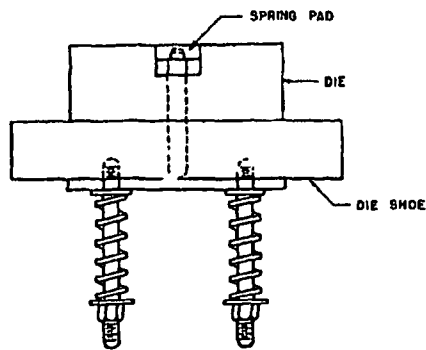
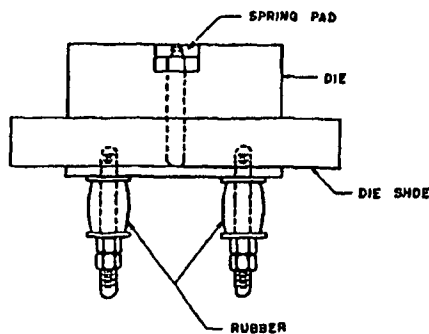


COLD FORMING OF METALS



DIE STRIPPER (SPRING)



DIE STRIPPER (RUBBER)

Fig 23-12. Two common methods for stripping parts from the die.

of the press bed to the bottom of the slide with the stroke down and adjustment up. In general, the shut height of a press is the maximum die height that can be accommodated for normal operation, taking the bolster into consideration.

Single-stroke attachment An arrangement that limits the travel of the slide to one complete cycle or stroke at each engagement of the clutch.

Slide (ram) The most common name for the main reciprocating member of a press. It is guided in the press frame, and the punch or upper die is fastened to it. It is also sometimes called the ram, the plunger, or, in the case of hydraulic presses,

the platen. The inner slide of a double-action press is called the plunger, and the outer slide is called the blank holder.

Slide, outer The slide mounted on the outside of an upright of a straight side trimming press, used for cutoff or other press operations.

Slide adjustment The distance the slide may be moved up or down to compensate for variations in the shut height of the dies.

Stop, automatic A device for positioning stock in a die or a mechanism which initiates the stopping action of a press after its complete cycle.

Stripper A device for removing the work (part or material) from the punch. The stripper may be stationary and attached to the die or may be spring or cam actuated and attached to the punch or the slide of the press (Fig 23-12).

Stripper plate A plate (solid or movable) used to strip the work piece or part from the punch. It may also guide the stock.

Stroke A press cycle is generally referred to as the "stroke." It is the maximum usable distance the ram or slide can move.

Subpress A type of die mounting holder (frequently cylindrical) in which the upper and lower members are incorporated in a self-contained unit so arranged as to always hold the die members in alignment. The subpress is a variation of the die set.

Throat The open space in a gap frame press in back of the slide center line.

Tongs A safety device for feeding objects to and removing them from a press.

Torque A twisting effort which produces or tends to produce rotation.

Trip or trip device An auxiliary mechanism, which may be manually, mechanically, or automatically operated, which starts, stops, or otherwise controls operation of the primary mechanism.

Point-of-operation guarding

Before a guard is built, the entire operation should be analyzed to determine how the processed piece can be best fed to the die, indexed or nested, and the piece and the scrap ejected in the safest and most efficient manner without the operator having to place his hands in the area between dies.