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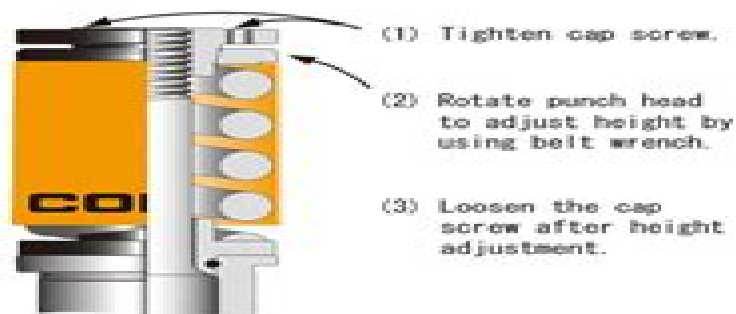
Use special tool safely.

- ◆ 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 down tool height.

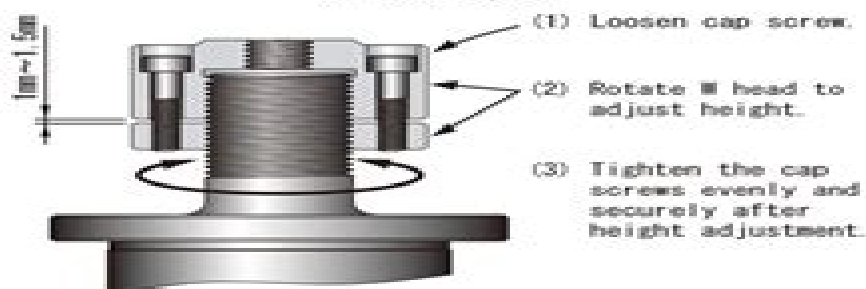
(small size tools are adjustment of head)



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

How to adjust forming up tool height.

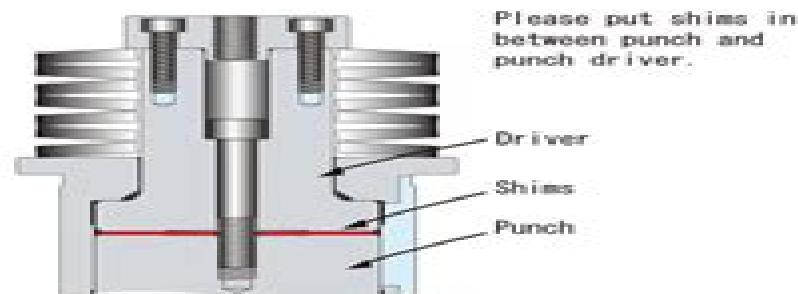
(H head style)



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" (D) 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.

(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.

Amada Turret Punch Manual

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