



Keyways and Notches

Lately we seem to have customers inquiring about the use of keyways and notches. As an introduction for new customers and a review for our customers already using these features, let's discuss the purpose of furnishing keyways and notches on your shaped punches and dies.

The use of a keyway on a shaped punch is crucial to proper alignment. A keyway is a groove or slot cut into the head of the punch; which when used with a piece of "keystock" will align the punch properly with the stem of the machine, thus keeping the punch from rotating during the punching operation. Each machine takes a different keyway and consequently a different piece of keystock. When ordering a shaped punch and die, make sure to let your CPD customer service rep know the type of machine you are using. Also, it is very important to use a piece of "soft" or unhardened keystock to avoid punch breakage.

Ordering shaped dies with notches will keep the die aligned properly with the punch. A setscrew on most ironworker die blocks will hold the die into place. A notch, sometimes referred to as locator or flat, will allow this setscrew to properly keep the die from rotating or pulling out of the die holder. Ultimately, the use of keyways and notches on shaped punches and dies will extend the life of the punch and die.

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