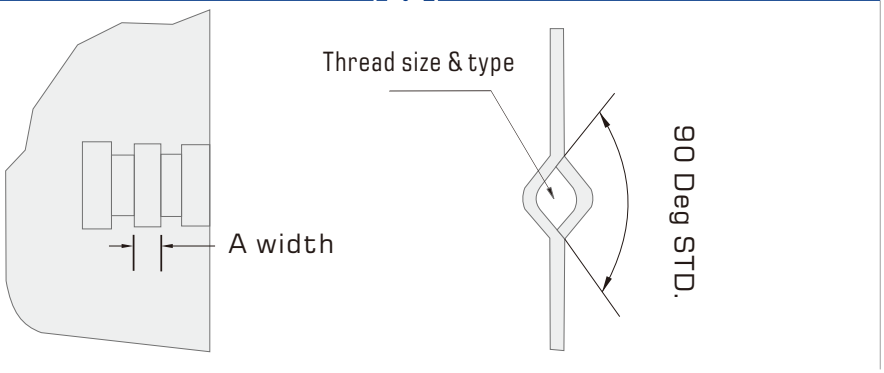
C _____ H _____ M _____

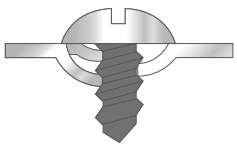
THREAD LOOP/THREAD FORM



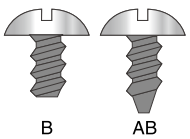


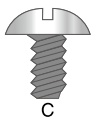
THREAD LOOP





THREAD FORM





(Machine Screws)

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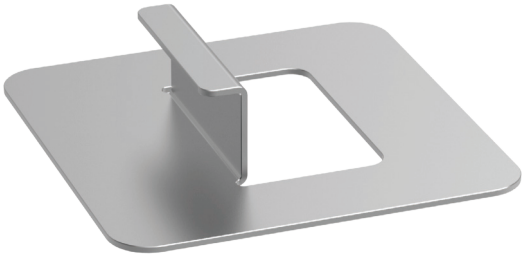
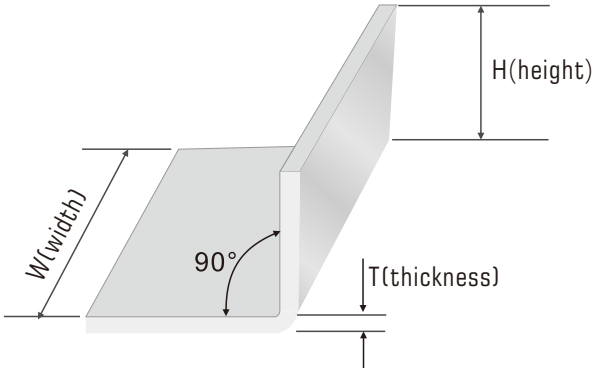
FORMING TOOLS

BENDING TOOL/EASY BREAK





BENDING TOOL

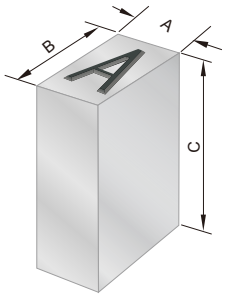
1. Tool can bend sheet to 90 degree, not 88 degree
2. For aluminium and mild steel, thickness 0.8mm～2.0mm
   For stainless steel, thickness 0.8mm～1.5mm
   Need not change insert
3. D station,Max height＝18mm ,Max.width＝80mm

BENDING TOOL

1. Be availabe at B,C,D station
2. Punch ass'y designed for specified thickness and material.Not adjust
3. V-line tip on punch and die insert create weak slot in both sides of sheet metal.Shake up and down to break parts
4. Restriction for thickness:Minimum 0.8mm, Maximum 1.5mm
5. Clear,smooth in cutting edge after breaking

MULTI SCRIBE/EXCHANGABLE LETTER MARKING

MULTI SCRIBE



Character font & range

ABCDEFGHIJKLM

NOPQRSTUVWXYZ

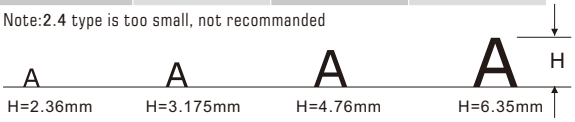
0123456789

&/.-()

