



CATALOG





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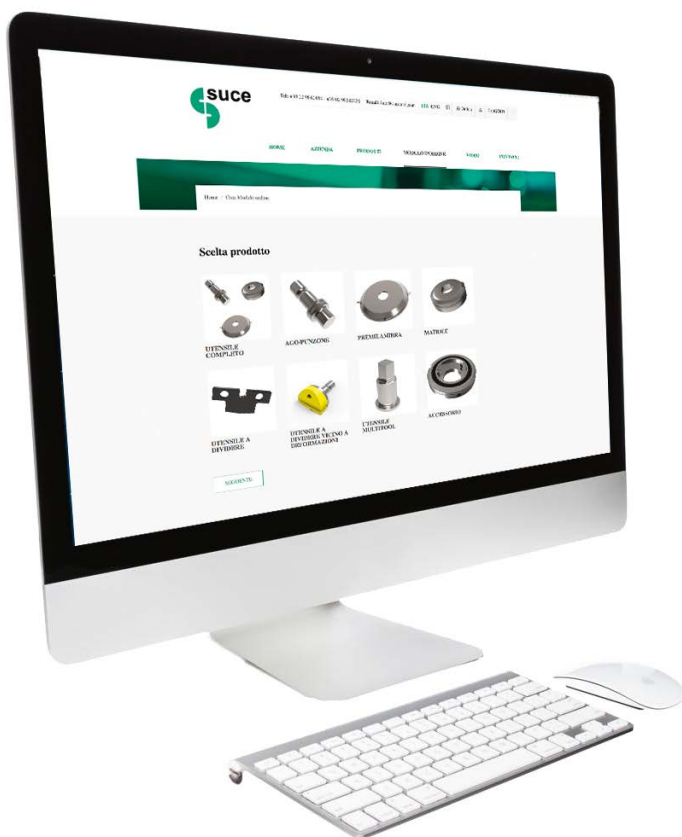
Inside the catalogue you'll find this symbol, that indicates the possibility of ordering our product online!



SHOP NOW WITH SUCE ECOMMERCE



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HIGH DEFINITION IMAGES

Detailed pictures of products in order to avoid choice errors.



SECURE PAYMENTS

&
BEST PRICES



FAST DELIVERY



INSTANT & DIRECT COMMUNICATION WITH SUPPLIER



SALES CONDITION

Availability of products in the catalogue is subject to change. Our sales department will check the availability of products before confirming your order.

Delivery:

The order confirmation provides an estimate of the date on which the order will be dispatched from the Suce warehouse. In the case of orders requiring an advanced payment we will provide an estimated delivery date as soon as we receive confirmation of payment.

Minimum invoice value: 100 €

Payment:

Payment terms are detailed in the order confirmation. Our finance department may charge interest on payment received more than 10 working days after the payment dead line.

Freight: according to Incoterms rules and are detailed in order confirmation

Cancellation, returns and complains:

Any claims will be considered if made within 2 weeks of receiving the goods. The return of materials must be authorized and managed by Suce. A return charge of 20% of the product's value will be applied to cover the costs of return.

Cancellations can be made free of charge up to 24h after order confirmation. Cancellations made after 24h could be subject to a charge.

Credit:

Customers with a credit account should be aware of their credit limit. Our finance department will provide instructions in the event that your order exceeds your credit limit.



WHY SUCE?



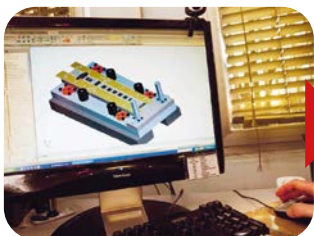
The use of double grinding wheel plants allows for a very low roughness coefficient.



The machine tooling dept. includes automatic lines of turning with lead bars and milling machines.



10,000 items available in stock divided into 20 different categories



Thanks to our project department, with 3D CAD stations, we are able to design both standard and special tools.



No shape limitation thanks to EDM technology.



The use of the best steel available on the market by SUCE tools ensures a high standard quality and a long tool life.





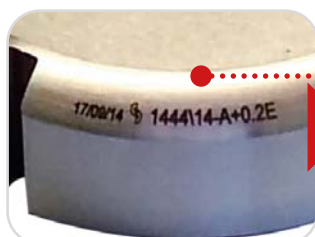
No shape limitation thanks to Wire EDM technology.



Wire EDM load-unload cell.



In warehouse: ready for delivery.

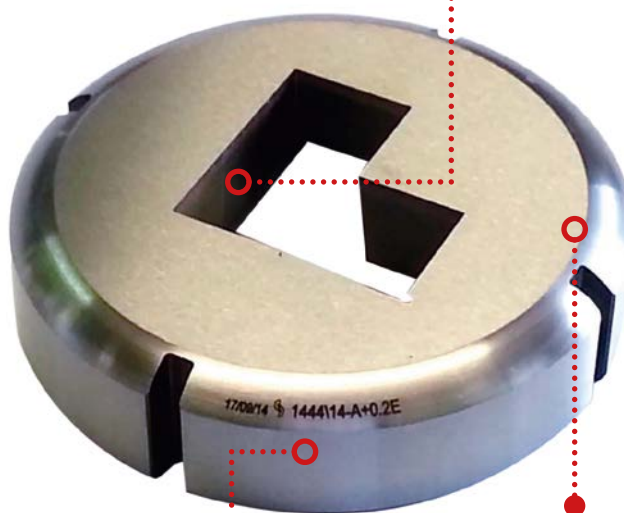


SUCE special ID number.



Manufacturing execution system.

Different lock-slug systems available



Tool testing: fault free.

DIE CLEARANCE

Die clearance is the total space between the die and the punch.

A correct clearance between the punch and the die ensures normal wear of the tool and punching without defects such as: burrs caused by excessive clearance and premature wearing of the tool and increased punching force in the case of clearance being too small.

MATERIAL				
Thickness mm	Mild steel 16-20%	Stainless steel 18-24%	Aluminum 12-16%	Copper 10-14%
0.5 – 0.6	0.08-0.1	0.1- 0.12	0.06 – 0.08	0.05 – 0.06
0.8	0.14 – 0.16	0.15 – 0.2	0.1 – 0.14	0.08 – 0.1
1	0.16 – 0.2	0.18 – 0.24	0.12 – 0.16	0.1 – 0.14
1.2	0.2 – 0.24	0.24 – 0.3	0.15 – 0.2	0.12 – 0.15
1.5	0.25 – 0.3	0.27 – 0.35	0.18 – 0.24	0.15 – 0.2
2	0.34 – 0.4	0.36 – 0.45	0.24 – 0.3	0.2 – 0.25
2.5	0.45 – 0.5	0.45 – 0.55	0.32 – 0.35	0.25 – 0.3
3	0.5 – 0.6	0.6 – 0.7	0.35 -0.45	0.3 – 0.4
4	0.65 – 0.8	0.7 – 0.95	0.45 – 0.6	0.4 – 0.55
5	0.85 – 1	0.9 – 1.15	0.6 – 0.8	0.55 – 0.65
6	0.95 – 1.2	1.1 – 1.4	0.75 – 0.95	0.7 – 0.85

In case of blanking mild steel and stainless steel, clearance is 15% of material thickness.

In case of blanking aluminum and copper clearance is 10% of material thickness.



System E :3 cuts with different angles ensures the locking of the slug.



Lock slug **AS** best option when thickness > 3 mm.

DIES LOCK SLUG

SUCE lock slug dies eliminate slug pulling. Slug pulling occurs when the slug returns to the top of the sheet during the stripping portion of the punching cycle. Because of this the slug comes between the punch and the top of the sheet on the next cycle, causing damage to the part and the tooling. How to avoid this problem?

The SUCE NO-SLUG has been designed with a reduction point of the shape below the surface so the slug cannot return once it passes through this point.

Once the slug is separated from the punch, it is free to fall through the die. Slug pulling is eliminated.

This solution isn't suggested with slug exhaust system machines ; AS lock slug design with protrusions is best solution with thickness more than 3 mm, minimum cl for AS system is 0.15 mm.

SUCE Lock slug E and A system is a standard for all Suce dies, AS is on request, reduced land is a standard for thick turret dies rt80x5 rt80x6 rt110x5 rt110x6.



lock slug **AS**
best opt.
th>3 mm



lock slug **E**
thick turret
B,C,D,E



lock slug **A**
thick turret **A**



straight and
conic
blank die



reduced land
slitting die



conic
trumpf style

TOOLS SHARPENING

Before starting, make sure that punch and die cutting edge are in perfect condition. Accurate maintenance of the tools guarantees a normal wearing and the result of punching will be without residual burr and defects. Regular sharpening of the 0.1 mm punch and 0.2 mm die guarantees a constant life time of tooling.

It is preferable that grinding operation is made with tangential grinding machine with adequate cooling in order to avoid tool tempering; after grinding it is necessary to demagnetize the tools with an appropriate demagnetizer. If a urethane ejectors is applied, restore the initial hole depth in such a way that the ejector can be compressed.

PUNCHING FORCE

Before starting ensure that punching force doesn't exceed the capacity of punching machine. In order to calculate the punching force in kg, use the following formula:

Perimeter of the shape (mm) x thickness (mm) x 4/5 x shear strength *

* mild steel 40 - 50 kg/mm² stainless steel 60 - 70 kg/mm² aluminium 20 - 25 kg/mm²

A sharpening other than the flat one reduces both punching stress and punching noise. Therefore to ascertain the true punching force, multiply the pressure calculated using the above formula by the **sharpening factor**:

Sharpening height	Thickness (mm)					
mm	1 - 1.5	2	3	4	5	6
1	0.75	0.9	1	1	1	1
1.5*	0.5	0.6	0.7	0.95	1	1
3**	0.5	0.5	0.5	0.6	0.7	0.75

* standard shear height thick turret style

** standard shear height Trumpf style



Double valley
Cod 3P



Best option when shape is long, but susceptible to breakage



Roof top
Cod V



Best option when punching force is high, punching surface 75%



Inverted roof top
Cod VR



Best option for nibbling but inverted stresses could cause breakage



Whisper
Cod W



Recommended only for blanking (turret machine)

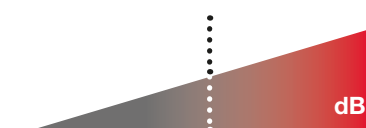


Four ways
Cod 4P



Recommended for round and square

**PUNCHES ARE FLAT, ABOVE SHEAR ARE AVAILABLE UPON REQUEST;
EACH TYPE OF SHARPENING REDUCES NOISE UP TO 50%**





COATING

PROBUS

The TiCN coating (Titanium Carbonitride) comes from an evolutionary study of the precursor TiN (Titanium Nitride), inheriting the already appreciated qualities and also some of its features. Indeed, thanks to the introduction of the C (Carbon) within the layer, it was possible to obtain a structure that provides a hardness greater than about 50% compared to that of TiN. In consequence to this, the TiCN coating ensures a higher wear resistance while retaining excellent toughness which makes it ideal when applied to tools for interrupted cutting. A further improvement of the TiCN was achieved by developing a "multilayer" (multi-layer) structure composed of several hundreds of layers that give better control of structural stress within the coating.



STRUCTURE	Micro Hardness (HV 0.05)	Friction coefficient (100 cr6)	Thickness (micron)	Deposition temperature (°C)	Max temperature (max°C)	Colour
Multilayer	3.500	0.5	2 - 4	350 - 480	350	Blu/Grey

GEMINUS

The double coating is obtained by overlaying the traditional Probus with Movic self-lubricating coating. The Probus coating comes from an evolutionary study of the precursor TiN, inheriting the already appreciated qualities and improving some of its features. In fact, thanks to the introduction of the Carbon (C) within the layer, it was possible to obtain a structure that has a hardness greater than 50% compared to that of TiN.

In consequence to this, the Probus coating ensures a higher wear resistance.

A further improvement of the Probus was achieved by developing a "multilayer" (multi-layer) composed of several hundreds of different layers that give better control of structural stress within the coating. MOVIC is a self-lubricating and anti-adhesive coating based on MoS₂ (Molybdenum), which is produced by PVD sputtering Magnetron technology. MOVIC has been developed in the aerospace to find alternatives to traditional oils (eg oil, grease) when their use is not permitted and it has shown excellent tribological features that made it very interesting for a variety of new applications.

STRUCTURE	Micro Hardness (HV 0.05)	Friction coefficient (100 cr6)	Thickness (micron)	Deposition temperature (°C)	Max temperature (max°C)	Colour
Single layer	-	<0.1	1	<150	-	GREY

BASIC COMPOSITION	Coating Structure	Microhardness (HV 0.05)	Coefficient of friction against (100 cr6)	µm thickness (microns)	Deposition Temperature (°C)	Max Temperature of use (max ° C)	Colour
Titanium carbonitride	Multilayer	3.500	0,5	1- 3	350 - 480	350	Pink

LEVATUS

DLC is an innovative carbon-based coating with wide spectrum of application which allows you to deal with problems related to abrasion, to chemical attack and sliding.

The low deposition temperature, the hardness and the low coefficient of friction make it of extreme interest. It is applied on finished parts while maintaining the state of the surface finishing.

The DLC is deposited by the PA-CVD (Plasma Assisted – Chemical Vapour Deposition) technology which allows to maintain low temperature of depositing and at the same time ensures an excellent adhesion.



BASIC COMPOSITION	Deposition Technology	Microhardness (HV 0.05)	Coefficient of friction against 100 Cr 6	µm thickness (microns)	Deposition Temperature (°C)	Max Temperature of use (max ° C)	Colour
a-C:H sp ² -sp ³	PA-CVD	1.500 - 3.000	0,05 - 0,1	0,5 - 3	250	350	Black

COATING	COPPER	ALUMINUM	MILD STEEL	GALVANIZED STEEL	STAINLESS STEEL
PROBUS	X	X	X	XX	XXX
GEMINUS	XX	XX	X	XXX	XX
LEVATUS	XXX	XXX	X	X	X

NEEDLESS	RECOMMENDED	HIGHLY RECOMMENDED
X	XX	XXX





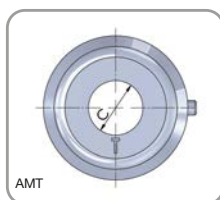
THICK TURRET

GENERAL RULES THICK TURRET TOOLING

In order to optimize the use of tooling we would recommend the following basic guidelines:

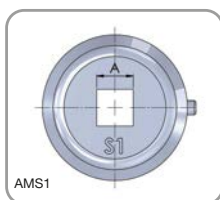
- a)** the punching surface must not be lower than 60% of the used punch surface, isn't recommended to punch the edge of the sheet less than 2.5 times material thickness;
- b)** in case of nibbling, minimum feed must be $0,5 \times$ thickness, smaller round punch with thickness 1 mm is 4 mm, smaller round punch with thickness 2 mm is 6 mm, smaller round punch with thickness 3 mm is 8 mm;
- c)** before exceeding tons capability calculate punching force with formula on page 5;
- d)** the tool dimension must not be lower than the material thickness and the shorter side must be at least 5% of the longest side;
- e)** the advantage of the technical improvements of some models of dies punching penetration should be at least 2.5 mm;
- f)** slitting tools must be appropriately sharpened;
- g)** the use of the steels commonly called High Speed Steel for our punches allows the punching of any steel. However, in order to considerably increase the punching effectiveness and reduce cold welds, apply some type of coating, see pag. 6 and use oil lubricant on sheet surface;
- h)** ensure that tooling cutting edges are without seizing or cold welding material; if any, remove them with a diamond file;
- i)** radius on punch corner is 0.25 mm, constant radius on the corner of the dies ensures proper wear and a uniform burr;

THICK TURRET ROUND AND STANDARD



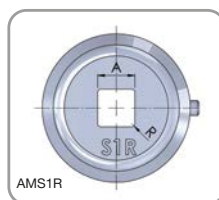
AMS1

C:



AMS2

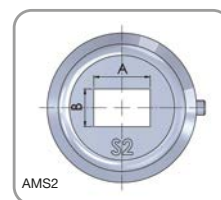
A:



AMS3

A:

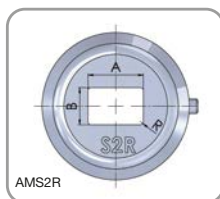
R:



AMS4

A:

B:

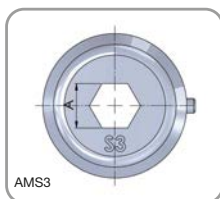


AMS5

A:

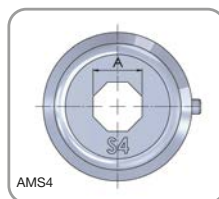
B:

R:



AMS6

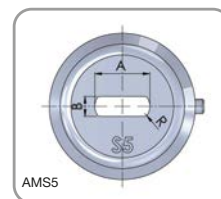
A:



AMS7

A:

B:

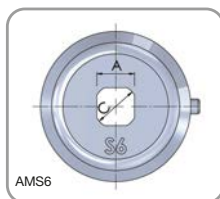


AMS8

A:

B:

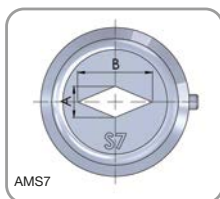
R:



AMS9

A:

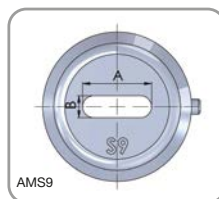
C:



AMS10

A:

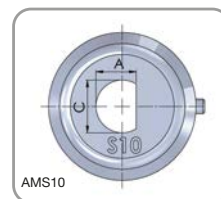
B:



AMS11

A:

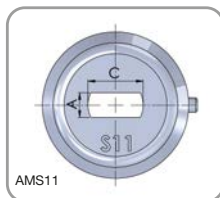
B:



AMS12

A:

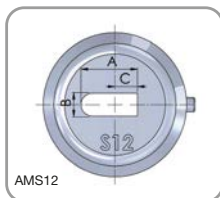
C:



AMS13

A:

C:



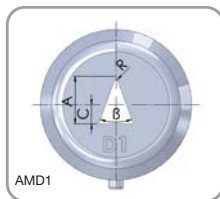
AMS14

A:

B:

C:

SPECIAL 1



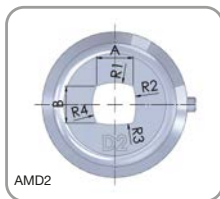
AMD1

A:

B:

C:

R:



AMD2

A:

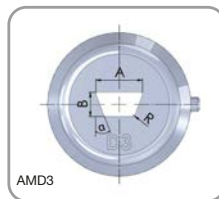
B:

R1:

R2:

R3:

R4:



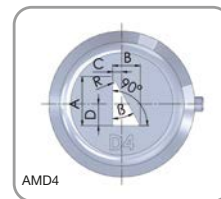
AMD3

A:

B:

α:

R:



AMD4

A:

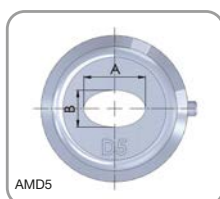
B:

C:

D:

B:

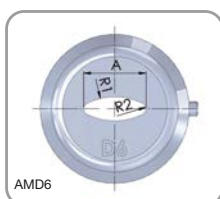
R:



AMD5

A:

B:

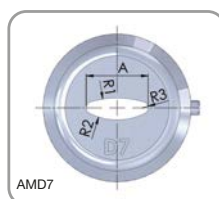


AMD6

A:

R1:

R2:



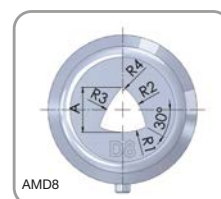
AMD7

A:

R1:

R2:

R3:



AMD8

A:

R1:

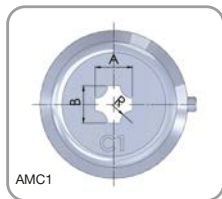
R2:

R3:

R4:

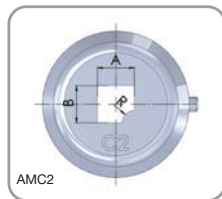
A AND B PIN DIE REFERENCE

SPECIAL 0



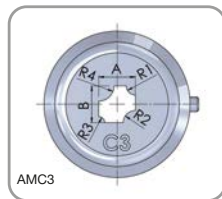
AMC1

A: B:
R:



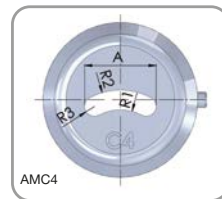
AMC2

A: B:
R:



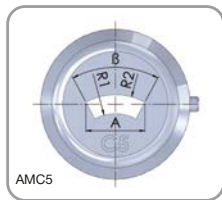
AMC3

A: B:
R1: R2:
R3: R4:



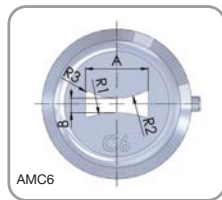
AMC4

A: R1:
R2: R3:



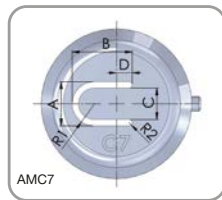
AMC5

A: B:
R1: R2:



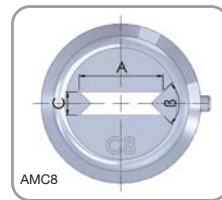
AMC6

A: B:
R1: R2:
R3:



AMC7

A: B:
C: D:
R1: R2:



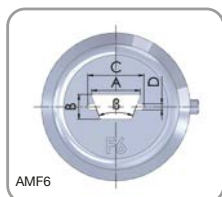
AMC8

A: B:
C:

Note:

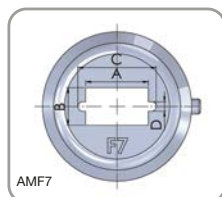
R<3 price is SPECIAL 2

SPECIAL 2



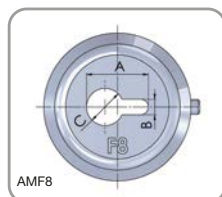
AMF6

A: B:
C: D:
B:



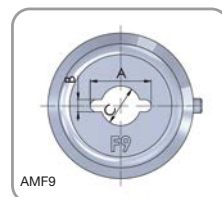
AMF7

A: B:
C: D:



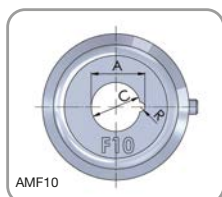
AMF8

A: B:
C:



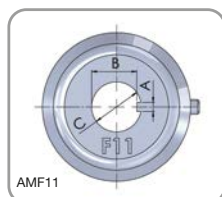
AMF9

A: B:
C:



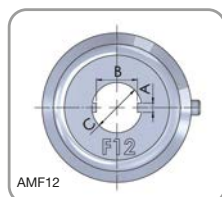
AMF10

A: C:
R:



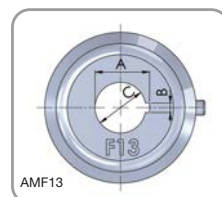
AMF11

A: B:
C:



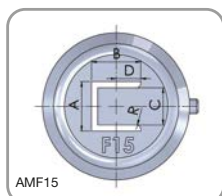
AMF12

A: B:
C:



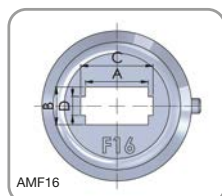
AMF13

A: B:
C:



AMF15

A: B:
C: D:
R:



AMF16

A: B:
C: D:

A AND B PIN DIE REFERENCE



MULTITOOL Mate style 20 - 8 & 24 - 8 mm

Data: Max size 8.00 mm

Regrinding life: Punch 1 mm, Die 0.5 mm

Regrinding life*: Punch 2 mm *with Euromac MTE10



ITEM	PUNCH	€	STRIPPER	€	DIE	€
ROUND	AMA0PSM2006T		AMA0PLM20T		AMA0MAM2001T	
STANDARD	AMA0PSM2006S		AMA0PLM20S		AMA0MAM2001S	
SPECIAL 0	AMA0PSM2006C		AMA0PLM20D		AMA0MAM2001D	
SPECIAL 1	AMA0PSM2006D		AMA0PLM20D		AMA0MAM2001D	
SPECIAL 2	AMA0PSM2006F		AMA0PLM20D		AMA0MAM2001D	
Coating	PROBUS		GEMINUS		LEVATUS	

MULTITOOL Mate style 10 - 16 mm

Data: Max size 16.00 mm

Regrinding life: Punch 1 mm, Die 0.5 mm



ITEM	PUNCH	€	STRIPPER	€	DIE	€
ROUND	AMA0PUM1606T		AMA0PLM16T		AMA0MAM1601T	
STANDARD	AMA0PUM1606S		AMA0PLM16S		AMA0MAM1601S	
SPECIAL 0	AMA0PUM1606C		AMA0PLM16D		AMA0MAM1601D	
SPECIAL 1	AMA0PUM1606D		AMA0PLM16D		AMA0MAM1601D	
SPECIAL 2	AMA0PUM1606F		AMA0PLM16D		AMA0MAM1601D	
Coating	PROBUS		GEMINUS		LEVATUS	

MULTITOOL Mate style 6 - 8 - 24 mm

Data: Max size 24.00 mm

Regrinding life: Punch 1 mm, Die 0.5 mm

Regrinding life*: Punch 2 mm, Die 1.5 mm

*with Euromac MTE10



ITEM	PUNCH	€	STRIPPER	€	DIE	€	HEAVY DUTY DIE thickness > 3 mm	€
ROUND	AMA0PUM2406T		AMA0PLM24T		AMA0MAM2401T		—	
STANDARD	AMA0PUM2406S		AMA0PLM24S		AMA0MAM24B1S		AMA0MAM24TP1S	
SPECIAL 0	AMA0PUM2406C		AMA0PLM24D		AMA0MAM24B1D		AMA0MAM24TP1D	
SPECIAL 1	AMA0PUM2406D		AMA0PLM24D		AMA0MAM24B1D		AMA0MAM24TP1D	
SPECIAL 2	AMA0PUM2406F		AMA0PLM24D		AMA0MAM24B1D		AMA0MAM24TP1D	
Coating	PROBUS		GEMINUS		LEVATUS			

DIE SHIMS

ITEM	SHIM Mt 24 - 8 mm	€
0.1 mm	AMA0MAM20SP10	
0.2 mm	AMA0MAM20SP20	
0.5 mm	AMA0MAM20SP60	

ITEM	SHIM - XMTE6, Mt 6/8 - 24 mm n. 3 0.3 mm - n. 3 0.5 mm - n. 3 1 mm	€
	AMA0SETSPMA24	



EUROMAC MULTITOOL XMTE6

Mate style XMTE 6 24 mm, Data: Regrinding life: Punch 2.6 mm, *Adjustable 9 mm
Die 1.5 mm, Max size 24.00 mm, Max size die is 24.4 mm



ITEM	PUNCH	€	PUNCH ADJUSTABLE	€	STRIPPER	€	DIE	€	HEAVY DUTY DIE thickness > 3 mm	€
ROUND	AMA0PUM24C6T		AMA0PUM24D6T		AMA0PLM24CT		AMA0MAM2401T		—	
STANDARD	AMA0PUM24C6S		AMA0PUM24D6S		AMA0PLM24CS		AMA0MAM24B1S		AMA0MAM24TP1S	
SPECIAL 0	AMA0PUM24C6C		AMA0PUM24D6C		AMA0PLM24CD		AMA0MAM24B1D		AMA0MAM24TP1D	
SPECIAL 1	AMA0PUM24C6D		AMA0PUM24D6D		AMA0PLM24CD		AMA0MAM24B1D		AMA0MAM24TP1D	
SPECIAL 2	AMA0PUM24C6F		AMA0PUM24D6F		AMA0PLM24CD		AMA0MAM24B1D		AMA0MAM24TP1D	

ITEM	2.PUNCH MAX DIM 10.4	€	PUNCH HEAD	€
	AMB105PST006T		AMA0TEM24	

Coating	PROBUS PUNCH INSERT		GEMINUS PUNCH INSERT		PROBUS		GEMINUS		LEVATUS	
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EUROMAC MULTITOOL XMTE12.7

Mate style XMTE 12.7 mm, Data: Regrinding life: Punch 2.6 mm Punch adjustable* 9 mm
Die 1.5 mm, Max size 12.70 mm, Max size die is 13.2 mm, *only keyed station

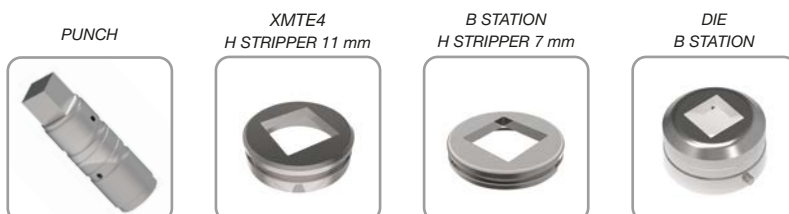


ITEM	PUNCH	€	PUNCH ADJUSTABLE	€	PUNCH HEAD	€	STRIPPER	€	DIE	€
ROUND	AMA0PUM1006T		AMA0PUM10B6T		AMA0TEM10		AMA0PLM10T		AMA0MAM1001T	
STANDARD	AMA0PUM1006S		AMA0PUM10B6S		AMA0TEM10		AMA0PLM10S		AMA0MAM1001S	
SPECIAL 0	AMA0PUM1006C		AMA0PUM10B6C		AMA0TEM10		AMA0PLM10D		AMA0MAM1001D	
SPECIAL 1	AMA0PUM1006D		AMA0PUM10B6D		AMA0TEM10		AMA0PLM10D		AMA0MAM1001D	
SPECIAL 2	AMA0PUM1006F		AMA0PUM10B6F		AMA0TEM10		AMA0PLM10D		AMA0MAM1001D	

Coating	PROBUS		GEMINUS		LEVATUS	
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EUROMAC MULTITOOL XMTE4

Mate style XMTE4 4B 31.7 mm
Data:
Regrinding life: Punch 8 mm
Die 2.5 mm
Max size 31.70 mm
Max tonnage: 22 tons



ITEM	PUNCH	€	STRIPPER XMTE4	€	STRIPPER B STATION	€	DIE B STATION	€
ROUND	AMB1IPLNL6T		AMB1PLM4T		AMB1PLWTT		AMB1MAT001T	
STANDARD	AMB1IPLNL6S		AMB1PLM4S		AMB1PLWTS		AMB1MAT001S	
SPECIAL 0	AMB1IPLNL6C		AMB1PLM4D		AMB1PLWTD		AMB1MAT001D	
SPECIAL 1	AMB1IPLNL6D		AMB1PLM4D		AMB1PLWTD		AMB1MAT001D	
SPECIAL 2	AMB1IPLNL6F		AMB1PLM4D		AMB1PLWTD		AMB1MAT001D	

Coating	PROBUS		GEMINUS		LEVATUS	
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PRIMA POWER MULTITOOL

Wilson style MT20Ri, MT20i 8 mm
Data: Max size 8.00 mm

PUNCH WITH PIN



STRIPPER



DIE



ITEM	PUNCH WITH PIN	€	STRIPPER	€	DIE	€
ROUND	AMA0PUM2006T		AMA0PLM20T		AMA0MAM2001T	
STANDARD	AMA0PUM2006S		AMA0PLM20S		AMA0MAM2001S	
SPECIAL 0	AMA0PUM2006C		AMA0PLM20D		AMA0MAM2001D	
SPECIAL 1	AMA0PUM2006D		AMA0PLM20D		AMA0MAM2001D	
SPECIAL 2	AMA0PUM2006F		AMA0PLM20D		AMA0MAM2001D	

Coating	PROBUS		GEMINUS		LEVATUS	
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PRIMA POWER MULTITOOL

Wilson style MT8Ri, MT8i 16 mm
Data: Max size 16.00 mm

PUNCH WITH PIN



PUNCH



STRIPPER



DIE



ITEM	PUNCH WITH PIN	€	PUNCH	€	STRIPPER	€	DIE	€
ROUND	AMA0PUM8W6T		AMA0PUM806T		AMA0PLM8T		AMA0MAM801T	
STANDARD	AMA0PUM8W6S		AMA0PUM806S		AMA0PLM8S		AMA0MAM801S	
SPECIAL 0	AMA0PUM8W6C		AMA0PUM806C		AMA0PLM8D		AMA0MAM801D	
SPECIAL 1	AMA0PUM8W6D		AMA0PUM806D		AMA0PLM8D		AMA0MAM801D	
SPECIAL 2	AMA0PUM8W6F		AMA0PUM806F		AMA0PLM8D		AMA0MAM801D	

Coating	PROBUS		GEMINUS		LEVATUS	
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PRIMA POWER MULTITOOL

