



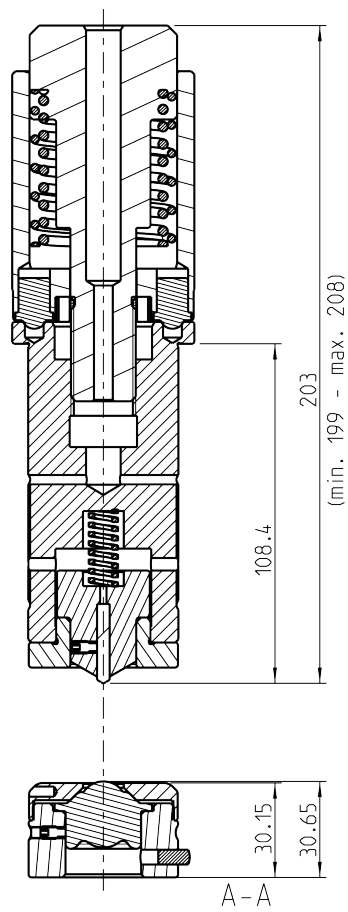
OPERATION MANUAL 03/2020-WW

ps:[®]engraving

ps:® engraving

FOR MACHINE TYPE THICK TURRET

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



PROGRAMMING

- option 1: as engraving tool
- option 2: as wheel beading

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: V = 20 (assemble the green or black spring)
- steel: V = 15 (assemble the blue spring)
- stainless steel: V = 7 (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 and galvanised 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. 5) 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.

Zur Bearbeitung unterschiedlicher Blechqualitäten kann die Feder im Oberteil (pos. 8-11) gewechselt werden!

rot - pos. 9 = stark (VA)
 blau - pos. 8 = mittel (Stahl) --> eingebaut
 grün - pos. 10 = weich (Alu)
 schwarz - pos. 11 = sehr weich (Alu weich)

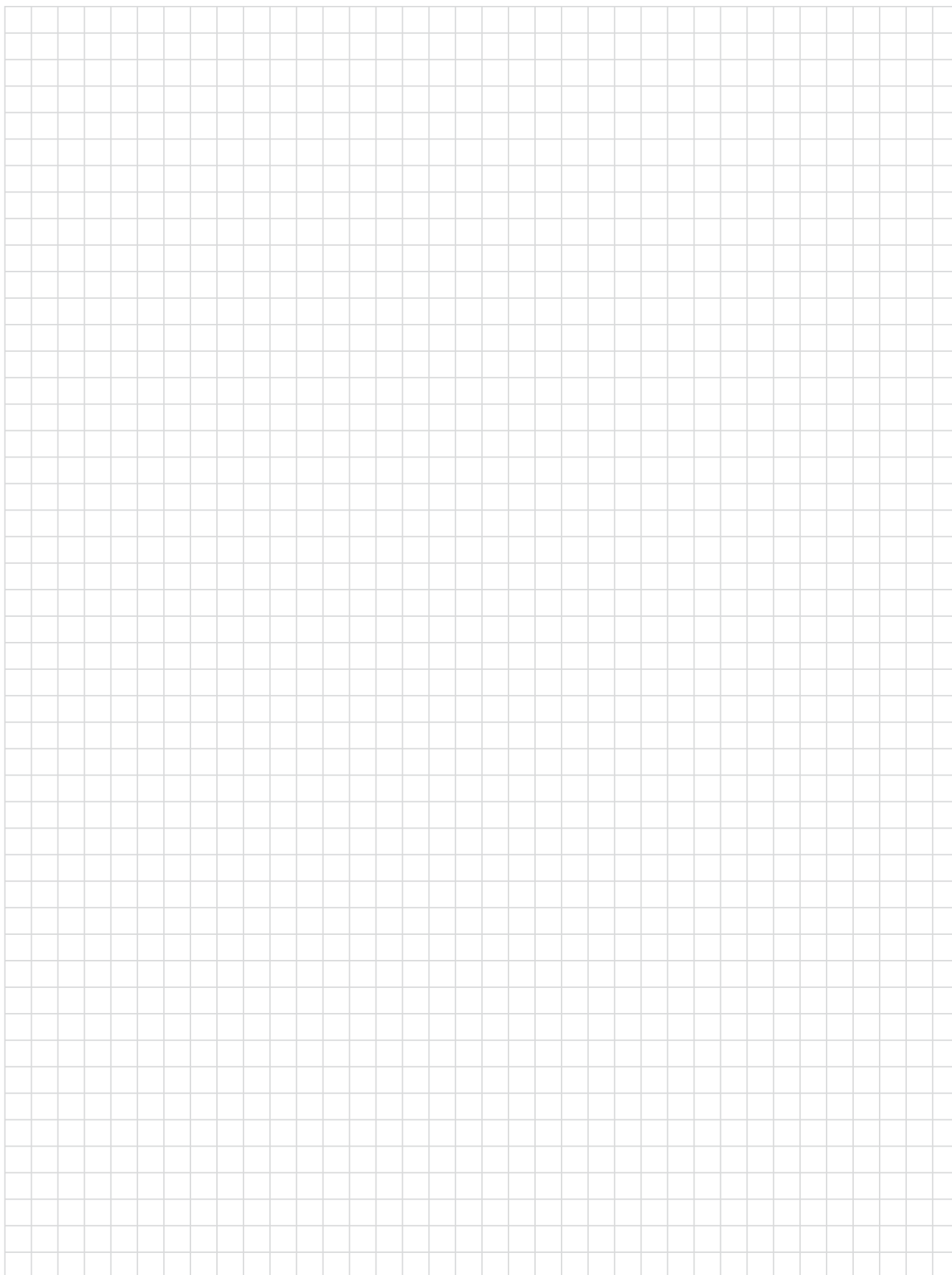
to work in different sheetqualities - you have to change the springs (pos. 8-11) in the upper part!

