



THE PERFORATING PRESS

Volume 4

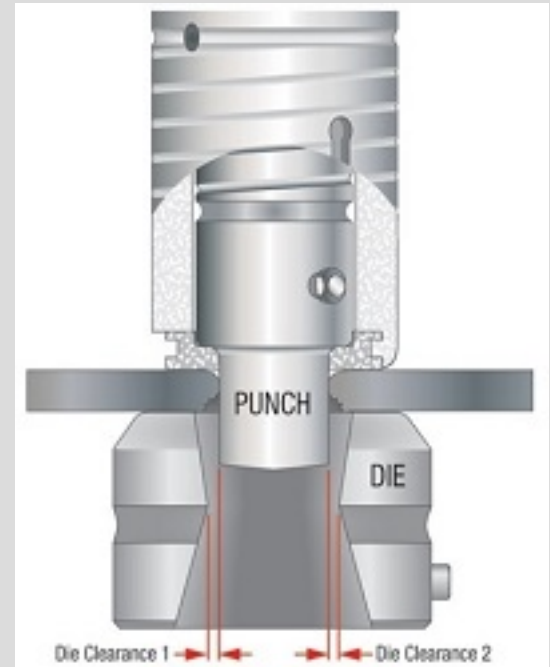
Quality Perforating, Inc.

Issue 06

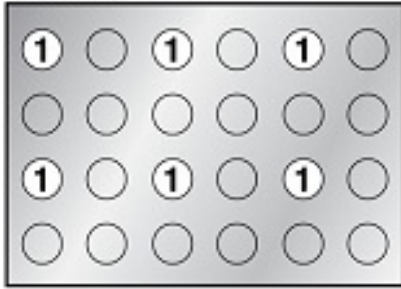
What Are the Considerations to Developing a Tool for a Job?

Sharp tools are a must for optimum job performance. Sharp tools reduce the stress and distortion a dull tool creates. In addition to the selection of the tool, coated punches may also improve overall performance.

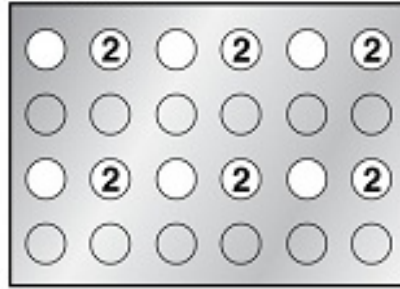
The grade of the tool, the design of the punch (concave, slant, house-top) and the material/thickness being processed are all considered. These will determine the press that will be used, torque and force needed to complete the cycle.



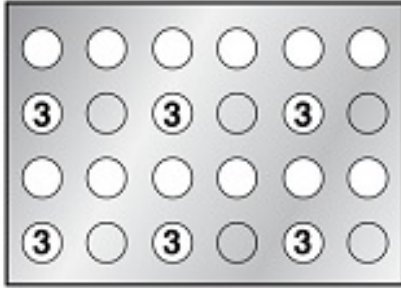
FIRST HIT...



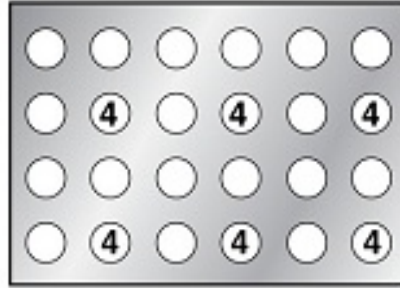
SECOND HIT...



THIRD HIT...



FOURTH HIT...



After the tool is selected, it is important the design specifications and clearance is maintained through out the process. This will insure the quality of the finished product/sheet.

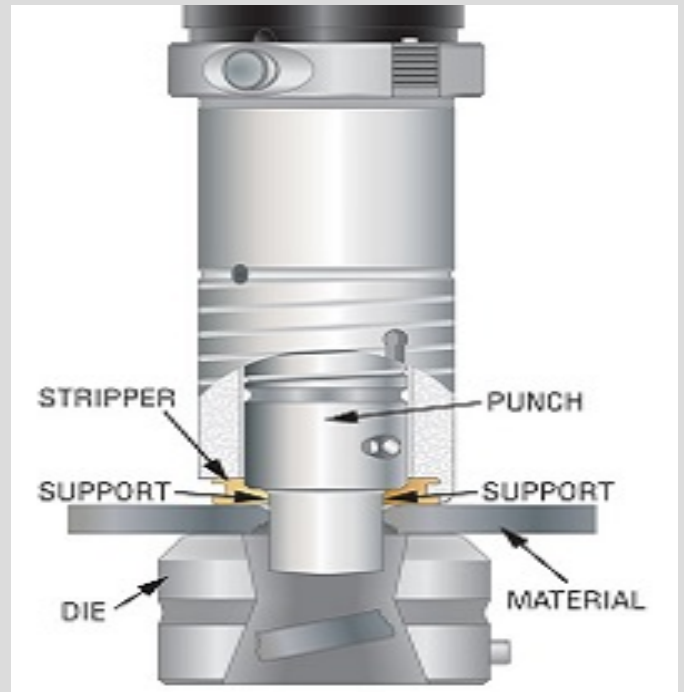
As the material/thickness is selected the ratio, size and pattern of the hole being punched will determine the speed of the press. The number of hits and any positioning will also impact the time it will take to complete this job.

The proper selection of material's and application of lubricants will help reduce galling. Lubrication prolongs tool life and reduces heat buildup in the tool and the sheet. The clean-up should be considered as an additional step in the process. However the performance, quality and tool life all have to be considered.

A guided tool can help. These tools have a stripper clearance. Along with the punch being guided by the holder, the stripper opening also guides the punch tip into the material, to ensure the punch travels straight.

This prevents deflection and, hence, reduces distortion.

Punching the hole is one process of many that go into our jobs. The knowledge of how all the components work together and the input from our customers has helped create a winning combination over the years.



We look forward to helping with your next project.
The Team at QPI...

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