Wilson style MT3Ri 31.7 mm
Data: Max size 31.7 mm

PUNCH



STRIPPER



DIE



ITEM	PUNCH	€	STRIPPER	€	DIE	€
ROUND	AMB1IPWT06T		AMA0PLMT3T		AMB1MAMT306T	
STANDARD	AMB1IPWT06S		AMA0PLMT3S		AMB1MAMT306S	
SPECIAL 0	AMB1IPWT06C		AMA0PLMT3D		AMB1MAMT306D	
SPECIAL 1	AMB1IPWT06D		AMA0PLMT3D		AMB1MAMT306D	
SPECIAL 2	AMB1IPWT06F		AMA0PLMT3D		AMB1MAMT306D	

Coating	PROBUS		GEMINUS		LEVATUS	
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PRIMA POWER MULTITOOL MT8Ri3 - 16

Data:
Max size 16.00 mm
Max thickness 4 ms, 3 ss

PUNCH



STRIPPER



DIE



ITEM	PUNCH	€	STRIPPER	€	DIE	€
ROUND	AMMTPU8RI06T		AMMTPLM8T		AMA0MAM1601T	
STANDARD	AMMTPU8RI06S		AMMTPLM8S		AMA0MAM1601S	
SPECIAL 0	AMMTPU8RI06C		AMMTPLM8D		AMA0MAM1601D	
SPECIAL 1	AMMTPU8RI06D		AMMTPLM8D		AMA0MAM1601D	
SPECIAL 2	AMMTPU8RI06F		AMMTPLM8D		AMA0MAM1601D	

Coating	PROBUS		GEMINUS		LEVATUS	
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DURMA MULTITOOL

Data:

6/24 Max size 24.00 mm

Max size die is 24.80 mm

10/18 Max size 18.00 mm

Max size die is 18.80 mm

PUNCH



STRIPPER



DIE



10/18	PUNCH	€	STRIPPER	€	DIE	€
ROUND	AMA0PUM18B6T		AMA0PLM18BT		AMA0MAM1801T	
STANDARD	AMA0PUM18B6S		AMA0PLM18BS		AMA0MAM18B1S	
SPECIAL 0	AMA0PUM18B6C		AMA0PLM18BD		AMA0MAM18B1D	
SPECIAL 1	AMA0PUM18B6D		AMA0PLM18BD		AMA0MAM18B1D	
SPECIAL 2	AMA0PUM18B6F		AMA0PLM18BD		AMA0MAM18B1D	

Coating	PROBUS		GEMINUS		LEVATUS	
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6/24	PUNCH	€	STRIPPER	€	DIE	€
ROUND	AMA0PUM24B6T		AMA0PLM24BT		AMA0MAM2401T	
STANDARD	AMA0PUM24B6S		AMA0PLM24BS		AMA0MAM24B1S	
SPECIAL 0	AMA0PUM24B6C		AMA0PLM24BD		AMA0MAM24B1D	
SPECIAL 1	AMA0PUM24B6D		AMA0PLM24BD		AMA0MAM24B1D	
SPECIAL 2	AMA0PUM24B6F		AMA0PLM24BD		AMA0MAM24B1D	

Coating	PROBUS		GEMINUS		LEVATUS	
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MULTITOOL 4/B ROTATING

DESCRIPTION

- 4 TOOLS MAX Ø31,7 mm
- ULTRA B STATION PUNCHES
- STANDARD INTERCHANGEABLE STRIPPER
- STANDARD B STATION DIES
- FULLY LUBRICATED SYSTEM
- MAXIMUM THICKNESS:
 - 6 MM MILD STEEL
 - 4 MM STAINLESS STEEL

HOWEVER, FOR THE LONGEST LIFE OF THE MULTITOOL WE SUGGEST TO WORK WITH MAXIMUM THICKNESS 3 mm

- DESIGN TO PREVENT SIGNS ON THE SHEET METAL CAUSED BY THE PUNCHES
- QUICK STRIPPER CHANGING
- STANDARD D STATION DIMENSION



ITEM	COMPLETE MULTITOOL 4/B ROTATING	€
	AMMT4B	



MULTITOOL 6/24 ROTATING

DESCRIPTION

- 6 TOOLS MAX Ø24 MM
- FULLY GUIDED TOOLS
- OCTAGONAL STRIPPERS THAT ALLOW TO ROTATE THE STRIPPER AND PUNCHES ON 8 DIFFERENT POSITIONS
- FULLY LUBRICATED SYSTEM
- MAXIMUM TONNAGE: 15 TONS
- DESIGN TO PREVENT SIGNS ON THE SHEET METAL CAUSED BY THE PUNCHES
- QUICK STRIPPER CHANGING
- QUICK PUNCH CHANGING. NO KEYS ARE NECESSARY.
- STANDARD D STATION DIMENSION



ITEM	COMPLETE MULTITOOL 6/24 ROTATING	€
	AMMT624	



MULTITOOL 10/18 ROTATING

DESCRIPTION

- 10 TOOLS MAX Ø18 MM
- FULLY GUIDED TOOLS
- OCTAGONAL STRIPPERS THAT ALLOW TO ROTATE THE STRIPPER AND PUNCHES ON 8 DIFFERENT POSITIONS
- FULLY LUBRICATED SYSTEM
- MAXIMUM TONNAGE: 12 TONS
- DESIGN TO PREVENT SIGNS ON THE SHEET METAL CAUSED BY THE PUNCHES
- QUICK STRIPPER CHANGING
- QUICK PUNCH CHANGING. NO KEYS ARE NECESSARY.
- STANDARD D STATION DIMENSION

ITEM	COMPLETE MULTITOOL 10/18 ROTATING	€
	AMMT1018	



MULTITOOL 6/24 ROTATING

DESCRIPTION

- 6 TOOLS MAX Ø24 MM
- FULLY GUIDED TOOLS
- OCTAGONAL STRIPPERS THAT ALLOW TO ROTATE THE STRIPPER AND PUNCHES ON 8 DIFFERENT POSITIONS
- FULLY LUBRICATED SYSTEM
- MAXIMUM TONNAGE: 15 TONS
- DESIGN TO PREVENT SIGNS ON THE SHEET METAL CAUSED BY THE PUNCHES
- QUICK STRIPPER CHANGING
- QUICK PUNCH CHANGING. NO KEYS ARE NECESSARY.
- STANDARD D STATION DIMENSION

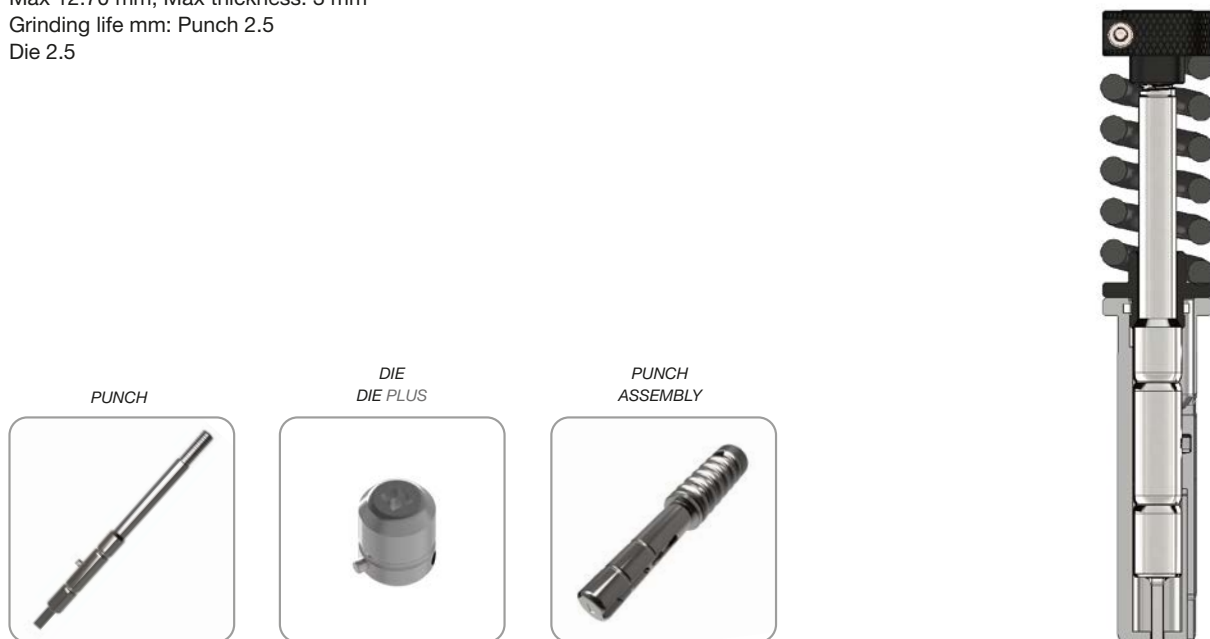
ITEM	COMPLETE MULTITOOL 6/24 EUROMAC	€
	AMMT624 ERHP	





A STATION STANDARD, CLOSED GUIDE

Max 12.70 mm, Max thickness: 3 mm
Grinding life mm: Punch 2.5
Die 2.5



ITEM	PUNCH	€	PUNCH ASSEMBLY	€	DIE	€
ROUND	AMA1PUT006T		AMA1PATE06T		AMA1MAT001T	
STANDARD	AMA1PUT006S		AMA1PATE06_*		AMA1MAT001S	
SPECIAL 0	AMA1PUT006C		AMA1PATE06C		AMA1MAT001D	
SPECIAL 1	AMA1PUT006D		AMA1PATE06D		AMA1MAT001D	
SPECIAL 2	AMA1PUT006F		AMA1PATE06F		AMA1MAT001D	

* S = Standard 0°-90°; Q = Square 0°-135°

Coating	PROBUS	☐	GEMINUS	☐	LEVATUS	☐
		☒		☒		☒

FITTING



PUNCH HEAD	€	SPRING	€	RETAINER	€	CLOSED STANDARD GUIDE	€
AMA1TECO		AMA1MSCO		AMA1RIC0		ROUND - AMA1GUTOT	
						SHAPE 0° - 90° - AMA1GUTOS	
						SQUARE 0° - 135° - AMA1GUTOQ	
						SPC 0° - 90° - AMA1GUTOD	



A STATION OIL LUBR. CLOSED GUIDE

Max 12.70 mm, Max thickness: 3 mm

Grinding life mm: Std Punch 2.5, Long life Punch 6

Die 2.5



ITEM	PUNCH	€	PUNCH ASSEMBLY	€	PUNCH ASSEMBLY LONG LIFE	€	DIE	€
ROUND	AMA1PUAB06T		AMA1PATAE6T		AMA1PALAE6T		AMA1MAT001T	
STANDARD	AMA1PUAB06S		AMA1PATAE6 *		AMA1PALAE6 **		AMA1MAT001S	
SPECIAL 0	AMA1PUAB06C		AMA1PATAE6C		AMA1PALAE6C		AMA1MAT001D	
SPECIAL 1	AMA1PUAB06D		AMA1PATAE6D		AMA1PALAE6D		AMA1MAT001D	
SPECIAL 2	AMA1PUAB06F		AMA1PATAE6F		AMA1PALAE6F		AMA1MAT001D	

* $\underline{S}$ = Standard 0°-90°; $\underline{Q}$ = Square 0°-135°

Coating	PROBUS	☐	GEMINUS	☐	LEVATUS	☐
		☒		☒		☒

FITTING



PUNCH HEAD	€	SPRING	€	RETAINER		PUNCH DRIVER max thickness 3 mm	€	CLOSED STANDARD GUIDE	€
AMA1TECO		AMA1MSCO		AMA1RICO		AMA1LLGIO		ROUND AMA1GUAIT	
								SHAPE 0° - 90° - AMA1GUAIS	
								SQUARE 0° - 135° - AMA1GUAIQ	
								SPC 0° - 90° - AMA1GUAID	



A STATION SMART 3

Max 12.70 mm,
 Max thickness: 4 mm mild steel, 3 mm stainless steel
 Stripper land 4 mm
 Thickness 1 mm : 10 mm , Thickness 2 mm : 9 mm
 Thickness 3 mm : 8 mm, Thickness 4 mm : 7 mm
 Grinding die life 2.5 mm



PUNCH



STRIPPER



DIE



ITEM	PUNCH	€	STRIPPER	€	DIE	€
ROUND	AMA1IPTM06T		AMA1PLTUT		AMA1MAT001T	
STANDARD	AMA1IPTM06S		AMA1PLTUS		AMA1MAT001S	
SPECIAL 0	AMA1IPTM06C		AMA1PLTUD		AMA1MAT001D	
SPECIAL 1	AMA1IPTM06D		AMA1PLTUD		AMA1MAT001D	
SPECIAL 2	AMA1IPTM06F		AMA1PLTUD		AMA1MAT001D	

Coating	PROBUS		GEMINUS	Ø		Ø
				Ø		Ø

FITTING

PUNCH DRIVER



OPEN SMART3 GUIDE



ITEM	SMART3 PUNCH DRIVER (max thickness 4 mm)	€	OPEN SMART3 GUIDE	€
	AMA1LLNM2		ONLY ROUND AMA1GUT3T	
			ROUND & SHAPE 0° - 90° - 225° AMA1GUT3S	



A STATION SMART 3, STANDARD AND A.B. LUBRIFICATION STYLE

Max 12.70 mm,

Max thickness: 4 mm mild steel, 3 mm stainless steel

Grinding life mm: Punch 7, Die 2.5



PUNCH



A. B. LUBR PUNCH



STRIPPER



DIE



ITEM	PUNCH	€	PUNCH A. B. LUBR	€	STRIPPER	€	DIE	€
ROUND	AMA1PUT006TS*		AMA1PUAB06TS*		AMA1PLTUT		AMA1MAT001T	
STANDARD	AMA1PUT006S		AMA1PUAB06S		AMA1PLTUS		AMA1MAT001S	
SPECIAL 0	AMA1PUT006C		AMA1PUAB06C		AMA1PLTUD		AMA1MAT001D	
SPECIAL 1	AMA1PUT006D		AMA1PUAB06D		AMA1PLTUD		AMA1MAT001D	
SPECIAL 2	AMA1PUT006F		AMA1PUAB06F		AMA1PLTUD		AMA1MAT001D	

* The adjustable length system requires that diameter punches are also equipped with a locating pin

Coating	PROBUS	Ø	GEMINUS	Ø	LEVATUS	Ø
		Ø		Ø		Ø

FITTING

PUNCH DRIVER



OPEN SMART3 GUIDE



ITEM	SMART3 PUNCH DRIVER (max thickness 4 mm)	€	OPEN SMART3 GUIDE	€
	AMA1LLGIO2		ONLY ROUND AMA1GUT3T	
			ROUND & SHAPE 0° - 90° - 225° AMA1GUT3S	



B STATION ECONO LINE, CLOSED GUIDE

Max 31.70 mm, Max thickness: 4-6 mm
Grinding life mm: Punch 2.5, Die 2.5



DIE



PUNCH

PUNCH
ASSEMBLY

ITEM	PUNCH	€	PUNCH ASSEMBLY	€	DIE	€
ROUND	AMB1PUT006T		AMB1PATE06T		AMB1MAT001T	
STANDARD	AMB1PUT006S		AMB1PATE06S		AMB1MAT001S	
SPECIAL 0	AMB1PUT006C		AMB1PATE06C		AMB1MAT001D	
SPECIAL 1	AMB1PUT006D		AMB1PATE06D		AMB1MAT001D	
SPECIAL 2	AMB1PUT006F		AMB1PATE06F		AMB1MAT001D	

Coating	PROBUS		GEMINUS		LEVATUS	
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FITTING

SPANNER WRENCH



PUNCH HEAD



SPRING



RETAINER



CLOSED GUIDE



SPANNER WRENCH	€	PUNCH HEAD	€	SPRING	€	REVERSIBLE RETAINER Included OR	€	CLOSED GUIDE	€
AMABSW		AMB1TECO		AMB1MSCO		AMB1RICO		RD AMB1GUTOT	
								STD 0° - 90° - 135° AMB1GUT4S	
								SPECIAL 0 - 1 - 2 0° - 90° - 135° AMB1GUT4D	



B STATION A.B LUBRICATION STYLE, CLOSED GUIDE

Max 31.70 mm, Max thickness: 4-6 mm

Grinding life mm: Standard Punch 4, Long life Punch 8

Die 2.5

PUNCH



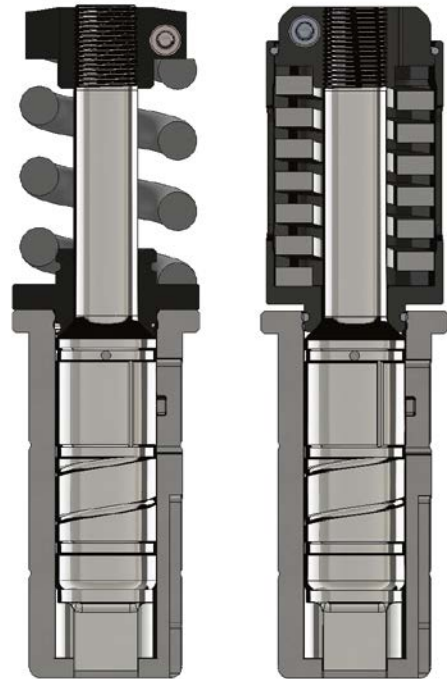
PUNCH
ASSEMBLY



PUNCH
ASSEMBLY LONG LIFE



DIE



ITEM	PUNCH	€	PUNCH ASSEMBLY	€	PUNCH ASSEMBLY LONG LIFE	€	DIE	€
ROUND	AMB1PUAB06T		AMB1PATAE6T		AMB1PALAE6T		AMB1MAT001T	
STANDARD	AMB1PUAB06S		AMB1PATAE6S		AMB1PALAE6S		AMB1MAT001S	
SPECIAL 0	AMB1PUAB06C		AMB1PATAE6C		AMB1PALAE6C		AMB1MAT001D	
SPECIAL 1	AMB1PUAB06D		AMB1PATAE6D		AMB1PALAE6D		AMB1MAT001D	
SPECIAL 2	AMB1PUAB06F		AMB1PATAE6F		AMB1PALAE6F		AMB1MAT001D	

Coating	PROBUS		GEMINUS		LEVATUS	
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FITTING

SPANNER WRENCH



PUNCH HEAD



SPRING



RETAINER



PUNCH DRIVER



CLOSED GUIDE



SPANNER WRENCH	€	PUNCH HEAD	€	SPRING	€	REVERSIBLE RETAINER Included OR	€	PUNCH DRIVER max thickness 6 mm	€	CLOSED GUIDE	€
AMABSW		AMB1TECO		AMB1MSCO		AMB1RITO		AMB1LLGIO		AMB1GUAIT	
										STD 0° - 90° AMB1GUAIS	
										SQ 0° - 135° AMB1GUAIQ	
										SPECIAL 0-1-2 - 0° - 90° AMB1GUAID	



B STATION A.B LUBRICATION STYLE, OPEN GUIDE

Max 31.70 mm, Max thickness: 4-6 mm

Grinding life mm: Standard Punch 4, Long life Punch 8

Die 2.5



PUNCH



PUNCH
ASSEMBLY



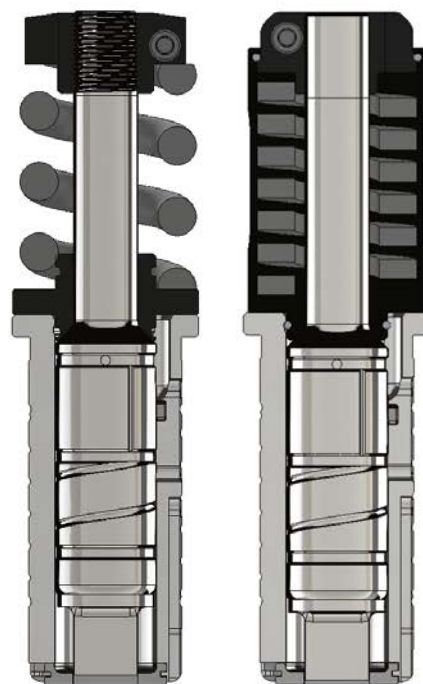
PUNCH
ASSEMBLY LONG LIFE



STRIPPER



DIE



ITEM	PUNCH	€	PUNCH ASSEMBLY	€	PUNCH ASSEMBLY LONG LIFE	€	STRIPPER	€	DIE	€
ROUND	AMB1PUAB06T		AMB1PATAB6T		AMB1PALLB6T		AMB1PLABT		AMB1MAT001T	
STANDARD	AMB1PUAB06S		AMB1PATAB6S		AMB1PALLB6S		AMB1PLABS		AMB1MAT001S	
SPECIAL 0	AMB1PUAB06C		AMB1PATAB6C		AMB1PALLB6C		AMB1PLABD		AMB1MAT001D	
SPECIAL 1	AMB1PUAB06D		AMB1PATAB6D		AMB1PALLB6D		AMB1PLABD		AMB1MAT001D	
SPECIAL 2	AMB1PUAB06F		AMB1PATAB6F		AMB1PALLB6F		AMB1PLABD		AMB1MAT001D	
Coating		PROBUS		GEMINUS		LEVATUS				

FITTING

SPANNER WRENCH



PUNCH HEAD



SPRING



RETAINER



PUNCH DRIVER



OPEN STANDARD GUIDE



SPANNER WRENCH	€	PUNCH HEAD	€	SPRING	€	REVERSIBLE RETAINER Included OR	€	PUNCH DRIVER max thickness 6 mm	€	OPEN STANDARD GUIDE	€
AMABSW		AMB1TERA		AMB1MST0		AMB1RIT0		AMB1LLGIO		ONLY ROUND AMB1GUABT	
										SHAPE 0° - 90° - 135° AMB1GUABS	

**B STATION SMART 3 - OPEN GUIDE**

Max 31.70 mm, Max thickness: 6 mm
 Grinding punch life with straight before rad 22 mm,
 Stripper land 4 mm
 Thickness 1 mm : 10 mm , Thickness 2 mm : 9 mm
 Thickness 3 mm : 8 mm, Thickness 4 mm : 7 mm
 Thickness 5 mm : 6 mm
 Grinding die life 2.5 mm



PUNCH



STRIPPER



ITEM	PUNCH	€	STRIPPER	€
ROUND	AMB1IPLNL6T		AMB1PLWTT	
STANDARD	AMB1IPLNL6S		AMB1PLWTS	
SPECIAL 0	AMB1IPLNL6C		AMB1PLWTD	
SPECIAL 1	AMB1IPLNL6D		AMB1PLWTD	
SPECIAL 2	AMB1IPLNL6F		AMB1PLWTD	

Coating	PROBUS		GEMINUS		LEVATUS	
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DIE

DIE

ITEM	DIE	€
ROUND	AMB1MAT001T	
STANDARD	AMB1MAT001S	
SPECIAL 0, 1, 2	AMB1MAT001D	

**B STATION PUNCH INSERT D10,5**

Max thickness 4 mm - Max size 10.4 mm

ITEM	HSS PUNCH	€
ROUND	AMB105PST006T	

Coating	PROBUS		GEMINUS		LEVATUS	
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PUNCH

**FITTING**

ITEM	PUNCH DRIVER (max thickness 6 mm)	€	OPEN GUIDE	€	OPEN GUIDE	€
	AMB1LLTM		ONLY ROUND AMB1GUTMT		RD & SHAPE 0° - 90° - 225° AMB1GUTMS	

PUNCH DRIVER



SHAPED GUIDE





B STATION SMART 3 STANDARD AND A. B. LUBRIFICATION STYLE

Max 31.70 mm, Max thickness: 6 mm
 Grinding punch life with straight before rad 22 mm,
 Stripper land 4 mm
 Thickness 1 mm : 10 mm , Thickness 2 mm : 9 mm
 Thickness 3 mm : 8 mm, Thickness 4 mm : 7 mm
 Thickness 5 mm : 6 mm
 Grinding die life 2.5 mm



PUNCH



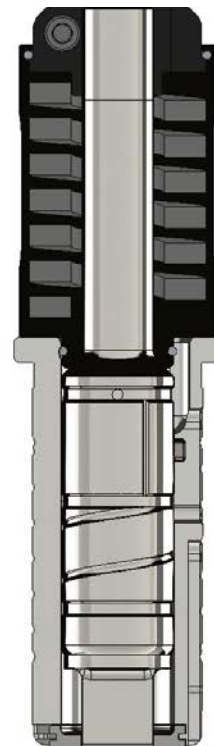
PUNCH A. B. LUBR



STRIPPER



DIE



ITEM	PUNCH	€	PUNCH A. B. LUBR	€	STRIPPER	€	DIE	€
ROUND	AMB1PUT006TS*		AMB1PUAB06TS*		AMB1PLWTT		AMB1MAT001T	
STANDARD	AMB1PUT006S		AMB1PUAB06S		AMB1PLWTS		AMB1MAT001S	
SPECIAL 0	AMB1PUT006C		AMB1PUAB06C		AMB1PLWTD		AMB1MAT001D	
SPECIAL 1	AMB1PUT006D		AMB1PUAB06D		AMB1PLWTD		AMB1MAT001D	
SPECIAL 2	AMB1PUT006F		AMB1PUAB06F		AMB1PLWTD		AMB1MAT001D	

* The adjustable lenght system requires that diameter punches are also equipped with a locating pin

Coating	PROBUS		GEMINUS		LEVATUS	
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ITEM	PUNCH DRIVER (max thickness 6 mm)	€	OPEN SMART3 GUIDE	€	OPEN SMART3 GUIDE	€
	AMB1LLGIO2		ONLY ROUND AMB1GUTMT		RD & SHAPE 0° - 90° - 225° AMB1GUTMS	

PUNCH DRIVER



SHAPED GUIDE





PUNCH AMADA OLD STYLE AND MATE STYLE

Data: Max size
C 50.8 mm
D 88.9 mm
E 114.3 mm

C STATION PUNCH



D STATION PUNCH



E STATION PUNCH



ITEM	C STATION PUNCH	€	D STATION PUNCH	€	E STATION PUNCH	€
ROUND	AMC1PUT006T		AMD1PUT006T		AME1PUT006T	
STANDARD	AMC1PUT006S		AMD1PUT006S		AME1PUT006S	
SPECIAL 0	AMC1PUT006C		AMD1PUT006C		AME1PUT006C	
SPECIAL 1	AMC1PUT006D		AMD1PUT006D		AME1PUT006D	
SPECIAL 2	AMC1PUT006F		AMD1PUT006F		AME1PUT006F	
Coating	C PROBUS		D PROBUS		E PROBUS	
	C GEMINUS		D GEMINUS		E GEMINUS	
	C LEVATUS		D LEVATUS		E LEVATUS	

STRIPPER AMADA OLD STYLE

C STATION



D STATION



E STATION



ITEM	C STATION	€	D STATION	€	E STATION	€
ROUND	AMC1PLT0T		AMD1PLT0T		AME1PLT0T	
STANDARD	AMC1PLT0S		AMD1PLT0S		AME1PLT0S	
SPECIAL 0 -1- 2	AMC1PLT0D		AMD1PLT0D		AME1PLT0D	

STRIPPER MATE ULTRATECH STYLE

C STATION



D STATION



ITEM	C STATION	€	D STATION	€
ROUND	AMC1PLTMT		AMD1PLTMT	
STANDARD	AMC1PLTMS		AMD1PLTMS	
SPECIAL 0 -1- 2	AMC1PLTMD		AMD1PLTMD	



PUNCH AMADA STYLE LUBRICATED, THREAD M12

Data: Max size

C 50.8 mm (Air Blow RD 47 mm)

D 88.9 mm (Air Blow RD 85.6 mm)

E 114.3 mm (Air Blow 110.5 mm)

C STATION PUNCH



D STATION PUNCH



E STATION PUNCH



ITEM	C STATION PUNCH	€	D STATION PUNCH	€	E STATION PUNCH	€
ROUND	AMC1PUAB06T		AMD1PUAB06T		AME1PUAB06T	
STANDARD	AMC1PUAB06S		AMD1PUAB06S		AME1PUAB06S	
SPECIAL 0	AMC1PUAB06C		AMD1PUAB06C		AME1PUAB06C	
SPECIAL 1	AMC1PUAB06D		AMD1PUAB06D		AME1PUAB06D	
SPECIAL 2	AMC1PUAB06F		AMD1PUAB06F		AME1PUAB06F	

PUNCH AMADA STYLE LUBRICATED, THREAD M14

Data: Max size

C 50.8 mm (Air Blow RD 47 mm)

D 88.9 mm (Air Blow RD 85.6 mm)

E 114.3 mm (Air Blow 110.5 mm)

ITEM	C STATION PUNCH	€	D STATION PUNCH	€	E STATION PUNCH	€
ROUND	AMC1PUAB16T		AMD1PUAB16T		AME1PUAB16T	
STANDARD	AMC1PUAB16S		AMD1PUAB16S		AME1PUAB16S	
SPECIAL 0	AMC1PUAB16C		AMD1PUAB16C		AME1PUAB16C	
SPECIAL 1	AMC1PUAB16D		AMD1PUAB16D		AME1PUAB16D	
SPECIAL 2	AMC1PUAB16F		AMD1PUAB16F		AME1PUAB16F	

Coating	C PROBUS		D PROBUS		E PROBUS	
	C GEMINUS		D GEMINUS		E GEMINUS	
	C LEVATUS		D LEVATUS		E LEVATUS	

STRIPPER LUBRICATED Z STYLE

Reduced clearance,
grooves for oil

C STATION



D STATION



E STATION



ITEM	C STATION	€	D STATION	€	E STATION	€
ROUND	AMC1PLTLT		AMD1PLTLT		AME1PLTLT	
STANDARD	AMC1PLTLS		AMD1PLTLS		AME1PLTLS	
SPECIAL 0 - 1 - 2	AMC1PLTLD		AMD1PLTLD		AME1PLTLD	

STRIPPER LUBRICATED ABS STYLE

Grooves for oil

C STATION



D STATION



E STATION



ITEM	C STATION	€	D STATION	€	E STATION	€
ROUND	AMC1PLTGT		AMD1PLTGT		AME1PLTGT	
STANDARD	AMC1PLTGS		AMD1PLTGS		AME1PLTGS	
SPECIAL 0 - 1 - 2	AMC1PLTGD		AMD1PLTGD		AME1PLTGD	

**PUNCH HOLDER FOR WILSON STYLE PUNCHES***A STATION
PUNCH DRIVER**A STATION
OPEN GUIDE**B STATION
PUNCH DRIVER**B STATION
OPEN GUIDE*

ITEM	A STATION PUNCH DRIVER	€	A STATION OPEN GUIDE	€	B STATION PUNCH DRIVER	€	B STATION OPEN GUIDE	€
	AMA1LLWT		S90 & ABS Style - only RD AMA1GUWTT		AMB1LLGIOPEWT		S90 & ABS Style - only RD AMB1GUWTS90T	
			S90 & ABS Style - 0-90-225° AMA1GUWTS				S90 & ABS Style - 0-90-225° AMB1GUWTS90S	

PUNCH WILSON STYLEData: Max size
12.7 mm*A STATION
PUNCH HP**A STATION
PUNCH HP
LUBRICATED*

ITEM	A STATION PUNCH HP	€	A STATION PUNCH HP LUBRICATED	€
ROUND	AMA1IPWS06T		AMA1IPWL06T	
STANDARD	AMA1IPWS06S		AMA1IPWL06S	
SPECIAL 0	AMA1IPWS06C		AMA1IPWL06C	
SPECIAL 1	AMA1IPWS06D		AMA1IPWL06D	
SPECIAL 2	AMA1IPWS06F		AMA1IPWL06F	

Coating	PROBUS		GEMINUS		LEVATUS	
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*B STATION
PUNCH S90**B STATION
PUNCH WLS - ABS*Data: Max size
31.7 mm

ITEM	B STATION PUNCH S90	€	B STATION PUNCH WLS - ABS	€
ROUND	AMB1IPS906T		AMB1IPWT06T	
STANDARD	AMB1IPS906S		AMB1IPWT06S	
SPECIAL 0	AMB1IPS906C		AMB1IPWT06C	
SPECIAL 1	AMB1IPS906D		AMB1IPWT06D	
SPECIAL 2	AMB1IPS906F		AMB1IPWT06F	

Coating	PROBUS		GEMINUS		LEVATUS	
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PUNCH WILSON STYLE

Data: Max size
C 50.8 mm
D 88.9 mm
E 114.3 mm

C STATION
PUNCH HP



D STATION
PUNCH HP



ITEM	C STATION PUNCH HP	€	D STATION PUNCH HP	€
ROUND	AMC1PUWT06T		AMD1PUWT06T	
STANDARD	AMC1PUWT06S		AMD1PUWT06S	
SPECIAL 0	AMC1PUWT06C		AMD1PUWT06C	
SPECIAL 1	AMC1PUWT06D		AMD1PUWT06D	
SPECIAL 2	AMC1PUWT06F		AMD1PUWT06F	
Coating	C PROBUS		D PROBUS	
	C GEMINUS		D GEMINUS	
	C LEVATUS		D LEVATUS	