EXCHANGABLE LETTER MARKING

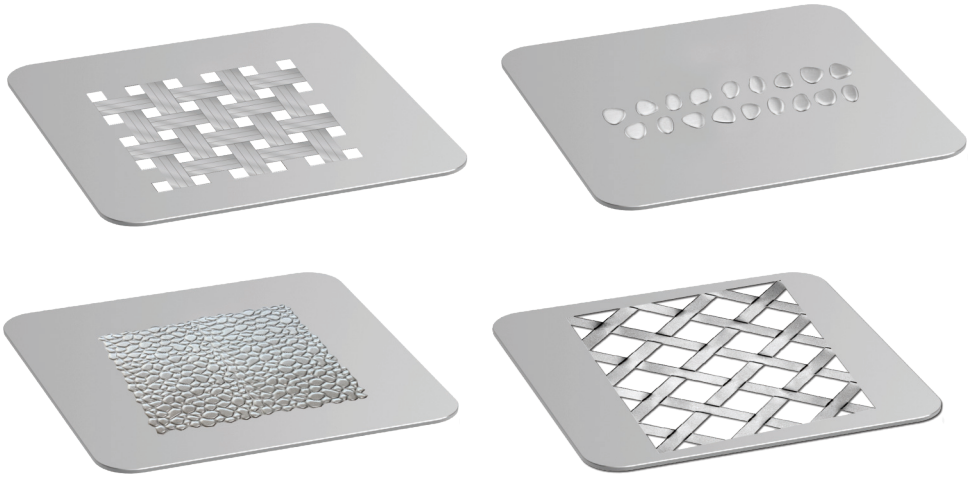
TYPE	A SIZE	B SIZE	C SIZE
2.4	2.36mm	6.35mm	19.05mm
3.2	3.175mm	6.35mm	19.05mm
4.8	4.76mm	7.94mm	19.05mm
6.4	6.35mm	9.52mm	19.05mm

Note:2.4 type is too small, not recommanded

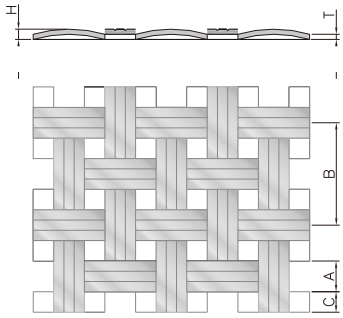


FORMING TOOLS

TEXTURE/DRIPS/LEATHER

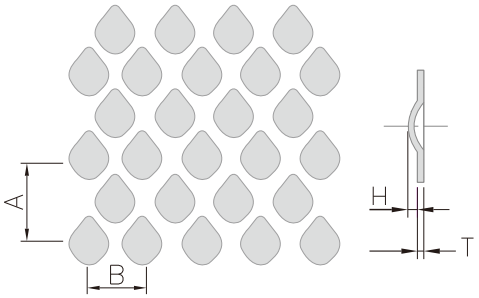


EMBOSS-EXPANDED METAL



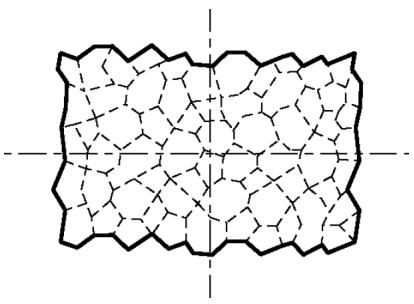
A: _____
B: _____ H: _____
C: _____ T: _____

EMBOSS-DRIPS



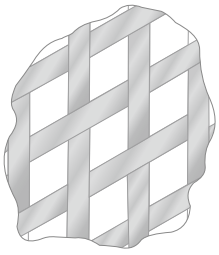
A: _____ H: _____
B: _____ T: _____

LEATHER TEXTURE



Max.thickness:2.0mm
Emboss height 0.5mm

EMBOSS-EXPANDED METAL



The texture need prepunch