

TOOL INFORMATION

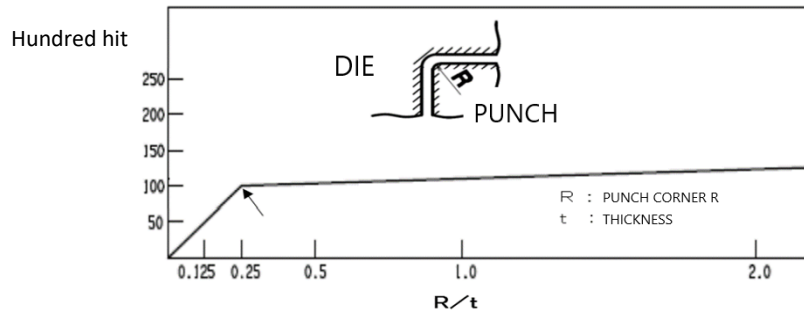
NO.9

TECHNICAL REPORT

Corner R

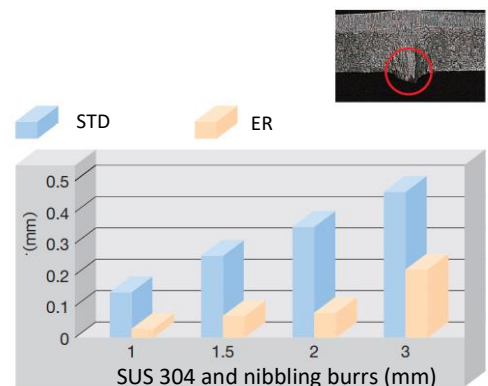
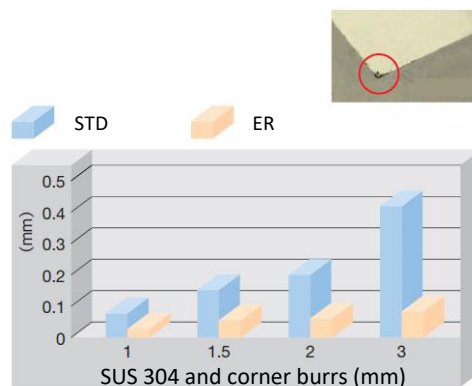
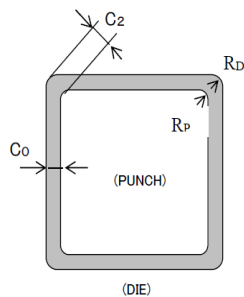
Has your punch been chipped earlier than expected?

A rounded corner may help. A sharp corner is fragile. MTL provides R0.15 to all our standard punches. You may make the corners less sharp if you want. R0.5-R1.0 will be effective to thick sheet or stainless steels. Just let us know a prefer Corner R size.



Have you been troubled by burrs while nibbling?

Corner R helps burr reduction. Try our ER die. The option realizes a totally even clearance. With a standard tool, a clearance of rectangles defers between the corner and the straight area. MTL standard punch (no ER) has a rounded corner of R0.15 and die has of R0.2. As shown below, C2 is larger than C0 and that is thought to be one of the trouble's factors. Just add "ER" to your die order. No change in price and lead time.

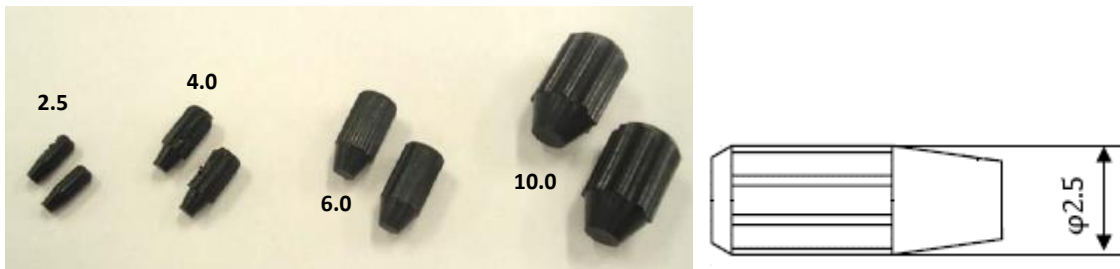


YOUR QUESTIONS

Q: What is a selection of Urethane Ejector?



There are four sizes – $\phi 2.5$, $\phi 4.0$, $\phi 6.0$ and $\phi 10$.



Ejector is determined by the size to cut.



Urethane Ejector	$\phi 2.5$	$\phi 4.0$	$\phi 6.0$	$\phi 10$
Size to cut Round / A	6.0-10.0	10.0-20.0	20.0-38.0	38.0-

The number of ejectors to be used are determined on the size to cut but can be changed – ask us for details.

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