



OPERATION MANUAL 08/2023-WW
SLITTING TOOLS

THANK YOU VERY MUCH,

for purchasing a slitting tool from the system TRUMPF, developed and produced by PASS Stanztechnik AG.

It is our utmost intention to guarantee you a long-term service with your new PASS product.

Therefore, we have prepared a detailed operation manual for you including notes on technology requirements, application area, installation, drawing and parts list, cleaning and care as well as general information.

Please feel free to contact us in any case of questions.

Yours

PASS Stanztechnik AG

SAFETY

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ps:[®]T8-shear

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ps:[®]T8-trim

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SAFETY

SLITTING TOOLS

A. WARRANTY AND LIABILITY

Before using the tools for the first time, it is recommended to read this operation manual carefully, as PASS Stanztechnik AG does not assume any liability for damages and malfunctions resulting from non-observance of this operation manual.

Please contact us by email if you require further information: sales@pass-ag.com.

Basically, the „General Terms and Conditions of Delivery and Payment“ of PASS Stanztechnik AG are to be obtained. These will be made available to the operator at the latest when the contract is concluded. Warranty and liability claims concerning personal injury and damage to property are excluded if they are due to one or more of the following causes:

- improper use of the tool
- improper assembly, disassembly and maintenance
- non-compliance with the instructions in the operation manual
- inadequate control of tools or tool parts subject to wear and non-observance of the prescribed maintenance intervals
- improperly performed repairs
- disasters caused by foreign objects and force majeure

Furthermore, when using tools from PASS Stanztechnik AG, the standards, regulations and laws applicable in the respective country must be observed.

B. GENERAL SAFETY INSTRUCTIONS



Risk of cuts and bruises!

Working without approved protective work clothing can result in cuts and bruises.

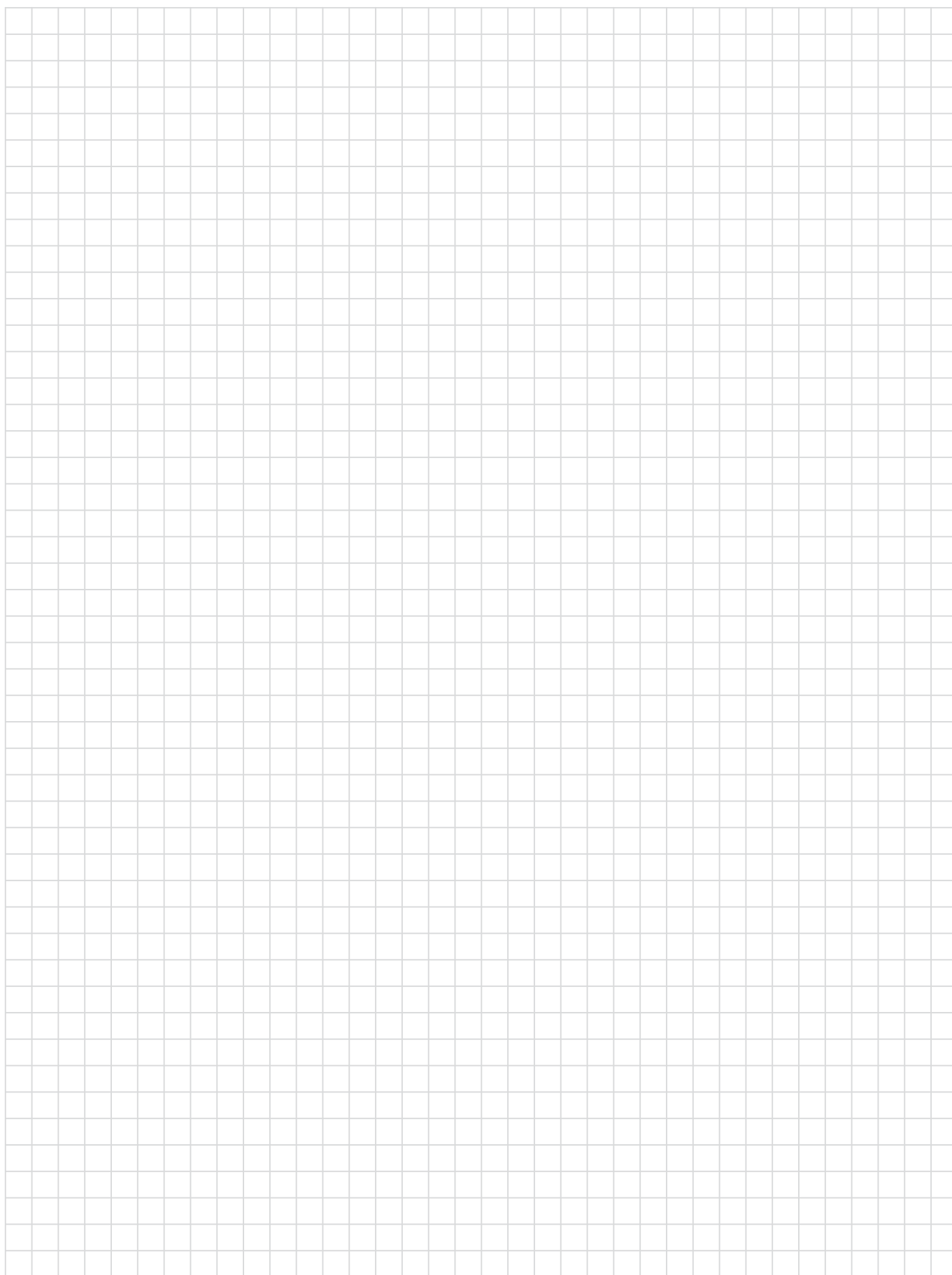
Therefore, always wear suitable protective clothing such as work shoes and work gloves to avoid injuries.



