

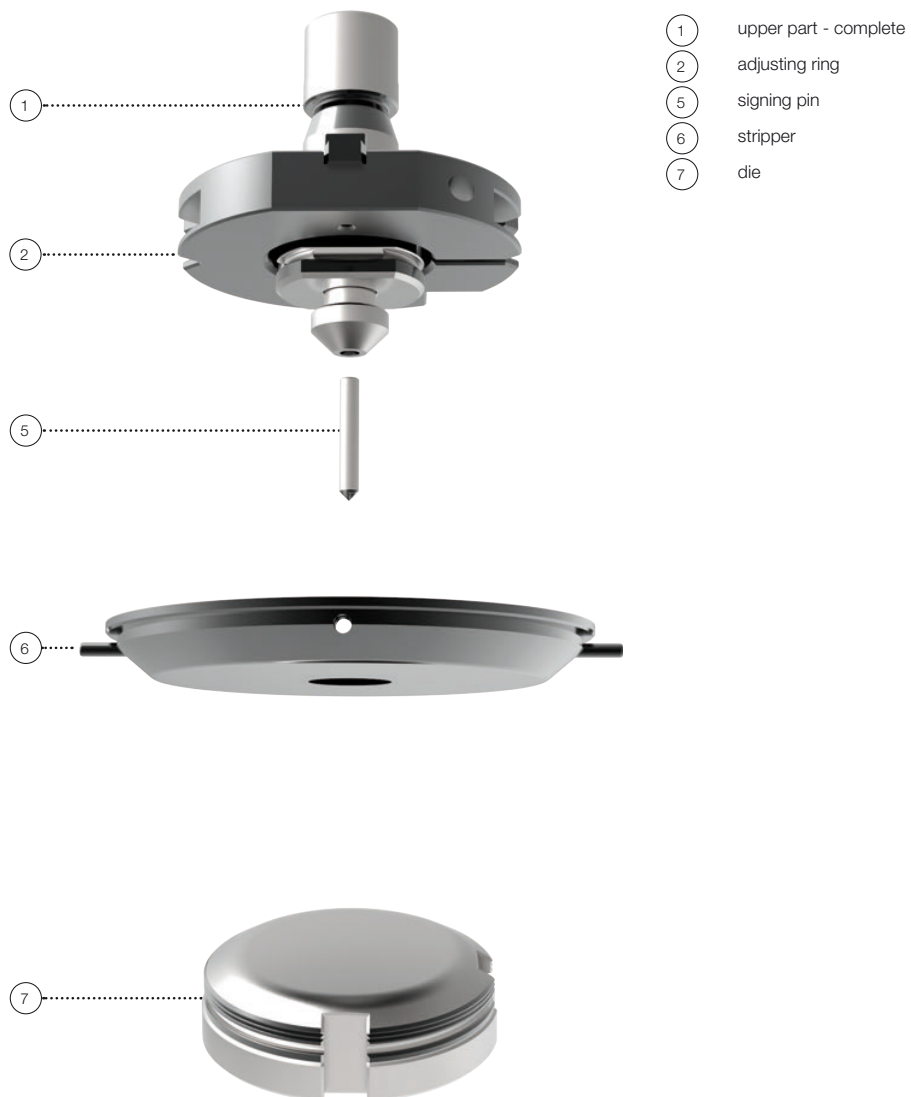
OPERATION MANUAL 01/2020-WW

ps:[®]signing

ps:® signing

FOR MACHINE TYPE TRUMPF - MACHINE GROUP I

- sheet quality: aluminium / steel / stainless steel
- sheet thickness: s = 1,0 - 8,0 mm



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FOR MACHINE TYPE TRUMPF - MACHINE GROUP I

PROGRAMMING AND TOOL TYPE

Programming as signing tool (tool type 20 in TruTops Punch – this operation must be activated)

- tool length = 34,3 mm
- UT-offset in PPT tab in each sheet thickness = 0
- die height = 30,0 mm
- use stroke type 1 (punch without support position)
- active die = 0 (no)

METHOD OF OPERATION

Typically, the tool is used to mark different characters, numbers and logos in the material. Therefore, the material is displaced chipless through the needle point.

