

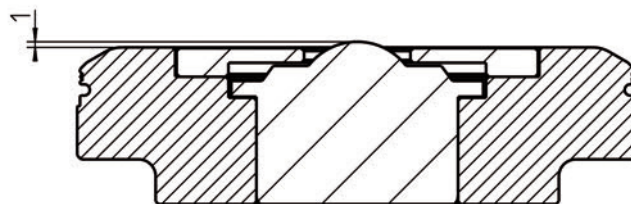
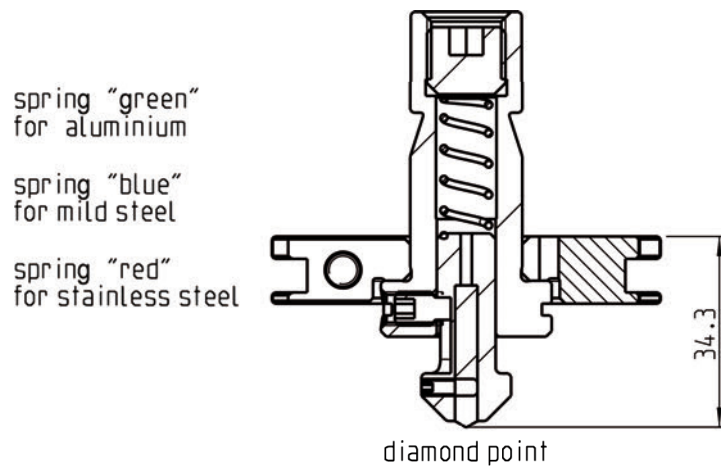
OPERATION MANUAL 03/2020-WW

ps:[®]engraving

ps:® engraving

FOR MACHINE TYPE TRUMPF - MACHINE GROUP I

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



PROGRAMMING AND TOOL TYPE

Programming as engraving tool (tool type 33 in TruTops Punch – this operation must be activated)

- tool length = 33,8 mm
- UT-offset in PPT tab in each sheet thickness = 0
- do not use VU value (S value)
- machining cycle TC_CARVE_ON (PTT1-tab)

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 sheet movement speed depends on empirical data that have to be determined by tests.

The following traversing speeds "V (in m/min.)" are recommended:

- aluminium anodised: V = 30 (assemble the black spring)
- aluminium: V = 30 (assemble the green spring)
- steel: V = 20 (assemble the blue spring)
- stainless steel: V = 15 (assemble the red spring)

SCOPE OF DELIVERY

The spring in the upper part can be changed for processing different sheet qualities.

- black spring: aluminium anodised (installed as standard)
- green spring: aluminium
- blue spring: Steel
- red spring: stainless steel