Danger of ejected metal shavings!

When grinding tools, there is an increased risk of injury from flying metal chips.

Always wear safety goggles when working to prevent eye injury.



ps:[®]T8-shear

SLITTING TOOLS

A. TECHNOLOGY REQUIREMENTS

Machines

Usable for machine group I:

- TruPunch 1000/2000/2020/3000/5000
- TruMatic 1000/3000/6000/7000

Control system

In TruTrops, the function tool type 27 must be enabled for programming as a multishear tool.

B. APPLICATION AREA

Typically, the tool is used for slitting sheets with smooth sheet edge. In this process, nibbling marks are avoided.

- sheet quality: aluminium / steel / stainless steel
- sheet thickness: $s = 0,5$ up to $3,0$ mm

C. INSTALLATION

Control inputs

- UT-offset in PPT tab in each sheet thickness: 0
- tool length: 44,2 mm
- slitting speed: max. 12 m/min.
- die height: 30,0 mm
- stripper type: $\leq 80,0$ mm
- shear length (tool size 1): 76,2 mm
- shear width (tool size 2): 5,0 mm
- shear angle (tool size 3): 8°
- blank holder type: 2 ($\leq 80,0$ mm)
- opt. embossing position (VU-value): -1,0 mm
- stroke type: punch without support position / stroke type 1
- active die: 0 (none)
- punching depth stripper: -1,0

Programming

- The existing calibration program has to be used to calibrate the UT2-offset value. Make sure that the machine is at operating temperature.
- Only full cuts can guarantee a smooth and clean cutting edge.
- Trimming with the **ps:[®]T8-shear** is NOT permitted.
- Slug extraction must be activated.
- Tool lubrication should be activated.
- OT-offset +0,4 at sheet thickness $s = < 1,2$ mm

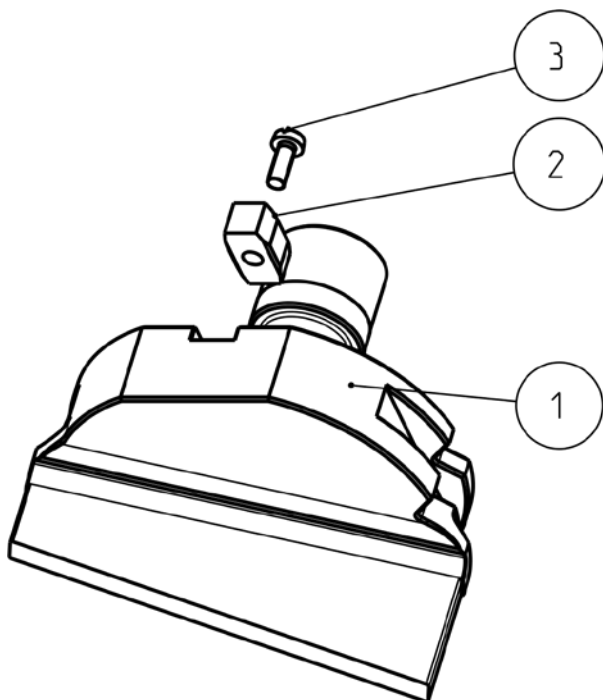
Die plate

Two die plate versions are available:

