



FPH-1-H Floating Punch Holder

The Corbin Floating Punch Holder is used to support and adjust the EXTERNAL punches for Corbin type -H die sets, in the CSP-2 Mega Mite, CSP-2H Hydro Jr., and CHP-1 Hydro-Press swaging presses.

The holder has a 1.5-inch by 12 turn/in thread. Each turn of the punch holder changes the insertion depth of the punch, and the length of core (in a core swage die) by exactly $1/12$ of an inch (.0833). A quarter turn adjusts the punch depth by 0.020833 inches (aprox. 20 thousandths).

A threaded hex bushing holds the external punch in the punch holder. Unscrew and remove the bushing, insert the punch, and then slip the bushing over the punch and screw it into the body of the punch holder by hand. Snug finger pressure is all that is desirable, allowing for slight movement of the punch if necessary to allow perfect alignment in the die bore. The punch holder is only used with swaging dies, not with bullet or jacket draw dies (which fit in the press head, replacing the punch holder, and have their own punches which screw into the 1-inch by 12 turn/in threaded ram of the press. The punch for a drawing die faces upward, pushing the component through the bottom of the die and out the top. The punch for a swaging die hangs down from the punch holder, facing the ram and the die screws into the ram, facing up. Swage dies eject the bullets from the top, the same direction in which they are inserted.



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