



**PASS MASTER E0 / E45**

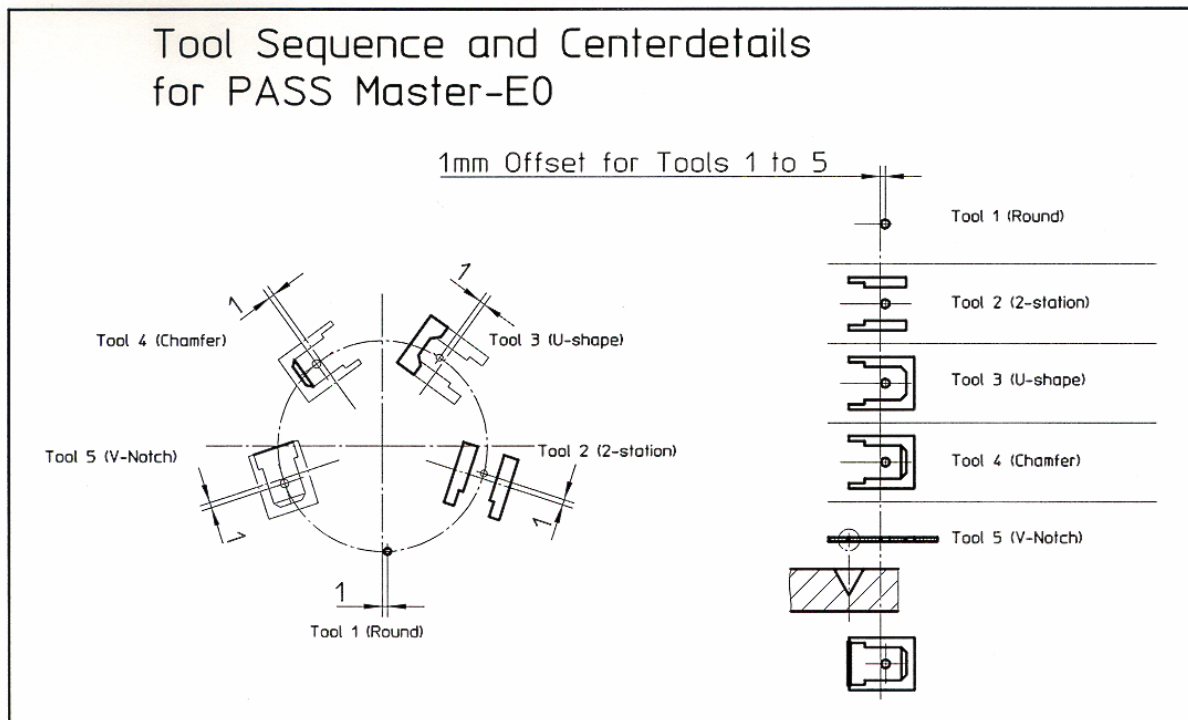
**For producing earthing connectors (locking connectors) for cable sockets according to DIN 46342 produced on a CNC-punching machine (tooling system Trumpf)**





## Sequence of operation for PASS\_Master-E0

- I. The excentric hole is punched with the round punching tool on place No. 1 (the offset within the earthing connector is already compensated with the tool).
- II. The pre-punch on the side of the earthing connector will be made with tool No. 2 (same position as tool on place 1).
- III. The pre-punch on the front of the earthing connector will be made with tool No. 3 (same position as tool on place 1).
- IV. The tool pos. No. 4 makes the chamfer on both sides on the front towards DIN 46342 (same position as tool on pos. No. 1). If necessary, the size of the chamfer must be corrected in the relevant PTT-scale by changing the UT-offset.
- V. At least one chamfer is punched with the tool on pos 5 in order to bend the earthing connector by hand (same position as tool on place 1). If necessary, the V-depth of the Notch must be corrected in the relevant PTT-scale by changing the UT-offset.





## Sequence of operation for PASS Master-E45

- I. The excentric hole is punched with the round punching tool on place No. 1 (the offset within the earthing connector is already compensated with the tool).
- II. The pre-punch on the side of the earthing connector will be made with tool No. 2 (same position as tool on place 1).
- III. The pre-punch on the front of the earthing connector will be made with tool No. 3 (same position as tool on place 1).
- IV. The tool pos. No. 4 makes the chamfer on both sides on the front towards DIN 46342 (same position as tool on pos. No. 1). If necessary, the size of the chamfer must be corrected in the relevant PTT-scale by changing the UT-offset.
- V. At least the 45° bend will be made with the tool on pos. 5 (the offset of the tool of 1,6 mm has to be observed). Please take attention that the Multitool-stripper was prepared that the bended sheet can go into 3 directions. (please note: the direction AGAINST the stripper is prohibited). If necessary, the 45° bending has to be corrected in the relevant PTT-scale by changing the UT-offset.