STRIPPER WILSON STYLE

A STATION
STRIPPER



B STATION
STRIPPER



C STATION
STRIPPER



D STATION
STRIPPER



E STATION
STRIPPER



ITEM	A STATION STRIPPER	€	B STATION STRIPPER	€	C STATION STRIPPER	€	D STATION STRIPPER	€	E STATION STRIPPER	€
ROUND	AMA1PLHPT		AMB1PLWTT		AMC1PLWTT		AMD1PLWTT		AME1PLWTT	
STANDARD	AMA1PLHPS		AMB1PLWTS		AMC1PLWTS		AMD1PLWTS		AME1PLWTS	
SPECIAL 0-1-2	AMA1PLHPD		AMB1PLWTD		AMC1PLWTD		AMD1PLWTD		AME1PLWTD	

DIE

A STATION
DIE



B STATION
DIE



C STATION
DIE



D STATION
DIE



E STATION
DIE



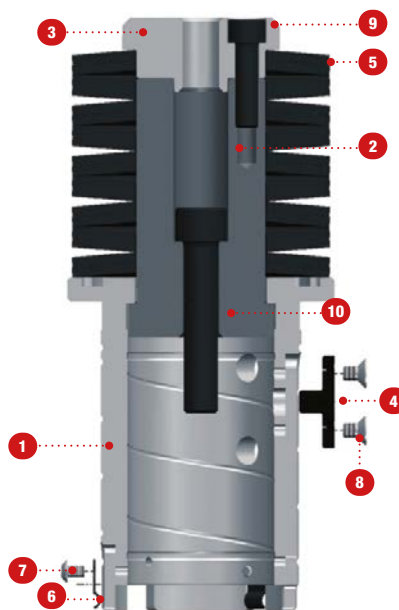
ITEM	A STATION DIE	€	B STATION DIE	€	C STATION DIE	€	D STATION DIE	€	E STATION DIE	€
ROUND	AMA1MAT001T		AMB1MAT001T		AMC1MAT001T		AMD1MAT001T		AME1MAT001T	
STANDARD	AMA1MAT001S		AMB1MAT001S		AMC1MAT001S		AMD1MAT001S		AME1MAT001S	
SQ REF. 0 - 135°	AMA1MAT001Q		AMB1MAT001Q		AMC1MAT001Q		AMD1MAT001Q		AME1MAT001Q	
SPECIAL 0-1-2	AMA1MAT001D		AMB1MAT001D		AMC1MAT001D		AMD1MAT001D		AME1MAT001D	



C STATION STANDARD GUIDE ASSEMBLY AMC1GATO

	QTY	COD	DESCRIPTION
10.	1	NVI 03 AR 12060	SCREW UNI 5931/M12X60 12.9
9.	3	NVI 05 AR 08030	SCREW UNI 5931 M8X30
8.	2	NVI 12 AR 05008	SCREW UNI 5933 M5X8
7.	3	NVI 00 AR 04006	SCREW UNI ISO/7380M4X6 10.9
6.	3	AMCFGAT05	STRIPPER CLIP
5.	18	NMO06009046B	DISC SPRING D90-46-3.5
4.	1	MAMC1GAT04	PUNCH HOLDER KEY
3.	1	MAMC1GAT03	HEAD
2.	1	MAMC1GAT02	PUNCH HOLDER
1.	1	MAMC1GAT01	GUIDE 0° - 90° - 135°

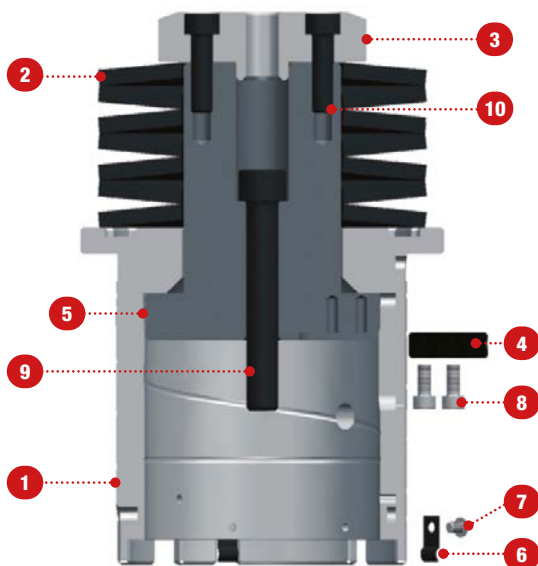
ITEM	GUIDE ASSEMBLY	€
	AMC1GATO	



D STATION STANDARD GUIDE ASSEMBLY AMD1GATO

	QTY	COD	DESCRIPTION
10.	4	NVI 05 AR 08030	SCREW UNI 5931 M8X30
9.	1	NVI 03 AR 12080	SCREW UNI 5931 M12X80
8.	2	NVI 12 AR 05008	SCREW UNI 5933 M5X8
7.	3	NVI 00 AR 04006	SCREW UNI ISO 7380M4X6 10.9
6.	4	AMCFGAT05	STRIPPER CLIP
5.	1	MAMD1GAT02	PUNCH HOLDER
4.	1	MAMDEGAT04	PUNCH HOLDER KEY
3.	1	MAMD1GAT03	HEAD
2.	7	NMO060012561B	DISC SPRING D125-61-6
1.	1	MAMD1GAT01	GUIDE 0° - 90° - 135°

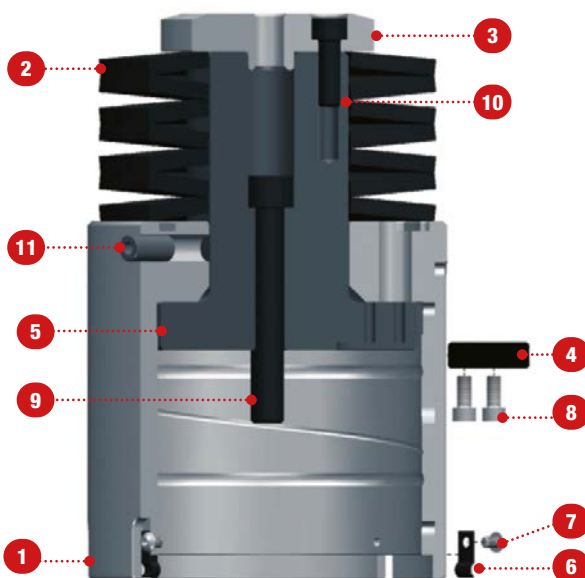
ITEM	GUIDE ASSEMBLY	€
	AMD1GATO	



E STATION STANDARD GUIDE ASSEMBLY AME1GATO

	QTY	COD	DESCRIPTION
11.	4	NSP00MR10020	ISO8735 UNI6364A
10.	4	NVI 05 AR 08025	SCREW UNI 5931 M8X25
9.	1	NVI 03 AR 12080	SCREW UNI 5931 M12X80
8.	2	NVI 12 AR 05012	SCREW UNI 5933 M5X12
7.	3	NVI 00 AR 04006	SCREW UNI ISO 7380M4X6 10.9
6.	3	AMCFGAT05	STRIPPER CLIP
5.	1	MAME1GAT02	PUNCH HOLDER
4.	1	MAMDEGAT04	PUNCH HOLDER KEY
3.	1	MAME1GAT03	HEAD
2.	7	NMO060012561B	DISC SPRING D125-61-6
1.	1	MAME1GAT01	GUIDE 0° - 90°

ITEM	GUIDE ASSEMBLY	€
	AME1GATO	





**C,D,E STATION
LONG LIFE GUIDE ASSEMBLY
QUICK ADJUSTABLE LENGTH, WITH LUBRICATION**



ITEM	GUIDE ASSEMBLY	€
C STATION STD (M12)	AMC1GATM	
C STATION W90	AMC1GATMWT	
C STATION A.B. (M14)	AMC1GATMAB	



ITEM	GUIDE ASSEMBLY	€
D STATION STD (M12)	AMD1GATM	
D STATION W90	AMD1GATMWT	
D STATION A.B. (M14)	AMD1GATMAB	



ITEM	GUIDE ASSEMBLY	€
E STATION STD (M12)	AME1GATM	
E STATION W90	AME1GATMWT	
E STATION A.B. (M14)	AME1GATMAB	



CLOSE TO CLAMP DIES



ITEM	D STATION		E STATION	
1 SIDE	D STATION HWS	€	E STATION HWS	€
	AMD1MATAP1S		AME1MATAP1S	
2 SIDES	D STATION HWS	€	E STATION HWS	€
	AMD1MATAP1D		AME1MATAP1D	

ADAPTORS



ITEM	B/A		C/B		D/B		D/C	
MAXIMUM T B to A 16 C to B 20 D to B >30	PUNCH	€	PUNCH	€	PUNCH	€	PUNCH	€
	AMABRIPU		AMCBRIPU		AMDBRIPU		AMDCRIPU	
	DIE	€	DIE	€	DIE	€	DIE	€
	AMABRIMA		AMCBRIMA		AMDBRIMA		AMDCRIMA	

URETHAN EJECTOR



ITEM	D1.7	€	D2.2	€	D3	€	D6	€	D10	€
	ES1.7TO		ES2.2TO		ES3TO		ES6TO		ES10TO	

BRUSHES DIES



ITEM	A STATION	€	B STATION	€	C STATION	€	D STATION	€	E STATION	€
	AMA1MASP		AMB1MASP		AMC1MASP		AMD1MASP		AME1MASP	



SLITTING TOOLS

PUNCH HOLDER
C STATION

C STATION

PUNCH HOLDER
D STATION

D STATION

PUNCH HOLDER
E STATION

E STATION

HSS BLADE
C STATION

C STATION

HSS BLADE
D STATION

D STATION

HSS BLADE
E STATION

E STATION

ITEM	C STATION		D STATION		E STATION	
	C STATION PUNCH HOLDER	€	D STATION PUNCH HOLDER FOR BLADE AMD1PULTG06S	€	E STATION PUNCH HOLDER FOR BLADE AME1PULTG06S	€
AMADA OLD STYLE AND MATE	AMC1PPLAT0		AMD1PPLAT0		AME1PPLAT0	
AMADA LUBR. M12	AMC1PPLATAM12		AMD1PPLATAM12		AME1PPLATAM12	
AMADA LUBR. M14	AMC1PPLATAM12		AMD1PPLATAM12		AME1PPLATAM12	
BLADE HSS AND POWDER STEEL METALLURGY	HSS BLADE	€	HSS BLADE	€	HSS BLADE	€
	W18 H47.5 AMC1PULTG06S		MATE STYLE W18 H45.5 AMD1PULTG06S		MATE STYLE W18 H45.5 AME1PULTG06S	
			AMADA STYLE TIP W16 H49 AMD1PULTA06S		AMADA STYLE TIP W16 H50 AME1PULTA06S	
			WILSON DURA STYLE W19.05 H70 AMD1PULTW06S		WILSON DURA STYLE W19.05 H70 AME1PULTW06S	

Coating	C PROBUS		D PROBUS		E PROBUS	
	C GEMINUS		D GEMINUS		E GEMINUS	
	C LEVATUS		D LEVATUS		E LEVATUS	

PUNCH SHIM



C STATION

PUNCH SHIM



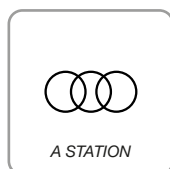
D STATION

PUNCH SHIM



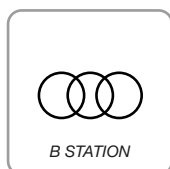
E STATION

DIE SHIM



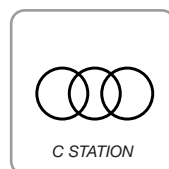
A STATION

DIE SHIM



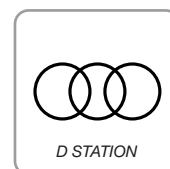
B STATION

DIE SHIM



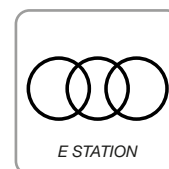
C STATION

DIE SHIM



D STATION

DIE SHIM



E STATION

ITEM	C STATION		D STATION		E STATION	
PUNCH SHIM	(0.3 - 0.5 - 1 - 1.5 mm)	€	(0.3 - 0.5 - 1 - 1.5 mm)	€	0.3 - 0.5 - 1 - 1.5 mm)	€
	AMC1SETSPPU		AMD1SETSPPU		AME1SETSPPU	

DIE SHIM		A STATION	€	B STATION	€	C STATION	€	D STATION	€	E STATION	€
	0.5 mm	AMA1SPMA05		AMB1SPMA05		AMC1SPMA05		AMD1SPMA05		AME1SPMA05	
	1.0 mm	AMA1SPMA1		AMB1SPMA1		AMC1SPMA1		AMD1SPMA1		AME1SPMA1	
	1.5 mm	AMA1SPMA15		AMB1SPMA15		AMC1SPMA15		AMD1SPMA15		AME1SPMA15	



TURRET CALIBER

A STATION Single track



B STATION Single track



C STATION



D STATION



ITEM	A STATION Single track	€	B STATION Single track	€	C STATION	€	D STATION	€
	AMA1CAAL		AMB1CAAL		AMC1CAAL		AMD1CALL	

DISC SPRING



ITEM	A STATION	€	B STATION	€	C STATION	€	D STATION	€	E STATION	€
DISC SPRING (guide amada standard)	34X16.3X1.5 NMO060034163A		60X20.5X3 NMO06006020C		90X46X3.5 NMO06009046B		125X61X6 NMO060012561B		125X61X6 NMO060012561B	
DISC SPRING adjustable guide					80X41X4 NMO06008041C		125X51X6 NMO060012551C		125X51X4 NMO060012551A	
DISC SPRING adjustable guide SMART					80X41X4 NMO06008041C		125X51X6 NMO060012551C		125X51X4 NMO060012551A	
2015 DISC SPRING adjustable guide 2					90X46X5 NMO06009046C		125X61X6 NMO060012561B		125X61X6 NMO060012561B	
2015 DISC SPRING adjustable guide SMART 2					90X46X5 NMO06009046C		125X61X6 NMO060012561B		125X61X6 NMO060012561B	

PUNCH LUBRICANT



ITEM	PUNCH LUBRICANT 1 KG	€
	C15M0000001	

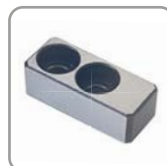


PUNCH HOLDER KEYS

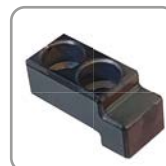
MAMC1GAT04



MAMDEGAT04



MAMD1GALLT019



MAMD1G2CHI



ITEM	GUIDE STANDARD, ADJUSTABLE & SMART2	€	D & E GUIDE STANDARD	€	D & E GUIDE ADJUSTABLE	€	D & E GUIDE SMART2	€
	MAMC1GAT04		MAMDEGAT04		MAMD1GALLT019		MAMD1G2CHI	

FIXTURE EQUIPMENT

D STATION ADAPTOR
FOR PRESSBRAKE MACHINES

ITEM	€
D STATION ADAPTOR FOR PRESSBRAKE MACHINES	AMDAP

PUNCH PINS

AMABSPPUR



AMABSPPU



AMA1SPPUT



MAMCDSPPUWT



ITEM	A STATION ERMAKSAN MT6	€	A STATION SMART XMTE12.7 XMTE6 B STATION all	€	ROUND A/B STATION SMART, MATE ULTRATECH STYLE XMTE6 ADJUSTABLE	€	C-D-E SMART PUNCH WILSONTOOL STYLE	€
	AMABSPPUR		AMABSPPU		AMA1SPPUT		MAMCDSPPUWT	

DIE PINS



ITEM	A STATION D4.76X8	€	B STATION D4.76X10	€	XMTE12.7 D3X6	€	MTE6 XMTE6 D4X8	€
	NSP02MR47008		NSP02MR47010		NSPMO02MR0306		NSP02MR0408	





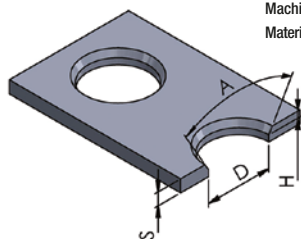
Bending tools compatible with all major brands of press brakes.

We are also able to supply special tools, tailor-made with our customers, to meet any need.

Type PROMECAM , WILA , LVD , BYSTRONIC , Rolla V dies.

FORMING TOOL DATA SHEET

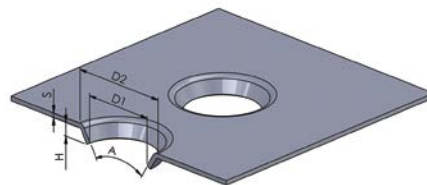
COUNTER SINK DOWN



Machine Model: _____
Material: _____

A: _____
D: _____
H: _____
S: _____

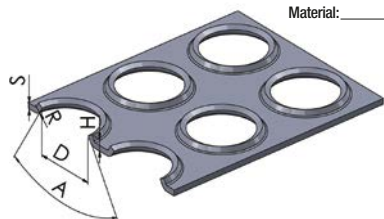
COUNTER SINK DOWN FORMING AFTER PRE PIERCE



Machine Model: _____
Material: _____

A: _____
D1: _____
D2: _____
H: _____
S: _____

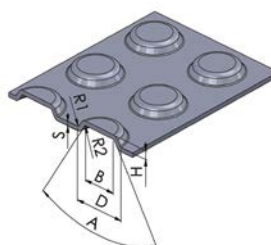
COUNTER SINK UP FORMING AFTER PRE PIERCE



Machine Model: _____
Material: _____

A: _____
B: _____
D: _____
H: _____
R: _____
S: _____

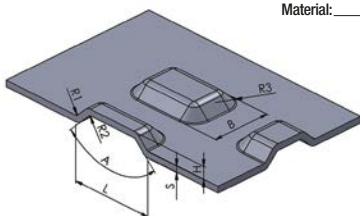
EMBOSS UP ROUND



Machine Model: _____
Material: _____

A: _____
B: _____
D: _____
H: _____
R1: _____
R2: _____
S: _____

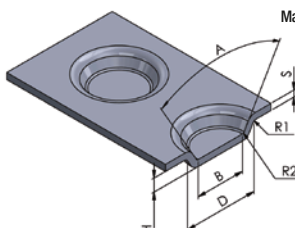
EMBOSS UP RECTANGULAR



Machine Model: _____
Material: _____

A: _____
B: _____
L: _____
H: _____
R1: _____
R2: _____
R3: _____
S: _____

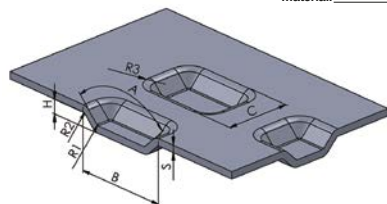
EMBOSS DOWN ROUND



Machine Model: _____
Material: _____

A: _____
B: _____
D: _____
H: _____
S: _____
R1: _____
R2: _____

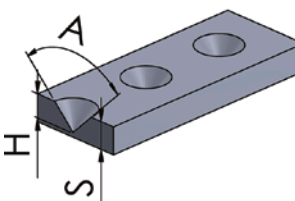
EMBOSS DOWN RECTANGULAR



Machine Model: _____
Material: _____

A: _____
B: _____
C: _____
H: _____
R1: _____
R2: _____
R3: _____
S: _____

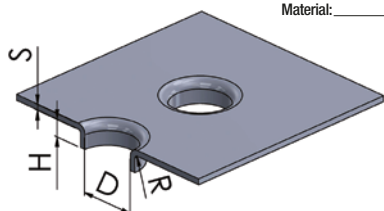
FORM DOWN MARKING TOOL



Machine Model: _____
Material: _____

A: _____
H: _____
S: _____

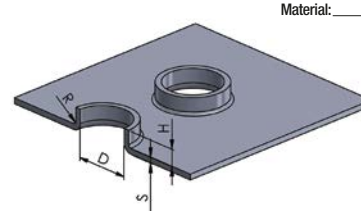
EXTRUSION DOWN ROUND



Machine Model: _____
Material: _____

D: _____
H: _____
R: _____
S: _____

EXTRUSION UP ROUND

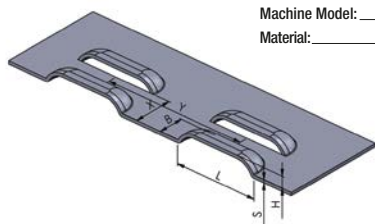


Machine Model: _____
Material: _____

D: _____
H: _____
R: _____
S: _____

FORMING TOOL DATA SHEET

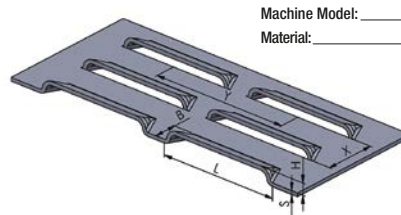
LOUVER



Machine Model: _____
Material: _____

B: _____
H: _____
L: _____
S: _____
X: _____
Y: _____

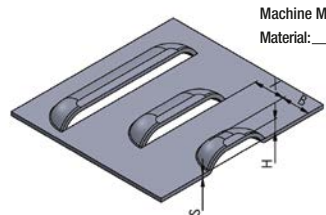
LOUVER TRUMPF



Machine Model: _____
Material: _____

B: 12
H: 60
L: 5.5
S: 0.8 - 2.5
X: 18
Y: 70

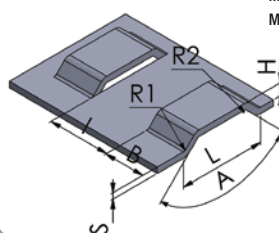
CONTINUOUS LOUVER



Machine Model: _____
Material: _____

B: _____
H: _____
S: _____
X: _____

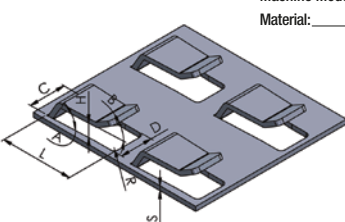
BRIDGE UP



Machine Model: _____
Material: _____

A: _____
B: _____
H: _____
L: _____
I: _____
R1: _____
R2: _____
S: _____

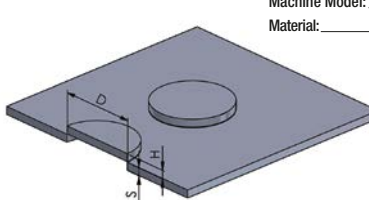
LANCE UP_3 BENDS



Machine Model: _____
Material: _____

A: _____
B: _____
C: _____
D: _____
H: _____
L: _____
R: _____
S: _____

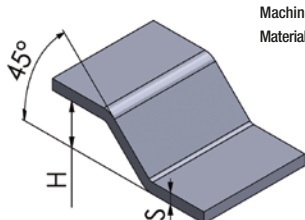
SHEAR BUTTON



Machine Model: _____
Material: _____

D: _____
H: _____
S: _____

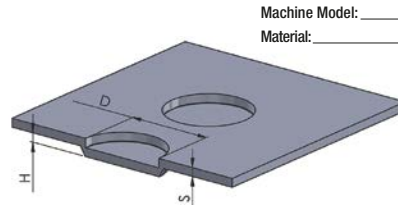
BEND 45°



Machine Model: _____
Material: _____

H: _____
S: _____

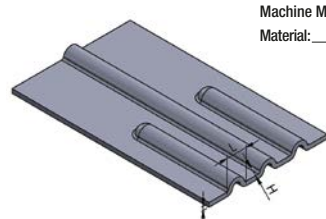
KNOCK-OUT DOWN



Machine Model: _____
Material: _____

D: _____
H: _____
S: _____

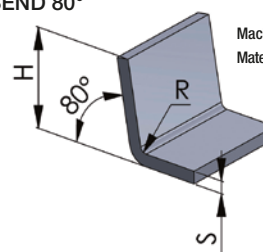
EMBOSS CONTINUOUS



Machine Model: _____
Material: _____

H: _____
L: _____
S: _____

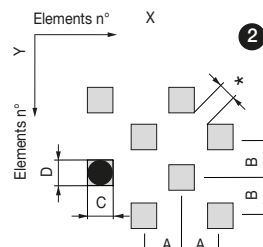
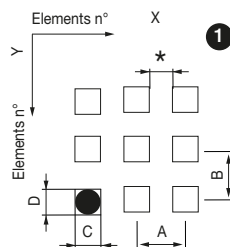
BEND 80°



Machine Model: _____
Material: _____

H: _____
R: _____
S: _____

CLUSTER



Punch dimensions (mm):

A: _____
B: _____
C: _____
D: _____

Round: _____
Shape: _____
Pattern: 1/2
Nx: _____
Ny: _____

* See data pag. 40

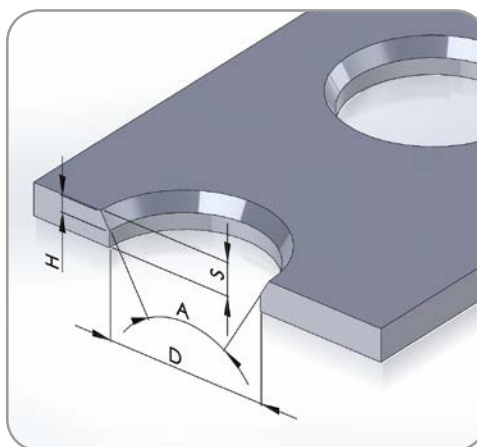
COUNTERSINK DOWN

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
 Machine model:
 Material:
 Thickness :
 Order / Offer :
 Item required:
 Number of previous order:

ORIGINAL OLD STYLE



B SMART 2

Custom dimensions (mm)

A:
 D:
 H:
 S:

Order with prepierce tool:

☐ Yes ☐ No

Prepierce dimension:
 $D_{max} - [(D_{max} - D_{min}) \times 0,7]$



ITEM	PACK SPRING UNIT	€	GUIDE	€	STRIPPER	€	PUNCH	€	PUNCH HOLDER	€	DIE	€
B station Dmax 19 Thickness 0.5 - 4 Original old style	AMB1LLGIO		AMB1GUTOT		-		AMB1PUT006D		-		AMB1MAT001T	

COUNTERSINK DATA

DIN EN ISO 10642 (hexagon socket)

SCREW	Upper Ø mm	Thickness mm
M3	7.1	1 - 3
M4	9.4	1.5 - 3
M5	11.7	1.5 - 4
M6	14	2 - 4
M8	18.5	2 - 4

COUNTERSINK DATA

DIN EN ISO 2009 and 7046-1

SCREW	Upper Ø mm	Thickness mm
M2.5	5.9	1 - 3
M3	6.7	1 - 3
M4	8.8	1.5 - 3
M5	10.6	1.5 - 4
M6	12.7	2 - 4
M8	16.7	2 - 4

MAXIMUM COUNTERSINK DEPTH

MATERIAL TYPE	Thickness mm	H Maximum S%
Aluminum, Copper, Brass	0.8 - 5	95
Mild Steel, Galvanized Steel	0.8 - 3	85
	3.1 - 5	60
Stainless Steel	0.8 - 2	85
	2.1 - 3	60
	3.1 - 5	50

EMBOSS DOWN

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:

Machine model:

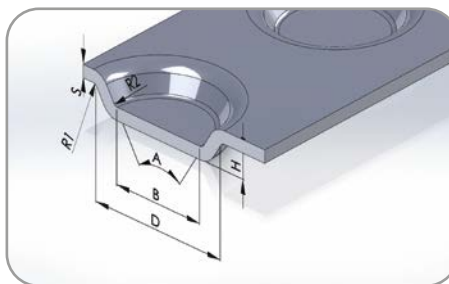
Material:

Thickness :

Order / Offer :

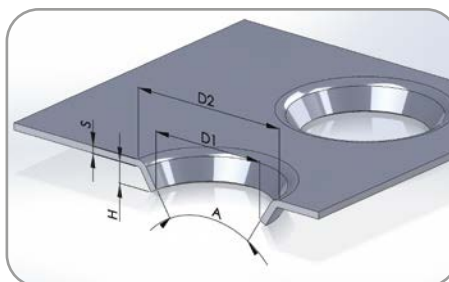
Item required:

Number of previous order:



Custom dimensions (mm)

A:
B:
D:
H:
S:
R1:
R2:

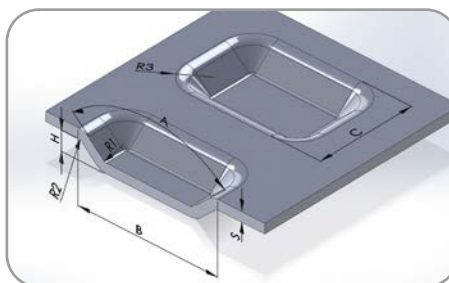


Custom dimensions (mm)

A:
D1:
D2:
H:
S:

ITEM ROUND	ECONO LINE PUNCH ASSEMBLY	€	PUNCH FOR STANDARD PUNCH HOLDER *	€	DIE	€	DIE WITH EJECTOR	€
B station ROUND	FLAMB05PA 0 - 25 mm		Amada AMB1PUT006D		FLAMB05M		FLAMB05ME	
			SMART Mate style AMB1PLLNL6D					
			Wilson style AMB1IPS906D					
C station ROUND	FLAMC05PA 25.1 - 50 mm		Amada and MATE style AMC1PUT006D		FLAMC05M		FLAMC05ME	
			WILSON style AMC1PUWT06D					
D station ROUND	FLAMD05PA 50.1 - 80 mm		AMADA and MATE style AMD1PUT006D		FLAMD05M		FLAMD05ME	

* add price of guide or stripper



Custom dimensions (mm)

A:
B:
C:
H:
S:
R1:
R2:
R3:

ITEM ROUND	ECONO LINE PUNCH ASSEMBLY	€	PUNCH FOR STANDARD PUNCH HOLDER *	€	DIE	€	DIE WITH EJECTOR	€
B station SHAPE	FLAMB06PA 0 - 25 mm		Amada AMB1PUT006F		FLAMB06M		FLAMB06ME	
			SMART Mate style AMB1IPLLNL6F					
			Wilson style AMB1IPS906F					
C station SHAPE	FLAMC06PA 25.1 - 50 mm		Amada and MATE style AMC1PUT006F		FLAMC06M		FLAMC06ME	
			WILSON style AMC1PUWT06F					
D station SHAPE	FLAMD06PA 50.1 - 80 mm		AMADA and MATE style AMD1PUT006F		FLAMD06M		FLAMD06ME	

* add price of guide or stripper

EMBOSS UP

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
 Machine model:
 Material:
 Thickness :
 Order / Offer :
 Item required:
 Number of previous order:

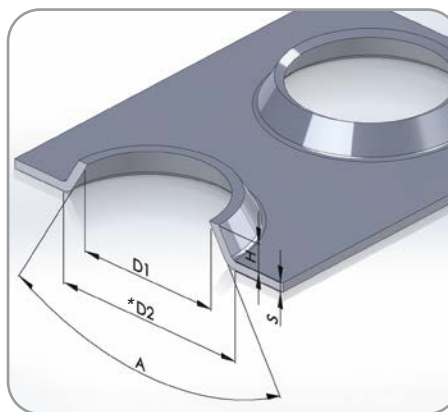
COUNTERSINK AFTER PRE.PIERCE

Size diameter pre.pierce

THICKNESS mm	0.5	1.0	1.5	2.0	2.5
M2.5	2.0	2.2	2.3	2.4	2.5
M3	2.4	2.6	2.7	2.8	3.0
M4	3.3	3.5	3.6	3.7	3.8
M5	4.2	4.4	4.5	4.6	4.8
M6	5.0	5.2	5.3	5.4	5.5
M8	6.2	6.5	6.8	7.0	7.2
M10	7.5	7.8	8.0	8.2	8.5

Thread	M2.5	M3	M4	M5	M6	M8	M10
*D2 Upper Ø mm	5.9	7.1	9.4	11.7	14	18.5	23

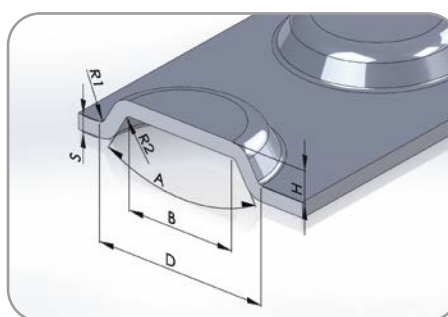
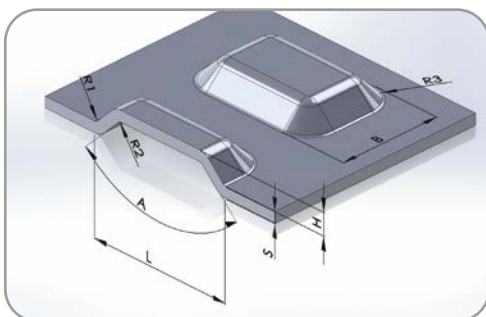
SOLID PUNCH



