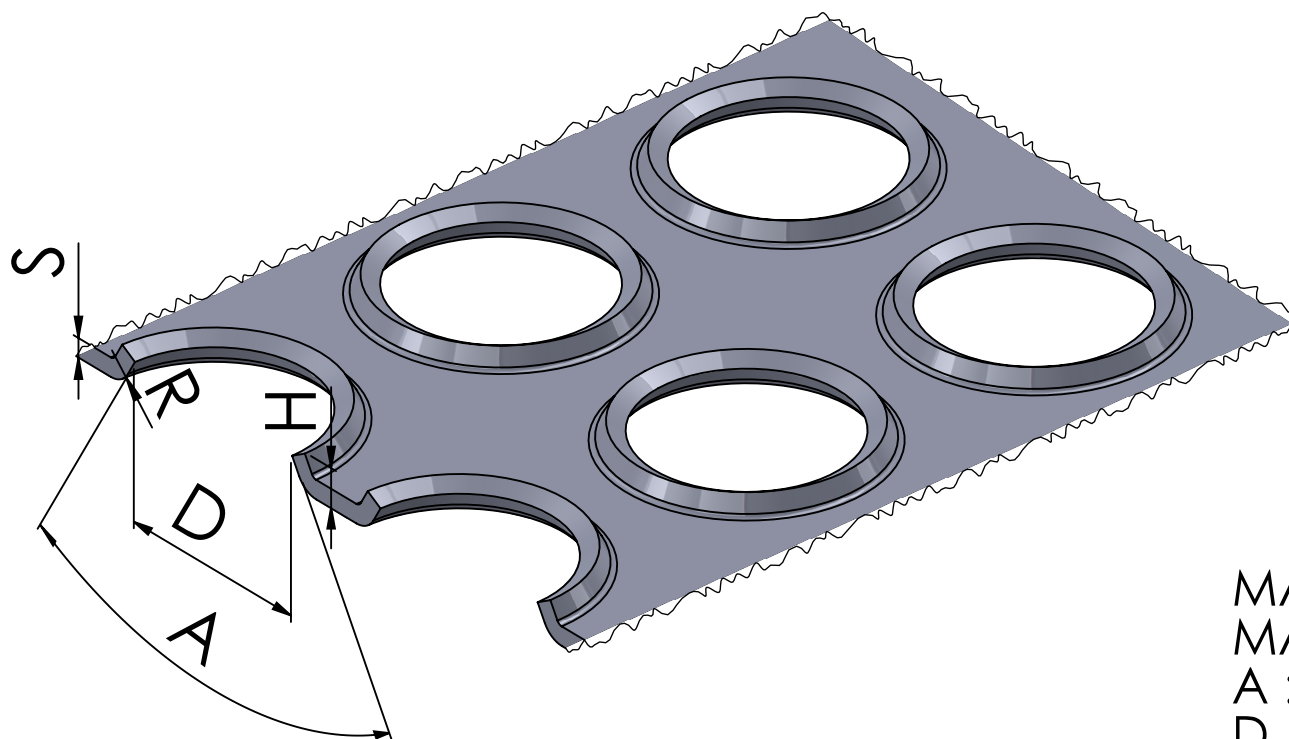


COUNTER SINK UP FORMING AFTER PRE PIERCE



MACHINE MODEL:
MATERIAL:
A :
D :
H :
R :
S :