- single die plate with A-MAX coating for $s = 0,5 - 1,5$ mm
- pair of die plates with A-MAX coating for $s = 2,0 - 3,0$ mm

D. DRAWING AND PARTS LIST

Punch



POSITION	DESCRIPTION	PIECES	PART-NO.
1 - 3	Punch	1	1S108100

Spare parts

POSITION	DESCRIPTION	PIECES	PART-NO.
2	Adjusting key	1	1S108100-2
3	Screw	1	1S108100-3

ps:[®]T8-shear

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Stripper

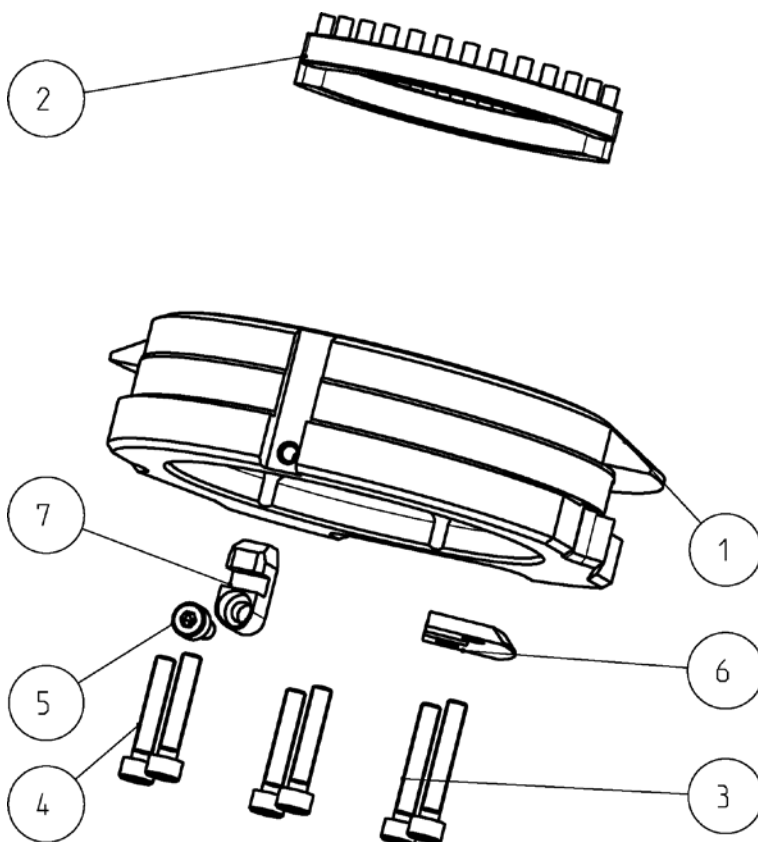


POSITION	DESCRIPTION	PIECES	PART-NO.
1 - 2	Stripper	1	1S108110

Spare parts

POSITION	DESCRIPTION	PIECES	PART-NO.
2	Pin	2	1S108110-2

Die plate holder



POSITION	DESCRIPTION	PIECES	PART-NO.
1 - 7	Die plate holder	1	1S108120

Spare parts

POSITION	DESCRIPTION	PIECES	PART-NO.
2	Pair brush segments	1	1S108122
3	Screw	2	1S108120-3
4	Screw	4	1S108120-4
5	Screw	1	1S108120-5
6	Guiding plate	1	1S108123
7	Wedge	1	1S108141

Accessories

POSITION	DESCRIPTION	PIECES	PART-NO.
	Single die plate	1	1S108131
	Pair of die plates	1	1S108132

E. CLEANING & CARE

We recommend to check and if necessary to clean the tool daily. Sharpening or grinding the material in time increases the tool life enormously.



NOTE

Carry out periodic (daily) visual inspections and clean the tool if necessary!

Especially when soft and galvanised or foil-coated sheets are processed, abrasion of material, zinc or foils can get into the tool and can lead to a damage of the tool!

