

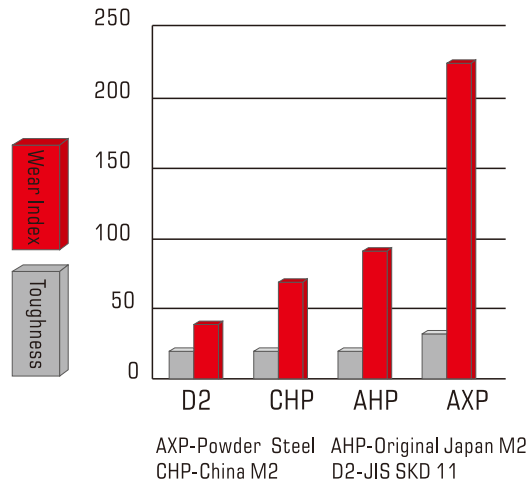
AFAB Tooling Material

Die-D2 material, HRC 58-60°
 Punch body- CHP material (China M2), HRC 60-64°

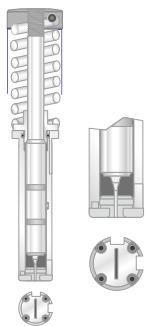
Optional material-AHP ,AXP material.
 For cutting size 5x30,5x80,advise AHP material

For small holes or slim size,round 1.0mm,1.2x20,
 AFAB advise AHP + TICN coating
 or AHP material. Strongly advise fully guided type tooling.

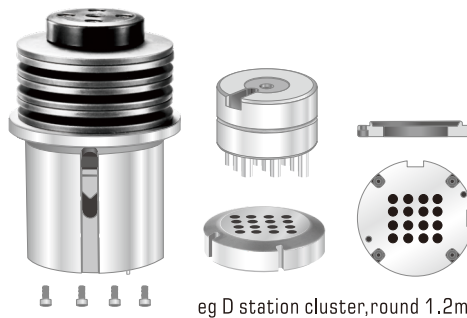
Comparison of toughness and wear index



Fully guided type



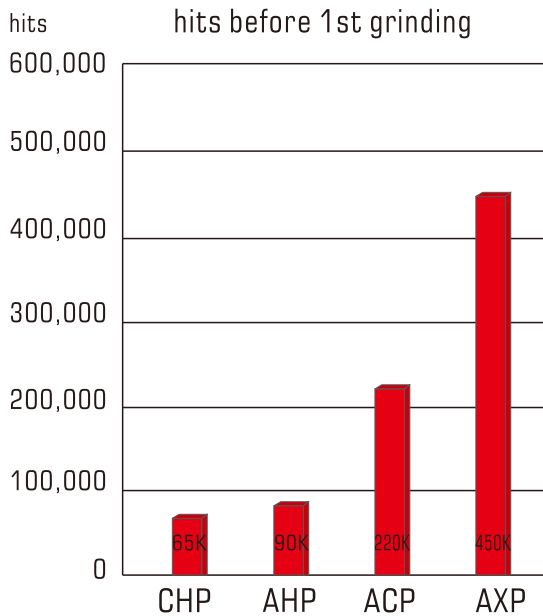
eg A station size 1x10mm



eg D station cluster,round 1.2mm,16holes

- 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

Sheet: SPCC 1.5mm hits before 1st grinding



CHP-China M2 AHP-Original Japan M2
 ACP-AHP + TICN AXP-Powder Steel

Punch life is affected by many factors,It's very difficult to get accurate punch hits number,but under the normal operation situation,we achieve punch hits as left chart.

Affects punch life as below point

1. Good alignment for upper and lower turret
2. Key on turret is not worn
3. The shape and die in good center line
4. Punch and die not regrind
5. Die in correct clearance
6. Punch and punch assembly lubricated
7. STD or fully guided type