Custom dimensions (mm)

A:
 D1:
 *D2:
 H:
 S:

SMART LINE - Replaceable parts, Die with Springs



Custom dimensions (mm)

A:
 B:
 D:
 H:
 L:
 R1:
 R2:
 R3:
 S:

ITEM ROUND	ECONO LINE PUNCH ASSEMBLY	€	ECONO LINE DIE	€	SMART LINE PUNCH ASSEMBLY	€	DIE WITH SPRINGS	€
B STATION	FLAMB01PA 0 - 25 mm		FLAMB01MA 0 - 25 mm		FLAMB03PA 0 - 20 mm		FLAMB03MA 0 - 20 mm	
C STATION	FLAMC01PA 25.1 - 50 mm		FLAMC01MA 25.1 - 50 mm		FLAMC03PA 20.1 - 40 mm		FLAMC03MA 20.1 - 40 mm	
D STATION	FLAMD01PA 50.1 - 80 mm		FLAMD01MA 50.1 - 80 mm		FLAMD03PA 40.1 - 70 mm		FLAMD03MA 0.1 - 70 mm	
ITEM SHAPE	ECONO LINE PUNCH ASSEMBLY	€	ECONO LINE DIE	€	SMART LINE PUNCH ASSEMBLY	€	DIE WITH SPRINGS	€
B STATION	FLAMB02PA 0 - 25 mm		FLAMB02MA 0 - 25 mm		FLAMB04PA 0 - 20 mm		FLAMB04MA 0 - 20 mm	
C STATION	FLAMC02PA 25.1 - 50 mm		FLAMC02MA 25.1 - 50 mm		FLAMC04PA 20.1 - 40 mm		FLAMC04MA 20.1 - 40 mm	
D STATION	FLAMD02PA 50.1 - 80 mm		FLAMD02MA 50.1 - 80 mm		FLAMD04PA 40.1 - 70 mm		FLAMD04MA 40.1 - 70 mm	

EXTRUSION ROUND UP

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:



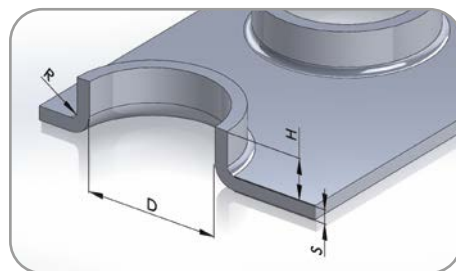
OPTIONS



OPTION 2
B station single extrusion 1 hit
up forming



OPTION 3
D station cluster extrusion 1 hit
up forming



Custom dimensions (mm)

D: S:
H: R:

Geminus coating: ☐ Yes ☐ No

ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B Station 0 - 15 mm	FLAMB12PA		FLAMB12MA		
C Station 15.1 - 40 mm	FLAMC12PA		FLAMC12MA		
D Station 40.1 - 60 mm	FLAMD12PA		FLAMD12MA		

SPARES	B STATION	€	C STATION	€	D STATION	€
Upper die	FLAMB03IMS		FLAMC03IMS		FLAMD03IMS	
Lower punch	FLAMB12IP		FLAMC12IP		FLAMD12IP	
Coating Geminus						

Extrusion according to DIN7952

THREAD SIZE	PRE-PUNCH DIAMETER mm	THICKNESS	DIAMETER HOLE
M2.5	1.0	0.8 - 1.5	2.10 - 2.30*
M3	1.5 - 1.8	0.8 - 1.5	2.55 - 2.80*
M4	2.0 - 2.3	1.0 - 2.0	3.35 - 3.70*
M5	2.5 - 2.7	1.0 - 2.0	4.25 - 4.65*
M6	3.0 - 3.3	1.5 - 2.5	5.10 - 5.55*
M8	4.1 - 4.5	1.5 - 2.5	6.80 - 7.40*
M10	5.0 - 5.5	1.5 - 2.5	8.50 - 9.30*

* Hole size with thread in machine - Extrusion tapping height = 2 times thickness

CLUSTER B, C, D, E station cluster data

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:

Machine model:

Material:

Thickness :

Order / Offer :

Item required:

Number of previous order:

OPTIONS

SOLID PUNCH



- OLD STYLE
- LUBR. STYLE
- WILSON STYLE
- MATE STYLE

REPLACEABLE INSERTS



- OLD STYLE
- LUBR. STYLE
- WILSON STYLE
- MATE STYLE

STRIPPER



- OLD STYLE
- LUBR. STYLE
- WILSON STYLE
- MATE STYLE

DIE



MATERIAL:
HWS and
ISODUR LOCK
SLUG AS

REPLACEABLE PUNCHES

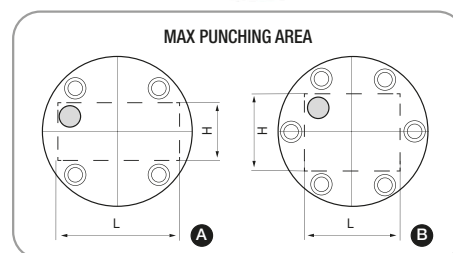


MATERIAL:
ISODUR OPTION
PSM

COATINGS

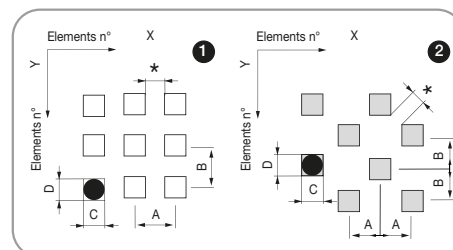


COATING
AVAILABLE:
PROBUS,
GEMINUS,
LEVATUS



	SOLID	REPLACEABLE			
		A		B	
	DIAM (mm)	L (mm)	H (mm)	L (mm)	H (mm)
C STATION	Ø 50.8	36	17	40	15
D STATION	Ø 88.9	70	35	55	45
E STATION	Ø 114.3	90	50	80	65

If particular dimensions or holes are needed, our technical department is available to find the solution that fits your needs.



Punch dimensions (mm):

A:

B:

C:

D:

Round:

Shape:

Pattern: 1/2

Nx:

Ny:

* See data pag. 65

Coating: ☐ Yes ☐ No

MODEL SELECTION

AMADA STYLE ☐

WILSON STYLE ☐

MATE STYLE ☐

AMADA LUB STYLE ☐

TYPE SELECTION

SOLID ☐

REPLACEABLE PUNCHES ☐

DATA:

* Minimum size 1.5 x thickness.

Minimum distance between rounds 2.5 thickness

If size C <30 mm example 20 x 3 minimum distance between shapes 3 time thickness

if size C >30 mm example 40 x 3 minimum distance between shapes 4 time thickness

ITEM		B STATION	€		C STATION	€		D STATION	€		E STATION	€	
			FIXED VALUE	QTY		FIXED VALUE	QTY		FIXED VALUE	QTY		FIXED VALUE	QTY
SOLID PUNCH STYLE	OLD STYLE	AMB1PUT006M		Ø S	AMC1PUT006M		Ø S	AMD1PUT006M		Ø S	AME1PUT006M		Ø S
	A.B.OIL System	AMB1PUAB06M		Ø S	AMC1PUAB06M		Ø S	AMD1PUAB06M		Ø S	AME1PUAB06M		Ø S
	ULTRAT. STYLE	AMB1PLLNL6M		Ø S	AMC1PUT006M		Ø S	AMD1PUT006M		Ø S	AME1PUT006M		Ø S
	WILSON STYLE	AMB1IPS9006M (S90) AMB1IPWT06M (WLS)		Ø S	AMC1PUWT06M		Ø S	AMD1PUWT06M		Ø S	AME1PUWT06M		Ø S
REPLACEABLE PUNCH STYLE	OLD STYLE	-	-	-	FLAMC21P		Ø* S**	FLAMD21P		Ø* S**	FLAME21P		Ø* S**
	A.B.OIL System	-	-	-	FLAMC21PAB		Ø* S**	FLAMD21PAB		Ø* S**	FLAME21PAB		Ø* S**
	ULTRAT. STYLE	-	-	-	FLAMC21P		Ø* S**	FLAMD21P		Ø* S**	FLAME21P		Ø* S**
	WILSON STYLE	-	-	-	FLAMC21WP		Ø* S**	FLAMD21WP		Ø* S**	FLAME21WP		Ø* S**
STRIPPER	OLD STYLE	AMB1PLWTM		Ø S	AMC1PLTOM		Ø S	AMD1PLTOM		Ø S	AME1PLTOM		Ø S
	WILSON STYLE	AMB1PLWTM		Ø S	AMC1PLWTM		Ø S	AMD1PLWTM		Ø S	AME1PLWTM		Ø S
	A.B.OIL system	AMB1PLABM		Ø S	AMC1PLTGM		Ø S	AMD1PLTGM		Ø S	AME1PLTGM		Ø S
	ULTRAT. STYLE	AMB1PLWTM		Ø S	AMC1PLTMM		Ø S	AMD1PLTMM		Ø S	AME1PLTMM		Ø S
DIE	HWS DIE	-	-	-	AMC1MAT001M		Ø S	AMD1MAT001M		Ø S	AME1MAT001M		Ø S
	ISODUR DIE	AMB1MATP06M		Ø S	AMC1MAT006M		Ø S	AMD1MAT006M		Ø S	AME1MAT006M		Ø S
DIES and STRIPPERS: ADD 15% DIE SIZE <3.5 mm; ADD 10% STRIPPER SIZE < 3.5 mm; ADD 15% DIE AND STRIPPER SPECIAL 0-1-2 ADD 20% DIE IF PERIMETER SHAPE >50 mm (ex SQUARE 15 mm), ADD 20% REINFORCED DIE (ONLY D ST.) *** From 20 onwards € X QTY PUNCHES: PUNCH BIGGER THEN MAX PUNCHING ADD 10% SOLID PUNCH SPECIAL 0-1-2 ADD € + IF PERIMETER <50 mm € X QTY, IF > 50 mm € X QTY													

* ROUND size mm	2 - 8	8,1 - 12	12,1 - 15	15,1 - 20
Add each Ø	€	€	€	€
Spare punch HSS	€	€	€	€

** SHAPE diagonal size mm	2.20 Square and rectangle	>20 Square and rectangle	2.20 Obround and hexagon	>20 Obround and hexagon
Add each shape	€	€	€	€
Spare punch HSS	€	€	€	€

DIAGONAL size mm	2 - 6	6.1 - 10	10.1 - 12	12.1 - 15	15.1 - 25
Coating Probus each Ø	€	€	€	€	€
Coating Geminus or L evatus each Ø	€	€	€	€	€

LOUVER

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
 Machine model:
 Material:
 Thickness :
 Order / Offer :
 Item required:
 Number of previous order:

OPTIONS



D station punch assembly
Standard size 75x15 and
85x15



D station die assembly
with coating



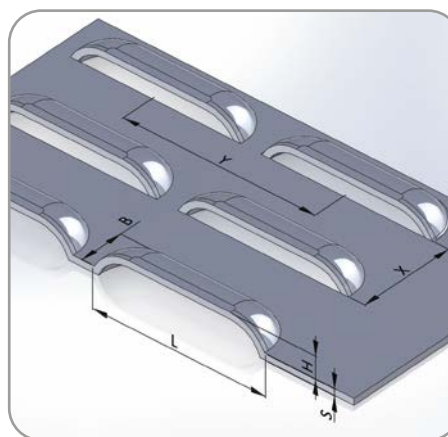
D station blade with
coating



The reversible blade
allows the punching
thickness from to 0.8 up
to 2.5 mm



Louver upper pocket



Custom dimensions (mm):

Y:
 X:
 B:
 H:
 L:
 S:

STD size:
 C 50x10 H5,
 D75x15 85x15 H6

ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B Station	FLAMB14PA		FLAMB14MA		
C Station std size 50x10 mm	FLAMC14PA		FLAMC14MA		
C Station special size	FLAMC14CPA		FLAMC14CMA		
D Station std size 75x15 mm	FLAMD14APA		FLAMD14AMA		
D Station std size 85x15 mm	FLAMD14BPA		FLAMD14BMA		
D Station special size max L 90 mm	FLAMD14CPA		FLAMD14CMA		
E station special size max L 115 mm	FLAME14PA		FLAME14MA		

LANCE UP

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:

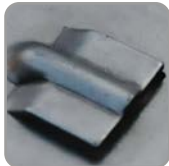
OPTIONS



2 BENDS



3 BENDS



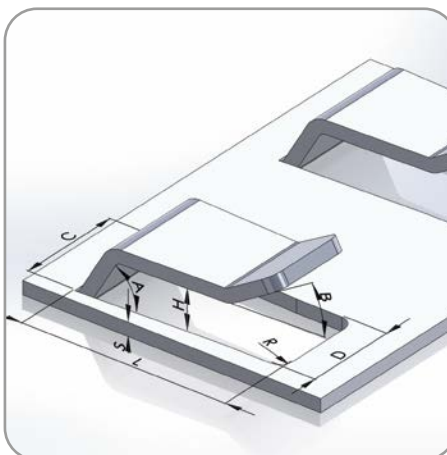
REINFORCED



SPECIAL



SNAPLOCK STYLE



Custom dimensions (mm):

A:
B:
C:
D:
H:
L:
R:
S:

ITEM	B STATION MAX L = 15 mm	€	B STATION MAX L = 15 mm	€	C STATION MAX L = 40 mm	€	C STATION MAX L = 40 mm	€
	PUNCH ASSEMBLY		DIE ASSEMBLY		PUNCH ASSEMBLY		DIE ASSEMBLY	
	FLAMB19PA		FLAMB19MA		FLAMC19PA		FLAMC19MA	
ITEM	D STATION MAX L = 70 mm	€	D STATION MAX L = 70 mm	€				
	PUNCH ASSEMBLY		DIE ASSEMBLY					
	FLAMD19PA		FLAMD19MA					

BRIDGE UP

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:

Machine model:

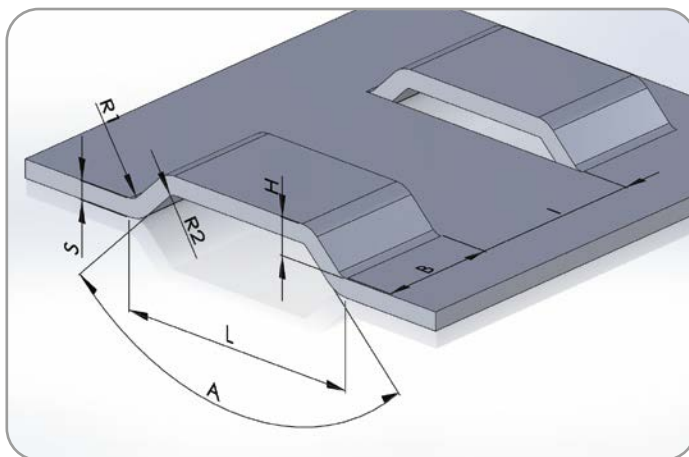
Material:

Thickness :

Order / Offer :

Item required:

Number of previous order:



Custom dimensions (mm):

A:

B:

H:

L:

L:

R1:

R2:

S:

B minimum:
1.5 x thickness (MS)
2 x thickness (SS)

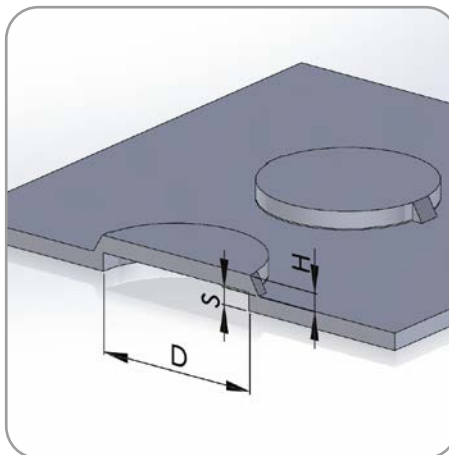
ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B Station single	FLAMB17PA 0 - 20 mm		FLAMB17MA 0 - 20 mm		
C Station single	FLAMC17PA 20.1 - 40 mm		FLAMC17MA 20.1 - 40 mm		
B Station double	FLAMB18PA 0 - 20 mm		FLAMB18MA 0 - 20 mm		
C Station double	FLAMC18PA 20.1 - 40 mm		FLAMC18MA 20.1 - 40 mm		

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:

KNOCK-OUT UP



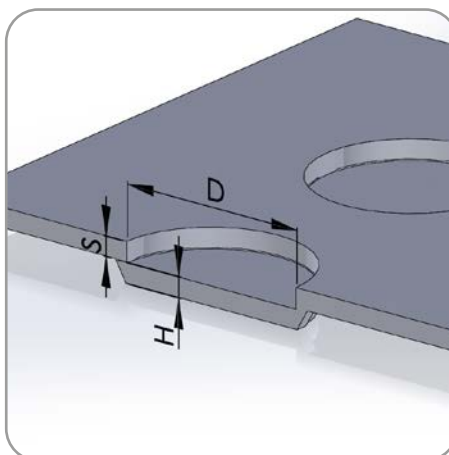
Custom dimensions (mm):

D:
H:
S:

ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B Station	FLAMB15PA 0 - 15 mm		FLAMB15MA 0 - 15 mm		
C Station	FLAMC15PA 15.1 - 45 mm		FLAMC15MA 15.1 - 45 mm		
D Station	FLAMD15PA 45.1 - 65 mm		FLAMD15MA 45.1 - 65 mm		
E Station	FLAME15PA 65.1 - 85 mm		FLAME15MA 65.1 - 85 mm		



KNOCK-OUT DOWN



Custom dimensions (mm):

D:
H:
S:

ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY (with ejector)	€	SET
B station punch assembly, die with ejector	FLAMB27PA		FLAMB27MA		

ITEM	PUNCH	€	STRIPPER	€	DIE ASSEMBLY (with ejector)	€	SET
C station set punch, stripper, die with ejector	AMC1PUT006C		AMC1PLT0T		FLAMC27MA		
D station set punch, stripper, die with ejector	AMD1PUT006C		AMD1PLT0T		FLAMD27MA		
E station set punch, stripper, die with ejector	AME1PUT006C		AME1PLT0T		FLAME27MA		

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
 Machine model:
 Material:
 Thickness :
 Order / Offer :
 Item required:
 Number of previous order:

OFFSET AND RIB TOOL

Max thickness:

2 mm AL , MS

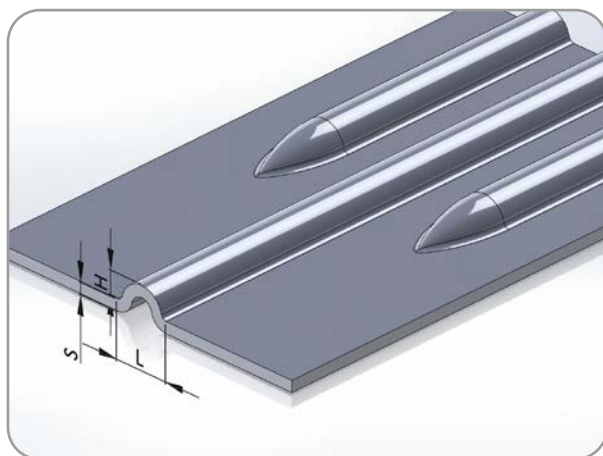
1.5 mm SS

Min thickness all mat. 0.8 mm



ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B STATION RIB	FLAMB35PA		FLAMB35MA		
B STATION OFFSET	FLAMB36PA		FLAMB35MA		

BEADING TOOL EMBOSS CONTINUOUS / OFFSET



Custom dimensions (mm):

S:

H:

L:

Material thickness:

0.8- 3 mm

Beading height:

2, 3, 4, 5 mm

Feed:

1 - 2 mm

ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B STATION	FLAMB39PA		FLAMB39MA		
C STATION	FLAMC39PA		FLAMC39MA		

LOGO

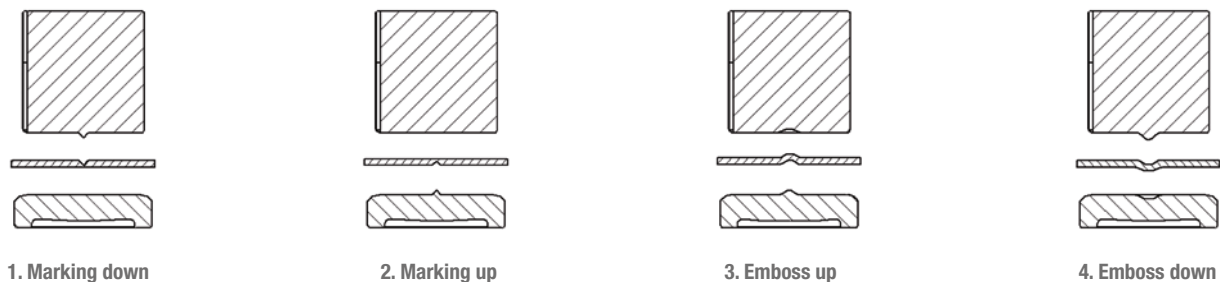
Logo type 1/2/3/4
Marking depth 0.4- 0.6

Send dxf,dwg logo file

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:



ITEM		PUNCH ASSEMBLY	€	DIE	€	SET
B Station Econo line	B Station 0 - 30 mm	FLAMB29P		FLAMB29M		
B station SMART style	B Station 0 - 30 mm	FLAMB29PA		FLAMB29M		
C station Econo line	C Station 30.1 - 50 mm	FLAMC29P		FLAMC29M		
C station SMART style	C Station 30.1 - 50 mm	FLAMC29PA		FLAMC29M		
D station Econo line	D Station 50.1 - 90 mm	FLAMD29P		FLAMD29M		
D station SMART style	D Station 50.1 - 90 mm	FLAMD29PA		FLAMD29M		
E station Econo line	E Station 90.1 - 115 mm	FLAME29P		FLAME29M		
E station SMART style	E Station 90.1 - 115mm	FLAME29PA		FLAME29M		
B station MARKED LOGO 1 side	B Station 0 - 30 mm	FLAMB29PC		AMB1MATP01D		
C station MARKED LOGO 1 side	C Station 30.1 - 50 mm	FLAMC29PC		AMC1MAT001T		
D station MARKED LOGO 1 side	D Station 50.1 - 90 mm	FLAMD29PC		AMD1MAT001T		
E station MARKED LOGO 1 side	E Station 90.1 - 115 mm	FLAME29PC		AME1MAT001T		



TRUMPF STYLE

GENERAL RULES TRUMPF STYLE TOOLING

In order to optimize the use of tooling we would recommend the following basic guidelines:

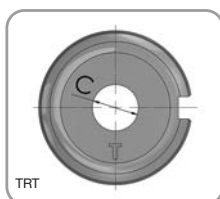
- a) the punching surface does not have to be lower than 60% of the used punch surface;
- b) in case of nibbling minimum feed must be $0.5 \times$ thickness, smaller rd punch with thickness 1 mm is 4 mm, smaller rd punch with thickness 2 mm is 6 mm, smaller rd punch with thickness 3 mm is 8 mm;
- c) before exceeding tons capability calculate punching force with formula at page 5;
- d) the tool dimension does not have to be lower than the material thickness and the shorter side must be at least 5% of the longest side;
- e) the advantage of the technical improvements of some models of dies punching penetration should be at least 2.5 mm;
- f) slitting tools must be appropriately sharpened and must have radius on corner (0.5 mm);
- g) the use of the steels commonly called High Speed Steel for our punches allows the punching of any steel; however in order to increase considerably the punching effectiveness and reduce cold welds, apply some type of coating, see pag. 6 and use oil lubricant on sheet surface;
- h) be sure that tooling cutting edge are without seizing or cold welding material; if any, remove them with a diamond file;
- i) radius on punch corner is 0.25 mm;
- j) ordering specifications: machine type, form, thickness and material, dimensions, desired delivery.



MACHINE GROUP:

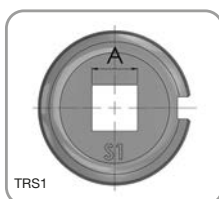
A: CN700, CN900 CN701, CN901	B: CN 901E, CN902 CS75, CS75,2	C: CN1200S_A CS15, CS20, CS20A, MP25_D	D: TRUMATIC 20, 20A, 202M	E: SUN400 TRUMATIC 150K, 151K, 152K, 180K, 1802K, 180KD, 180LK, 202K, 225K 235K, 300K, 400K
F: TRUMATIC 150, 180W, 180R, 185, 240, 240R, 250, 260R	G: TRUMATIC 20AW, 202W, 300W, 300LW, 300PW, 300TOP, 400W	H: TRUMATIC 500R, 200R, 190R, 600L	I: TRUMATIC 1000R, 2000R, 2020R, 3000R, 5000R, 6000L, 7000	S: MINIMATIC 100 TRUMATIC 120R, 160R

TRUMPF ROUND AND STANDARD SHAPE



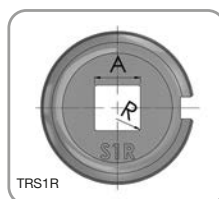
TRT

C:



TRS1

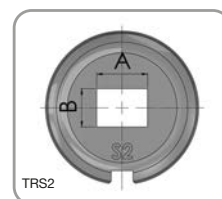
A:



TRS1R

A:

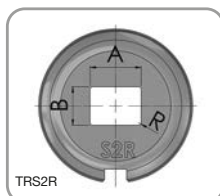
R:



TRS2

A:

B:

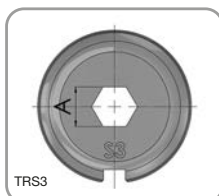


TRS2R

A:

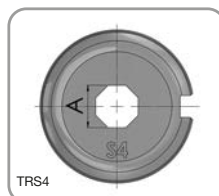
B:

R:



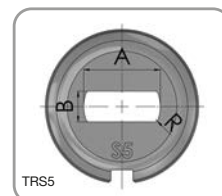
TRS3

A:



TRS4

A:

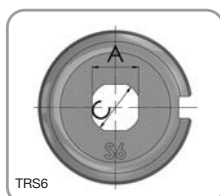


TRS5

A:

B:

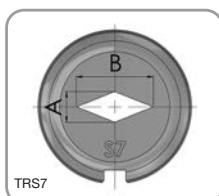
R:



TRS6

A:

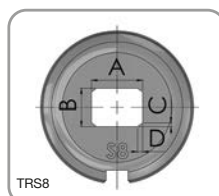
C:



TRS7

A:

B:



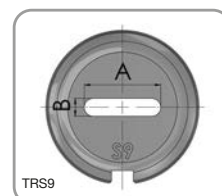
TRS8

A:

B:

C:

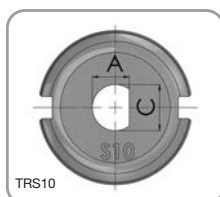
D:



TRS9

A:

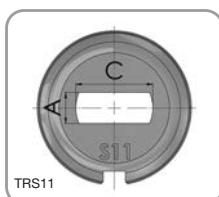
B:



TRS10

A:

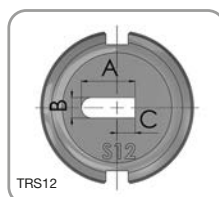
C:



TRS11

A:

C:



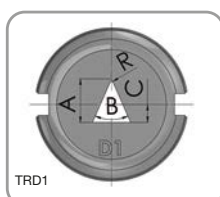
TRS12

A:

B:

C:

SPECIAL A



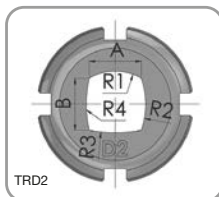
TRD1

A:

B:

C:

R1:



TRD2

A:

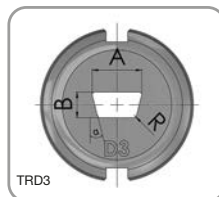
B:

R1:

R2:

R3:

R4:



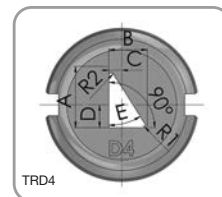
TRD3

A:

B:

 α :

R:



TRD4

A:

B:

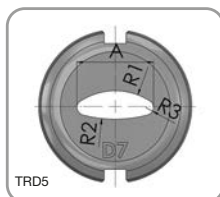
C:

D:

E:

R1:

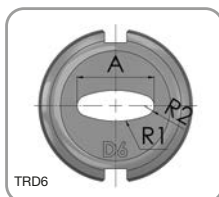
R2:



TRD5

A:

B:

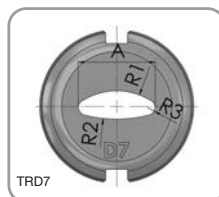


TRD6

A:

R1:

R2:



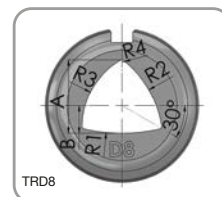
TRD7

A:

R1:

R2:

R3:



TRD8

A:

B:

R1:

R2:

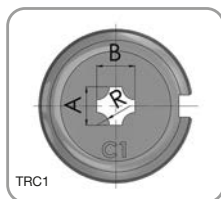
R3:

R4:

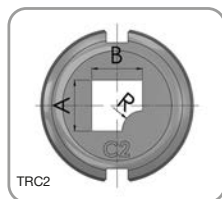
Die key:

Machine gr H, I ● Round 0° ● Std shape, Square S1, S1R 0° ● Machine gr A, B, C, D, E, F, G
Round 0° ● Standard shape 0-90° ● Square S1, S1R 0-135°

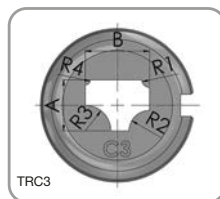
SPECIAL B



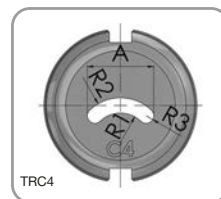
A: B:
R:



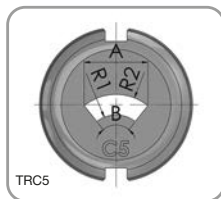
A: B:
R:



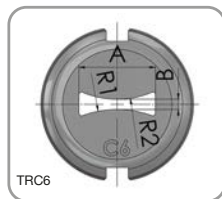
A: B:
R1: R2:
R3: R4:



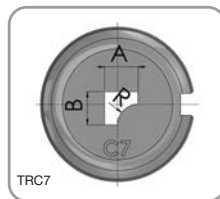
A: R1:
R2: R3:



A: B:
R1: R2:



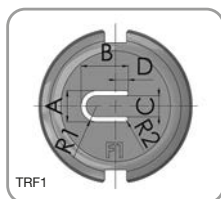
A: B:
R1: R2:



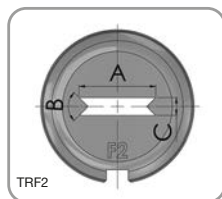
A: B:
R:

Note:
R<3 price is SPECIAL 2

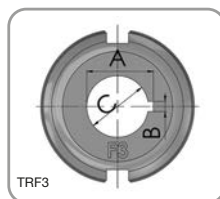
SPECIAL C & CUSTOMIZED



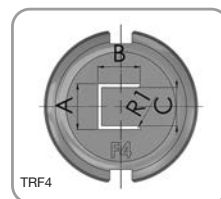
A: B:
C: D:
R1: R2:



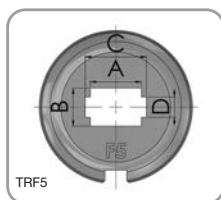
A: B:
C:



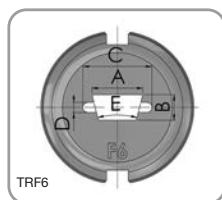
A: B:
C:



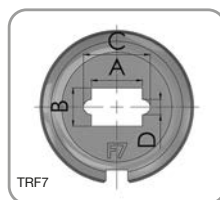
A: B:
C: R1:



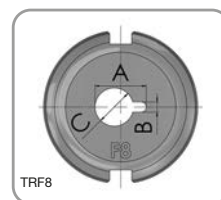
A: B:
C: D:



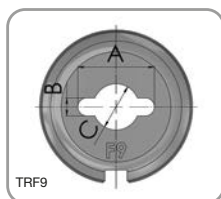
A: B:
C: D:
E:



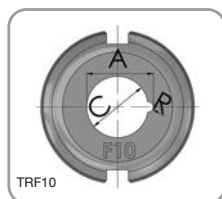
A: B:
C: D:



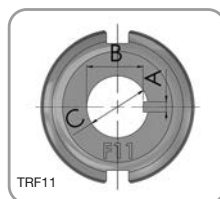
A: B:
C:



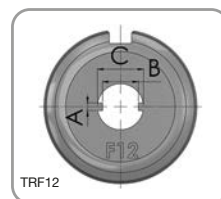
A: B:
C:



A: C:
R:



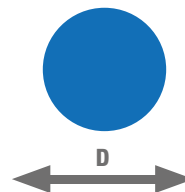
A: B:
C:



A: B:
C:



ROUND



Shapes:
TRT

SIZE	PUNCH Ø mm *	€	Probus	Geminus	Levatus
0	Ø6 mis 1.5 - 6.0 L59.5 TRA6PST006T L63 TRA6PSTL06T				
	Ø10.5 mis 1.5 - 6.0 L59.5 TRA105PST006T L63 TRA105PSTL06T				
	Ø10.5 mis 6.1 - 10.5 L59.5 TRA105PST006T L63 TRA105PSTL06T				
1	1.5 - 30.0 L74 TRA1PUT006T L77.5 TRA1PUTL06T				
2	30.1 - 40.0 L74 TRB2PUT006T L77.5 TRB2PUTL06T				
	40.1 - 51.0 L74 TRC1PUT006T L77.5 TRC1PUTL06T				
	51.1 - 60.0 L74 TRD1PUT006T** L77.5 TRD1PUTL06T**				
	60.1 - 76.2 L74 TRE1PUT006T*** L77.5 TRE1PUTL06T***				



PUNCH 0

max punching cap.50kN
D6 max thickness 2 mm
mat. 40 kg/mm²
D6 max thickness 1.5 mm
mat.60 kg/mm²
D10.5 max thickness 4 mm
mat.40 kg/mm²
D10.5 max thickness 2 mm
mat.60 kg/mm²
Punch grinding life 3 mm h 59,5
Punch grinding life 6.5 mm h 63,0



PUNCH

GR1 max thickness 10 mm
Mat 60kg/mm²
GR1 punching force 20 KN

GR2 max thickness 12 mm
Mat.60kg/mm²
GR2 punching force 30 KN*

Punch grinding life 3 mm h 74
Punch grinding life 6.5 mm h 77,5
*20 kN Whisper tool

HEAVY DUTY PUNCH WITH COLLAR Ø 40mm

GR2 TRC1PUTR06T+ € ...