Regrinding

The max. regrinding length of the punch is 2,8 mm:

- s = 1,0 mm / max. regrinding length = 2,8 mm / min. tool length = 41,4 mm
- s = 1,5 mm / max. regrinding length = 2,8 mm / min. tool length = 41,4 mm
- s = 2,0 mm / max. regrinding length = 2,8 mm / min. tool length = 41,4 mm
- s = 2,5 mm / max. regrinding length = 2,0 mm / min. tool length = 42,2 mm
- s = 3,0 mm / max. regrinding length = 1,0 mm / min. tool length = 43,2 mm
- The die plate must not be reground.

F. GENERAL INFORMATION

Additional lubrication should be applied when working with aluminium.

Working with active blank holder is NOT permitted.



CAUTION

Be careful when repositioning with the punching head!

The ps:[®]T8-shear can seriously be damaged, when repositioning with the punching head. Therefore, repositioning is only allowed with repositioning cylinders or a standard tool has to be put in before repositioning with the punching head.

ps:[®]T8-trim

SLITTING TOOLS

A. TECHNOLOGY REQUIREMENTS

Machines

Usable for machine group I:

- TruPunch 1000/2000/2020/3000/5000
- TruMatic 1000/3000/6000/7000

Control system

In TruTrops, the function tool type 27 must be enabled for programming as a multishear tool.

B. APPLICATION AREA

Typically, the tool is used for trimming sheets. In this process, nibbling marks are avoided.

- sheet quality: aluminium / steel / stainless steel
- sheet thickness: $s = 0,5$ up to $3,0$ mm

C. INSTALLATION

Control inputs

- UT-offset in PPT tab in each sheet thickness: 0
- tool length: 44,2 mm
- trimming speed: max. 12 m/min.
- die height: 30,0 mm
- stripper type: $\leq 80,0$ mm
- shear length (tool size 1): 73,0 mm
- shear width (tool size 2): 18,0 mm
- shear angle (tool size 3): 8°
- blank holder type: 2 ($\leq 80,0$ mm)
- variable embossing position (VU-value): -1,0 mm
- stroke type: punch without support position / stroke type 1
- active die: 0 (none)
- punching depth stripper: 0

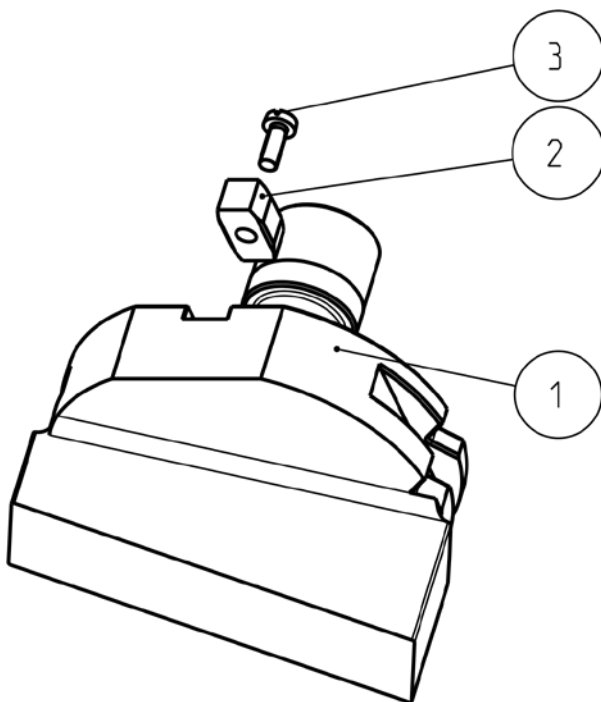
Programming

- The existing calibration program has to be used to calibrate the UT2-offset value. Make sure that the machine is at operating temperature.
- The punch width should be at least 10,0 mm for obtaining an optimal result.
- A minimum trimming width of 3,0 mm should be used for sheet thicknesses less than 1,0 mm.
- Slug extraction must be activated.
- Tool lubrication should be activated.
- OT-offset +0,4 at sheet thickness $s = < 1,2$ mm

Die plate

Two die plate versions are available:

- single die plate with A-MAX coating for $s = 0,5 - 1,5$ mm
- pair of die plates with A-MAX coating for $s = 2,0 - 3,0$ mm

