

Cupping Die Set Installation Fixture

for Stolle Cupping Systems



Stolle
Cupping Systems
Technical Update 1903-1

Stolle Canton is now offering a new and improved installation fixture for cupping die sets. Inserted in the four corners of the die set, the installation fixtures (also called parallel blocks) keep the outer punch holder separated at a specific height from the lower die holder while the die set is out of the press, and during removal from and installation in the press. Once the outer punch holder is bolted to the outer press slide, the parallel blocks *must be removed* from the die set before stroking the press over. The parallel block installation fixtures have up to now been made of solid steel, so if they are not removed from the die set before stroking the press, a crash will occur that can damage the die set and the press (see photos at right).

Stolle is now offering new **collapsible cupping die installation fixtures** that are designed to support the weight of the outer and inner punch holder (in a set of 4). These new fixtures have an internal gas cylinder that is filled with nitrogen gas to a specific pressure proportional to the mass of a typical cupping die. The advantage of the gas cylinder design is that if additional force is added (such as the outer press slide moving downward), the piston will collapse and prevent damage to the die set and press.



Traditional solid steel parallel block



New gas cylinder installation fixture



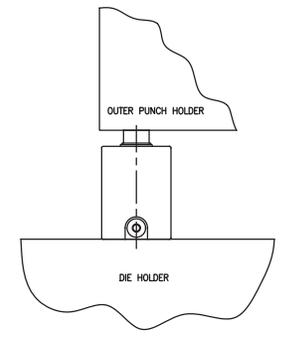
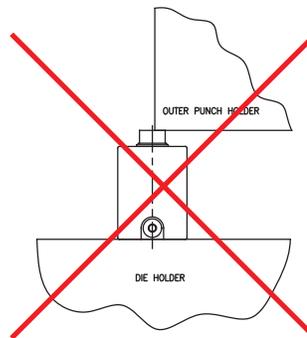
Cupping die shoe damage caused by lowering the upper press slides with traditional solid parallel blocks in place



Installing the gas cylinder installation fixtures in a cupping die set

The part number for the new installation fixtures is 222170818, and they are sold only as a set of (4) four. This part number is a direct replacement for installation fixtures JC109224 and 59587BC only. The fixtures are precision ground to a specific height of 2.125" for cupping die applications; other sizes and applications have not been developed at this time.

NOTE: The new cupping die set installation fixtures carry a (5) year expiration date from manufacture. This is due to the internal seals eventually leaking down over time. If leak-down is excessive, the internal pressure decreases and the fixtures will no longer support the mass of the die. Fixtures should be discarded after the expiration date or returned to Stolle for rebuild/recharge.



Proper installation of the new fixtures in the cupping die is important. The entire piston top should be covered by the outer punch holder.



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For pricing and/or to order a set of the new gas cylinder cupping die set installation fixtures, please contact Kelly Hurst at Stolle Canton at +330-244-0537 or kelly.hurst@stollemachinery.com.

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