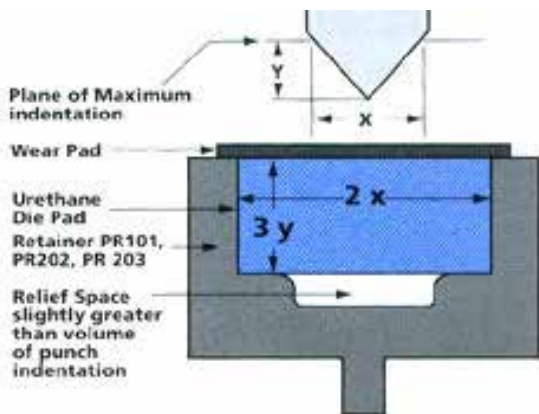


Die-thane die pads function as universal female dies. The same bottom die can be used with a variety of materials, gauges, and punches to form different shapes, radii & angles.

Product Features

- Wear pads are used to prevent cutting by the sheet metal or punch, thus prolonging pad life.



Die Pads

Available as squares and rectangles in several grades. Available in 48" lengths. Pads must be used in retainers for optimum life. Retainers must have relief below pads.

Die Blocks

Pads cut to 2" lengths are butted end to end in a retainer. Under load, these blocks function the same way as a single pad. Damaged portion of the pad can be re-placed economically.

Wafer Pads

4 sheets (1/4" or 1/2" thick) are stacked on top of each other. Ideal for light gauge metals (up to 16 Ga. M.S.) Wafers enable deeper penetration such as in U-forming.

Forming Pad Selection Guide

PPC DIE-THANE GRADE	DIE PAD SIZE (HEIGHT X WIDTH)		
	1 X 1 (INCH) METAL GAUGE	2 X 2 (INCH) METAL GAUGE	2 X 3 (INCH) METAL GAUGE
DT-25	Commonly used for V-forming up to 11 Ga. M.S.	Can be used for V-forming up to 3/16" thick M.S. Radius U-form up to 11 Ga. M.S. Flat bottom U-form up to 16Ga. M.S.	Used similar to 1" and 2" wide pads. Can be used for deeper penetrations. Larger radius bends and wider channel.
Most commonly used general purpose material. Recommended for most V-forming applications. Recommended Maximum Deflection: 25%			
DT-35	Used for lighter metals less than 20 Ga. M.S.) because of the higher deflections possible, this grade is commonly used for applications requiring deeper penetrations. Recommended Maximum Deflection: 35%		
DT-15	Used for applications requiring higher blank holding and forming pressures. Used for forming harder metals (i.e. 5.5.), sharper inside radii and heavier gauges Recommended Maximum Deflection: 15%		

Press Brake Tonnage Requirements

For forming 90° bend in M.s. with sharp V-Punch. Figures are only for guidance, in tons per ft. length.

PPC DIE-THANE GRADE	DIE PAD SIZE (HEIGHT X WIDTH)											
	1 X 1 (INCH) METAL GAUGE				2 X 2 (INCH) METAL GAUGE				2 X 3 (INCH) METAL GAUGE			
	20	16	14	11	20	16	14	11	20	16	14	11
DT-25	4	6	9	21	3	5	7	14	3	4	6	11
DT-15	6	8	12	25	5	7	11	21	5	7	9	15
DT-35	2	4	7	15	3	4	7	13	3	4	6	10