D. DRAWING AND PARTS LIST**Punch**

POSITION	DESCRIPTION	PIECES	PART-NO.
1 - 3	Punch	1	1S108200

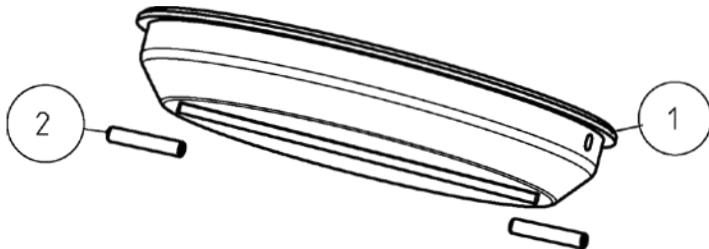
Spare parts

POSITION	DESCRIPTION	PIECES	PART-NO.
2	Adjusting key	1	1S108200-2
3	Screw	1	1S108200-3

ps:®T8-trim

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Stripper

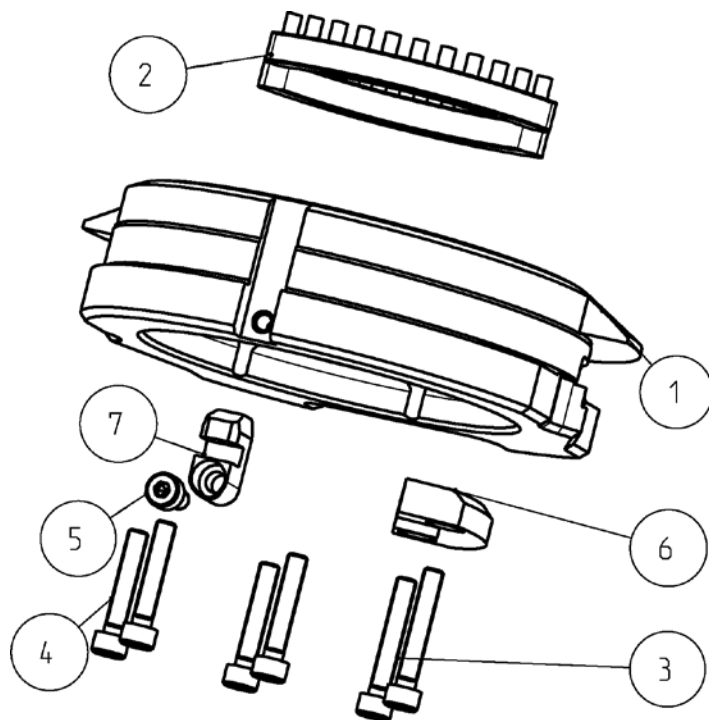


POSITION	DESCRIPTION	PIECES	PART-NO.
1 - 2	Stripper	1	1S108210

Spare parts

POSITION	DESCRIPTION	PIECES	PART-NO.
2	Pin	2	1S108210-2

Die plate holder



POSITION	DESCRIPTION	PIECES	PART-NO.
1 - 7	Die plate holder	1	1S108220

Spare parts

POSITION	DESCRIPTION	PIECES	PART-NO.
2	Pair brush segments	1	1S108222
3	Screw	2	1S108220-3
4	Screw	4	1S108220-4
5	Screw	1	1S108220-5
6	Guiding plate	1	1S108223
7	Wedge	1	1S108141

Accessories

POSITION	DESCRIPTION	PIECES	PART-NO.
	Single die plate	1	1S108231
	Pair of die plates	1	1S108232
	Shim 0,3 mm	1	1S108253
	Shim 0,5 mm	1	1S108255

E. CLEANING & CARE

We recommend to check and if necessary to clean the tool daily. Sharpening or grinding the material in time increases the tool life enormously.



NOTE

Carry out periodic (daily) visual inspections and clean the tool if necessary!

Especially when soft and galvanised or foil-coated sheets are processed, abrasion of material, zinc or foils can get into the tool and can lead to a damage of the tool!

Regrinding

The max. regrinding length of the punch is 2,8 mm:

- s = 1,0 mm / max. regrinding length = 2,8 mm / min. tool length = 41,4 mm
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- s = 2,5 mm / max. regrinding length = 2,0 mm / min. tool length = 42,2 mm
- s = 3,0 mm / max. regrinding length = 1,0 mm / min. tool length = 43,2 mm
- The die plate must not be reground.

F. GENERAL INFORMATION

Additional lubrication should be applied when working with aluminium.

