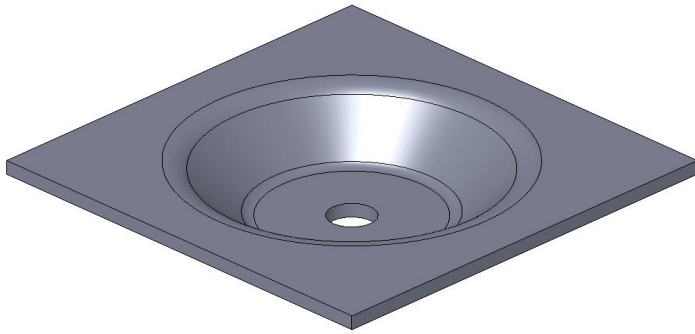


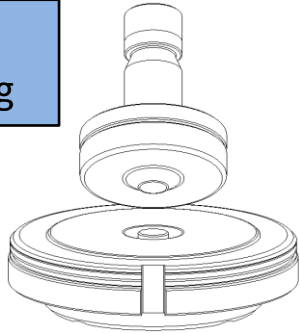
# Embossing - Round / Downwards Direction



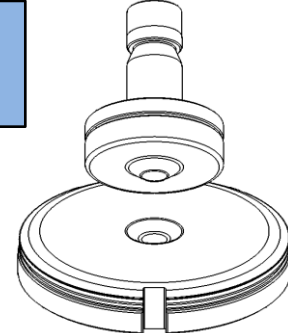
## Typical applications:

- Mounting locations
- Spacers and stand offs
- Architectural effects
- Depressions to captivate or hide components
- Drainage outlets

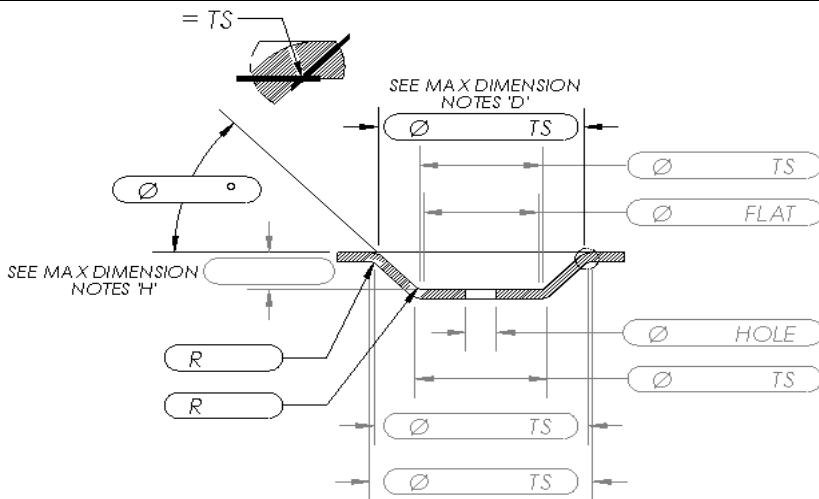
With Stripping



Without Stripping



Tooling Size	Price	Delivery	Cat N°	Tooling Size	Price	Delivery	Cat N°
Size 1		N/A		Size 1	€ 370	2 Days	25353
Size 2	€ 756	2 Days	25191	Size 2	€ 420	3 Days	25174



Company Name

Customer Number (If Known)

Contact Person

- Quote Only  
 Order Number (Specify)

Machine Type & Model

Material Type

- AL  MS  SS  
 Other \_\_\_\_\_

Sheet Thickness (S)

Lower Unit Stripping

- Yes  No

Other Forms Close By

- Yes (Add £50 & Inc Sketch)  No

Punch Style

- Classic  
 Alignment Ring Required  
 2·4·1  
 2·4·1 Holder Required

Tool ID Marking (Specify)

### Maximum Dimensions

for applications exceeding these sizes please contact us for alternative solutions

S = Sheet Thickness

	With Stripping		Without Stripping	
	Size 1	Size 2	Size 1	Size 2
D = Ø	N/A	Ø40	Ø15	Ø50
H =	N/A	4.5	6	
S =	N/A	2	5	

### Ordering Tips & Advice:-

- With stripping option recommended if angle > 55° so form can lift out of the lower unit without sticking
- **Important - Advise if any specific tolerances apply to any dimensions**
- Minimum recommended bend radii = Height ÷ Sheet Thickness x 0.8
- Keeping side wall angle 45° or less helps reduce the risk of form splitting
- Adding a hole in the centre can help minimise risk of forms splitting by reducing stretching around bend radius
- Lubricate the sheet prior to forming using Xcel™ spray helps material flow more easily
- Hole can be punched after forming if tight tolerance required - Ask for details
- Keep a minimum 4X sheet thickness between hole & radius to stop the top of form springing upwards