

	DIE DATA PROCESS SHEET		Form No.: CF501K
			Rev.:
			Ref.:

Die No.:	TBD	Class of Tool:	A	Date:	01/23/17
Part Name:	Quick Click				
Part No.:	211248	Rev. Lev.:	A		
Part No.:		Rev. Lev.:			
Part No.:		Rev. Lev.:			
Part No.:		Rev. Lev.:			

Die Builder: TBD

Phone No.: _____

Contact: _____

Part Info.:

Est. Volume: 50,000,000

Est. Volume: _____

Est. Volume: _____

Raw Material No.: 030232

Gross Weight: 0.00129 Lbs.

Part Weight: _____

Die Components:

4 Post Ball Bearing Fortel / Danly QC-10

4 Post Ball Bearing Fortel / Danly QC-10

Back Plate: A-2(Rc56-59)

Punch Plate: A-2(Rc54-56)

Frame: A-2(Rc54-56)

Cylindrical Punches: Tungsten Carbide

Blanking Punches: Tungsten Carbide

Forming Punches: Tungsten Carbide

Leader/Pilot: M-2(60-62Rc)

Spring Stripper: A-2(Rc52-54)

Die Sections: Tungsten Carbide

Die Inserts: Tungsten Carbide

Bushings: Tungsten Carbide

Shim: None

Stripper Plate: A-2(Rc52-54)

Spare Parts: If Required

Suggest Mat'l:

Note if Other:

Steel

Steel

Grade TBD

Grade TBD

Grade TBD

Titanium Nitride Coat

Grade TBD

Grade TBD/Slug Ret.

Grade TBD/Slug Ret.

Press Info.:

Work Center: 2092

Press Make: Minster, Bliss

Ton. Rating: 60-75 Ton

Speed Capacity: see die set note below

Stroke: 1.5 Inches

Slide Adj.: see die set note below

S.D.A.U.: see die set note below

Note Dwg Die Set: Use CD ref. 7152.dwg.

Note: Use two Pancake sensors on opposite corners of Stripper Plates

Die Info.:

Die Type: Progressive blanking and forming die.

Shut Height: 9.000 Inches

Feeder Height: 3.750 Inches

Pcs/Stroke: Four

Advance: 0.6500 Inches

Strokes/Min.: 200

	<u>Concept Review</u>	<u>Pre-TM1 Review</u>	<u>Design Review</u>
Advanced Manufacturing:	_____	_____	_____
Manufacturing Engineering:	_____	_____	_____