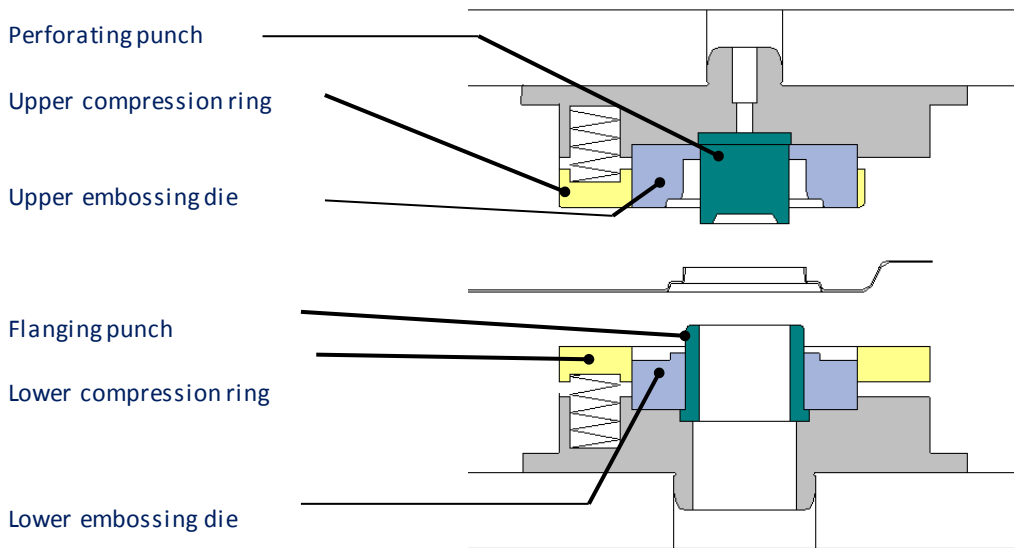


TRI-SURE® FLANGE INSERTION

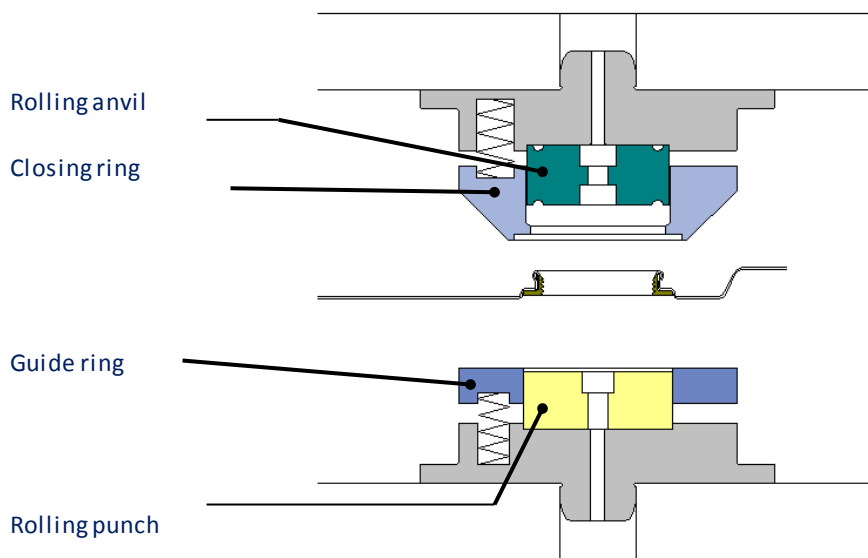
The insertion of the Tri-Sure flanges consists of two separate operations

Tri-Sure Insertion 1st operation



In the **1st operation** die a cylindrical blank is punched out of the end- material with the perforating punch and the flanging punch. By forcing the end material over the flanging punch a cylindrical collar is formed. The upper and lower embossing dies form the octagonal shape in the end material.

Tri-Sure Insertion 2nd operation



In the **2nd operation** die the flange is placed on the rolling punch and is located by the guide ring. The closing ring pushes the end material over the flange and thereby compresses the two flange washers. The cylindrical part of the flange is curled over the collar made in the 1st operation by means of the rolling anvil.