

ADDING VALUE TO YOUR PARTS

Retractable Forming Tools

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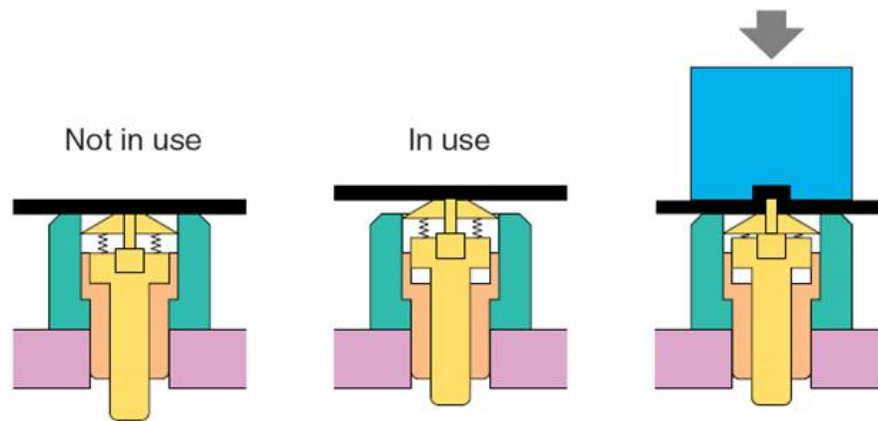
Issue: You have forming tools you use all the time. However, because of the raised dies, they require special programming; they scratch the material and stations next to this tool may not be able to be used.

Solution: Using a retractable type forming tool, the forming die is lowered to die height. This eliminates special programming to avoid it, scratching of the material is reduced or eliminated as it rides over the die, and stations next to the forming tool are available to be freely used. In many of Murata's turret punch presses, this is a standard feature.

All that is required is a special die holder and a special forming die. The die has a shank that extends through and hangs below the lower turret. The tool is defined as a retractable type forming tool in the machine's tool library. When the tool is commanded up to the punching position, it is recognized and an air-activated mechanism raises the die into position. Using programming M-codes, the tool can remain raised for a series of hits, or raise and lower between hits.



**Retractable
Forming Die**



Retractable Forming Process

If you have questions about this feature or want to check if your machine has this capability, contact Murata Machinery. All die holders also come from Murata. Mate Precision Tool (mate.com) can provide tooling for both 114 and thick turret style machines.