Recommended when
punching force >20 tons



* Punch 0 HSS

** not suitable with urethan stripper

*** max Ø 70 mm with urethan stripper

SIZE	DIE	€
0/1 1.5 - 32 mm	TRA1MAT001T	
2 32.1 - 77.8 mm	TRE1MAT001T	



DIE

GR1 max thickness 10 mm
mat.60kg/mm², Max 250 kN
GR2 max thickness 12 mm
mat.60kg/mm², Max 180 kN
Die grinding life 1 mm
Key 0° round, standard

Machine without rotation*:
Keys 0 - 90° standard shape
Keys 0 - 135° square
* to specify

REINFORCED DIE

GR1 TRA1MATP01S + € ...

GR2 TRC1MATR01S + € ...

Recommended when punching force >15 tons



SIZE	STRIPPER GROUP MACHINE E - F - G	€	STRIPPER GROUP MACHINE H - I	€	STRIPPER GROUP MACHINE HACO OMES	€
0/1/2 1.5 - 76.2 mm	TRAELT0T		TRAELT500T		TRAELP0MT	

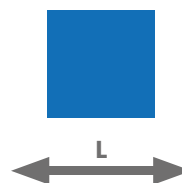
Punch size +1 mm

Stripper pin:
NSP060003016
€ ...





SQUARE



Shapes:
TRS1 - TRS1R

SIZE	PUNCH L mm *	€	Probus	Geminus	Levatus
0	1.0 - 4.2 L59.5 TRA6PST006S L63 TRA6PSTL06S				
	4.21 - 7.4 L59.5 TRA105PST006S L63 TRA105PSTL06S				
1	1.5 - 21.0 L74 TRA1PUT006S L77.5 TRA1PUTL06S				
2	21.1 - 28.0 L74 TRB2PUT006S L77.5 TRB2PUTL06S				
	28.1 - 35.0 L74 TRC1PUT006S L77.5 TRC1PUTL06S				
	35.1 - 42.0 L74 TRD1PUT006S** L77.5 TRD1PUTL06S**				
	42.1 - 53.8 L74 TRE1PUT006S*** L77.5 TRE1PUTL06S***				

PUNCH 0



max punching cap.50kN
D6 max thickness 2 mm
mat. 40 kg/mm²
D6 max thickness 1.5 mm
mat.60 kg/mm²
D10.5 max thickness 4 mm
mat.40 kg/mm²
D10.5 max thickness 2 mm
mat.60 kg/mm²
Punch grinding life 3 mm h 59,5
Punch grinding life 6.5 mm h 63,0

PUNCH



GR1 max thickness 10 mm
Mat 60kg/mm²
GR1 punching force 20 KN

GR2 max thickness 12 mm
Mat.60kg/mm²
GR2 punching force 30 KN*

Punch grinding life 3 mm h 74
Punch grinding life 6.5 mm h 77,5
*20 kN Whisper tool

HEAVY DUTY PUNCH WITH COLLAR Ø 40mm

GR2 TRC1PUTR06S+ € ...

Recommended when
punching force > 20 tons
Recommended radius
on corner 1 m



* Punch 0 HSS

** not suitable with urethan stripper

*** max diagonal 70 mm with urethan stripper

SIZE	DIE	€
0/1 1.5 - 22 mm	TRA1MAT001Q	
2 22.1 - 55 mm	TRE1MAT001Q	

DIE



GR1 max thickness 10 mm
mat.60kg/mm² ,Max 250 kN
GR2 max thickness 12 mm
mat.60kg/mm² ,Max 180 kN
Die grinding life 1 mm
Key 0° round, standard

Machine without rotation*:
Keys 0 - 90° standard shape
Keys 0 - 135° square
* to specify + € ...

REINFORCED DIE

GR1 TRA1MATP01S + € ...

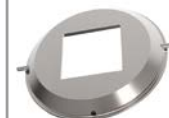
GR2 TRC1MATR01S + € ...

Recommended when punching force >15 tons
Recommended radius on corner 1 mm



Punch size +1 mm

STRIPPER



Stripper pin:
NSP060003016
€ ...

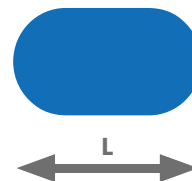
SIZE	STRIPPER GROUP MACHINE E - F - G	€	STRIPPER GROUP MACHINE H - I	€	STRIPPER GROUP MACHINE HACO OMES	€
0/1/2 1.5 - 53.8 mm	TAEPLT0S		TAEPLT500S		TAEPL0MS	



RECTANGLE



OVBROUND



Shapes:

TRS2 - TRS2R - TRS3 - TRS4 - TRS5 - TRS6 - TRS7 - TRS8
TRS9 - TRS10 - TRS11 - TRS12

SIZE	PUNCH L mm *	€	Probus	Geminus	Levatus
0	1.0 - 5.9 L59.5 TRA6PST006A L63 TRA6PSTL06A				
	5.91 - 10.4 L59.5 TRA105PST006A L63 TRA105PSTL06A				
1	1.5 - 30.5 L74 TRA1PUT006A L77.5 TRA1PUTL06A				
2	30.6 - 40.0 L74 TRB2PUT006A L77.5 TRB2PUTL06A				
	40.1 - 50.8 L74 TRC1PUT006A L77.5 TRC1PUTL06A				
	50.9 - 60.0 L74 TRD1PUT006A** L77.5 TRD1PUTL06A**				
	60.1 - 76.2 L74 TRE1PUT006A*** L77.5 TRE1PUTL06A***				

PUNCH 0



max punching cap. 50kN
D6 max thickness 2 mm
mat. 40 kg/mm²
D6 max thickness 1.5 mm
mat. 60 kg/mm²
D10.5 max thickness 4 mm
mat. 40 kg/mm²
D10.5 max thickness 2 mm
mat. 60 kg/mm²
Punch grinding life 3 mm h 59,5
Punch grinding life 6.5 mm h 63,0

PUNCH



GR1 max thickness 10 mm
Mat 60kg/mm²
GR1 punching force 20 KN

GR2 max thickness 12 mm
Mat. 60kg/mm²
GR2 punching force 30 KN*

Punch grinding life 3 mm h 74
Punch grinding life 6.5 mm h 77,5
*20 kN Whisper tool

HEAVY DUTY PUNCH WITH COLLAR Ø 40mm

GR2 TRC1PUTR06A + € ...

Recommended when
punching force > 20 tons
Recommended radius
on corner 1 mm



* Punch 0 HSS

** not suitable with urethan stripper

*** max diagonal 70 mm with urethan stripper

SIZE	DIE	€
0/1 1.5 - 32 mm	TRA1MAT001S	
2 32.1 - 77.8 mm	TRE1MAT001S	

DIE



GR1 max thickness 10 mm
mat. 60kg/mm², Max 250 kN
GR2 max thickness 12 mm
mat. 60kg/mm², Max 180 kN
Die grinding life 1 mm
Key 0° round, standard

Machine without rotation*:
Keys 0 - 90° standard shape
Keys 0 - 135° square
* to specify + € ...

REINFORCED DIE

GR1 TRA1MATP01S + € ...

GR2 TRC1MATR01S + € ...

Recommended when punching force > 15 tons
Recommended radius on corner 1 mm



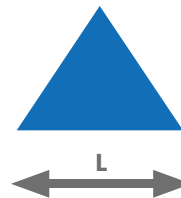
Punch size +1 mm

STRIPPER



SIZE	STRIPPER GROUP MACHINE E - F - G	€	STRIPPER GROUP MACHINE H - I	€	STRIPPER GROUP MACHINE HACO OMES	€
0/1/2 1.5 - 76.2 mm	TRAELT0S		TRAELT500S		TRAELPOMS	

Stripper pin:
NSP060003016
€ ...


Shapes:
TRD1 - TRD2 - TRD3 - TRD4 - TRD5 - TRD6 - TRD7 - TRD8

SIZE	PUNCH L mm *	€	Probus	Geminus	Levatus
0	1.5 - 10.4 L59.5 TRA105PST006D L63 TRA105PSTL06D				
1	1.5 - 30.5 L74 TRA1PUT006D L77.5 TRA1PUTL06D				
2	30.6 - 40.0 L74 TRB2PUT006D L77.5 TRB2PUTL06D				
	40.1 - 50.8 L74 TRC1PUT006D L77.5 TRC1PUTL06D				
	50.9 - 60.0 L74 TRD1PUT006D** L77.5 TRD1PUTL06D**				
	60.1 - 76.2 L74 TRE1PUT006D*** L77.5 TRE1PUTL06D***				


PUNCH 0

max punching cap.50kN
D6 max thickness 2 mm
mat. 40 kg/mm²
D6 max thickness 1.5 mm
mat.60 kg/mm²
D10.5 max thickness 4 mm
mat.40 kg/mm²
D10.5 max thickness 2 mm
mat.60 kg/mm²
Punch grinding life 3 mm h 59,5
Punch grinding life 6.5 mm h 63,0


PUNCH

GR1 max thickness 10 mm
Mat 60kg/mm²
GR1 punching force 20 KN

GR2 max thickness 12 mm
Mat.60kg/mm²
GR2 punching force 30 KN*

Punch grinding life 3 mm h 74
Punch grinding life 6.5 mm h 77,5
*20 kN Whisper tool

HEAVY DUTY PUNCH WITH COLLAR Ø 40mm
GR2 TRC1PUTR06D + € ...

Recommended when
punching force > 20 tons
Recommended radius
on corner 1 mm



* Punch 0 HSS

** not suitable with urethan stripper

*** max diagonal 70 mm with urethan stripper

SIZE	DIE	€
0/1 1.5 - 32 mm	TRA1MAT001D	
2 32.1 - 77.8 mm	TRE1MAT001D	


DIE

GR1 max thickness 10 mm
mat.60kg/mm² ,Max 250 kN
GR2 max thickness 12 mm
mat.60kg/mm² , Max 180 kN
Die grinding life 1 mm
Key 0° round, standard

Machine without rotation*:
Keys 0 - 90° standard shape
Keys 0 - 135° square
* to specify + € ...

REINFORCED DIE
GR1 TRA1MATP01S + € ...
GR2 TRC1MATR01S + € ...

Recommended when punching force >15 tons
Recommended radius on corner 1 mm

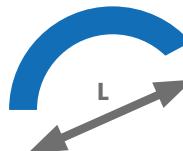


Punch size +1 mm

SIZE	STRIPPER GROUP MACHINE E - F - G	€	STRIPPER GROUP MACHINE H - I	€	STRIPPER GROUP MACHINE HACO OMES	€
0/1/2 1.5 - 76.2 mm	TRAELPT0D		TRAELPT500D		TRAELPOMD	

Stripper pin:
NSP060003016
€ ...





Shapes:

TRC1 - TRC2 - TRC3 - TRC4 - TRC5 - TRC6 - TRC7 R>2.95

SIZE	PUNCH L mm *	€	Probus	Geminus	Levatus
0	1.5 - 10.4 L59.5 TRA105PST006C L63 TRA105PSTL06C				
1	1.5 - 30.5 L74 TRA1PUT006C L77.5 TRA1PUTL06C				
2	30.6 - 40.0 L74 TRB2PUT006C L77.5 TRB2PUTL06C				
	40.1 - 50.8 L74 TRC1PUT006C L77.5 TRC1PUTL06C				
	50.9 - 60.0 L74 TRD1PUT006C** L77.5 TRD1PUTL06C**				
	60.1 - 76.2 L74 TRE1PUT006C*** L77.5 TRE1PUTL06C***				

PUNCH 0



max punching cap.50kN
D6 max thickness 2 mm
mat. 40 kg/mm²
D6 max thickness 1.5 mm
mat.60 kg/mm²
D10.5 max thickness 4 mm
mat.40 kg/mm²
D10.5 max thickness 2 mm
mat.60 kg/mm²
Punch grinding life 3 mm h 59,5
Punch grinding life 6.5 mm h 63,0

PUNCH



GR1 max thickness 10 mm
Mat 60kg/mm²
GR1 punching force 20 KN

GR2 max thickness 12 mm
Mat.60kg/mm²
GR2 punching force 30 KN*

Punch grinding life 3 mm h 74
Punch grinding life 6.5 mm h 77,5
*20 kN Whisper tool

HEAVY DUTY PUNCH WITH COLLAR Ø 40mm

GR2 TRC1PUTR06C + € ...

Recommended when
punching force > 20 tons
Recommended radius
on corner 1 m



* Punch 0 HSS

** not suitable with urethan stripper

*** max diagonal 70 mm with urethan stripper

SIZE	DIE	€
0/1 1.5 - 32 mm	TRA1MAT001F	
2 32.1 - 77.8 mm	TRE1MAT001F	

DIE



GR1 max thickness 10 mm
mat.60kg/mm², Max 250 kN
GR2 max thickness 12 mm
mat.60kg/mm², Max 180 kN
Die grinding life 1 mm
Key 0° round, standard

Machine without rotation*:
Keys 0 - 90° standard shape
Keys 0 - 135° square
* to specify

REINFORCED DIE

GR1 TRA1MATP01S + € ...

GR2 TRC1MATR01S + € ...

Recommended when punching force >15 tons
Recommended radius on corner 1 mm



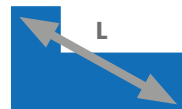
Punch size +1 mm

SIZE	STRIPPER GROUP MACHINE E - F - G	€	STRIPPER GROUP MACHINE H - I	€	STRIPPER GROUP MACHINE HACO OMES	€
0/1/2 1.5 - 76.2 mm	TRAELT0D		TRAELT500D		TRAELP0MF	

Stripper pin:
NSP060003016
€ ...

STRIPPER




Shapes:
TRC1 - TRC2 - TRC3 - TRC4 - TRC5 - TRC6 - TRC7 R<2.95
TRF1 - TRF2 - TRF3 - TRF4 - TRF5 - TRF6 - TRF7 - TRF8
TRF9 - TRF10 - TRF11 - TRF12

SIZE	PUNCH L mm *	€	Probus	Geminus	Levatus
0	1.5 - 10.4 L59.5 TRA105PST006F L63 TRA105PSTL06F				
1	1.5 - 30.5 L74 TRA1PUT006F L77.5 TRA1PUTL06F				
2	30.6 - 40.0 L74 TRB2PUT006F L77.5 TRB2PUTL06F				
	40.1 - 50.8 L74 TRC1PUT006F L77.5 TRC1PUTL06F				
	50.9 - 60.0 L74 TRD1PUT006F** L77.5 TRD1PUTL06F**				
	60.1 - 76.2 L74 TRE1PUT006F*** L77.5 TRE1PUTL06F***				

PUNCH 0


max punching cap.50kN
D6 max thickness 2 mm
mat. 40 kg/mm²
D6 max thickness 1.5 mm
mat.60 kg/mm²
D10.5 max thickness 4 mm
mat.40 kg/mm²
D10.5 max thickness 2 mm
mat.60 kg/mm²
Punch grinding life 3 mm h 59,5
Punch grinding life 6.5 mm h 63,0

PUNCH


GR1 max thickness 10 mm
Mat 60kg/mm²
GR1 punching force 20 KN

GR2 max thickness 12 mm
Mat.60kg/mm²
GR2 punching force 30 KN*

Punch grinding life 3 mm h 74
Punch grinding life 6.5 mm h 77,5
*20 kN Whisper tool

HEAVY DUTY PUNCH WITH COLLAR Ø 40mm
GR2 TRC1PUTR06F + € ...

Recommended when
punching force > 20 tons
Recommended radius
on corner 1 mm



* Punch 0 HSS

** not suitable with urethan stripper

*** max diagonal 70 mm with urethan stripper

SIZE	DIE	€
0/1 1.5 - 32 mm	TRA1MAT001F	
2 32.1 - 77.8 mm	TRE1MAT001F	

DIE


GR1 max thickness 10 mm
mat.60kg/mm² ,Max 250 kN
GR2 max thickness 12 mm
mat.60kg/mm² ,Max 180 kN
Die grinding life 1 mm
Key 0° round, standard

Machine without rotation*:
Keys 0 - 90° standard shape
Keys 0 - 135° square
* to specify

REINFORCED DIE
GR1 TRA1MATP01S + € ...
GR2 TRC1MATR01S + € ...

Recommended when punching force >15 tons
Recommended radius on corner 1 mm



Punch size +1 mm

STRIPPER


SIZE	STRIPPER GROUP MACHINE E - F - G	€	STRIPPER GROUP MACHINE H - I	€	STRIPPER GROUP MACHINE HACO OMES	€
0/1/2 1.5 - 76.2 mm	TRAELPT0D		TRAELPT500D		TRAELPOMF	

Stripper pin:
NSP060003016
€ ...



MULTITOOL

MT3 MT4 MT6

MODEL TC500R, TC200R, TC190R, TC600L

Max thickness 3.2 mm (40 kg/mm²) - 2 mm (60 kg/mm²)

Punching force 55 Kn

Punch grinding life 0.2 mm DIE 1 mm

MT5 , MT10

MODEL TC2000R, TC2020R, TC5000R, TC6000L

Max thickness 4.5 mm (40 kg/mm²)

Max thickness 3mm (60 kg/mm²)

Mt5 max punching force 87 kn

Mt10 max punching force 57 Kn

Punch grinding life 0.2 mm DIE 1 mm

MT3 MT6 - 10.5 mm



MT4 - 16 mm



MT5 - 16 mm



MT10 - 10.5 mm



MULTITOOL	ITEM MT3 - MT6	€	ITEM MT4	€	ITEM MT5	€	ITEM MT10	€
HSS PUNCH ROUND	TRA0PUM606T		TRA0PUM406T		TRA0PUM506T		TRA0PUM1006T	
DIE ROUND	TRA0MAM601T		TRA0MAM401T		TRA0MAM501T		TRA0MAM1001T	
HSS PUNCH STANDARD SHAPE	TRA0PUM606S		TRA0PUM406S		TRA0PUM506S		TRA0PUM1006S	
DIE STANDARD SHAPE	TRA0MAM601S		TRA0MAM401S		TRA0MAM501S		TRA0MAM1001S	

Coating	PROBUS	MT6 €	MT4 €	MT5 €	MT10 €
	GEMINUS	MT6 €	MT4 €	MT5 €	MT10 €
	LEVATUS	MT6 €	MT4 €	MT5 €	MT10 €



REVOTOOL BOSCHERT 6, 7-8 POSITION

REVO 7-8



REVO 7-8



REVO 6



REVO 6



ITEM	PUNCH REVO 7-8	€	DIE REVO 7-8	€	PUNCH REVO 6	€	DIE REVO 6	€
ROUND	TRA0PUM806T		TRA0MAM801T		BOA0PUM606T		BOA0MAM606T	
STANDARD	TRA0PUM806S		TRA0MAM801S		BOA0PUM606S		BOA0MAM606S	
SPECIAL B	TRA0PUM806C		TRA0MAM801D		BOA0PUM606C		BOA0MAM606D	
SPECIAL A	TRA0PUM806D		TRA0MAM801D		BOA0PUM606D		BOA0MAM606D	
SPECIAL CUSTOMIZED	TRA0PUM806F		TRA0MAM801D		BOA0PUM606F		BOA0MAM606D	

Coating	PROBUS	REVO7-8 €	REVO6 €
	GEMINUS	REVO7-8 €	REVO6 €
	LEVATUS	REVO7-8 €	REVO6 €



SLITTING TOOL

Max. Thickness 3 mm
Radius on corner 0.5 mm

BLADE HOLDER 30x5 56x5 76.2x5 WITH INTEGRATED ALIGN.RING

ITEM	€
TR56/76PL	



30 x 5



56 x 5



76.2 x 5



BLADE	30X5		56X5		76.2X5	
	HSS	€	HSS	€	HSS	€
RECT	TR30LRE06		TR56LRE06		TR76LRE06	
TRAP	TR30LTP06		TR56LTP06		TR76LTP06	
MICROJ	TR30LMJ06		TR56LMJ06		TR76LMJ06	

30 x 5



56 x 5



76.2 x 5

BLADE
PROBUS

BLADE PROBUS COATING	30X5		56X5		76.2X5	
	HSS + Probus	€	HSS + Probus	€	HSS + Probus	€
RECT	TR30LRE06H		TR56LRE06H		TR76LRE06H	
TRAP	TR30LTP06H		TR56LTP06H		TR76LTP06H	
MICROJ	TR30LMJ06H		TR56LMJ06H		TR76LMJ06H	

30 x 5



56 x 5



76.2 x 5

BLADE
GEMINUS

BLADE GEMINUS COATING	30X5		56X5		76.2X5	
	HSS + Geminus	€	HSS + Geminus	€	HSS + Geminus	€
RECT	TR30LRE06F		TR56LRE06F		TR76LRE06F	
TRAP	TR30LTP06F		TR56LTP06F		TR76LTP06F	
MICROJ	TR30LMJ06F		TR56LMJ06F		TR76LMJ06F	



SLITTING TOOL

Max. Thickness 3 mm
Radius on corner 0.5 mm



SLITTING TOOL	30 x 5		56 x 5		76.2 x 5	
	ITEM	€	ITEM	€	ITEM	€
DIE HOLDER (with shims)	TRCEMAIN90		TRCEMAIN90		TRCFMAIN76TT	
DIE HOLDER WITH BRUSHES (with shims)					TRCFMAIN76BR	
DIE SHIMS 1 SET INCLUDES 0.2 0.3 0.5 mm	TRCEMAINSP56		TRCEMAINSP56		TRCEMAINSP76	



SLITTING TOOL	30x5		56x5		76.2x5	
	ITEM	€	ITEM	€	ITEM	€
RECTANGLE PAIR HSS DIE INSERT MAX THICKNESS 3 mm	—		TRCEIM56P206		TRCFIM76P206	
MICROJ HSS DIE INSERT MAX THICKNESS 3mm mm	TRCEIM309MI6		TRCEIM569MI6		TRCFIM76TMI06	

CL: 0,1 - 0,15 - 0,2 - 0,3 - 0,4 - 0,6 Different CL + 25%

SLITTING TOOL CLOSE TO DEFORMATION

Minimum distance to emboss:
min 35mm H5, min 22 H2
URETHAN STRIPPER



ITEM	56X5 max thickness 2.5 mm		76.2x5 max thickness 2 mm	
	ITEM	€	ITEM	€
PUNCH ASSEMBLY	TRD1PA56X5		TRE1PA76.2X5	
PUNCH	TRD1PU56X5		TRE1PU76.2X5	
PAIR OF URETHAN STRIPPER	TRD1PLPO56X5		TRE1PLPO76.2X5	
PAIR OF SCREW	TRDEVI76.2X5		TRDEVI76.2X5	
ALIGNMENT RING SIZE2	TRCFAATP		TRCFAATP	

Coating		€		€		€
56x5	PROBUS		GEMINUS		LEVATUS	
76.2x5						



ALIGNMENT RING



FITTING	MACHINE GR E, F, G, H, I	
	ITEM	€
ALIGNMENT RING SIZE 1	TRABAATI	
ALIGNMENT RING SIZE 2	TRCFAATP	
ALIGNMENT RING HD 40 mm	TRAFATR	
ALIGNMENT KEY	TRAFACHT0	
ALIGNMENT KEY RING HD	TRAFACHTR	

DIE ADAPTOR



FITTING	MACHINE GR E, F, G, H, I	
	ITEM	€
DIE ADAPTOR ALL MODELS SIZE 1/2	TRABPMT0	
DIE ADAPTOR ALL MODELS SIZE 1/2 WITH BRUSHES	TRABPMT0SP	
DIE HOLDER SIZE 2	TRCEPMT0*	

* Only for machines group H, I

PUNCH CHUCK



FITTING	ITEM	€	ITEM	€	ITEM	€
PUNCH CHUCK	D6 SIZE 0A - TRA6PPT0T		D10.5 SIZE 0B - TRA105PPT0T		SCREW M14 - MGR14MBX135	

TOOL CARTRIDGE

FITTING	ITEM	€
TOOL CARTRIDGE	TRAACP	





SHIM



FITTING	TRAOSPMAM5	€	TRAOSPMAM10	€	TRABSPMA	€	TRCESPMA	€
DIE SHIMS mm	0,1		0,1		0,1		0,1	
	0,2		0,2		0,3		0,3	
	0,3		0,3		0,5		0,5	
	0,5		0,5		1		1	

URETHAN STRIPPER



0 - 30,5 mm



30,6 - 40 mm



40,1 - 51 mm



51,1 - 70 mm

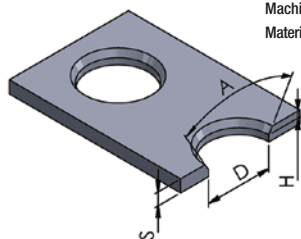


STRIPPER	ITEM	€	ITEM	€	ITEM	€	ITEM	€
ROUND	TRA1PLPOT		TRB2PLPOT		TRC1PLPOT		TRE1PLPOT	
STANDARD	TRA1PLPOS		TRB2PLPOS		TRC1PLPOS		TRE1PLPOS	
SPECIAL A - B	TRA1PLPOD		TRB2PLPOD		TRC1PLPOD		TRE1PLPOD	



FORMING TOOL DATA SHEET

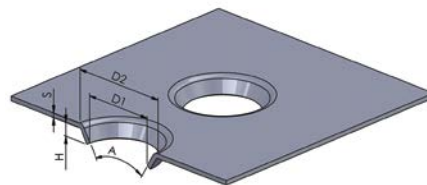
COUNTER SINK DOWN



Machine Model: _____
Material: _____

A: _____
D: _____
H: _____
S: _____

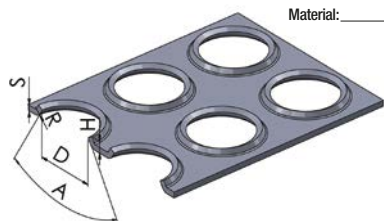
COUNTER SINK DOWN FORMING AFTER PRE PIERCE



Machine Model: _____
Material: _____

A: _____
D1: _____
D2: _____
H: _____
S: _____

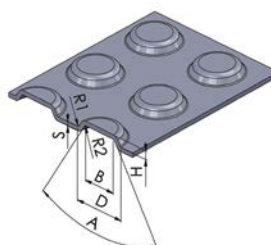
COUNTER SINK UP FORMING AFTER PRE PIERCE



Machine Model: _____
Material: _____

A: _____
B: _____
D: _____
H: _____
R: _____
S: _____

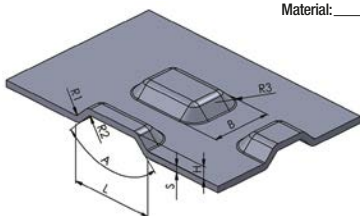
EMBOSS UP ROUND



Machine Model: _____
Material: _____

A: _____
B: _____
D: _____
H: _____
R1: _____
R2: _____
S: _____

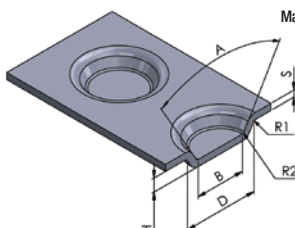
EMBOSS UP RECTANGULAR



Machine Model: _____
Material: _____

A: _____
B: _____
L: _____
H: _____
R1: _____
R2: _____
R3: _____
S: _____

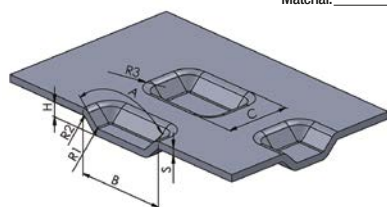
EMBOSS DOWN ROUND



Machine Model: _____
Material: _____

A: _____
B: _____
D: _____
H: _____
S: _____
R1: _____
R2: _____

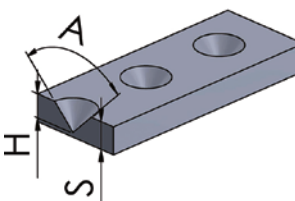
EMBOSS DOWN RECTANGULAR



Machine Model: _____
Material: _____

A: _____
B: _____
C: _____
H: _____
R1: _____
R2: _____
R3: _____
S: _____

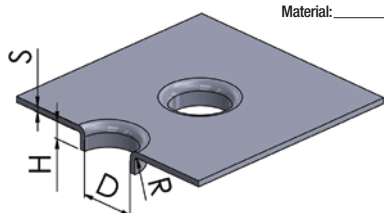
FORM DOWN MARKING TOOL



Machine Model: _____
Material: _____

A: _____
H: _____
S: _____

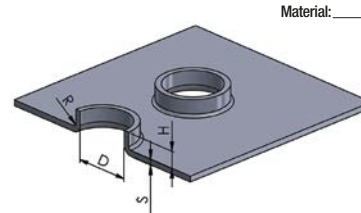
EXTRUSION DOWN ROUND



Machine Model: _____
Material: _____

D: _____
H: _____
R: _____
S: _____

EXTRUSION UP ROUND

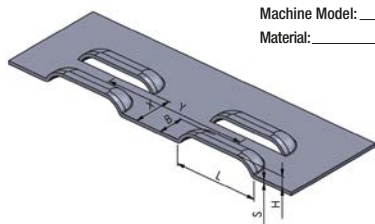


Machine Model: _____
Material: _____

D: _____
H: _____
R: _____
S: _____

FORMING TOOL DATA SHEET

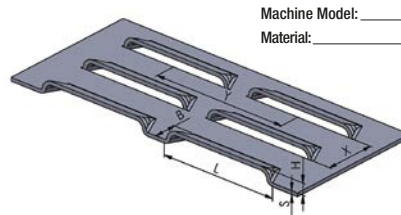
LOUVER



Machine Model: _____
Material: _____

B: _____
H: _____
L: _____
S: _____
X: _____
Y: _____

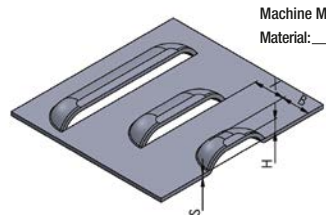
LOUVER TRUMPF



Machine Model: _____
Material: _____

B: 12
H: 60
L: 5.5
S: 0.8 - 2.5
X: 18
Y: 70

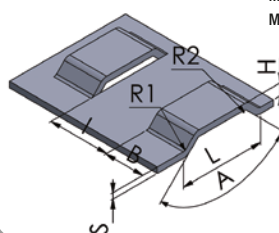
CONTINUOUS LOUVER



Machine Model: _____
Material: _____

B: _____
H: _____
S: _____
X: _____

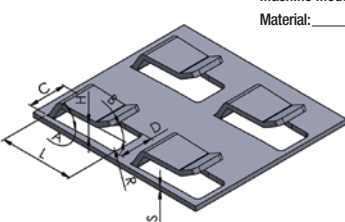
BRIDGE UP



Machine Model: _____
Material: _____

A: _____
B: _____
H: _____
L: _____
I: _____
R1: _____
R2: _____
S: _____

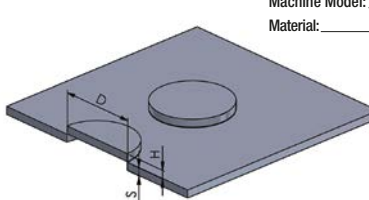
LANCE UP_3 BENDS



Machine Model: _____
Material: _____

A: _____
B: _____
C: _____
D: _____
H: _____
L: _____
R: _____
S: _____

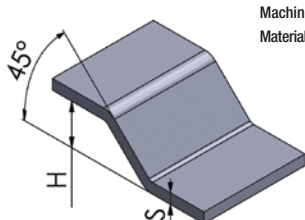
SHEAR BUTTON



Machine Model: _____
Material: _____

D: _____
H: _____
S: _____

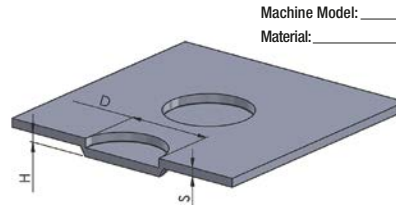
BEND 45°



Machine Model: _____
Material: _____

H: _____
S: _____

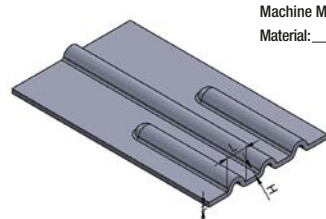
KNOCK-OUT DOWN



Machine Model: _____
Material: _____

D: _____
H: _____
S: _____

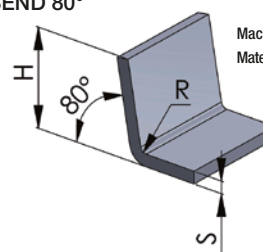
EMBOSS CONTINUOUS



Machine Model: _____
Material: _____

H: _____
L: _____
S: _____

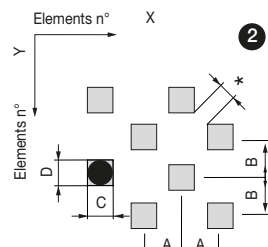
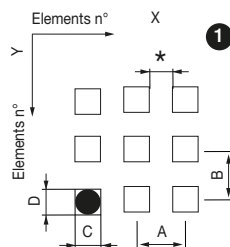
BEND 80°



