

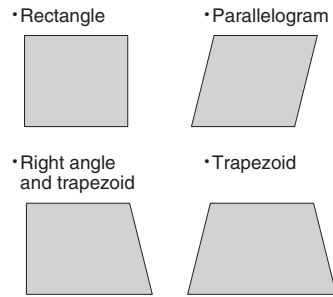
Blanking Die System

CUSTOM MADE

Blanking line requiring small lot production of blanks in various shapes.

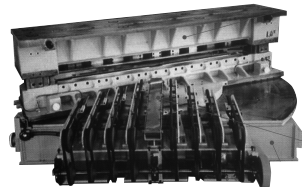
Since the die area of the blanking die system turns with the drive mechanism, one system is able to produce many blank shapes.

(Shapes capable of cutting)



Type of blanking die system

• Turn blanking die system



▲ One unit of the turn blanking die can produce trapezoid blank sheets. One press stroke can produce one blank sheet.

Features

(1) Reduction of die costs

The blanking die system can easily cut trapezoid blanks to desired shape. It is not necessary to manufacture a trapezoid blanking die for each shape. (Rectangle and parallelogram can also be cut.)

(2) Improvement of press line operation rate

Just input of the angle data for the die or programmable retrieve the preset part number to complete the setup of the blank cutting shape.

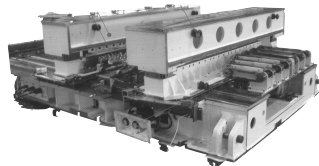
The die does not have to be changed, resulting in great reduction of the setup time. Productivity of the press line can be improved drastically.

(3) Reduction of die storage space

Since one unit of this system can produce various number of blank sheets, the number of dies in possession can be reduced, and the die storage space can be greatly reduced.

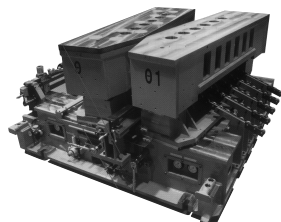
• Double variable blanking die system

Automatic type



◀ Desired trapezoid blanks can be produced with two turning cutting dies. Two blanks can be produced with one press stroke. Two turning cutting dies are automatically positioned with the servo motor drive control.

Manual type



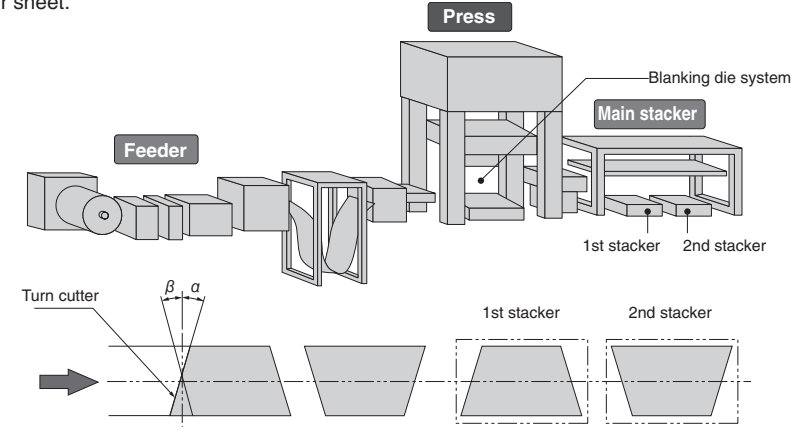
◀ The mechanism is the same as the automatic type. Positioning of the die is determined only by manual handle operation.

From cutting to stock

• Turn Blanking Die System

According to the turn angle (α , β) preset with the numerical control system, the die area turns for each stroke of the press and the trapezoid blanks are produced.

As shown in the figure below, trapezoid blanks are produced inverse in the feed direction every other sheet.



• Double Variable Blanking Die System

Cutting is performed at the movable side (loading side) and fixed side (unloading side) for each stroke of the press. Two trapezoid blanks are produced at the same time.

Two blanks are ejected to the main stacker and the side stacker as shown in the figure below.