The step depends on the machine and is between 1,0 and 2,2 mm/min.

TOOL SPECIFICATIONS

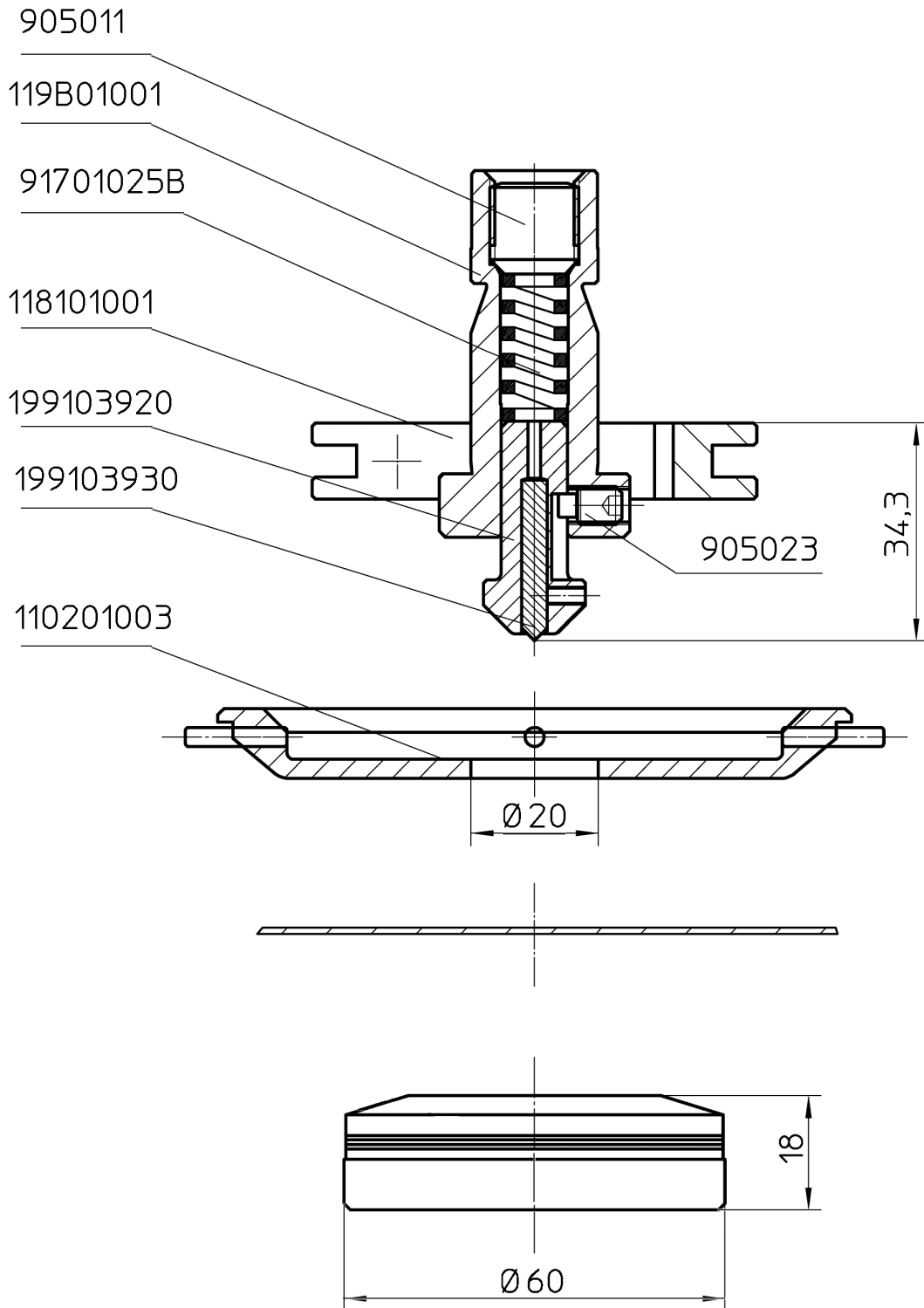
- please do NOT grease the sheet
- NOT suitable for foil-coated sheet metal