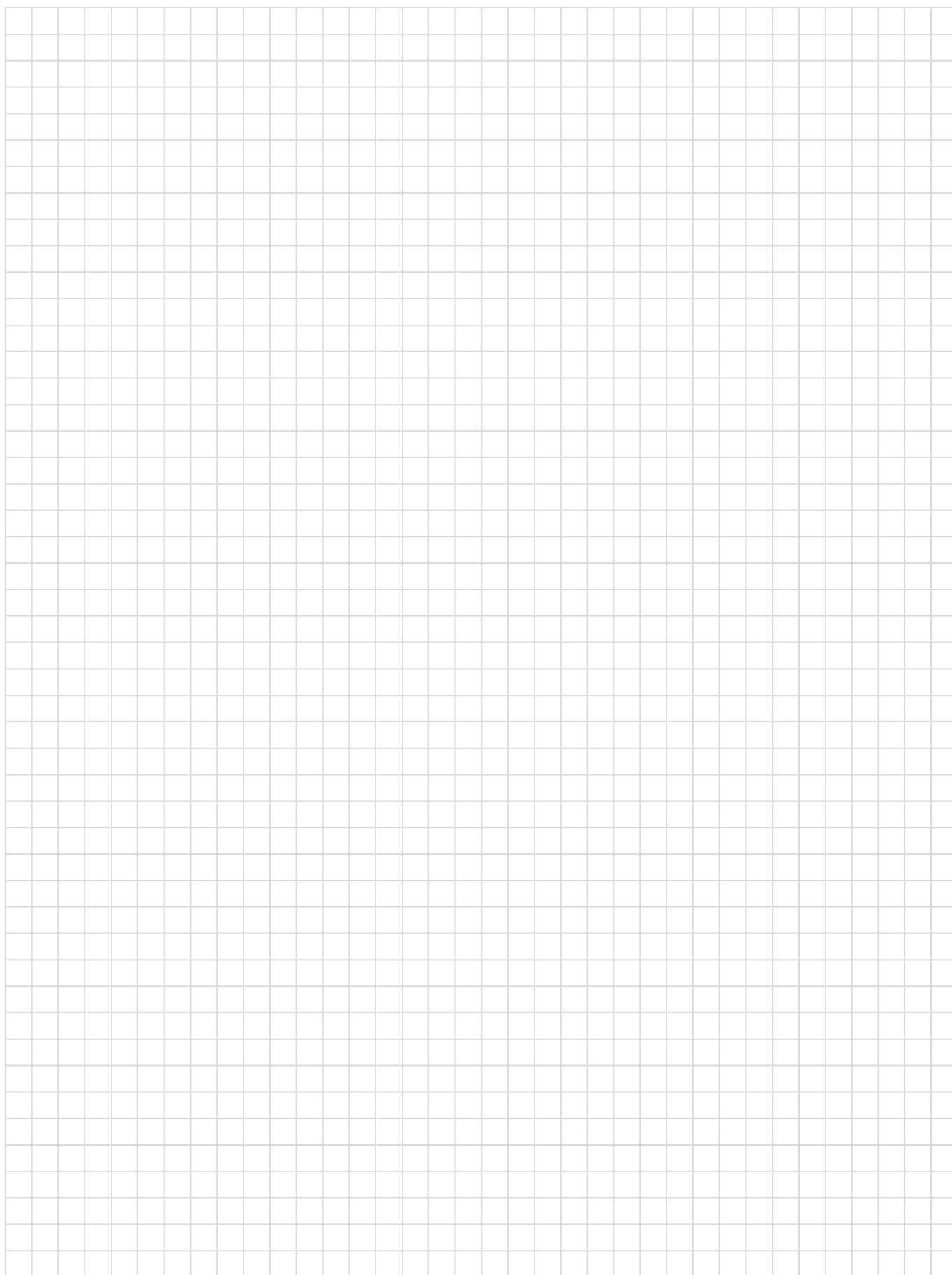
Working with active blank holder is NOT permitted.



CAUTION

Be careful when repositioning with the punching head!

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SALVAGNINI | THICK TURRET | TRUMPF



Am Steinkreuz 2
95473 Creußen | Germany

WEB: www.pass-ag.com
MAIL: info@pass-ag.com

FON: +49 (0) 92 70 / 9 85 - 0
FAX: +49 (0) 92 70 / 9 85 - 99