

TOOL INFORMATION

NO.15 March 2023

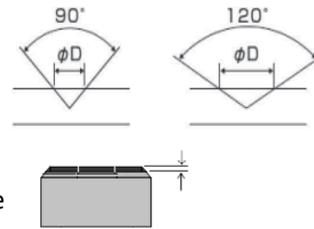
NEW RELEASE

VULCAN II ADJUSTABLE CENTER PUNCH

VULCAN II Adjustable Center Punch is renewed.

✓ Two pin options – 90 and 120.

✓ The AB **LOW** model can handle more thickness variety than the predecessor.



Selection	t	Max size ΦD		
		MS	SUS	AL
JOMEN X / TOP SIDE MARKING X	1.0-6.3	2.1	1.4	2.6
JOMEN AB /TOP SIDE MARKING AB	1.0-6.3	2.4	1.6	2.8
KAMEN STANDARD X / BTM MARKING X	1.0-6.3	1.5	1.3	1.7
KAMEN STANDARD AB / BTM MARKING AB	1.0-6.3	1.8	1.5	1.8
KAMEN LOW X / BTM MARKING X	1.0-2.3	1.5	1.3	1.7
KAMEN LOW AB / BTM MARKING AB	1.0-3.2	1.8	1.5	1.8

(mm)

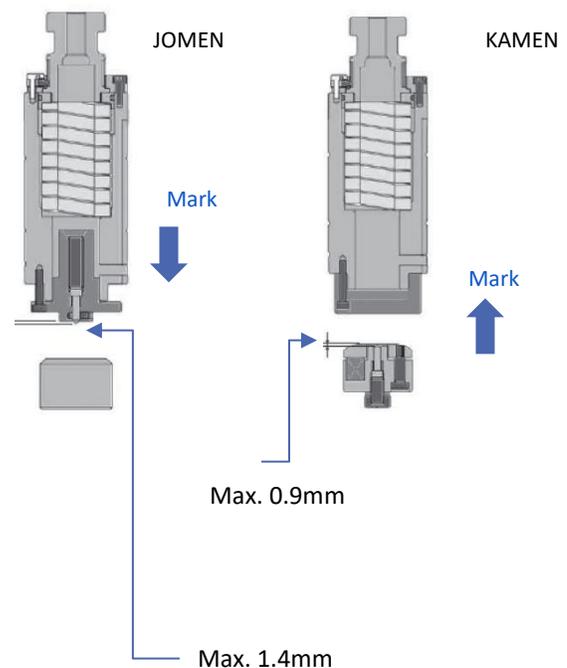
MS mild steel; SUS stainless steel; AL aluminum

The selection refers to a full set of punch holder and punch assembly and die.

*LOW model die is shorter than other marking dies.
The die is as high as the turret surface level. That is good for less scratches on the sheet.

The punch holder for CENTER PUNCH is exclusive and cannot be used for other tools.

VULCAN II ADJUSTABLE CENTER PUNCH is usable at Motorum series, Vectrum series and M5000.



TECHNICAL REPORT

Q: How much could we sharpen a punch and a die?

A: The table helps. All the unit is mm.

PUNCH - 114, VULCAN							
							
t	D~1.5	1.5~4.0	4.0~	t	D~2.0	2.0~4.0	4.0~D
1.0	1.0	1.5	3.0	1.0	1.0	1.5	3.0
1.6	1.0	1.5	3.0	1.6	1.0	1.5	3.0
2.3		1.5	3.0	2.3		1.5	3.0
3.2		1.5	3.0	3.2		1.5	3.0
4.5			3.0	4.5			3.0
6.0			3.0	6.0			3.0

PUNCH - VULCAN II, VUCAN II AIR							
							
t	D~1.5	1.5~4.0	4.0~	t	D~2.0	2.0~4.0	4.0~
1.0	1.5	4.0	5.0	1.0	1.5	5.0	5.0
1.6	1.0	3.5	5.0	1.6	1.0	4.5	5.0
2.3		2.5	5.0	2.3		3.5	5.0
3.2		2.0	5.0	3.2		3.0	5.0
4.5			4.0	4.5			4.0
6.0			3.0	6.0			3.0

DIE							
							
t	~1.5	1.5~4.0	4.0~	t	~2.0	2.0~4.0	4.0~
1.0				1.0			
1.6				1.6			
2.3		1.0		2.3		1.0	
3.2				3.2			
4.5				4.5			
6.0				6.0			

Do not grind over 0.3 mm in one time. Frequent and regular care is required.
 For Stainless t2.0, do not grind over 5.0 mm in total. For Stainless t2.5 or thicker, do not grind 3.0 mm in total.
 When a punch is grounded over 3.0mm in total, the ejector hole shall be made again.
 Chipped products may not be recovered by grinding.
 Do not grind over 3.0mm in total for the tonnage or larger below.

X	AB	C	D	EF/GHJ/INDEX
5.0	10.0	15.0	23.0	No limit

(ton)