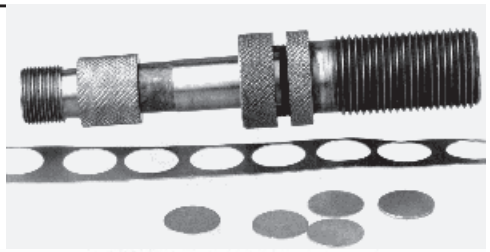
CORBIN Gas Check Maker Kit

GCM-1 ☐-R ☐-M ☐-H Size: _____



The Corbin Gas Check Maker Kit consists of a DISK CUTTING DIE and a CUPPING DIE, with their associated punches. The Disk Cutting Die screws into the press head from the bottom side, so that the slotted end faces DOWN and the threads face UP (just the opposite of most dies which fit the press head). The Disk Cutting Punch fits into the press ram.The die is set so that the tip of the punch is just past the top of the slot when the ram is fully extended. A strip of copper, .030-thick by 1-inch wide is placed in the slot, and the ram is moved up and down just far enough to punch out copper disks, which move up and out the top of the die.

The CUPPING DIE is then put into the press head, from the top side (normal way). The punch with spring and sliding guide assembly is put into the press ram. A copper disk is placed in the top of the guide assembly, and the ram is raised so that the spring pushes the guide against the die face, and then the punch continues upward, pulling the disk into the die from under the spring pressure against the guide. The die must be set so that the resulting gas check is clear of the tightest portion of the die hole before the next disk is pushed up into the die. Gas checks will stack in the die and come out the top, pushed by the next one in line. There should be no folds or wrinkles, but only perfectly drawn gas check cups. Use Corbin Swage Lube on the copper to reduce friction, galling and folding. Apply a light film to the strip with the fingers or a clean cotton pad.

1. Install the disk cutting die into the top of the press, from the bottom of the press head (screw the die UP into the head, the opposite of how most dies are installed). The slot will be at the bottom facing the ram. Wipe a film of Corbin Swage Lube on both sides of the copper strip.

2. Screw the disk cutting punch into the press ram. Insert a strip of .030 inch thick by 1 inch wide annealed copper strip in the slot of the die and raise the ram to punch a disk out of the copper strip. Lower the ram slightly, move the strip to the next position, and cut another disk. Eventually disks will begin coming out top of the die.

3. After you have made a quantity of disks, remove the first die and punch, and install the cupping die and punch. The cupping die is screwed down, from the top, so the knurled end is on top. ;The punch has a spring and a guide around it. The punch screws into the press ram.

4. Place a disk in the guide that is supported by a spring around the punch. Push the disk up into the die mouth with the punch, and it will be centered and pushed into a cup shape. Do not crush the spring! Load another disk and continue to push the disks up through the die, until cups come out the top.

Tip: A piece of plastic rain gutter channel can be used as a guide for the finished parts. Drill a 1 inch diameter hole near one end of a section of gutter, and hang the gutter over the top of the die by placing the gutter over the die, so that the gutter hangs down at an angle, secured by the hole around the die body. Leave enough length around the die so that cups will be caught on either side as they come out the die top. When pieces fall out of the die, they will land in this gutter and slide down into a box placed under the other end of the gutter. If pieces tend to jump or fly out the top from air pressure, you can use a paper clip or short length of wire bent in an L-shape and attached to the gutter, as a guide and stop over the top of the die. Leave enough room under the wire so that the disks will be able to come out of the die, strike the wire off center, and be directed to the downward slope of gutter as they fall.