Machine Model: _____
Material: _____

H: _____
R: _____
S: _____

CLUSTER



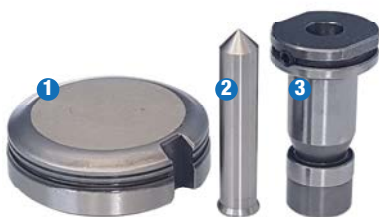
Punch dimensions (mm):

A: _____
B: _____
C: _____
D: _____

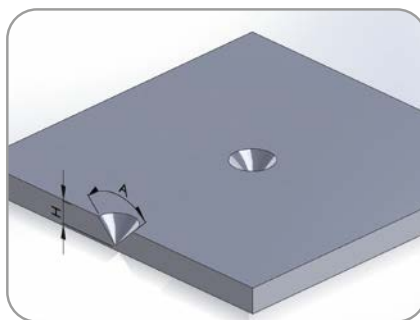
Round: _____
Shape: _____
Pattern: 1/2
Nx: _____
Ny: _____

* See data pag. 40

MARKING



3. PUNCH CHUCK
2. MARKING PUNCH 1 - 4.5 mm
1. MARKING PUNCH 5 - 8 mm
1. DIE



Custom dimensions (mm)

A :

H:

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:

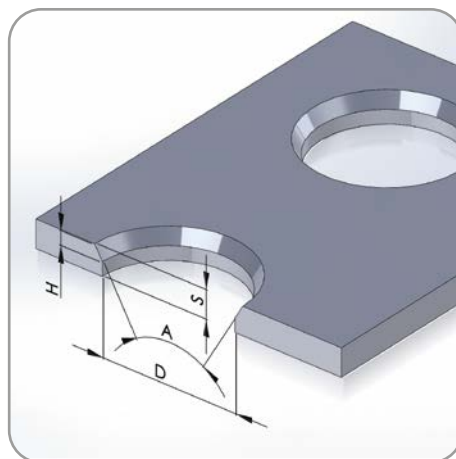
ITEM	PUNCH CHUCK	€	DIE	€	PUNCH TH1 - 4.5 mm	€	PUNCH TH5 - 8 mm	€
MARKING TOOL	TRA105PPT0T		TRA1MAT001T		FLTRA23P1 - 4.5		FLTRA23P4.5 - 8	

COUNTERSINK AFTER PREPIERCE

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:



Custom dimensions (mm)

A :

D:

H:

S:

Order with prepierce tool:

☐ Yes ☐ No

Prepierce dimension:
 $D_{max} - [(D_{max} - D_{min}) * 0,7]$

ITEM	PUNCH	€	DIE	€
COUNTERSINK AFTER PRE PUNCH	FLTRA09P		TRA1MAT001T	

COUNTERSINK DATA

DIN EN ISO 10642 (hexagon socket)

SCREW	Upper Ø mm	Thickness mm
M3	7.1	1 - 3
M4	9.4	1.5 - 3
M5	11.7	1.5 - 4
M6	14	2 - 4
M8	18.5	2 - 4

COUNTERSINK DATA

DIN EN ISO 2009 and 7046-1

SCREW	Upper Ø mm	Thickness mm
M2.5	5.9	1 - 3
M3	6.7	1 - 3
M4	8.8	1.5 - 3
M5	10.6	1.5 - 4
M6	12.7	2 - 4
M8	16.7	2 - 4

MAXIMUM COUNTERSINK DEPTH

MATERIAL TYPE	Thickness mm	H Maximum S%
Aluminum, Copper, Brass	0.8 - 5	95
Mild Steel, Galvanized Steel	0.8 - 3	85
	3.1 - 5	60
Stainless Steel	0.8 - 2	85
	2.1 - 3	60
	3.1 - 5	50

EMBOSS UP

Sheet thickness 0.5 - 3 mm
Maximum size with solid Die 60 mm
Maximum size with Die with Springs 42 mm

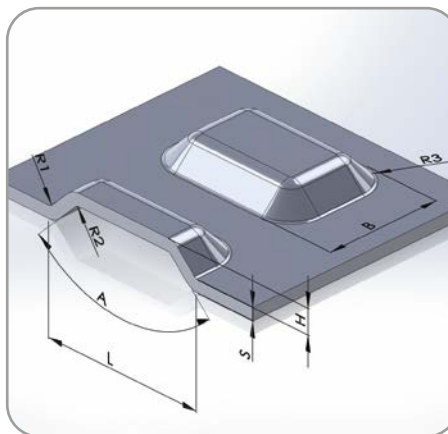
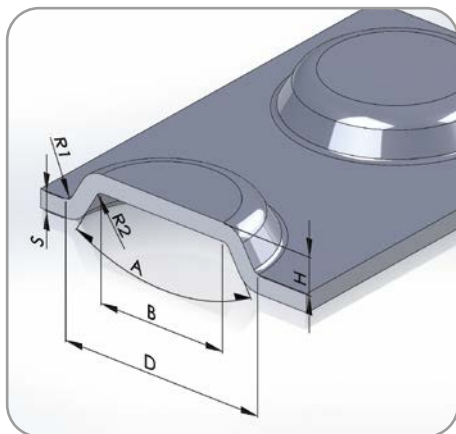
Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:

Solid Die sample "A" - min 90°

Die with Spring sample



Custom dimensions (mm)
ROUND/SHAPE :

A:
B:
D:
H:
L:
R1:
R2:
R3:
S:

ROUND	PUNCH	€	SOLID DIE	€	DIE ASSEMBLY	€	ALIGN. RING	€	URETHAN STRIPPER (OPT)	€
0 - 15 mm	FLTRB01BP		FLTRB01MA (S1)		FLTRB03MA		TRABAATI		FLTRB12E	
15.1 - 23 mm	FLTRB01B2P		FLTRB01ME (S2)		FLTRB03MA		TRCFAATP		FLTRB12EB2	
23.1 - 30 mm	FLTRB01CP		FLTRB01ME (S2)		FLTRB03MA		TRCFAATP		FLTRB12EC	
30.1 - 42 mm	FLTRB01DP		FLTRB01ME (S2)		FLTRB03MA		TRCFAATP		FLTRB12ED	
42.1 - 60 mm	FLTRB01EP		FLTRB01ME (S2)		FLTRB03MA		TRCFAATP			

SHAPE Diagonal	PUNCH	€	SOLID DIE	€	DIE ASSEMBLY	€	ALIGN. RING	€	URETHAN STRIPPER (OPT)	€
0 - 15 mm	FLTRB02BP		FLTRB02MA (S1)		FLTRB04MA		TRABAATI		FLTRB12E	
15.1 - 23 mm	FLTRB02B2P		FLTRB02ME (S2)		FLTRB04MA		TRCFAATP		FLTRB12EB2	
23.1 - 30 mm	FLTRB02CP		FLTRB02ME (S2)		FLTRB04MA		TRCFAATP		FLTRB12EC	
30.1 - 42 mm	FLTRB02DP		FLTRB02ME (S2)		FLTRB04MA		TRCFAATP		FLTRB12ED	
42.1 - 60 mm	FLTRB02EP		FLTRB02ME (S2)		FLTRB04MA		TRCFAATP			

COUNTERSINK UP FORMING AFTER PRE PIERCE

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:

Machine model:

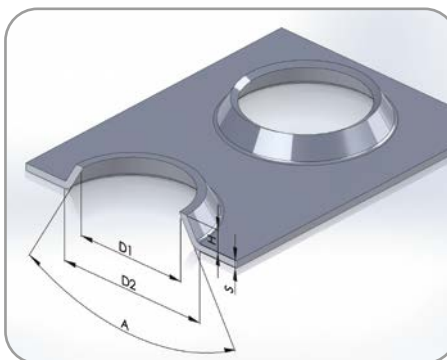
Material:

Thickness :

Order / Offer :

Item required:

Number of previous order:



Custom dimensions (mm)

Direction: Up

A:

D1:

D2:

H:

S:

Pre-hole tool needed:

☐ Yes

☐ No

Pre-pierce diameters (mm)

Thickness 0.5: (M2.5 2.0) (M3 2.4) (M4 3.3) (M5 4.2) (M6 5.0) (M8 6.2) (M10 7.5)

Thickness 1.0: (M2.5 2.2) (M3 2.6) (M4 3.5) (M5 4.4) (M6 5.2) (M8 6.5) (M10 7.8)

Thickness 1.5: (M2.5 2.3) (M3 2.7) (M4 3.6) (M5 4.5) (M6 5.3) (M8 6.8) (M10 8.0)

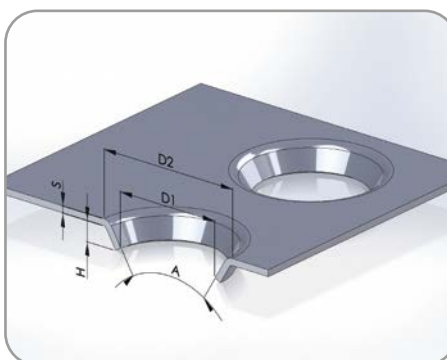
Thickness 2.0: (M2.5 2.4) (M3 2.8) (M4 3.7) (M5 4.6) (M6 5.4) (M8 7.0) (M10 8.2)

Thickness 2.5: (M2.5 2.5) (M3 3.0) (M4 3.8) (M5 4.8) (M6 5.5) (M8 7.2) (M10 8.5)

Thread	Upper Ø mm
M2.5	5.9
M3	7.1
M4	9.4
M5	11.7
M6	14
M8	18.5
M10	23

ITEM	PUNCH	€	DIE ASSEMBLY	€	ALIGN.RING	€	SET
M2.5 M3 M4 M5 M6	FLTRB01BP		FLTRB03MA		(GR1)		
M8 M10	FLTRB01B2P		FLTRB03MA		(GR2)		

COUNTERSINK DOWN FORMING AFTER PRE PIERCE



Custom dimensions (mm)

Direction: Up

A:

D1:

D2:

H:

S:

Pre-hole tool needed:

☐ Yes

☐ No

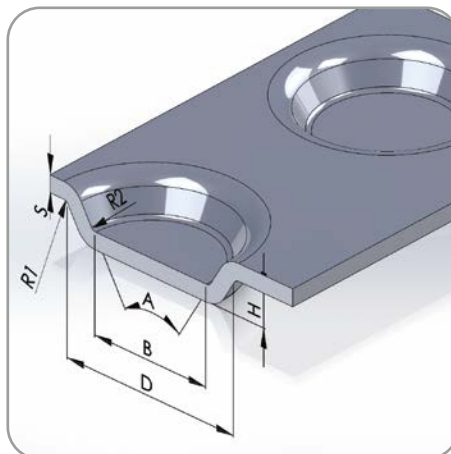
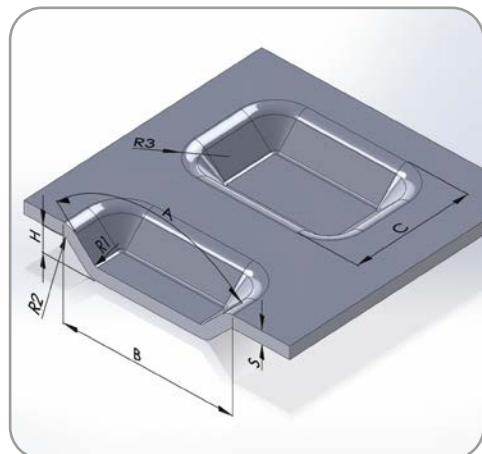
ITEM	PUNCH	€	SOLID DIE	€	ALIGN.RING	€
M2.5 M3 M4 M5 M6	FLTRB05BP		FLTRB01MA (S1)		TRABAATI	
M8 M10	FLTRB05CP		FLTRB05MA (S2)		TRCFAATP	

EMBOSS DOWN

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:



Custom dimensions (mm)
ROUND/SHAPE :

Direction: Down

A:
B:
C:
H:
R1:
R2:
R3:
S:

ROUND	PUNCH	€	URETHAN STRIPPER (optional)	€	DIE 2	€***	ALIGN.RING	€
0 - 15 mm	FLTRB05BP		FLTRB12E		FLTRB05MA		(GR1)	
15.1 - 30 mm	FLTRB05CP		FLTRB12EC		FLTRB05MA		(GR2)	
30.1 - 42 mm	FLTRB05EP		FLTRB12ED		FLTRB05MA		(GR2)	
SHAPE Diagonal	PUNCH	€/**	URETHAN STRIPPER (optional)	€	DIE 2	€***	ALIGN.RING	€
0 - 15 mm	FLTRB06BP		FLTRB12E		FLTRB06MA		(GR1)	
15.1 - 23 mm	FLTRB06B2P		FLTRB12EB		FLTRB06ME		(GR2)	
23.1 - 30 mm	FLTRB06CP		FLTRB12EC		FLTRB06ME		(GR2)	
30.1 - 40 mm	FLTRB06EP		FLTRB12ED		FLTRB06ME		(GR2)	

* GRINDED - ** MILLED - *** DIE WITH EJECTORS + €

CLUSTER

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:

Machine model:

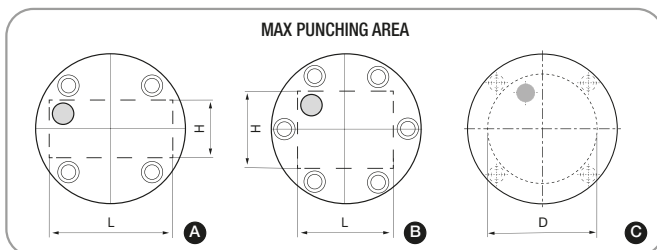
Material:

Thickness :

Order / Offer :

Item required:

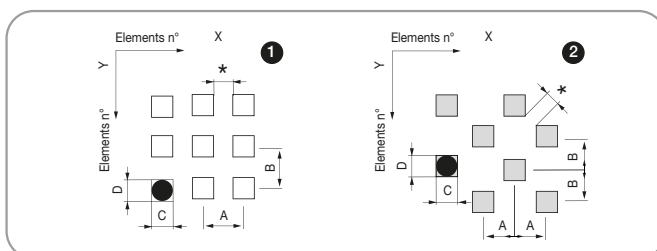
Number of previous order:



	SOLID	WITH REPLACEABLE INSERTS				
		A		B		C
		L (mm)	H (mm)	L (mm)	H (mm)	D (mm)
II	Ø 76	65	25	45	40	Ø 55
I	Ø 30/38*	-	-	-	-	-

* machine group S

If particular dimensions or holes are needed, our technical department is willing to find the solution that fits your needs.



Punch dimensions (mm):

A:
B:
C:
D:

Round:

Shape:

Pattern: 1/2

Nx:

Ny:

* Minimum size 1.5 x thickness.

Minimum distance between rounds 2.5 thickness

If size C < 30 mm example 20 x 3 minimum distance between shapes 3 time thickness

If size C > 30 mm example 40 x 3 minimum distance between shapes 4 time thickness

ITEM	SOLID PUNCH H74	SOLID PUNCH H77.5	€	ALIGNMENT RING	€
1.5 - 30	TRA1PUT006M	TRA1PUTL06M		TRABAATI	
30.1 - 40	TRB2PUT006M	TRB2PUTL06M		TRCFAATP	
40.1 - 50.8	TRC1PUT006M	TRC1PUTL06M		TRCFAATP	
50.9 - 60	TRD1PUT006M	TRD1PUTL06M		TRCFAATP	
60.1 - 76.2	TRE1PUT006M	TRE1PUTL06M		TRCFAATP	

PUNCHES:

* STANDARD SHAPE € X QTY

SOLID PUNCH SPECIAL 0-1-2 ADD € + IF PERIMETER <50 mm € X QTY

IF > 50 mm € X QTY

ITEM	INSERTS STYLE - ROUND *	INSERT STYLE - SHAPE **	€	ALIGNMENT RING	€
AREA 65X25 OR 45X40	FLTRB20PA	FLTRB21PA	Ø Ø	TRAFAATR	
INTEGRATED ALIGN.RING VERSION AREA Ø 55	FLTRB21IPA		Ø Ø		

* ROUND size mm	2 - 8	8,1 - 12	12,1 - 15	15,1 - 20
Add each Ø	€	€	€	€
Spare punch HSS	€	€	€	€

** SHAPE diagonal size mm	2-20 Square and rectangle	>20 Square and rectangle	2-20 Obround and hexagon	>20 Obround and hexagon
Add each shape	€	€	€	€
Spare punch HSS	€	€	€	€

PUNCHES:

REPLACEABLE INSERT STYLE PUNCH ADD: SPC. 0 € X QTY, SPC.1 € X QTY

SPC. 2 € X QTY (+ 50% IF PERIMETER > 50 mm)

ITEM	STRIPPER MACHINES GR E - F - G	STRIPPER MACHINES GR H - I	€
1.5 - 76.2	TRAELT0M	TRAELT500M	Ø Ø

ITEM	DIE SIZE 1	€	DIE SIZE 2	€	REINFORCED DIE SIZE 2	€
	TRA1MATP06M	Ø Ø	TRE1MAT006M	Ø Ø	TRE1MATR01M	

DIES and STRIPPERS:

ADD 15% DIE SIZE <3.5 mm; ADD 10% STRIPPER SIZE < 3.5 mm; ADD 15% DIE AND STRIPPER SPECIAL 0-1-2

ADD 20% DIE IF PERIMETER SHAPE >50 mm (ex SQUARE 15 mm), ADD 20% REINFORCED DIE



SOLID PUNCH



INSERTS STYLE



ROUND



SHAPE



STRIPPER



DIE

DIAGONAL size mm	2 - 6	6.1 - 10	10.1 - 12	12.1 - 15	> 15.1
Coating Probus each Ø	€	€	€	€	€
Coating Geminus or Levatus each Ø	€	€	€	€	€

LOUVER STANDARD 60 x 12 AND SPECIAL SIZE

Standard size 60 x 12
Technical info:
Thickness: 0.8 ÷ 2.5 mm
Height : 5.5 mm
Spacing X 18 mm, Y 70 mm



Notes and personal drafts.
Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:

TRUMPF STYLE DIM. (mm)

Y: 70
X: 18
B: 12
H: 5.5
L: 60
S: 0.8 - 2.5

Probus Coating:

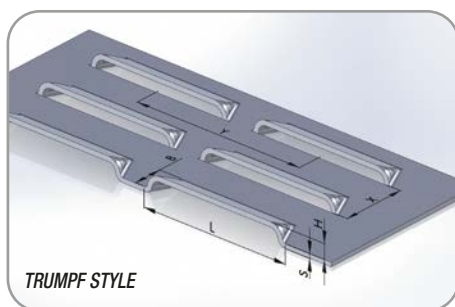
☐ Yes

TRUMPF CUSTOMIZED DIM. (mm)

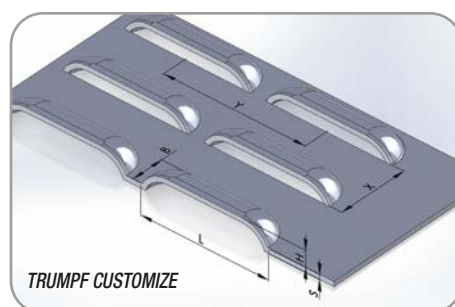
Y:
X:
B:
H:
L:
S:

Probus Coating:

☐ Yes



TRUMPF STYLE



TRUMPF CUSTOMIZE

LOUVER SIZE:	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	ALIGN.RING	€	SET
Standard 60 x 12 mm	FLTRB14PA		FLTRB14M		(GR2)		
Special size (max 70 mm)	FLTRB14PB		FLTRB14MB		(GR2)		
SPARES	Upper revolving blade 60x12 Probus		Lower punch 60x12 Probus				

CONTINUOUS LOUVER

PUNCH SIZE 24 x 12 mm
Standard: L 12, H 5.5
Technical info:
Thickness: 0.8 ÷ 2.5 mm,
Height: 5.5 mm,
Spacing minimum 20 mm

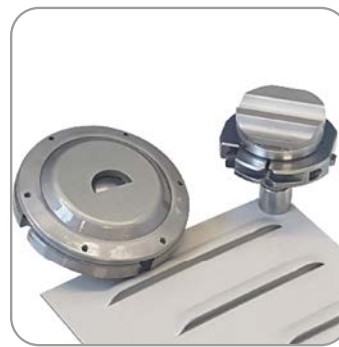
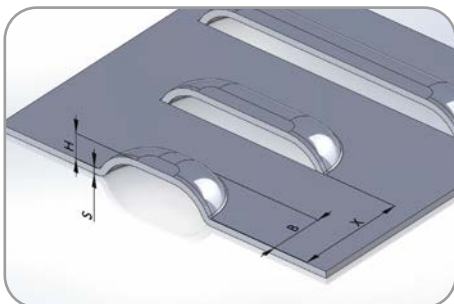
SPECIAL DIM. (mm)

B:
H:
S:
X:

Probus coating:

☐ Yes

☐ No



LOUVER SIZE:	PUNCH	€	DIE	€	DIE ASSEMBLY	€	ALIGN.RING	€
24x12 h 5.5	FLTRB13P		FLTRB13M1 (GR1)		FLTRB14MB		(GR2)	
			FLTRB13M2 (GR2)					

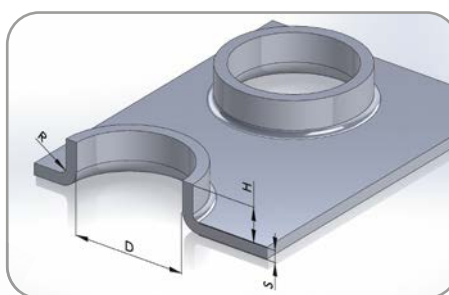
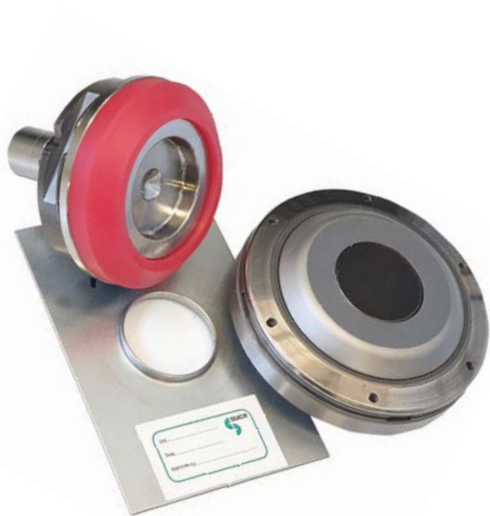
EXTRUSION UP AFTER PRE.PIERCE

Sheet thickness 1 - 3 mm

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:



Custom dimensions (mm)

D:
H:
R:
S:

Geminus coating: ☐ Yes ☐ No

Extrusion according to DIN7952

Thread size M2.5 pre-punch diameter 1.0 mm, thickness 0.8 - 1.5, diameter hole 2.10 - 2.30*
Thread size M3 pre-punch diameter 1.5/1.8 mm, thickness 0.8 - 1.5, diameter hole 2.55 - 2.80*
Thread size M4 pre-punch diameter 2.0/2.3 mm, thickness 1.0 - 2.0, diameter hole 3.35 - 3.70*
Thread size M5 pre-punch diameter 2.5/2.7 mm, thickness 1.0 - 2.0, diameter hole 4.25 - 4.65*
Thread size M6 pre-punch diameter 3.0/3.3 mm, thickness 1.5 - 2.5, diameter hole 5.10 - 5.55*
Thread size M8 pre-punch diameter 4.1/4.5 mm, thickness 1.5 - 2.5, diameter hole 6.80 - 7.40*
Thread size M10 pre-punch diameter 5/5.5 mm, thickness 1.5 - 2.5, diameter hole 8.50 - 9.30*
Extrusion tapping Height: 2 times thickness

*Hole size for tapping in machine.

D SIZE	PUNCH	€	URETHAN STRIPPER	€	DIE ASSEMBLY	€	ALIGN.RING	€	SET
0 - 6 mm	FLTRB12PB		FLTRB12E		FLTRB12M1 (GR1)		(GR1)		
6.1 - 9.40 mm	FLTRB12PB		FLTRB12E		FLTRB12ME		(GR1)		
9.5 - 25 mm	FLTRB12PC		FLTRB12EC		FLTRB12ME		(GR2)		
25.1 - 42 mm	FLTRB12PE		FLTRB12EE		FLTRB12ME		(GR2)		
SPARES	PUNCH 0 - 25 mm FLTRB12IP				PUNCH 25.1 - 42mm FLTRB12IPB				
	COATING GEMINUS 0 - 25 mm				COATING GEMINUS 25.1 - 42 mm				

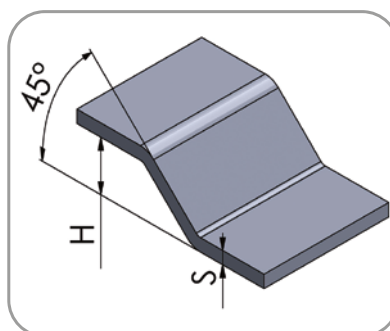


STEPPING TOOL

Notes and personal drafts. Please specify here the distance of any close deformation.

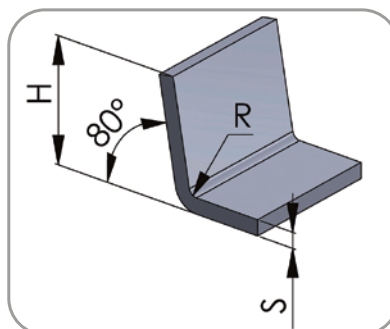
ORDERING SPECIFICATIONS

Company:
 Machine model:
 Material:
 Thickness :
 Order / Offer :
 Item required:
 Number of previous order:



Custom dimensions (mm)

H:
 S:



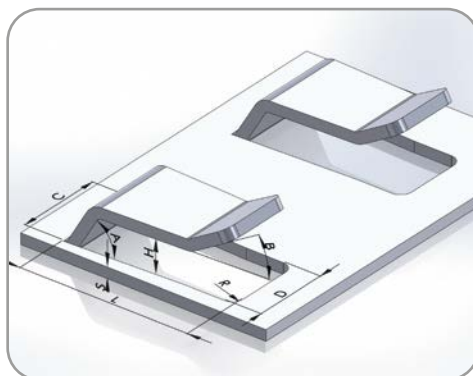
Custom dimensions (mm)

H:
 R:
 S:

ANGLE	PUNCH	€	DIE	€	ALIGN.RING	€	SET
45°	FLTRB07P		FLTRB02ME		(GR2)		
80°	FLTRB07P80		FLTRB02ME		(GR2)		

LANCE UP

Sheet thickness 0.5 - 2.5 mm



Custom dimensions (mm)

A:
 B:
 C:
 D:
 H:
 L:
 R:
 S:

Probus Coating: ☐ Yes ☐ No

SHEET THICKNESS 0.5 - 2.5 mm	PUNCH	€	DIE ASSEMBLY	€	URETHAN STRIPPER	€	ALIGN. RING	€	SET
1 - 2 BENDS	FLTRB19P		FLTRB19M		FLTRB19E		(GR2)		
3 BENDS	FLTRB193P		FLTRB19-3M		FLTRB19E		(GR2)		
REINFORCED	FLTRB19PR		FLTRB19MR		FLTRB19E		(GR2)		

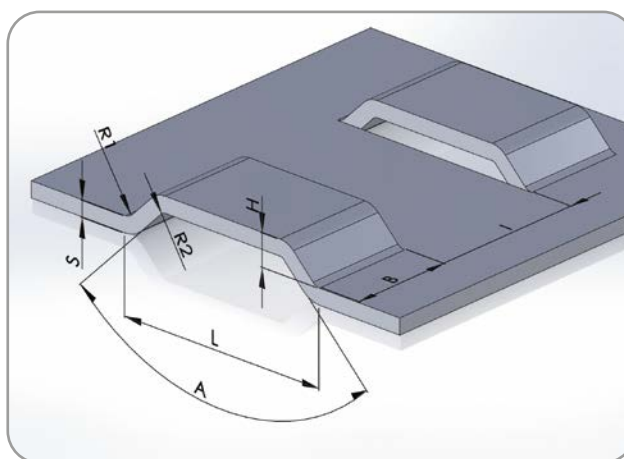
SINGLE AND DOUBLE BRIDGE

Sheet thickness 0.5 - 2.5 mm

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:



Custom dimensions (mm)

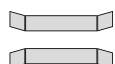
A:
B:
H:
S:
L:
R1:
R2:

TYPE: ☐ DOUBLE ☐ SINGLE

Geminus Coating: ☐ Yes ☐ No

SIZE	PUNCH*	€	URETHAN STRIPPER	€	DIE ASSEMBLY	€	ALIGN. RING	€	SET
0 - 18 mm	FLTRB17P1		FLTRB17-18E1		FLTRB17M		(GR1)		
18.1 - 40 mm	FLTRB17P2		FLTRB17-18E2		FLTRB17M		(GR2)		
0 - 18 mm DOUBLE	FLTRB18P1		FLTRB17-18E1		FLTRB18M		(GR1)		
18.1 - 40 mm DOUBLE	FLTRB18P2		FLTRB17-18E2		FLTRB18M		(GR2)		

PUNCH WITH EJECTOR + € ...