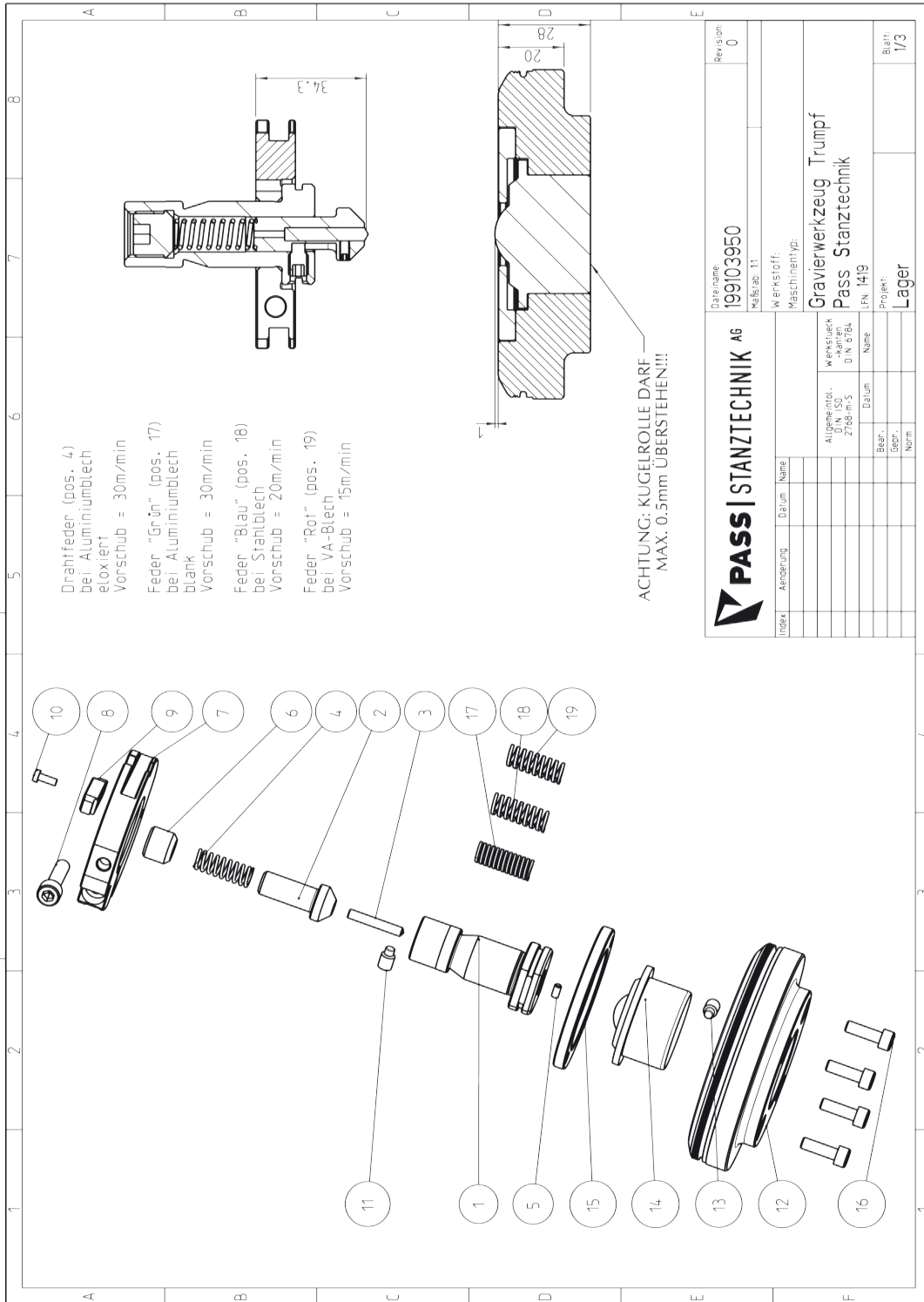
TOOL SPECIFICATIONS

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

CLEANING AND CARE

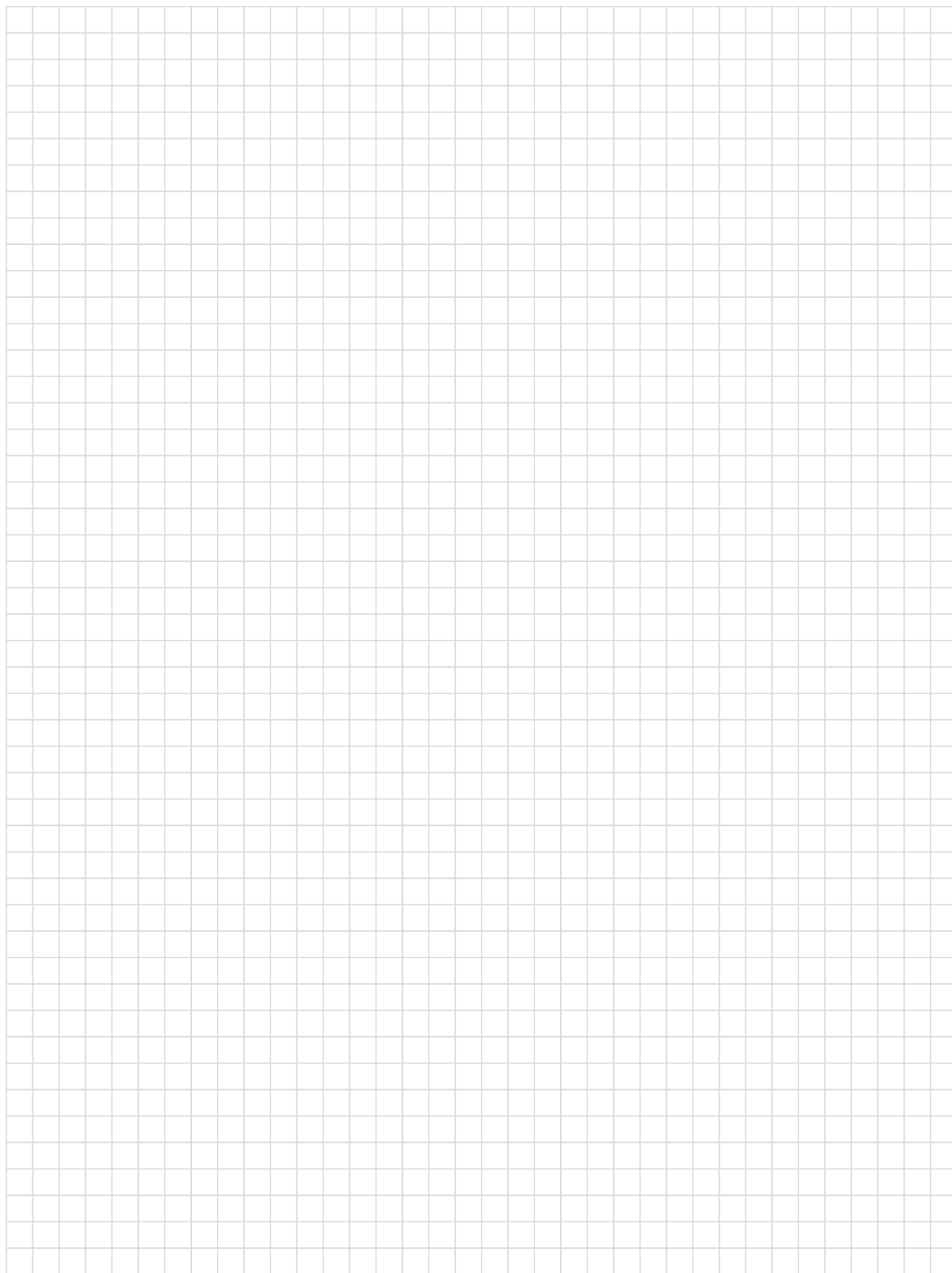
We recommend to check and if necessary to clean the tool daily. Before assembly, the engraving holder (pos. 2) has to be greased in the guide area. Especially when you work with stainless steel, periodic visual inspections for wear and tear should be made more frequently.

A sample sheet was enclosed with the tool.



