

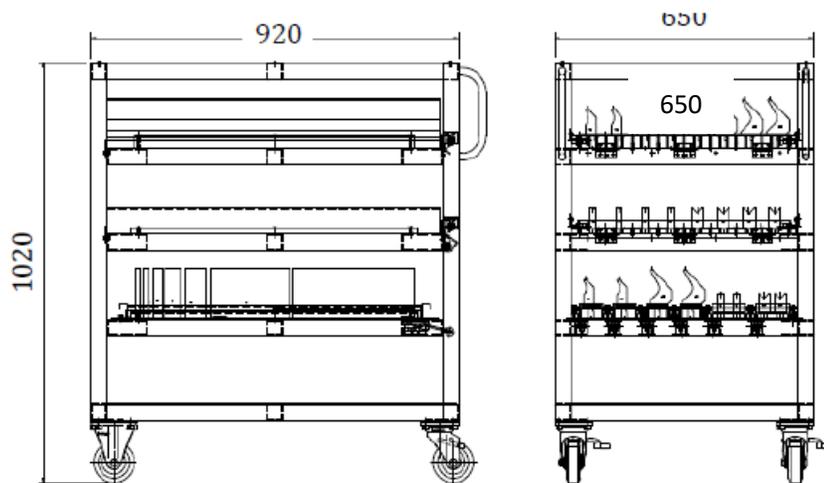
TOOL INFORMATION

NO.13 March 2023

NEW RELEASE

Wagon for press breaking tools – TC6595 BM

- Easy to carry
- Easy to store
- Easy to draw
- Easy to organize



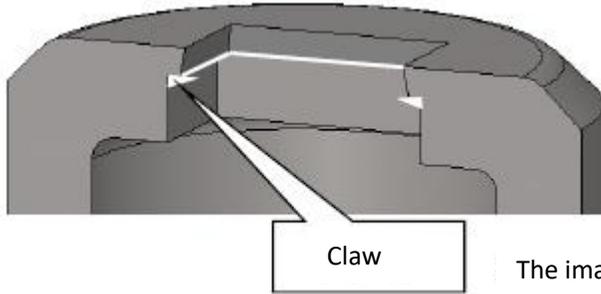
NOTE

Product specifications are subject to change without notice.
Punches and dies are not included.

TECHNICAL REPORT

Q: I cannot have Punch insert into its SW Die by hand. Is that an NG product?

A: No. That is an OK product. Have the machine do the punch-and-die test. Clearance of 0.2 or smaller with Slug Wiper usually requires a severe level of alignment and centering when insertion is tested.



The image is a little exaggerated.

Q: How small could a die's clearance be at the minimum?

A: See below. The requirement varies. For thinner sheet (0.6 or less), clearance could not be the best because of the minimum limit below. Burrs may incur.

Shapes	Range	SLIDE IN	Non SLIDE IN
RD	X – J	0.12	0.15
	INDEX	0.15	0.15
	MULTI	0.15	0.15
RD CLUSTER	B – J	0.15	0.15
SQ, RECT, OB, SD, WD	X – J	0.12	0.15
	INDEX	0.2	0.2
	MULTI	0.2	0.2
SPECIAL SHAPES	X – J	0.15	0.2
	INDEX	0.2	0.2
	MULTI	0.2	0.2



SLIDE IN DIE HOLDER
Motorum (except EZ and TC)
Vectrum



Non SLIDE IN DIE HOLDER
Centrum and Magnam