

Copper Punch Die Air Hole Orientation

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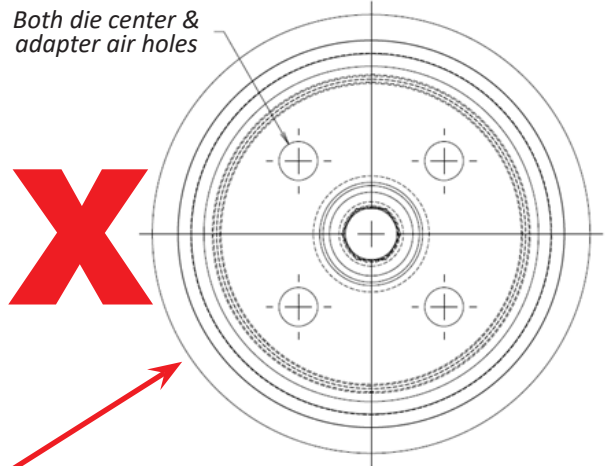
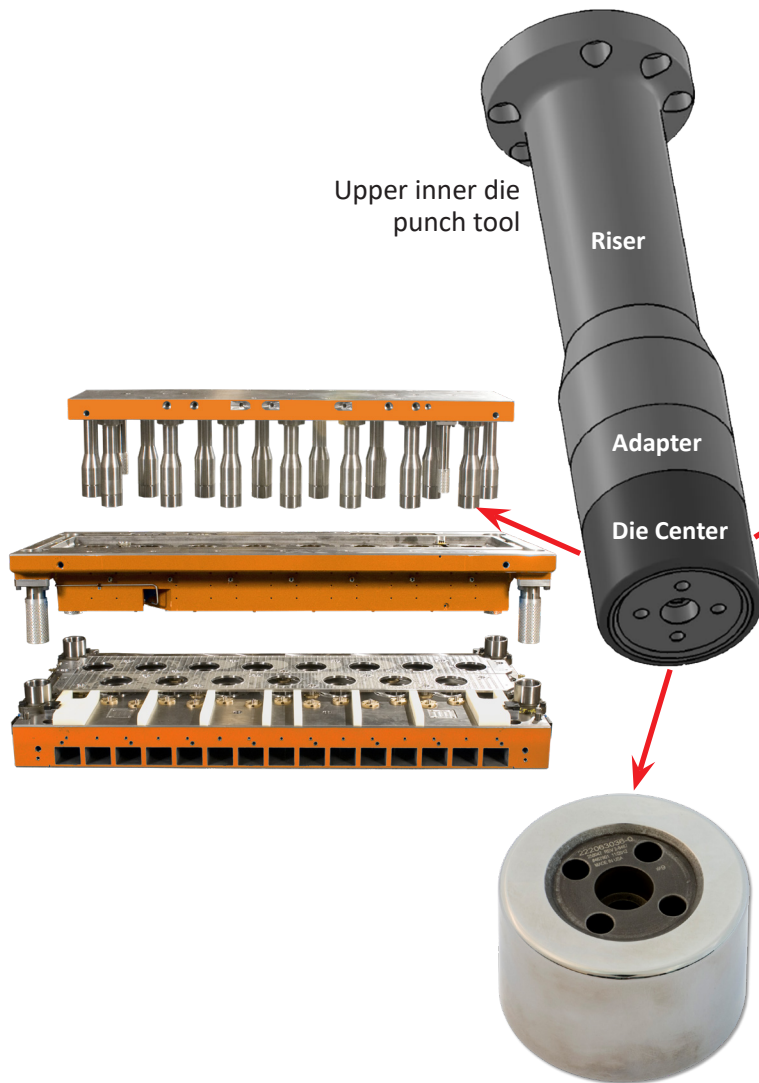
Technical Bulletin 2409-4 for Stolle Cupping Systems

When installing copper die centers (form punches) to the inner die, Stolle recommends the orientation of the blowoff air holes in the die center be purposely mis-aligned with the air holes in the adapter or riser. This misalignment helps to balance the air flow through all four holes and provides a more effective means of stripping the cup from the die center.

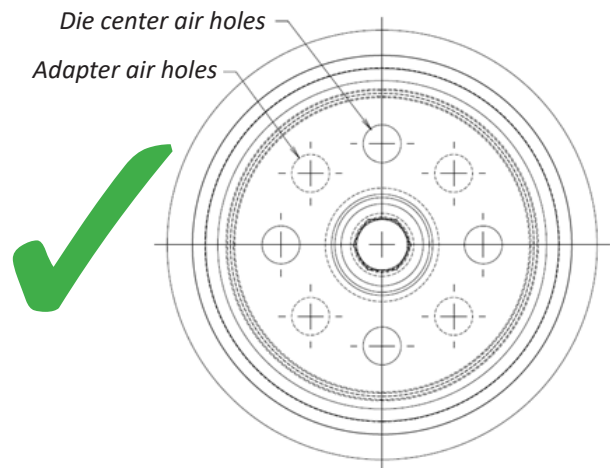
This is an important point for customer service technicians to observe when installing the die centers on their copper punch tools in the plant. See the illustrations on the right for the incorrect and correct orientation of the die center on adapter or riser.



Blow-off air holes in die center should not be aligned with air holes in adapter



Blow-off air holes in die center should be rotationally offset with air holes in adapter



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