PASS STANZTECHNIK AG		Dateiname: 199103950	Revision: 0
Index		Maßstab: 1:1	
Anwendung		Werkstoff:	
Datum		Maschinentyp:	
Name		Gravierwerkzeug Trumpf	
Werkstoff		Pass Stanztechnik	
U _{max} ISO: 2768-mS		IPN: 1419	
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Bearb. Genr. Norm		Blatt:	
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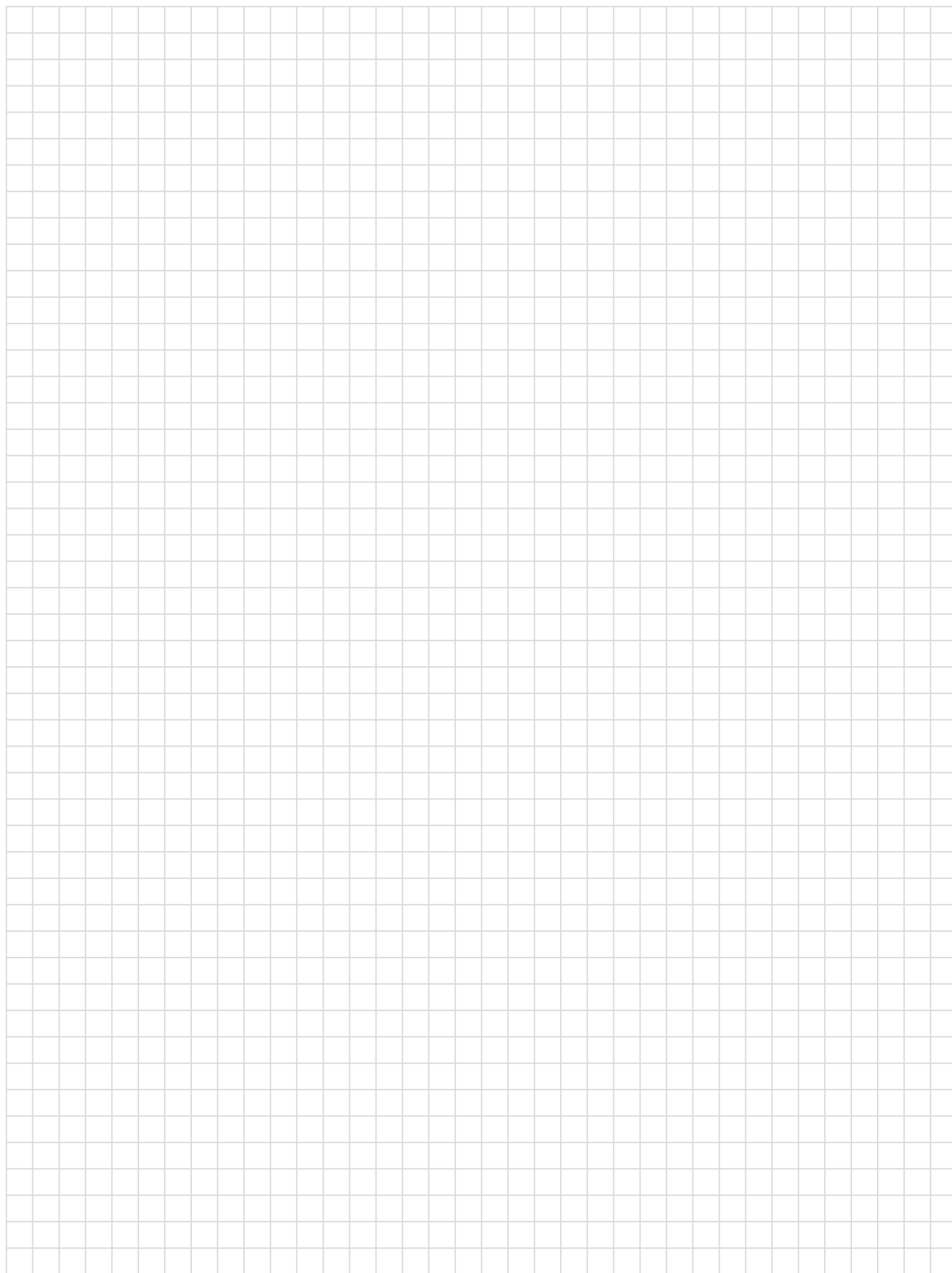
NOTES



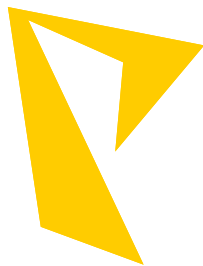
NOTES

A large grid of graph paper for taking notes, consisting of approximately 25 columns and 40 rows of small squares.

NOTES



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