CLEANING AND CARE

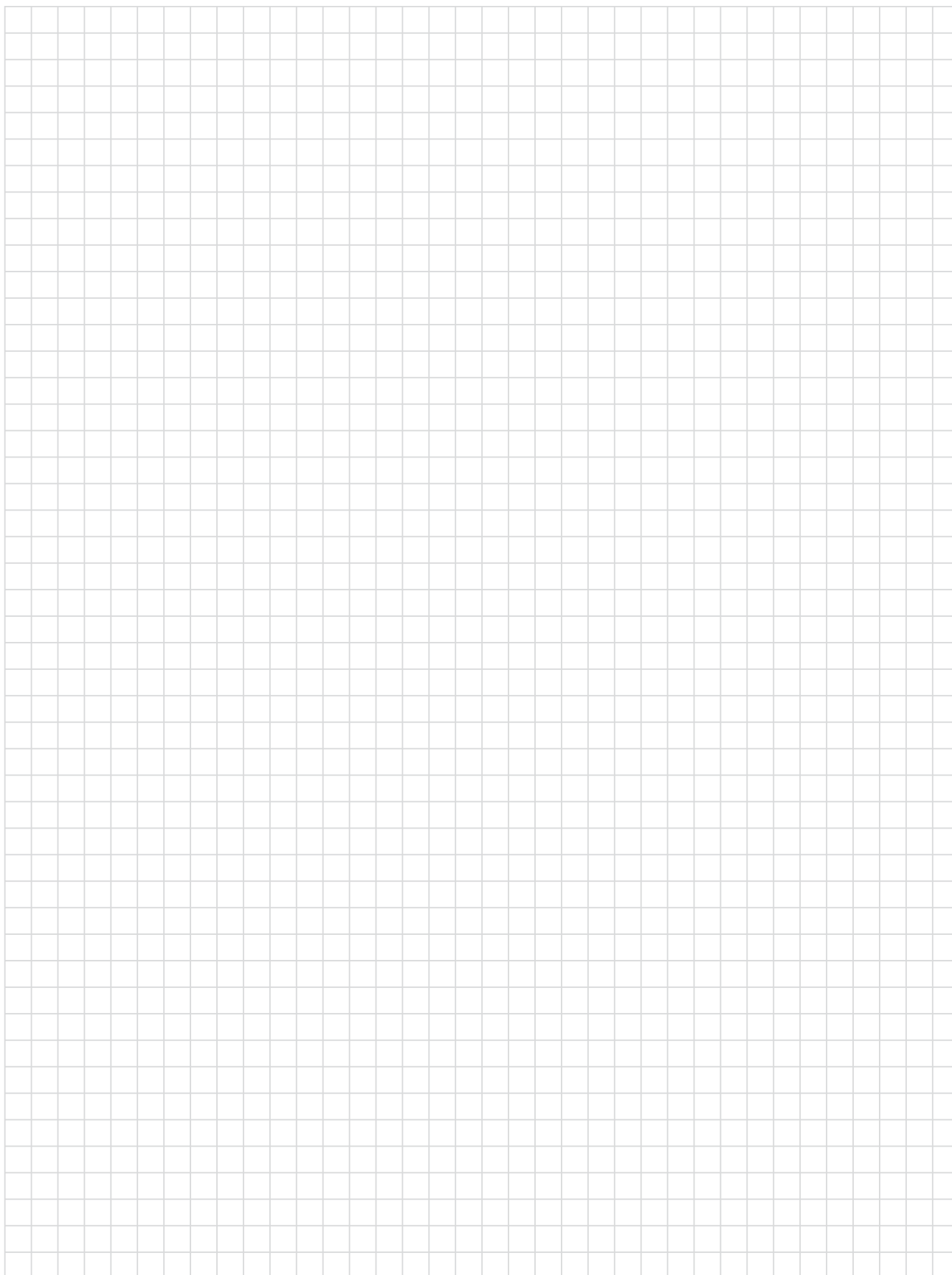
We recommend to check and if necessary to clean the tool daily. Before assembly, the adapter has to be greased in the guide area. Especially when you work with stainless steel, periodic visual inspections for wear and tear should be made more frequently.

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PRACTICAL TEST

A sample sheet was enclosed with the tool.



NOTES



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