



The FPH-2-H Positive Stop Punch Holder consists of four main parts. These are (1) the body (large threaded cylinder at left), (2) the rod (hardened, threaded plunger with one smooth end and a groove machined around the threads, right side of the picture), (3) the rod locking nut, which fits around the rod and (4) the main lock nut, which fits around the body and holds it from turning in the press head.

In order to use the punch holder, turn off the position switch and turn on the pressure switch on the CHP-1 Hydro-press. Set the maximum pressure just slightly above the minimum required to do the job you need done, but in no case should the pressure exceed the die breaking pressure for your given size of die, as listed in the tables of the e-book Power Swaging.

Set the pressure reversing knob so that the ram will reverse just below the pressure setting on the drive pressure knob. Then, put the punch into the holder from the top, screw in the rod, and push the punch up by hand to find the point at which the punch will be stopped and held by the rod. Make sure the groove in the threaded rod is not visible above the top of the body! Swage a core, and adjust the position of the body to stop the ram and cause it to reverse. Adjust the rod so that the punch is held the correct distance into the die to give the desired core weight.

## FPH-2-H Positive Stop Punch Holder



The Corbin Positive Stop Punch Holder allows more precise weight control in the core swaging operation by providing a positive stop to the ram travel of the Hydro Press, rather than relying on the electronic sensors. There is a certain amount of drift and inertia in the hydraulic oil, plus a small delay between the time the position sensor "sees" the ram, and the time that the hydraulic valve shuts off oil flow and the oil actually stops moving. This tiny amount of drift can make a .001 to .005 inch difference in the exact stopping point of the ram, which in turn changes the weight slightly on a swaged core.

The Corbin Positive Stop Punch Holder is used to stall the Hydro-press ram against the die face, bringing the ram to a positive stop, and using the PRESSURE REVERSE controls to stop, hold, and reverse the ram travel. Punches are dropped into the holder from the top, by first removing the threaded rod. Thus, the positive stop punch holder is slower to change punches than the standard punch holder, but it provides a more accurate weight control.

The depth of punch insertion into the die is controlled by the position of the threaded rod. The punch can slide back until it contacts the end of the rod. Then it applies pressure to the core until the face of the die contacts the face of the punch holder, and stops the ram. There is a groove machined in the threaded rod, which indicates the maximum safe extension of the rod. Do not operate with this groove exposed, as it means that too few threads remain to hold the rod into the punch holder. The groove must be hidden within the body when pressure is applied, to avoid stripping threads.