ADD € ... PUNCH, € ... DIE

BEADING CONTINUOUS TOOL

Thickness 0.8 - 3 mm

Height 2, 3, 4, 5 mm, Feed 1 - 2 mm

Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:

Machine model:

Material:

Thickness :

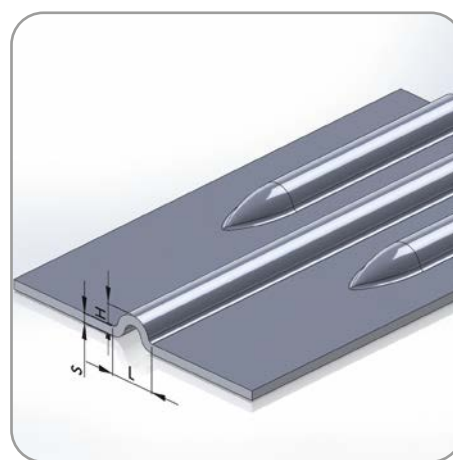
Order / Offer :

Item required:

Number of previous order:



SOLID DIE



Custom dimensions (mm)

H:

S:

L:

DIE WITH SPRINGS



RIB TOOL

Thickness 0.8 - 2.5 Aluminium, 0.8 - 2 Mild steel, 0.8 - 1.5 Stainless steel

Minimum radius 25 mm

Width 5 - 6 mm



ITEM	PUNCH	€	DIE GR2	€	ALIGN.RING	€	SET
BEADING CONTINUOUS TOOL	EMBOSS PUNCH FLTRB29P		EMBOSS SOLID DIE FLTRB29M		(GR2)		
BEADING CONTINUOUS TOOL			EMBOSS DIE WITH SPRINGS FLTRB29M2				
WHEEL TOOL	WHEEL PUNCH FLTRB29P2		WHEEL DIE FLTRB29M3				

SHEAR BUTTON

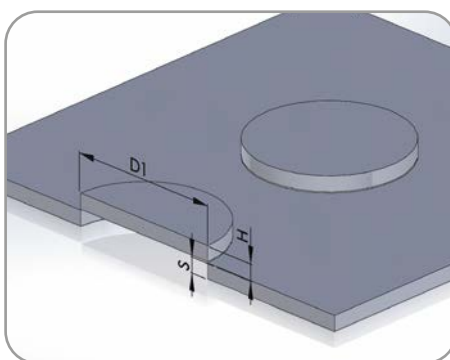
Thickness 1 - 3 mm
Height 0.5 x thickness



Notes and personal drafts. Please specify here the distance of any close deformation.

ORDERING SPECIFICATIONS

Company:
Machine model:
Material:
Thickness :
Order / Offer :
Item required:
Number of previous order:



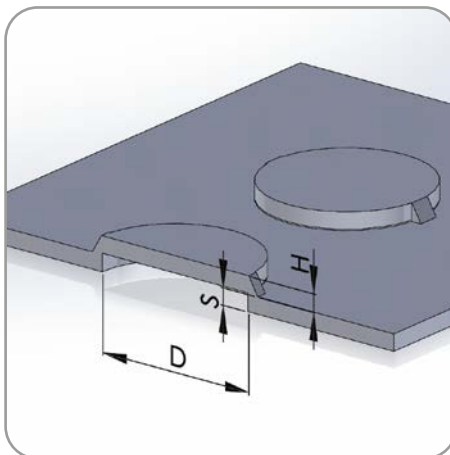
Custom dimensions (mm)

D:
H:
S:

SHEAR BUTTON	PUNCH	€	URETHAN STRIPPER	€	DIE ASSEMBLY GR1	€	ALIGN.RING	€	SET
D 1.9, 2.9, 3.9, 4.9, 5.9	FLTRB15BP		FLTRB12E		FLTRB15M1		(GR1)		

KNOCK OUT ROUND

Sheet thickness 1 - 2 mm



Custom dimensions (mm)

D:
H:
S:

D SIZE	PUNCH	€	DIE ASSEMBLY	€	URETHAN STRIPPER	€	ALIGN.RING	€	SET
0 - 8 mm	FLTRB15PB		FLTRB15M1(GR1)		FLTRB15E		(GR1)		
8.1 - 15 mm	FLTRB15PB		FLTRB15M2B		FLTRB15E		(GR1)		
15.1 - 25 mm	FLTRB15PC		FLTRB12M2C		FLTRB15EC		(GR2)		
25.1 - 42 mm	FLTRB15PE		FLTRB12M2E		FLTRB15EE		(GR2)		

CARD GUIDE



CARD GUIDE	PUNCH	€	DIE ASSEMBLY	€	ALIGN.RING	€	SET
0 - 60 mm	FLTRB34P		FLTRB34M		(GR2)		

MARKING TOOL ALPHA NUMERIC



MARKING TOOL ALPHA NUMERIC	PUNCH HOLDER	€	DIE	€	ALIGN.RING	€	SET
	FLTRB26PR		FLTRC1MAT001T		(HD 40 mm)		

FORMED STAMPING LOGO

Embossed Logo



Marked Logo



FORMED STAMPING LOGO	PUNCH	€	DIE	€	ALIGN.RING	€	SET
EMBOSSSED	FLTRB26P		FLTRB26M		(GR2)		
MARKED	FLTRB26P		FLTRC1MAT001T		(GR2)		

MARKING GROUND SYMBOL DIN40011

Marking Depth: 0.4 - 0.6 mm



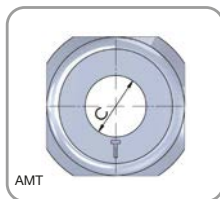
MARKING DEPTH: 0.4 - 0.6 mm	PUNCH	€	DIE	€	ALIGN.RING	€	SET
From the top	FLTRB27P		TRA1MAT001T		(GR1)		
From the bottom	TRA1PUT006T		FLTRB27M		(GR1)		



SALVAGNINI style

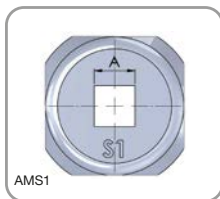


ROUND AND STANDARD



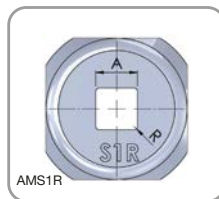
AMS1

C:



AMS2

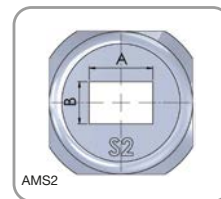
A:



AMS3

A:

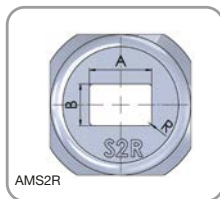
R:



AMS4

A:

B:

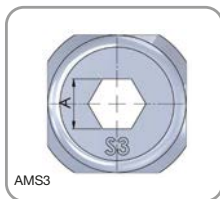


AMS5

A:

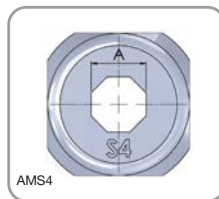
B:

R:



AMS6

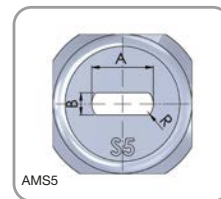
A:



AMS7

A:

B:

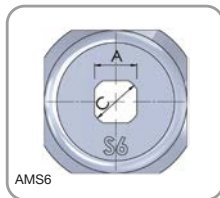


AMS8

A:

B:

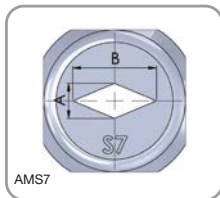
R:



AMS9

A:

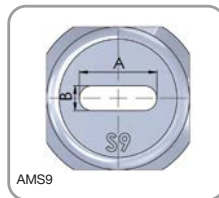
C:



AMS10

A:

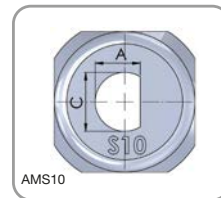
B:



AMS11

A:

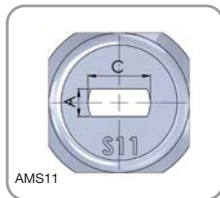
B:



AMS12

A:

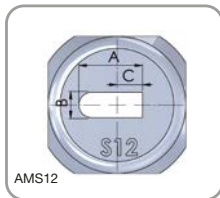
C:



AMS13

A:

C:



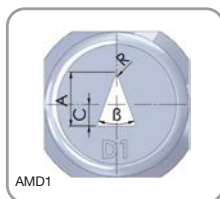
AMS14

A:

B:

C:

SPECIAL 1



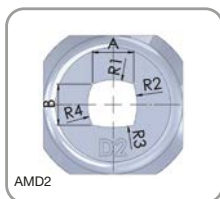
AMD1

A:

B:

C:

R:



AMD2

A:

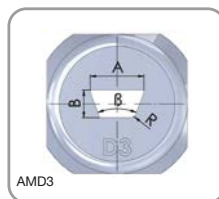
B:

R1:

R2:

R3:

R4:



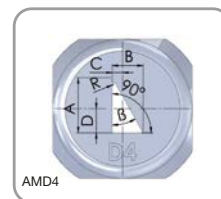
AMD3

A:

B:

B:

R:



AMD4

A:

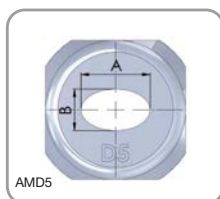
B:

C:

D:

B:

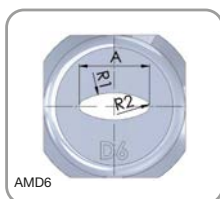
R:



AMD5

A:

B:

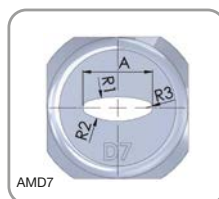


AMD6

A:

R1:

R2:



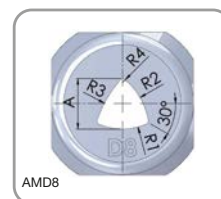
AMD7

A:

R1:

R2:

R3:



AMD8

A:

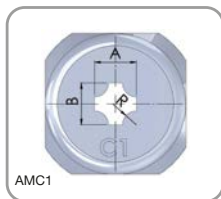
R1:

R2:

R3:

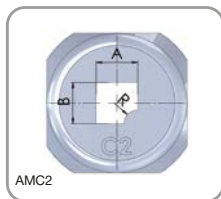
R4:

SPECIAL 0



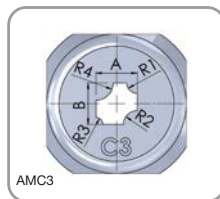
AMC1

A: _____ B: _____
R: _____



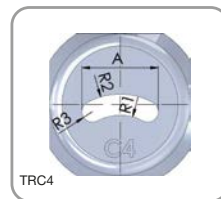
AMC2

A: _____ B: _____
R: _____



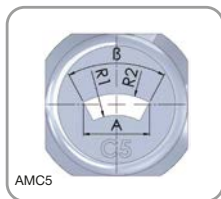
AMC3

A: _____ B: _____
R1: _____ R2: _____
R3: _____ R4: _____



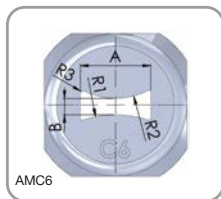
TRC4

A: _____ R1: _____
R2: _____ R3: _____



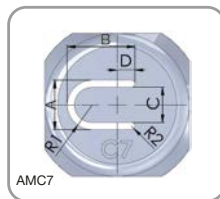
AMC5

A: _____ B: _____
R1: _____ R2: _____



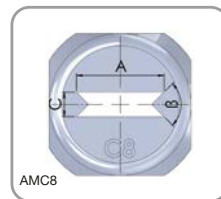
AMC6

A: _____ B: _____
R1: _____ R2: _____
R3: _____



AMC7

A: _____ B: _____
C: _____ D: _____
R1: _____ R2: _____



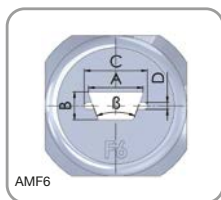
AMC8

A: _____ B: _____
C: _____

Note:

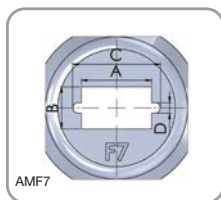
R<3 price is SPECIAL 2

SPECIAL 2



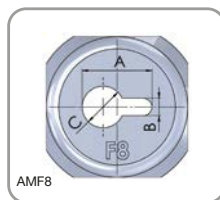
AMF6

A: _____ B: _____
C: _____ D: _____
B: _____



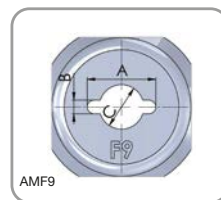
AMF7

A: _____ B: _____
C: _____ D: _____



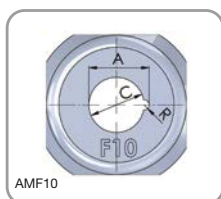
AMF8

A: _____ B: _____
C: _____



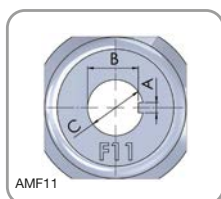
AMF9

A: _____ B: _____
C: _____



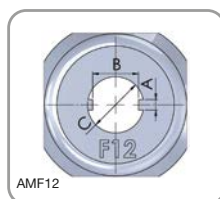
AMF10

A: _____ C: _____
R: _____



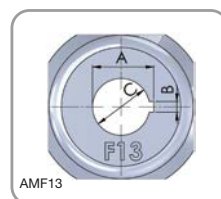
AMF11

A: _____ B: _____
C: _____



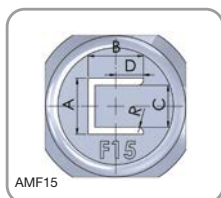
AMF12

A: _____ B: _____
C: _____



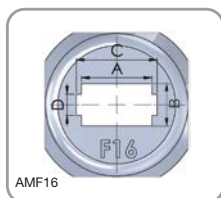
AMF13

A: _____ B: _____
C: _____



AMF15

A: _____ B: _____
C: _____ D: _____
R: _____



AMF16

A: _____ B: _____
C: _____ D: _____

P0 70 kN STATION

Pos 1-20 41-76

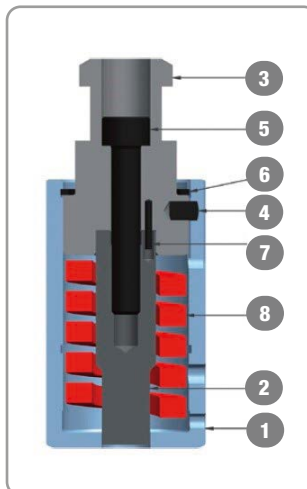
Max 10 mm

Punch grinding life:

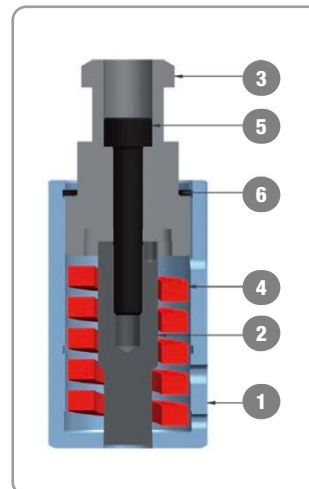
1.5 mm shape - 1.2 mm round



P0 ROUND ASSEMBLY



P0 SHAPE ASSEMBLY



ITEM	PUNCH P0	€	PUNCH P0 ASSEMBLY	€
ROUND	SAA12PUT006T		SAA1PAP006T	
STANDARD	SAA12PUT006S		SAA1PAP006S	

STATION	P0
Item	€
Coating Probus	
Coating Geminus	
Coating Levatus	

8. Cod. NM0020025038 SPRING**
 7. Cod. NSP060001510 PIN
 6. Cod. NSG050026012 SEEGER
 5. Cod. NVI05AR06035 SCREW M6X35
 4. Cod. NSP01MR04006 PIN
 3. Cod. MSAA12TET HEAD
 2. Cod. SAA12PUT006T PUNCH
 1. Cod. SAA26GUT0T GUIDE

6. Cod. NSG050026012 SEEGER
 5. Cod. NVI05AR06035 SCREW M6X35
 4. Cod. NM0020025038 SPRING **
 3. Cod. MSAA12TES HEAD
 2. Cod. SAA12PUT006S PUNCH
 1. Cod. SAA26GUT0S GUIDE

** To replace after 800.000 hits

P3 70 kN STATION

Pos 1-20 41-76, P3

Max 26 mm

Punch grinding life 1.5 mm

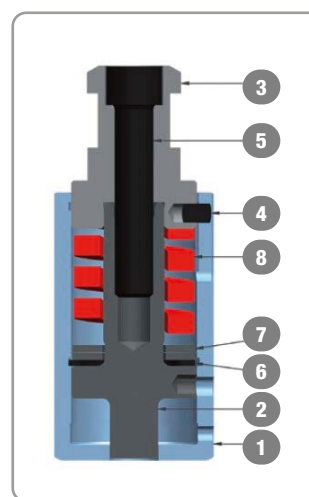
PUNCH P3



PUNCH P3 ASSEMBLY



P3 ASSEMBLY



ITEM	PUNCH P3	€	PUNCH P3 ASSEMBLY	€
ROUND	SAA26PUT006T		SAA26PPAPPT	
STANDARD	SAA26PUT006S		SAA26PPAPPS	
SPECIAL 0	SAA26PUT006C		SAA26PPAPPC	
SPECIAL 1	SAA26PUT006D		SAA26PPAPPD	
SPECIAL 2	SAA26PUT006F		SAA26PPAPPF	

STATION	P3 - P9
Item	€
Coating Probus	
Coating Geminus	
Coating Levatus	

8. Cod. NM0020025025 SPRING**
 7. Cod. MSAA26PPPPU7 SHIM
 6. Cod. NSG060026012 SEEGER
 5. Cod. NVI03AR08040 SCREW M6X35
 4. Cod. NSP01MR04006 PIN
 3. Cod. MSAA26PPPPU3 HEAD
 2. Cod. SAA26PUT006S PUNCH
 1. Cod. SAA26GUT0T/S GUIDE

* To replace after 200.000 hits

P9 70 kN STATION

Pos 1-20 41-76
Max 26,5 mm
Punch grinding life 3 mm
Die grinding life 1.2 mm

STATION	P3 - P9
Item	€
Coating Probus	
Coating Geminus	
Coating Levatus	

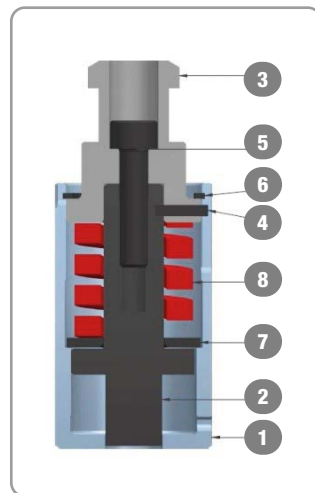
PUNCH P9



PUNCH P9 ASSEMBLY



P9 ASSEMBLY



ITEM	PUNCH P9	€	PUNCH P9 ASSEMBLY	€
ROUND	SAA265PUT006T		SAA265PPAPPT	
STANDARD	SAA265PUT006S		SAA265PPAPPS	
SPECIAL 0	SAA265PUT006C		SAA265PPAPPC	
SPECIAL 1	SAA265PUT006D		SAA265PPAPPD	
SPECIAL 2	SAA265PUT006F		SAA265PPAPPF	

8. Cod. NM0020025025 SPRING**
7. Cod. MSAA265PPPPU7 SHIM
6. Cod. NSG060026012 SEEGER SB29
5. Cod. NVI03AR0625 SCREW M6X35
4. Cod. NSP02MR23012 PIN
3. Cod. MSAA265PPPPU3 HEAD
2. Cod. SAA265PUT006_ PUNCH
1. Cod. SAA265GUT0S GUIDE

* To replace after 200.000 hits



Punch key reference



0°
RECT / OBOURD



0° SQ



0° HEXAGON



90°
RECT / OBOURD



45° SQ



90° HEXAGON

S4 70 kN STATION

Pos 1-20 41-76
Max 33 mm
Punch grinding life 4 - 2 mm
Die grinding life 1.2 mm

STATION	S4
Item	€
Coating Probus	
Coating Geminus	
Coating Levatus	

PUNCH S4



STRIPPER



DIE



DIE SHIM



ITEM	PUNCH S4	€	STRIPPER	€	DIE 0 - 12 mm	€	DIE 12.1 - 33 mm	€	DIE SHIM mm	€
ROUND	SAA1PUT00VT		SAA1PLT0T		SAA1MAT00VT		SAA3MAT00VT		0.2 SAA1SPMA02	
STANDARD	SAA1PUT00VS		SAA1PLT0S		SAA1MAT00VS		SAA3MAT00VS		0.3 SAA1SPMA03	
SPECIAL 0	SAA1PUT00VC		SAA1PLT0D		SAA1MAT00VD		SAA3MAT00VD		0.5 SAA1SPMA05	
SPECIAL 1	SAA1PUT00VD		SAA1PLT0D		SAA1MAT00VD		SAA3MAT00VD			
SPECIAL 2	SAA1PUT00VF		SAA1PLT0D		SAA1MAT00VD		SAA3MAT00VD			

S5 PUNCH 70 kN STATION

Pos 1-20 41-76
Max 33 mm
Punch grinding life 4 - 2 mm
Die grinding life 1.2 mm

DIE SHIM mm

STATION	S5
Item	€
Coating Probus	
Coating Geminus	
Coating Levatus	

PUNCH S5 Ø



PUNCH S5 ∅



STRIPPER



DIE



ITEM	PUNCH S5 Ø	€	PUNCH S5 ∅	€	STRIPPER	€	DIE 0 - 12 mm	€	DIE 12.1-33 mm	€	DIE SHIM mm	€
ROUND	SAA1IPTIOVT				SAA1PLT0T		SAA1MAT00VT		SAA3MAT00VT		0.2 SAA1SPMA02	
STANDARD	—		SAA1IPTIOVS		SAA1PLT0S		SAA1MAT00VS		SAA3MAT00VS		0.3 SAA1SPMA03	
SPECIAL 0	—		SAA1IPTIOVC		SAA1PLT0D		SAA1MAT00VD		SAA3MAT00VD		0.5 SAA1SPMA05	
SPECIAL 1	—		SAA1IPTIOVD		SAA1PLT0D		SAA1MAT00VD		SAA3MAT00VD			
SPECIAL 2	—		SAA1IPTIOVF		SAA1PLT0D		SAA1MAT00VD		SAA3MAT00VD			

P5_PU_P2R 120 kN INDEX STATION

Pos 30-35
Max 42.4 mm
Punch grinding life 1.5 mm
Die grinding life 1.2 mm

PUNCH



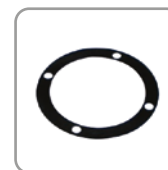
STRIPPER



DIE



DIE SHIM 0.2 mm



ITEM	PUNCH	€	STRIPPER	€	DIE	€	DIE SHIM 0.2 mm	€
ROUND	SAB1PUT106T		SAB1PLT1T		SAB1MAT101T		SAB1SPMA	
STANDARD	SAB1PUT106S		SAB1PLT1S		SAB1MAT101S			
SPECIAL 0	SAB1PUT106C		SAB1PLT1D		SAB1MAT101D			
SPECIAL 1	SAB1PUT106D		SAB1PLT1D		SAB1MAT101D			
SPECIAL 2	SAB1PUT106F		SAB1PLT1D		SAB1MAT101D			

Punch key reference



0°
RECT /OBROUND



0° SQ



90°
RECT /OBROUND



45° SQ

STATION	P5
Item	€
Coating Probus	
Coating Geminus	
Coating Levatus	

S6 120 kN STATION

Pos 30-35 - Max 60 mm - Punch grinding life 4 - 2 mm - Die grinding life 1.2 mm

STATION	S6
Item	€
Coating Probus	
Coating Geminus	
Coating Levatus	

PUNCH



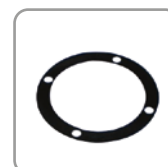
STRIPPER



DIE



DIE SHIM 0.2 mm



ITEM	PUNCH	€	STRIPPER	€	DIE	€	DIE SHIM 0.2 mm	€
ROUND	SAB1PUT00VT		SAB1PLT0T		SAB1MAT101T		SAB1SPMA	
STANDARD	SAB1PUT00VS		SAB1PLT0S		SAB1MAT101S			
SPECIAL 0	SAB1PUT00VC		SAB1PLT0D		SAB1MAT101D			
SPECIAL 1	SAB1PUT00VD		SAB1PLT0D		SAB1MAT101D			
SPECIAL 2	SAB1PUT00VF		SAB1PLT0D		SAB1MAT101D			

S8 90 x 70 TYPE 70 260 kN STATION

Pos 21-22-23-24
Max 90 x 70 mm
Punch grinding life 4 - 2 mm
Die grinding life 1.2 mm

PUNCH
Max 70 x 50 mm



PUNCH
Max 90 x 70 mm



DIE SHIM
0.2 mm



STRIPPER
Max 90 x 70 mm



DIE
Max 90 x 70 mm



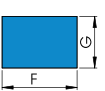
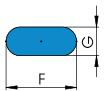
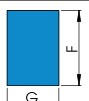
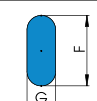
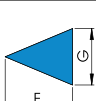
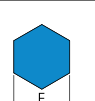
STATION	S8 90 x 70
Item	€
Coating Probus	
Coating Geminus	
Coating Levatus	

ITEM	PUNCH Max 70 x 50 mm	€	PUNCH Max 90 x 70 mm	€	STRIPPER Max 90 x 70 mm	€	DIE Max 90 x 70 mm	€	DIE SHIM 0.2 mm	€
ROUND	SAC1PUT00VT		SAC1PUT60VT		SAC1PLT3T		SAC1MAT30VT		SAC1SPMAT3	
STANDARD	SAC1PUT00VS		SAC1PUT60VS		SAC1PLT3S		SAC1MAT30VS			
SPECIAL 0	SAC1PUT00VC		SAC1PUT60VC		SAC1PLT3D		SAC1MAT30VD			
SPECIAL 1	SAC1PUT00VD		SAC1PUT60VD		SAC1PLT3D		SAC1MAT30VD			
SPECIAL 2	SAC1PUT00VF		SAC1PUT60VF		SAC1PLT3D		SAC1MAT30VD			



Technical data:



	Round	Square	Rectangle	Oround	Triangle	shape C1	Exagon
0°							
90°							

S9 90 x 70 TYPE 90 260 kN STATION

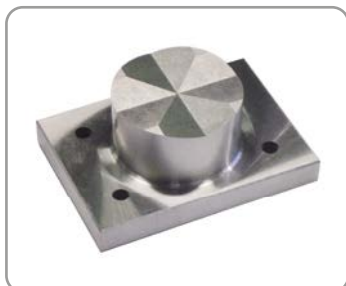
Pos 22-23

Max 90 x 70 mm

Punch grinding life 4 - 2 mm

Die grinding life 1.2 mm

PUNCH
Max 70 x 50 mm



PUNCH
Max 90 x 70 mm



DIE SHIM
0.2 mm



STRIPPER
Max 90 x 70 mm



DIE
Max 90 x 70 mm



STATION	S9 90 x 70
Item	€
Coating Probus	
Coating Geminus	
Coating Levatus	

ITEM	PUNCH Max 70 x 50 mm	€	PUNCH Max 90 x 70 mm	€	STRIPPER Max 90 x 70 mm	€	DIE Max 90 x 70 mm	€	DIE SHIM 0.2 mm	€
ROUND	SAC1PUT00VT		SAC1PUT60VT		SAC1PLT0T		SAC1MAT00VT		SAC1SPMAT0	
STANDARD	SAC1PUT00VS		SAC1PUT60VS		SAC1PLT0S		SAC1MAT00VS			
SPECIAL 0	SAC1PUT00VC		SAC1PUT60VC		SAC1PLT0D		SAC1MAT00VD			
SPECIAL 1	SAC1PUT00VD		SAC1PUT60VD		SAC1PLT0D		SAC1MAT00VD			
SPECIAL 2	SAC1PUT00VF		SAC1PUT60VF		SAC1PLT0D		SAC1MAT00VD			

Technical data:



	Round	Square	Rectangle	Obound	Triangle	shape C1	Exagon
0°							
90°							

SA 90 x 90 TYPE 90 260 kN STATION

Pos 21-24

Max 90 x 90 mm

Punch grinding life 4 - 2 mm

Die grinding life 1.2 mm

PUNCH
Max 90 x 70 mm



PUNCH
Max 90 x 90 mm



DIE SHIM
0.2 mm



STRIPPER
Max 90 x 70 mm



DIE
Max 90 x 90 mm



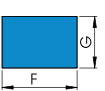
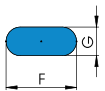
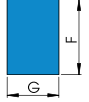
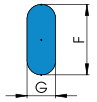
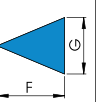
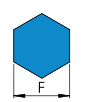
STATION	SA 90 x 90
Item	€
Coating Probus	
Coating Geminus	
Coating Levatus	

ITEM	PUNCH Max 70 x 90 mm	€	PUNCH Max 90 x 90 mm	€	STRIPPER Max 90 x 90 mm	€	DIE Max 90 x 90 mm	€	DIE SHIM 0.2 mm	€
ROUND	SAC1PUT40VT		SAC1PUT50VT		SAC1PLT2T		SAC1MAT20VT		SAC1SPMAT2	
STANDARD	SAC1PUT40VS		SAC1PUT50VS		SAC1PLT2S		SAC1MAT20VS			
SPECIAL 0	SAC1PUT40VC		SAC1PUT50VD		SAC1PLT2D		SAC1MAT20VD			
SPECIAL 1	SAC1PUT40VD		SAC1PUT50VC		SAC1PLT2D		SAC1MAT20VD			
SPECIAL 2	SAC1PUT40VF		SAC1PUT50VF		SAC1PLT2D		SAC1MAT20VD			



Technical data:



	Round	Square	Rectangle	Oround	Triangle	shape C1	Exagon
0°							
90°							



WIEDEMANIN MURATEC

VARITOOL

Max Size mm: 12.7



ITEM	DIE	€	PUNCH	€	PUNCH ASSEMBLY	€
ROUND	WNA0MAM801T		H130 mm WNA0PUM806T H152 mm WNA0PUM8L06T		H130 mm WNA0PAM806T H152 mm WNA0PAM8L06T	
STANDARD	WNA0MAM801S		H130 mm WNA0PUM806S H152 mm WNA0PUM8L06S		H130 mm WNA0PAM806S H152 mm WNA0PAM8L06S	

STATION X

Max Size mm: Round 12.7



ITEM	PUNCH	€	DIE	€	STRIPPER	€
ROUND	WNX1PUT006T		WNB1MAT001T		WNX1PLT0	

STATION A - B

Max Size mm:
Obr - Round 25
Square 16
Rect diagonal 22



ITEM	PUNCH	€	PUNCH	€	DIE	€	STRIPPER	€
ROUND	WNA1PUT006T		WNB1PUT006T		WNB1MAT001T		WNB1PLTA1	
STANDARD			WNB1PUT006S WNB1PUT006Q 0 - 45°		WNB1MAT001S WNB1MAT001Q 0 - 45°		WNB1PLTA1	
SPECIAL 0			WNB1PUT006C		WNB1MAT001D		WNB1PLTA1	
SPECIAL 1			WNB1PUT006D		WNB1MAT001D		WNB1PLTA1	
SPECIAL 2			WNB1PUT006F		WNB1MAT001D		WNB1PLTA1	

STATION C

Max Size mm:
Obr - Round 38
Square 22
Rect diagonal 31



ITEM	PUNCH	€	DIE	€	STRIPPER	€
ROUND	WNC1PUT006T		WNC1MAT001T		WNC1PLT0	
STANDARD	WNC1PUT006S WNC1PUT006Q 0 - 45°		WNC1MAT001S WNC1MAT001Q 0 - 45°		WNC1PLT0	
SPECIAL 0	WNC1PUT006C		WNC1MAT001D		WNC1PLT0	
SPECIAL 1	WNC1PUT006D		WNC1MAT001D		WNC1PLT0	
SPECIAL 2	WNC1PUT006F		WNC1MAT001D		WNC1PLT0	

STATION D

Max Size mm:
Obr - Round 51
Square 32
Rect diagonal 44

PUNCH



DIE



STRIPPER



ITEM	PUNCH	€	DIE	€	STRIPPER	€
ROUND	WND1PUT006T		WND1MAT001T		WND1PLT0	
STANDARD	WND1PUT006S		WND1MAT001S		WND1PLT0	
SPECIAL 0	WND1PUT006C		WND1MAT001Q 0 - 45°		WND1PLT0	
SPECIAL 1	WND1PUT006D		WND1MAT001D		WND1PLT0	
SPECIAL 2	WND1PUT006F		WND1MAT001D		WND1PLT0	

STATION E

Max Size mm:
Obr - Round 64
Square 41
Rect diagonal 57

PUNCH



DIE



STRIPPER



ITEM	PUNCH	€	DIE	€	STRIPPER	€
ROUND	WNE1PUT006T		WNE1MAT001T		WNE1PLT0	
STANDARD	WNE1PUT006S		WNE1MAT001S		WNE1PLT0	
SPECIAL 0	WNE1PUT006C		WNE1MAT001D		WNE1PLT0	
SPECIAL 1	WNE1PUT006D		WNE1MAT001D		WNE1PLT0	
SPECIAL 2	WNE1PUT006F		WNE1MAT001D		WNE1PLT0	

STATION F

Max Size mm:
Obr - Round 76
Square 48
Rect diagonal 67

PUNCH



DIE



STRIPPER



ITEM	PUNCH	€	DIE	€	STRIPPER	€
ROUND	WNF1PUT006T		WNF1MAT001T		WNE1PLT0	
STANDARD	WNF1PUT006S		WNF1MAT001S		WNE1PLT0	
SPECIAL 0	WNF1PUT006C		WNF1MAT001D		WNE1PLT0	
SPECIAL 1	WNF1PUT006D		WNF1MAT001D		WNE1PLT0	
SPECIAL 2	WNF1PUT006F		WNF1MAT001D		WNE1PLT0	

