



FPH-1-S
Floating Punch Holder,
Type -S

The Corbin Floating Punch Holder fits the 7/8-14 threaded head of the CSP-1 S-Press. It is used to adjust the position of the external punch with all Corbin -S type swage dies. The punch position is set relative to the face of the internal punch, which is held at a fixed position within the die, at the top position of the ram stroke.

The FPH-1-S punch holder comes with a lock ring and hex bushing to retain the punch. One is provided with each CSP-1 press. Others can be purchased as spares if desired.

The position of the external punch determines the insertion of the punch into the die, which in turn controls the amount of pressure generated against the swaged material.

Punches made for earlier Corbin presses also fit the FPH-1-S, provided they are used with an optional spacer bushing, which is placed over the body of the punch. Current punches do not use this bushing. External punches with tip diameters larger than .375-inches use a captive head and hex bushing, instead of the separate hex bushing that comes with the Floating Punch Holder. This is because the larger calibers would not permit the hex bushing to slip over the end of the punch. Smaller caliber punches use the hex bushing that comes with the punch holder.

Tighten the hex bushing by hand to hold the punch. Do not grasp the punch holder with pliers, as this will damage it. Hand tight is tight enough. The FPH-1HEX bushing is available as a spare or replacement item.



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