red - pos. 9 = strong (VZA)
 blue - pos. 8 - middle (steel) --> built-in
 green - pos. 10 = soft (alu)
 black - pos. 11 = very soft (alu soft)

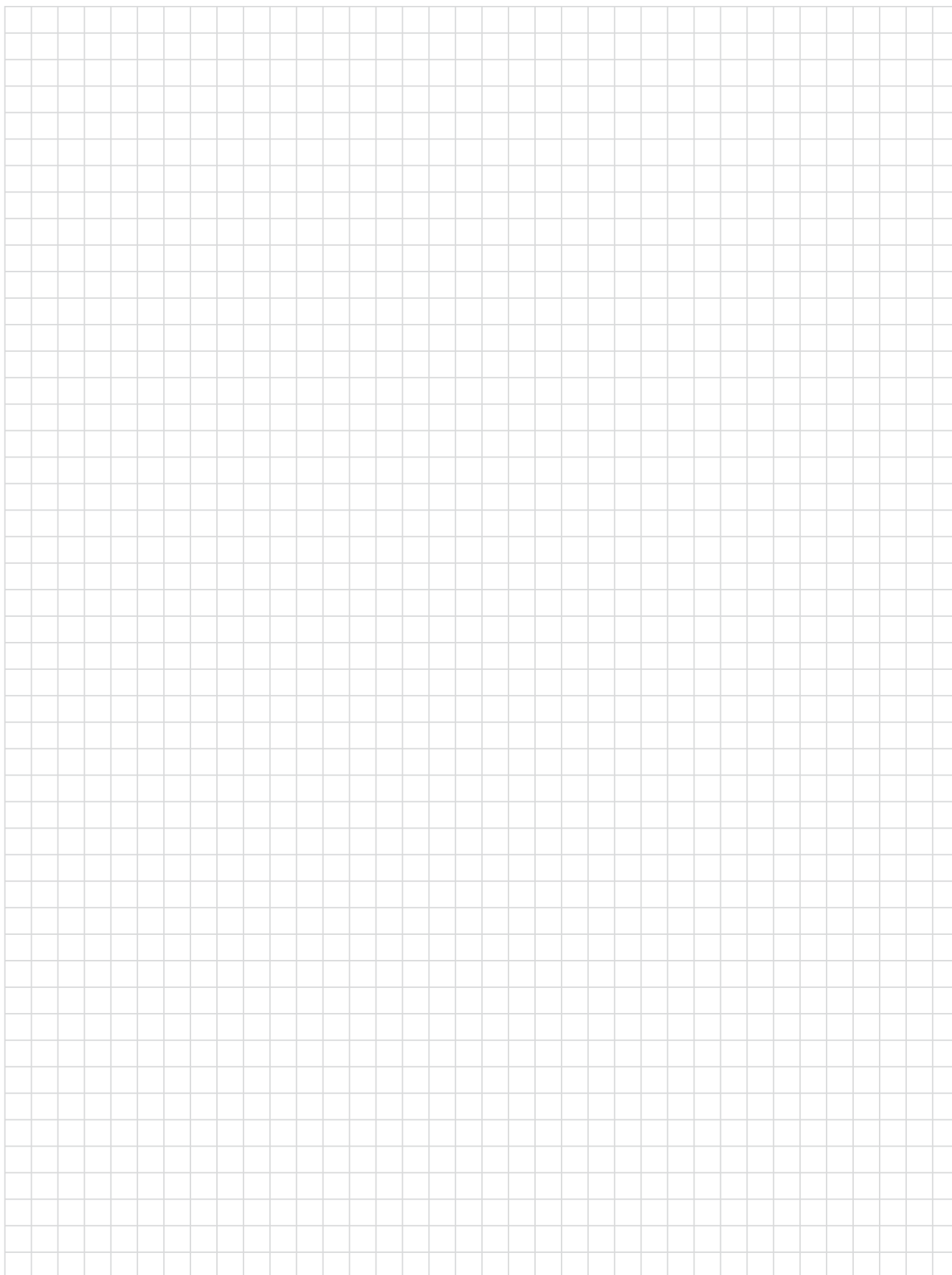
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| index | | Werkstoff: | | Gravierwerkzeug TT | |
| Anwendung | | Maschinentyp: | | PASS Stanztechnik | |
| Datum | | Name | | Lager | |
| Werkstück | | Lager | | WZTID: 0 | |
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| Gepr. | | Lager | | | |
| Norm | | Lager | | | |

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NOTES



NOTES



SALVAGNINI | **THICK TURRET** | **TRUMPF**



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