STATION G

Max Size mm:
Obr - Round 89
Square 57
Rect diagonal 79



ITEM	PUNCH	€	DIE	€	STRIPPER	€
ROUND	WNG1PUT006T		WNG1MAT001T		WNH1PLT0	
STANDARD	WNG1PUT006S		WNG1MAT001S		WNH1PLT0	
SPECIAL 0	WNG1PUT006C		WNG1MAT001D		WNH1PLT0	
SPECIAL 1	WNG1PUT006D		WNG1MAT001D		WNH1PLT0	
SPECIAL 2	WNG1PUT006F		WNG1MAT001D		WNH1PLT0	

STATION H

Max Size mm:
Obr - Round 105, Square 70, Rect diagonal 98



ITEM	PUNCH	€	DIE	€	STRIPPER	€
ROUND	WNH1PUT006T		WNH1MAT001T		WNH1PLT0	
STANDARD	WNH1PUT006S		WNH1MAT001S		WNH1PLT0	
SPECIAL 0	WNH1PUT006C		WNH1MAT001D		WNH1PLT0	
SPECIAL 1	WNH1PUT006D		WNH1MAT001D		WNH1PLT0	
SPECIAL 2	WNH1PUT006F		WNH1MAT001D		WNH1PLT0	

STATION	VARITOOL H 130	VARITOOL H 152	B ROUND	B SHAPE	C ROUND	C SHAPE	D R & S	E R & S	F R & S	G R & S	H R & S
Coating Probus											
Coating Geminus											

Shims



ITEM	B STATION	€	C STATION	€	D STATION	€	E STATION	€
SET DIE SHIMS 0.5 - 1 - 2 MM	WNB1SETSPMA		WNC1SETSPMA		WND1SETSPMA		WNE1SETSPMA	
SET PUNCH SHIMS 1 - 2.5 - 4 MM	WNB1SETSPPU		WNC1SETSPPU		WND1SETSPPU		WNE1SETSPPU	

ITEM	F STATION	€	G STATION	€	H STATION	€
SET DIE SHIMS 0.5 - 1 - 2 MM	WNF1SETSPMA		WNG1SETSPMA		WNH1SETSPMA	
SET PUNCH SHIMS 1 - 2.5 - 4 MM	WNF1SETSPPU		WNG1SETSPPU		WNH1SETSPPU	



FPL TECHNOLOGY ITALIANA

S 15

PUNCH 7.5
Punzone ridotto D7.5



PUNCH CHUCK D7.5
Portapunzone D7.5



PUNCH
Punzone



GUIDE Guida



DIE Matrice



ITEM	PUNCH 7.5 Punzone D7.5 ridotto	€	PUNCH CHUCK D7.5 Portapunzone D7.5	€	PUNCH Punzone	€	GUIDE Guida	€	DIE Matrice	€
ROUND Diametro	TEA575PST006T		D7.5 TEA175PPT0T		TEA1PUT006T		TEA1GUT0T		TEA1MAT001T	
SHAPE STD Sagoma std					TEA1PUT006S		TEA1GUT0S		TEA1MAT001S	
SPECIAL 0					TEA1PUT006C		TEA1GUT0D		TEA1MAT001D	
SPECIAL 1					TEA1PUT006D		TEA1GUT0D		TEA1MAT001D	
SPECIAL 2					TEA1PUT006F		TEA1GUT0D		TEA1MAT001D	

FITTING S15 Accessori S15

TCNT-TECNOINDEX
PUNCH ADAPTOR



TECNUMERIK
PUNCH ADAPTOR



TCNT-TECNOINDEX
TECNUMERIK SPRING PACK



TCNT-TECNOINDEX
TECNUMERIK PUNCH HOLDER



TCNT-TECNOINDEX
DIE HOLDER



TECNUMERIK DIE HOLDER



MODEL	ITEM	€	ITEM	€
TCNT-TECNOINDEX	ADAPTOR Piastra di riduzione 71.0.1.100.0000 TEA1PRS15X		DIE HOLDER Contenitore matrice 71.1.1.500.000 TEA1PMATS15X	
TECNUMERIK	ADAPTOR Piastra di riduzione 91.0.1.100.0000 TEA1PRS15K		DIE HOLDER Contenitore matrice 91.1.1.500.000 TEA1PMATS15K	

MODEL	ITEM	€
TCNT - TECNOINDEX - TECNUMERIK	SPRING PACK Estrattore completo 91.2.1.400.0000 TEA1ESS15	
	SPRING Molla G37X42 - 91.2.1.430.0000 TEA1MSS15	
	SPRING PLATE Portamolla 91.2.1.410.0000 TEA1PMS15	
	SPRING DISK Disco premimolla 91.2.1.420.0000 TEA1DPMS15	
	PUNCH HOLDER Contenitore punzone predisposto 91.1.1.200.400 TEA1PPS15P	

S 40

PUNCH Punzone
Corpo D 26 mmPUNCH Punzone
Corpo D 26 mm SHARPENING
Tipo scaricato H 96 mmPUNCH Punzone
Corpo D 40 mmPUNCH Punzone
Corpo D 40 mm SHARPENING
Tipo scaricato H 96 mmPUNCH GUIDE
GuidaDIE
Matrice

ITEM	PUNCH Punzone	€	PUNCH WITH SHARPENING Punzone scaricato	€	PUNCH Punzone	€	PUNCH WITH SHARPENING Punzone scaricato	€	GUIDE Guida	€	DIE Matrice	€
ROUND Diametro	TEB1PUT006T		TEB1PUTL06T		TEB2PUT006T		TEB2PUTL06T		Ø26 TEB1GUT0T - For sharp punch Ø26 TEB1GUTLT - Ø40 TEB2GUT0T - For sharp punch Ø40 TEB2GUTLT		TEB1MAT001T	
SHAPE STD Sagoma std	TEB1PUT006S		TEB1PUTL06S		TEB2PUT006S		TEB2PUTL06S		Ø26 TEB1GUT0S - For sharp punch Ø26 TEB1GUTLS - Ø40 TEB2GUT0S - For sharp punch Ø40 TEB2GUTLS		TEB1MAT001S	
SPECIAL 0	TEB1PUT006C		TEB1PUTL06C		TEB2PUT006C		TEB2PUTL06C		Ø26 TEB1GUT0D - For sharp punch Ø26 TEB1GUTLD - Ø40 TEB2GUT0D - For sharp punch Ø40 TEB2GUTLD		TEB1MAT001D	
SPECIAL 1	TEB1PUT006D		TEB1PUTL06D		TEB2PUT006D		TEB2PUTL06D					
SPECIAL 2	TEB1PUT006F		TEB1PUTL06F		TEB2PUT006F		TEB2PUTL06F					

FITTING S 40 Accessori S40

PUNCH HOLDER
Contentitore punzoneDIE HOLDER
Contentitore matriceSTRIPPER UNIT
Gruppo estrattore

MODEL	ITEM	€	ITEM	€
TCNT-TECNOINDEX	PUNCH HOLDER Contentitore punzone 72.1.1.200.0000 TEB2PPUS40X		DIE HOLDER Contentitore matrice 72.1.1.500.0000 TEB2PMATS40X	
TECNUMERIK	PUNCH HOLDER Contentitore punzone 92.1.1.200.0000 TEB2PPUS40K		DIE HOLDER WITH LEVER Contentitore matrice con leva 92.1.1.500.0000 TEB2PMATS40K	

MODEL	ITEM	€
TCNT - TECNOINDEX - TECNUMERIK	STRIPPER UNIT D26 Gruppo estrattore completo D26 92.2.1.400.1625 TEB2ESS26	
	STRIPPER UNIT D40 Gruppo estrattore completo D40 92.2.1.400.2640 TEB2ESS40	
	KIT N.10 SPRING DISCK IT N.10 MOLLE A TAZZA S40 92.2.1.430.0000 TEB2KITMTS40	

S 70

PUNCH
Punzone



STRIPPER
Estrattore



DIE
Matrice



PUNCH HOLDER
Porta punzone



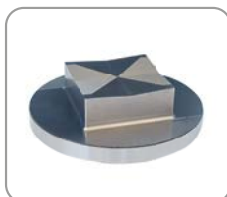
DIE HOLDER
Porta matrice



ITEM	PUNCH Punzone	€	STRIPPER Estrattore	€	DIE Matrice	€		€		€
ROUND <i>Diametro</i>	TEC1PUT006T		TEC1PLT0BT h10 TEC1PLT0AT h13		TEC1MAT001T		TCNT TECNOINDEX PUNCH HOLDER Contentitore punzone 73.1.1.200.0000 TEC1CONTPUS70X		TCNT TECNOINDEX DIE HOLDER Contentitore matrice 73.1.1.500.0000 TEC1CONTMAS70X	
SHAPE STD <i>Sagoma std</i>	TEC1PUT006S		TEC1PLT0BS h10 TEC1PLT0AS h13		TEC1MAT001S		TECNUMERIK PUNCH HOLDER Contentitore punzone 93.1.1.200.0000 TEC1CONTPUS70K		TECNUMERIK DIE HOLDER WITH LEVER Contentitore matrice con leva 93.1.1.500.0000 TEC1CONTMAS70K	
SPECIAL 0	TEC1PUT006C		TEC1PLT0BD h10 TEC1PLT0AD h13		TEC1MAT001D					
SPECIAL 1	TEC1PUT006D		TEC1PLT0BD h10 TEC1PLT0AD h13		TEC1MAT001D					
SPECIAL 2	TEC1PUT006F		TEC1PLT0BD h10 TEC1PLT0AD h13		TEC1MAT001D					
					REINFORCED DIE <i>Matrice rinforzata</i>	€				
			SHAPE STD Sagoma std		TEC1MATR01S					
			SPECIAL 0 - 1 - 2		TEC1MATR01D					

S 100

PUNCH
Punzone



STRIPPER
Estrattore



DIE
Matrice



PUNCH HOLDER
Porta punzone



DIE HOLDER
Porta matrice



ITEM	PUNCH Punzone	€	STRIPPER Estrattore	€	DIE Matrice	€		€		€
ROUND <i>Diametro</i>	TED1PUT006T		TED1PLT0BT h10 TED1PLT0AT h13		TED1MAT001T		TCNT TECNOINDEX PUNCH HOLDER Contentitore punzone 74.1.1.200.0000 TED1CONTPUS70X		TCNT TECNOINDEX DIE HOLDER Contentitore matrice 74.1.1.500.0000 TED1CONTMAS70X	
SHAPE STD <i>Sagoma std</i>	TED1PUT006S		TED1PLT0BS h10 TED1PLT0AS h13		TED1MAT001S		TECNUMERIK PUNCH HOLDER Contentitore punzone 94.1.1.200.0000 TED1CONTPUS70K		TECNUMERIK DIE HOLDER WITH LEVER Contentitore matrice con leva 94.1.1.500.0000 TED1CONTMAS70K	
SPECIAL 0	TED1PUT006C		TED1PLT0BD h10 TED1PLT0AD h13		TED1MAT001D					
SPECIAL 1	TED1PUT006D		TED1PLT0BD h10 TED1PLT0AD h13		TED1MAT001D					
SPECIAL 2	TED1PUT006F		TED1PLT0BD h10 TED1PLT0AD h13		TED1MAT001D					
					REINFORCED DIE <i>Matrice rinforzata</i>	€				
			SHAPE STD Sagoma std		TED1MATR01S					
			SPECIAL 0 - 1 - 2		TED1MATR01D					

NIBBLING RD10 *Roditore D10*



MODEL		ART.	€
ALL Tutti	NIBBLING PUNCH D10 <i>Punzone roditore DIAM.10</i>	TEA10PUTR06T	
ALL Tutti	NIBBLING PUNCH D10 WITH COATING <i>Punzone roditore DIAM 10 rivestito</i>	TEA10PUTR06TH	
ALL Tutti	NIBBLING PUNCH D10 GEMINUS <i>Punzone roditore DIAM.10 rivestito Geminus</i>	TEA10PUTR06TC	
TCNT-TECNOINDEX	DISC <i>Disco premi molla 75.1.1.720.1000</i>	TEA10DPMX	
TECNUMERIK	DISC <i>Disco premi molla 95.1.1720.1000</i>	TEA10DPMK	
ALL Tutti	SPRING <i>Molla a spirale G51X65 95.1.1.730.1000</i>	TEA10MS	
ALL Tutti	NIBBLING GUIDE RD10 <i>Guida punzone roditore GPR10</i>	TEA10GU	
ALL Tutti	DIE <i>Matrice per roditore</i>	TEA1MAT001T	



SLITTING TOOL 90x5 *Utensile da taglio 90x5*

PUNCH HOLDER
Porta punzone



BLADE
Lama



DIE HOLDER
Porta matrice



DIE
Matrice ellittica



MODEL	DESCR.	ART.	€
TCNT-TECNOINDEX	HOLDER PUNCH 90x5 <i>Gruppo porta punzone 90x5 PP 90x5 TCNT-TIX</i>	TED1CONTPU90X5X	
TECNUMERIK	HOLDER PUNCH 90x5 <i>Gruppo porta punzone 90x5 PP90X5TK</i>	TED1CONTPU90X5K	
ALL Tutti	SLITTING PUNCH SHARP BLADE <i>Lama punzone 90x5 scaricata</i>	TED1PULT006S	
	SLITTING PUNCH SHARP BLADE COATING <i>Lama punzone 90x5 scaricata RIVESTITA</i>	TED1PULT006SRIV	
ALL Tutti	STRIPPER 90x5 <i>Estrattore 90x5 ESE90X5</i>	TED1ES90X5	
ALL Tutti	KIT n.°4 SPRING DISK 32x38 <i>Set N.4 molle spirale 32x38 MG32X38</i>	TED1KITMS90X5	
ALL Tutti	DIE HOLDER 90x5 <i>Portamatrice 90x5 PMTCNT-TIX</i>	TED1CONTMA90X5	
ALL Tutti	SLITTING DIE 90x5 <i>Matrice ellittica 90x5</i>	TED1MATE01S	

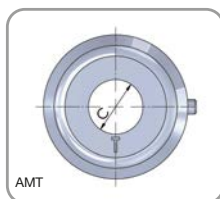
STATION	PUNCH D7.5	PUNCH S15	PUNCH S26/40	PUNCH S70	PUNCH S100
Coating PROBUS	€	€	€	€	€
Coating GEMINUS	€	€	€	€	€
Coating LEVATUS	€	€	€	€	€



RAINER

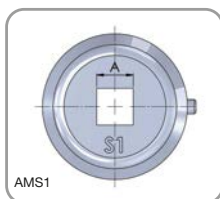


ROUND AND STANDARD



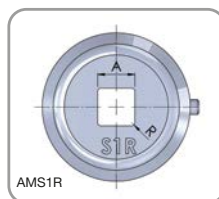
AMS1R

C:



AMS1

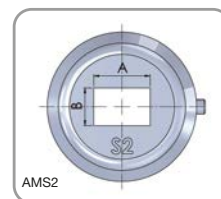
A:



AMS1R

A:

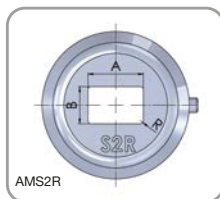
R:



AMS2

A:

B:

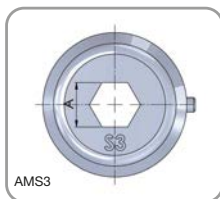


AMS2R

A:

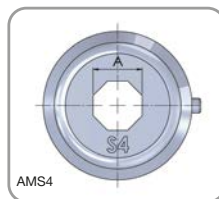
B:

R:



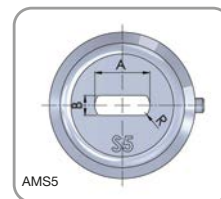
AMS3

A:



AMS4

A:

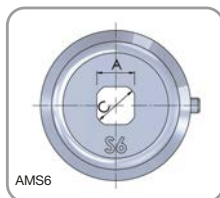


AMS5

A:

B:

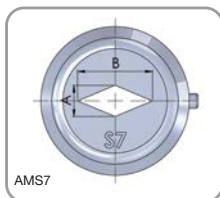
R:



AMS6

A:

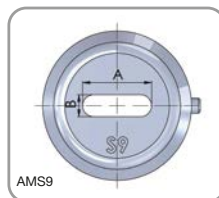
C:



AMS7

A:

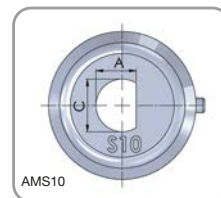
B:



AMS9

A:

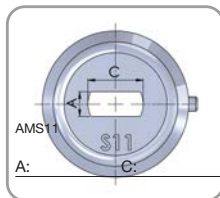
B:



AMS10

A:

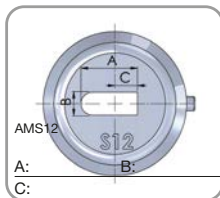
C:



AMS11

A:

C:



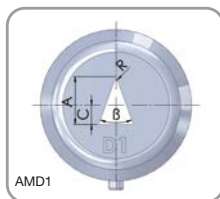
AMS12

A:

B:

C:

SPECIAL 1



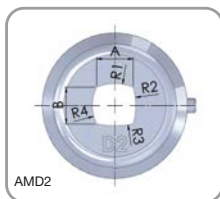
AMD1

A:

B:

C:

R:



AMD2

A:

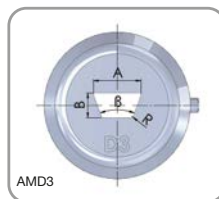
B:

R1:

R2:

R3:

R4:



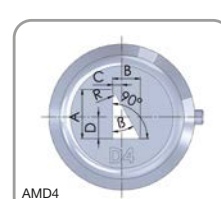
AMD3

A:

B:

B:

R:



AMD4

A:

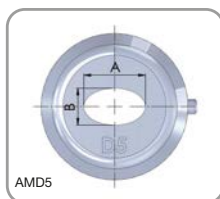
B:

C:

D:

B:

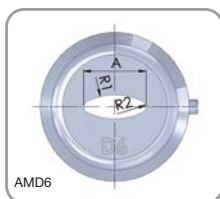
R:



AMD5

A:

B:

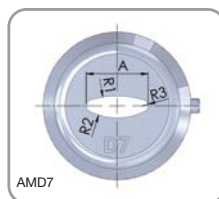


AMD6

A:

R1:

R2:



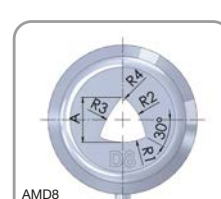
AMD7

A:

R1:

R2:

R3:



AMD8

A:

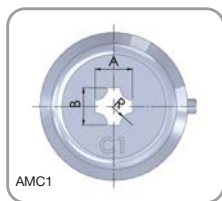
R1:

R2:

R3:

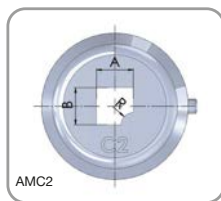
R4:

SPECIAL 0



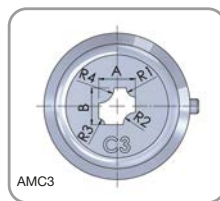
AMC1

A: B:
R:



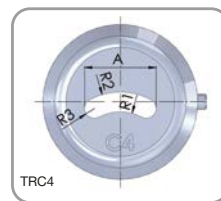
AMC2

A: B:
R:



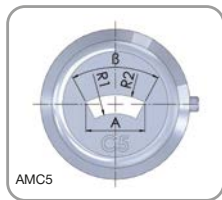
AMC3

A: B:
R1: R2:
R3: R4:



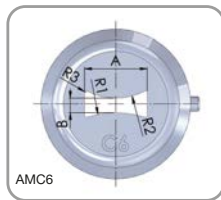
TRC4

A: R1:
R2: R3:



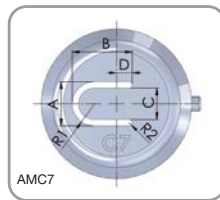
AMC5

A: B:
R1: R2:



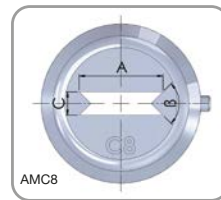
AMC6

A: B:
R1: R2:
R3:



AMC7

A: B:
C: D:
R1: R2:



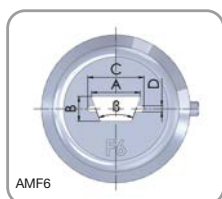
AMC8

A: B:
C:

Note:

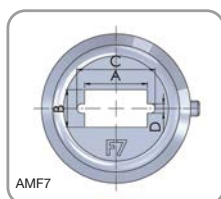
R<3 price is SPECIAL 2

SPECIAL 2



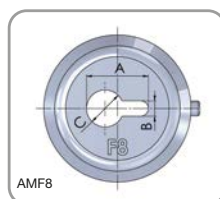
AMF6

A: B:
C: D:
B:



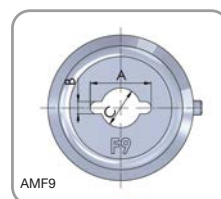
AMF7

A: B:
C: D:



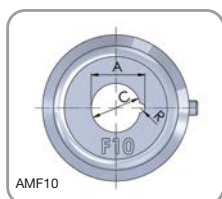
AMF8

A: B:
C:



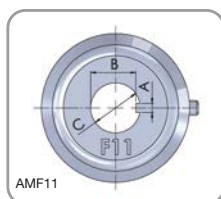
AMF9

A: B:
C:



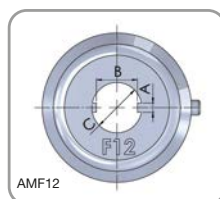
AMF10

A: C:
R:



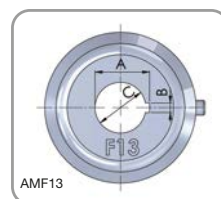
AMF11

A: B:
C:



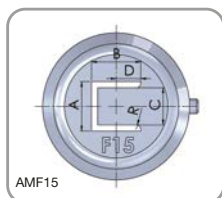
AMF12

A: B:
C:



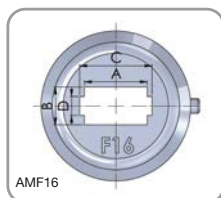
AMF13

A: B:
C:



AMF15

A: B:
C: D:
R:



AMF16

A: B:
C: D:

A STATION ECONO LINE, SOLID GUIDE

PUNCH
PunzonePUNCH ASSEMBLY
Punzone assemblatoDIE
Matrice

ITEM	PUNCH Punzone	€	PUNCH ASSEMBLY Punzone assemblato	€	DIE HWS Matrice HWS	€
ROUND	AMA1PUT006T		AMA1PARE06T		AMA1MAT001T	
STANDARD	AMA1PUT006S		AMA1PARE06S		AMA1MAT001S	

FITTING



ITEM	HEAD Testa	€	SPRING Gruppo molle	€	OR COLLAR Ghiera inferiore	€	STANDARD GUIDE Guida standard	€
	RNA0CNTET0		AMA1MST0		AMA1RIT0		ROUND AMA1GUT0T	
							SHAPE 0-90° AMA1GUT0S	
							SQUARE 0-135° AMA1GUT0Q	

CAT 251

Max 22 mm

PUNCH HSS
Punzone HSSSTRIPPER
EstrattoreGUIDE COMPLETE
Guida completaDIE Ø 34
Matrice Ø 34

ITEM	PUNCH HSS Punzone HSS	€	STRIPPER Estrattore	€	GUIDE COMPLETE Guida completa	€	DIE HWS Matrice HWS	€
ROUND	RNB1PUCN06T		RNB1PLCNT		RNB1GACNT		RNB1MACN01T	
STANDARD	RNB1PUCN06S		RNB1PLCNS		RNB1GACNS		RNB1MACN01S	
SPECIAL 0	RNB1PUCN06C		RNB1PLCND		RNB1GACNS		RNB1MACN01D	
SPECIAL 1	RNB1PUCN06D		RNB1PLCND		RNB1GACNS		RNB1MACN01D	
SPECIAL 2	RNB1PUCN06F		RNB1PLCND		RNB1GACNS		RNB1MACN01D	

CAT 252

Max 34 mm

PUNCH HSS
Punzone HSS

STRIPPER
Estrattore

GUIDE COMPLETE
Guida completa

DIE Ø 56
Matrice Ø 56


ITEM	PUNCH HSS Punzone HSS	€	STRIPPER Estrattore	€	GUIDE COMPLETE Guida completa	€	DIE HWS Matrice HWS	€
ROUND	RNC1PUCN06T		RNC1PLCNT		RNC1GACNT		RNC1MACN01T	
STANDARD	RNC1PUCN06S		RNC1PLCNS		RNC1GACNS		RNC1MACN01S	
SPECIAL 0	RNC1PUCN06C		RNC1PLCND		RNC1GACNS		RNC1MACN01D	
SPECIAL 1	RNC1PUCN06D		RNC1PLCND		RNC1GACNS		RNC1MACN01D	
SPECIAL 2	RNC1PUCN06F		RNC1PLCND		RNC1GACNS		RNC1MACN01D	

CAT 253

Max 60 mm

PUNCH HSS
Punzone HSS

STRIPPER
Estrattore

GUIDE COMPLETE
Guida completa

DIE Ø 80
Matrice Ø 80


ITEM	PUNCH HSS Punzone HSS	€	STRIPPER Estrattore	€	GUIDE COMPLETE STANDARD Guida completa std	€	DIE HWS Matrice HWS	€
ROUND	RND1PUCN06T		RND1PLCNT		RND1GACNS		RND1MACN01T	
STANDARD	RND1PUCN06S		RND1PLCNS		RND1GACNS		RND1MACN01S	
SPECIAL 0	RND1PUCN06C		RND1PLCND		RND1GACNS		RND1MACN01D	
SPECIAL 1	RND1PUCN06D		RND1PLCND		RND1GACNS		RND1MACN01D	
SPECIAL 2	RND1PUCN06F		RND1PLCND		RND1GACNS		RND1MACN01D	

CAT 254

Max 100 mm

PUNCH HSS
Punzone HSS

STRIPPER
Estrattore

GUIDE COMPLETE
Guida completa

DIE Ø 135
Matrice Ø 135


ITEM	PUNCH HSS Punzone HSS	€	STRIPPER Estrattore	€	GUIDE COMPLETE INDEX Guida completa rotante	€	DIE HWS Matrice HWS	€
ROUND	RNE1PUCN06T		RNE1PLCNT		RNE1GACNR		RNE1MACN01T	
STANDARD	RNE1PUCN06S		RNE1PLCNS		RNE1GACNR		RNE1MACN01S	
SPECIAL 0	RNE1PUCN06C		RNE1PLCND		RNE1GACNR		RNE1MACN01D	
SPECIAL 1	RNE1PUCN06D		RNE1PLCND		RNE1GACNR		RNE1MACN01D	
SPECIAL 2	RNE1PUCN06F		RNE1PLCND		RNE1GACNR		RNE1MACN01D	

PUNCH INSERT

PUNCH CHUCK
Porta punzone



INSERT PUNCH
Inserto punzone



STRIPPER
Estrattore



DIE Ø 34
Matrice Ø 34



ITEM	PUNCH CHUCK Porta punzone	€	INSERT PUNCH Inserto punzone	€	STRIPPER Estrattore	€	DIE Ø 34 Matrice Ø 34	€
D10	RNA10PPT0T		RNA10PST006T		RNA10PLT0T		RNA0MAT001T	
D15	RNA15PPT0T		RNA15PST006T		RNA15PLT0T		RNA0MAT001T	

DIMENSION INSCRIBED BETWEEN Ø1.5 and Ø20

PUNCH
Punzone



STRIPPER
Estrattore



DIE Ø 34
Matrice Ø 34



DIE Ø 80
Matrice Ø 80



ITEM	PUNCH Punzone	€	STRIPPER Estrattore	€	DIE Ø 34 Matrice Ø 34	€	DIE Ø 80 Matrice Ø 80	€
ROUND	RNA1PUTG06T		RNA1PLTGT		RNA0MAT001T		RNB1MATG01T	
STANDARD	RNA1PUTG06S		RNA1PLTGS				RNB1MATG01S	

DIMENSION INSCRIBED BETWEEN Ø20.1 AND Ø40

ITEM	PUNCH Punzone	€	STRIPPER Estrattore	€	DIE Ø 80 Matrice Ø 80	€
ROUND	RNB1PUTG06T		RNB1PLTGT		RNB1MATG01T	
STANDARD	RNB1PUTG06S		RNB1PLTGS		RNB1MATG01S	

PUNCH
Punzone



STRIPPER
Estrattore



DIE Ø 80
Matrice Ø 80



DIMENSION INSCRIBED BETWEEN Ø40.1 AND Ø60

ITEM	PUNCH Punzone	€	STRIPPER Estrattore	€	DIE Ø 80 Matrice Ø 80	€
ROUND	RNC1PUTG06T		RNC1PLTGT		RNC1MATG01T	
STANDARD	RNC1PUTG06S		RNC1PLTGS		RNC1MATG01S	

PUNCH
Punzone



STRIPPER
Estrattore



DIE Ø 80
Matrice Ø 80



DIMENSION BETWEEN Ø60.1 and Ø80

ITEM	PUNCH Punzone	€	STRIPPER Estrattore	€	DIE Ø 130 Matrice Ø 130	€
ROUND	RND1PUTG06T		RND1PLTGT		RND1MATG01T	
STANDARD	RND1PUTG06S		RND1PLTGS		RND1MATG01S	

PUNCH
Punzone



STRIPPER
Estrattore



DIE Ø 130
Matrice Ø 130



DIMENSION BETWEEN Ø80.1 and Ø100

ITEM	PUNCH Punzone	€	STRIPPER Estrattore	€	DIE Ø 130 Matrice Ø 130	€
ROUND	RNE1PUTG06T		RNE1PLTGT		RNE1MATG01T	
STANDARD	RNE1PUTG06S		RNE1PLTGS		RNE1MATG01S	

PUNCH
Punzone



STRIPPER
Estrattore



DIE Ø 130
Matrice Ø 130



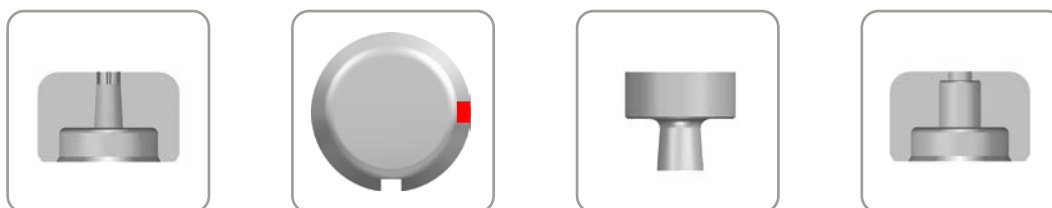
ADD ON

Shear option

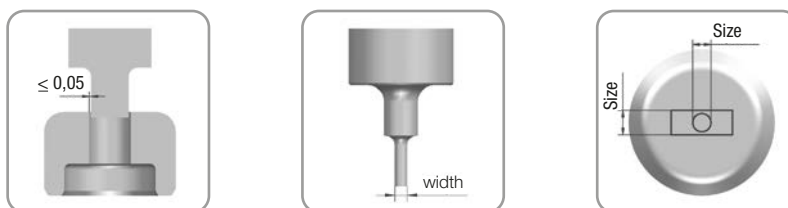


TYPE OF SHEAR	Roof top	Inverted roof top	Double valley	Whisper	Four ways
WHEN	Best option when punching force is high, minimum feed 75% of tool lenght	Recommended for nibbling at maximum tonnage but inverted stress could cause breakage	Recommended when punch is longer than 80mm But inverted stress could cause breakage	Best option classic trumpf style to reduce noise and tonnage, max 5°	Recommended for punching and nibbling Ø and square at maximum tonnage
CODE	Cod V	Cod VR	Cod 3P	Cod W	Cod 4P
ADD ON	€	€	€	€	€

Add on



	Die lock slug	Extra Key slot	Back taper punch Jump station*	Reduced milled land
ADD ON	€	€		shape: € diam<11 € ; diam>11 €
WHEN	Best option to prevent the come out of the slug	C-D-E thick turret dies keys 0-90 standard shape 0-135 square	Recommended for punching thick material, more than 4mm. *Thick turret punches example: square10 in C station	To facilitate the fall of the slug; recommended when long side is more than 20 times short side, ex re22x1



	Die clearance <0.1	Punch width	Die size
ADD ON			





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