

MODEL 69 UNIVERSAL PEENING TOOL

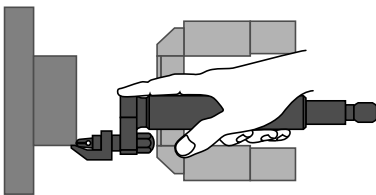
Peen Worn Punches & Dies Right Inside Your Trim Press

A must for anyone running punch and die or matched-metal trim tooling. Our remarkable peening hammer can be used to renew worn tooling without the time and cost associated with pulling the trim tool out of the press. Tooling Technology has pioneered the revolutionary design of the Model 69 Universal Peening Tool. This pneumatic tool can be introduced inside the Punch and Die assembly right through the Bolster Plate and Die Shoe where it can perform a perfect peening job.

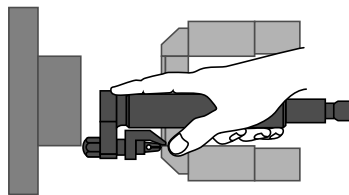
A worn punch or die can be back in operation within minutes! After one time of "peening" excessive clearance between worn punch and die, this proven tool will have paid for itself!



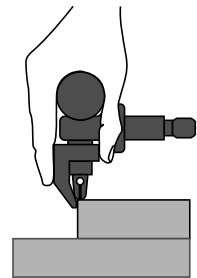
Mode I: Shown peening "soft" punch in trim press.



Mode II: Shown peening "soft" die in trim press.



Mode III: Shown peening with "bench" set up.



Fully Adaptable

The Model 69 Peening Tool can switch to three different modes in a matter of minutes (see drawings left). This tool can handle any peening job, dies, punches – on or off your machine.

Main Features

- Simple design allows relatively unskilled workers to perform a professional peening job
- Assures easy access to hard-to-reach equipment
- Unique tracer allows the hammer to follow the cutting edge of the Punch or the Die with unerring accuracy – internal corner radii as small as 1/2"
- Shaped and dimensioned to deliver 6,000 blows per minute with just the right force to cause steel to yield and flow in the precise form and direction
- Perfectly counter-balanced for vibration-free control and ease of use. A perfectly smooth appearance of the peened cutting edges is the result

PEENING HAMMER – OPERATING INSTRUCTIONS

Keep the “clean cut” appearance to your finished parts by keeping matched metal tools sharp (zero clearance).

The hammer can provide “inside”, vertical or horizontal peening while the tool is still mounted in the press. As you can see by the drawings shown here some limitations may apply, however anywhere a clenched fist will reach can be peened with this tool. Bench peening can also be done using the included handle.

Normally the punch and die sets will have the die side soft, 40-45 RC, the punch side hard, 6-65 RC. The soft side is peened and then sheared, as shown in the diagram below. It is not recommended to peen material above 52 RC as piston damage will occur.

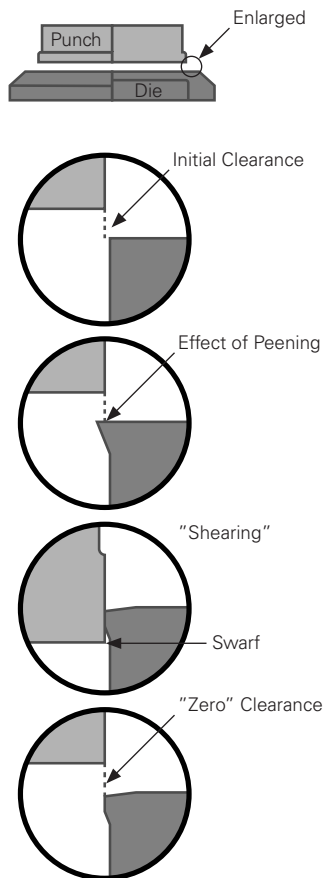
The piston makes about 6000 strokes a minute and will seize without sufficient lubrication. Apply a few drops of light oil inside the valve port prior to connecting the air hose. Only lubricated air should be used to operate the hammer.

The unique tracer design allows the hammer to follow a corner radius as small as 1/2". The weight of the entire tool is just right to counterbalance the mass inertia of the oscillating piston which results in a smooth even peened surface.

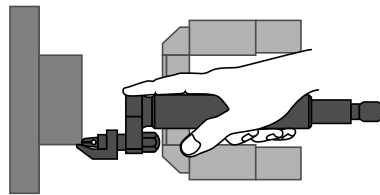
The tool comes with a handy carrying case and wrenches to accomplish any setup. This tool is truly “Heavy Duty”; however nothing lasts forever so we also supply a complete line of spare parts.

PEEN MATCHED METAL TOOLS INSIDE THE PRESS

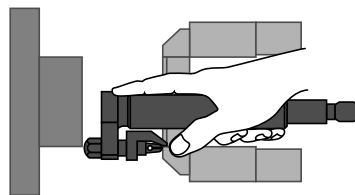
IMPORTANT: Lock Out machine before starting



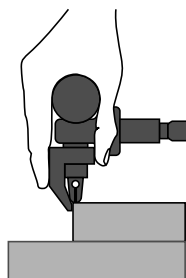
Mode I: Shown peening “soft” punch in trim press.



Mode II: Shown peening “soft” die in trim press.



Mode III: Shown peening with “bench” set up.



OPERATING PROCEDURES

- 1) Tracer guide to be in contact with die land at all times. Peening hammer head must be held firmly against top die surface.
- 2) Line pressure 80 to 100 psi.
- 3) Peen as necessary until metal appears from die, when punch is entered into die while in trim press. (See diagram at left)
- 4) Do this on one punch and die at a time.



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