

CORBIN Disk Cutter Die for GCM-1-H Kit



This die and punch set is used in the Corbin CSP-2 and CHP-1 presses to punch a strip of copper tubing, normally 1-in wide by .030-in thick, into proper diameter disks which are then used to make gas checks.

The die screws into the press head from the bottom of the top plate, backward from most dies. The slot is oriented so that a strip of copper can be easily pulled through it from back to front.

The punch screws into the press ram. The short stroke is used on a multi-stroke hand press, because only a small amount of movement is needed. The punch rides within the bottom of the die, in an extended guide. This supports and aligns the punch so it will cleanly pass through the copper strip and into a sharp edged cutting hole on the other side of the slot.

If you have trouble fitting the punch into the space available between die and ram, try inserting the punch into the die, holding it in place, and screwing the die into the top of the press. Then slide the punch down and screw it into the ram while it is still engaged in the guide portion of the die.

Corbin Draw Lube is recommended for use on the copper strip. Swage Lube will also work in most applications.



CORBIN Cupping Die for GCM-1-H Kit



This die and punch set is used to draw a proper size disk of copper into a gas check. The die fits into the press head from the bottom, just the opposite of most dies. The large disk section faces the ram.

The punch with spring and disk guide/pressure pad assembly screws into the press ram. The same punch may also be used in a -S press with the appropriate size of die. It is equipped with 5/8-24 threads, and an adapter with a 5/8-24 to 1-in x 12 tpi thread, to fit the standard 1 x 12 ram thread of the larger Corbin presses (CSP-2 and CHP-1).

Lubricate the disk with Corbin Draw Lube, and place it in the cavity formed by the tip of the punch and the spring-loaded guide. Raise the ram until the guide engages and aligns with the die, pushing the disk into the die cavity. Continue raising the ram until the punch pushes the disk through the die, forming a cup.

The spring-loaded guide acts as a pressure pad, holding the edges of the disk firmly but with just enough force to allow the material to flow into the die hole without wrinkling or folding.