



CRATER MAKER DIMPLE DIES

THESE DIES ARE CNC MACHINED IN THE USA FROM 4140 ALLOY STEEL, THEN HEAT TREATED FOR HARDNESS AND TUMBLED FOR A SMOOTH FINISH. THESE DIES ARE OPTIMIZED FOR 22, 20, AND 18 GAUGE MILD STEEL. THEY ARE NOT CLEARANCED FOR ANYTHING THICKER THAN 18GA MILD STEEL .045".

PRE STRETCHING OF THE AREA TO BE DIMPLED MAY BE NECESSARY.

AFTER YOU DECIDE WHERE TO PLACE YOUR DIMPLES, DRILL OR PUNCH A 1/4" HOLE. SANDWICH THE PANEL WITH ONE HALF OF THE DIE ON EACH SIDE, (ANTI SEIZE OR OTHER LUBRICATION IS RECOMMENDED ON DIES AND THREADS) THEN USE EITHER AN IMPACT GUN, HYDRAULIC PRESS, OR LARGE BENCH VICE TO COMPRESS THE DIES. MAKE SURE THAT IF YOU USE A PRESS OR A VICE NOT TO PRESS ON THE BOLT. TO PREVENT THIS, USE SOMETHING WITH A HOLE OR GAP UNDER THE LOWER DIE BIG ENOUGH FOR THE NUT TO PASS THROUGH SUCH AS A PIECE OF TUBE.

USE A BRASS, LEAD, OR RUBBER Mallet TO REMOVE THE DIES IF THEY STICK.

SOME DISTORTION OF YOUR PANEL IS TO BE EXPECTED. THIS IS DUE TO THE NATURE OF THIS PARTICULAR SHAPE AND CAN BE CORRECTED EASILY WITH A KICK SHRINKER , OXYACETYLENE TORCH, PLANISHING HAMMER OR OTHER PLANISHING METHODS. . SOME SURFACE BLENDING MAY BE REQUIRED AFTER DIMPLES ARE INSTALLED.

THANK YOU FOR CHOOSING HAMMERFAB FOR YOUR SPECIALTY FABRICATION ACCESSORIES.

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