

# One Stroke Pierce and Form

Variants of this option are available for both CNC Turret and Fixed tooling for the sizes listed below.

## Tooling Inserts to allow "UP" forming

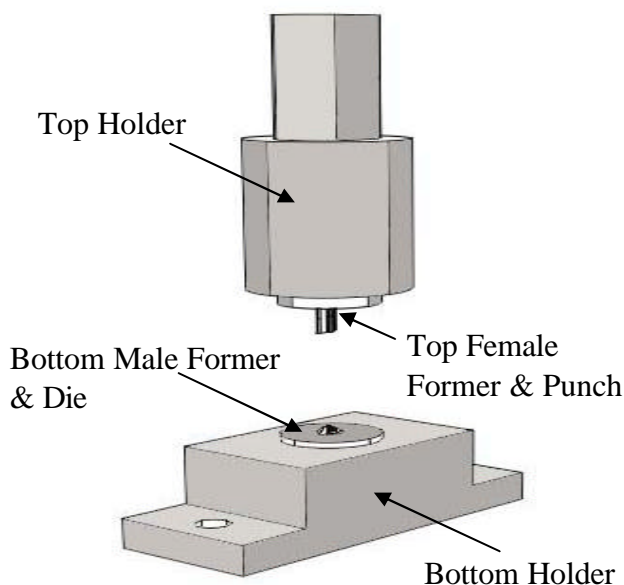
Material Thickness			Screw Diameter Ø	Dimension's			
Imperial	UK Wire	Metric		Ø"A"	"B"	"C"	Ø"D"
0.020/0.024	25	0.5/0.6	4,5,6	25	23	25	14.0
0.028/0.032	22/21	0.7/0.8	4,5,6				
0.036/0.040	20/19	0.9/1.0	4,5,6,8				
0.043/0.047	18	1.1/1.2	5,6,8				
0.051/0.055	17	1.3/1.4	6				
0.059/0.063	16	1.5/1.6	6,8	32	30	20.0	16.0
			10				
0.067/0.071	15	1.7/1.8	8				
0.074/0.078	14	1.9/2.0	10				

## Tooling Inserts to allow "DOWN" forming

Material Thickness			Screw Diameter Ø	Dimension's			
Imperial	UK Wire	Metric		Ø"A"	"B"	"C"	Ø"D"
0.020/0.024	25	0.5/0.6	4,5,6	25	23	25	14.0
0.028/0.032	22/21	0.7/0.8	4,5,6				
0.036/0.040	20/19	0.9/1.0	4,5,6,8				
0.043/0.047	18	1.1/1.2	6,8				

Above dimensions A, B, C and D are in millimetres.  
 General Tolerance ("A" & "B" +0 -0.05), ("C" & "D" +0.5, -0)  
 Designs may vary depending on machine type and manufacturer

### Tool Layout



1. This option is available for both "UP and DOWN" forming of the helix in the sheet material.
2. Forming inserts to be set on hardened support plates to eliminate the possibility of bedding down during production.
3. To reduce the possibility of material build-up beneath the bottom former/die insert and to achieve maximum support it is recommended that the hole clearance in the fitted hardened support plate be (Ø"D" -0, +2mm).
4. The drawing layout above does not show any stripping requirements which need to be evaluated with each machine type and product variations.
5. This option can also be used for prototyping and engineering feasibility prior to full scale production.

The information above is meant as a guide, High Torque Fastener Systems reserves the right to alter the information at any time.