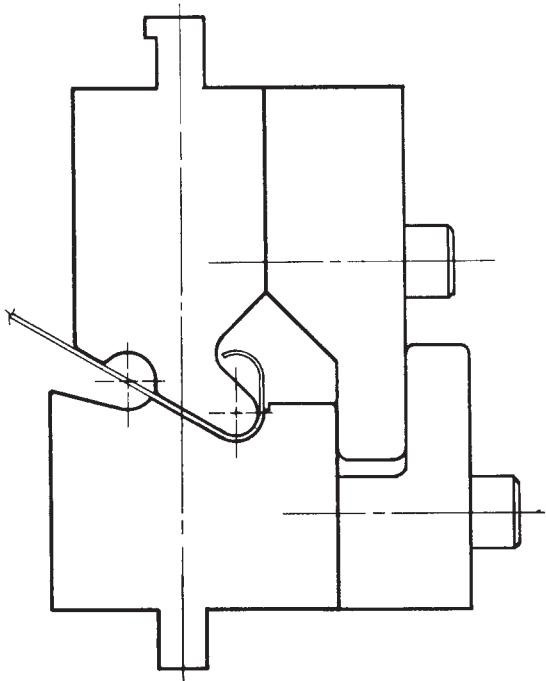




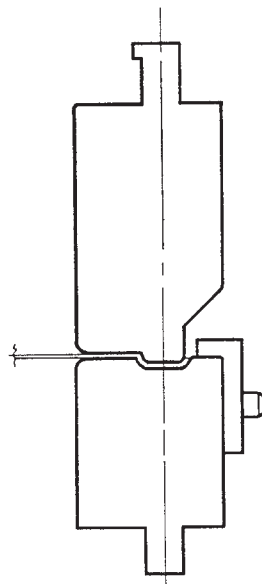
CURLING DIES

SET 121

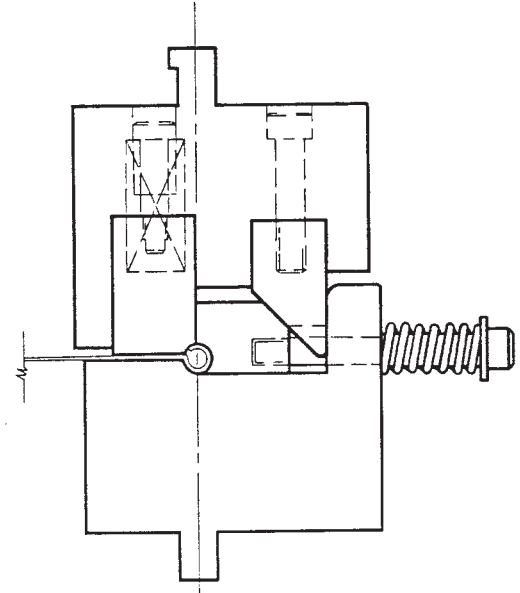


Die set #121 will produce an off-center curl, 1/4" to 3/4" diameter, in 16 gauge material, in three strokes.

SET 122

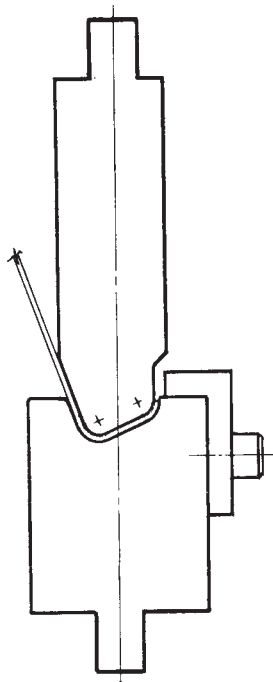


SET 122A



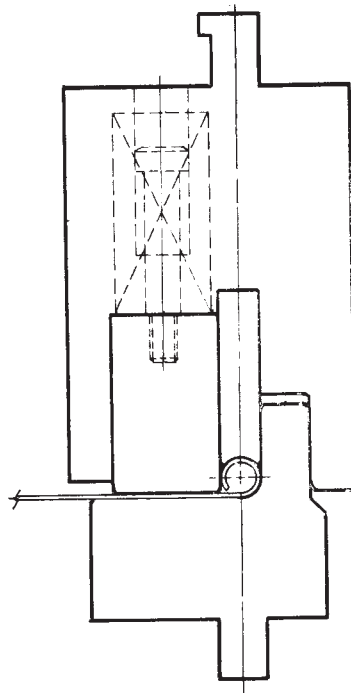
Die sets 122 and 122A should be considered when an accurate on center curl is desired. These dies may be used to produce a curl from 1/4" inside diameter to 1/2" diameter in light gage material. A minimum flat appears on the lead edge, and the sheet remains relatively flat during the forming operation. The sheet to be formed must be wide enough to provide for a reasonable amount of stock to extend in front of the die sets for safe feeding of the part.

SET 123



First operation

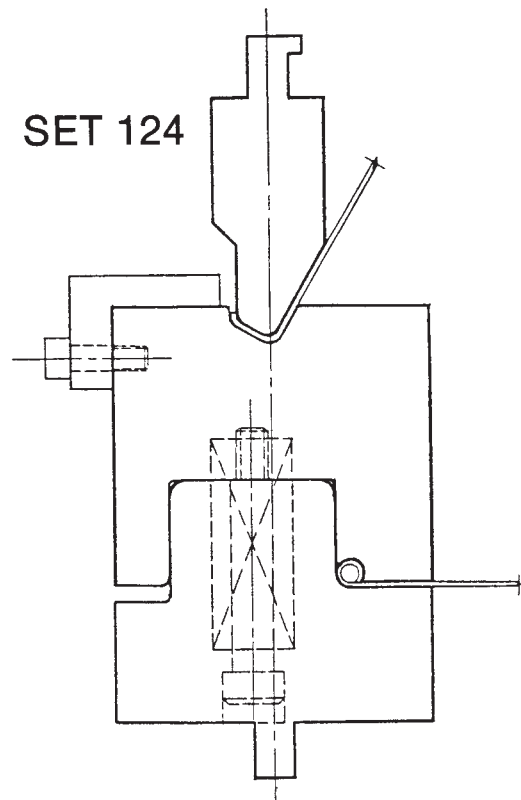
SET 123A



Second operation

Die sets 123 and 123A produce the tightest and roundest curl that can be formed in two strokes. Dies can be mounted side by side for progressive forming if press has sufficient length.

SET 124



If press length is a problem set #124 will provide a clean curl in a one set two hit operation.