

Setting Trap Die

These instructions will cover how to set a trap pin with the trap die when you do not have the die length. (Pilot Jobs / No Setup Sheet).

1. Use a pin to find the top of the extrusion inside the die, then place a mark on your pin. Make sure you're at the top of the angle of the extrusion when you do this.
2. Flip the part around 180 degrees. Using your samples or a measurement from your progression sheet, line up the extrusion of your part to the mark you put on your pin. Place another mark at the bottom of your part, $+.100$ to make sure you're not bottomed out.
3. Put a mark at the top of the head. The distance from the top of the pin to the mark you just made is how far the trap pin will be inside the die. Refer to picture #3.
4. Put the pin inside the die and run your die length in or out, until your top mark(Picture #4) is at the mouth of the die. You do not want to be bottomed out in the trap. You want a gap of about $.050$ -. $.100$ from the end of your part to the knockout pin.

