



Catalog



TURRET THICK THICK TURRET THICK

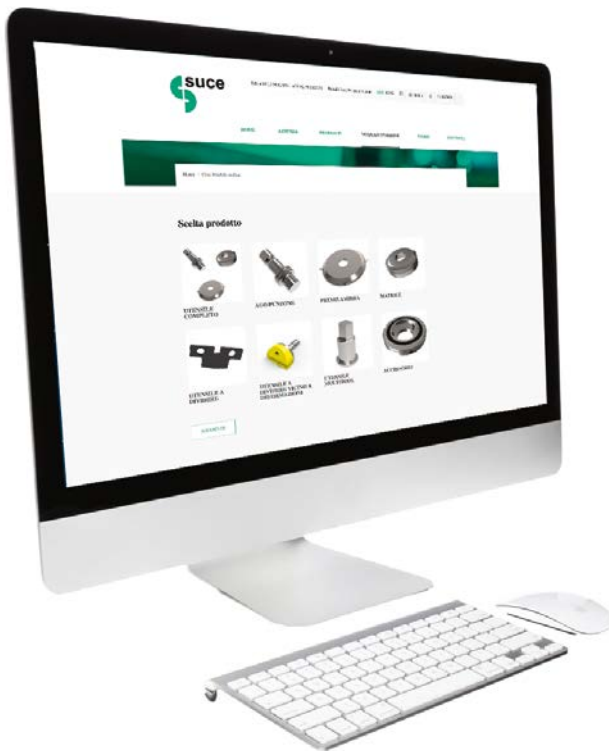
Inside the catalogue you' ll find this symbol, that indicates the possibility of ordering our product online!



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HIGH DEFINITION IMAGES

Detailed pictures of products in order to avoid choice errors.



SECURE PAYMENTS

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FAST DELIVERY



INSTANT
&
DIRECT COMMUNICATION WITH SUPPLIER





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 x 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;

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?



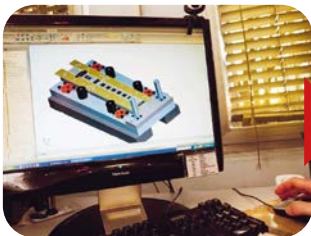
The use of double grinding wheel plants allows for a very low roughness coefficient.



The machine tooling dept. includes automatic lines of turning with load 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.





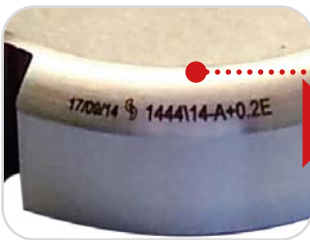
No shape limitation thanks to Wire EDM technology.



Wire EDM load-unload cell.



In warehouse: ready for delivery.

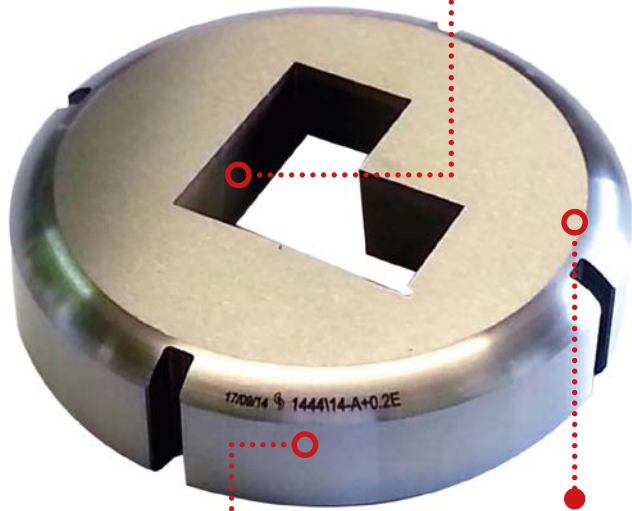
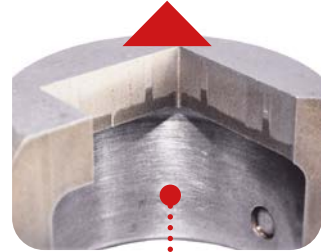


SUCE special ID number.



Manufacturing execution system.

Different lock-slug systems available



Tool testing: fault free.

THICK TURRET

THICK TURRET

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)					
	1 - 1.5	2	3	4	5	6
mm						
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)

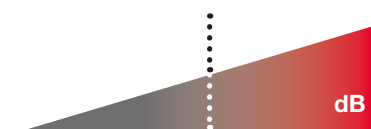


Four ways
Cod 4P



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 sp2-sp3	PA-CVD	1.500 - 3.000	0,05 - 0,1	0,5 - 3	250	350	Black

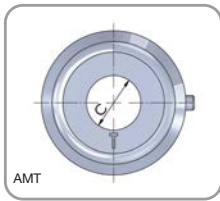
COATING	COPPER	ALUMINUM	MILD STEEL	GALVANIZED STEEL	STAINLESS STEEL
PROBUS	X	X	X	XX	XXX
GEMINUS	XX	XX	X	XXX	XX
LEVATUS	XXX	XXX	X	X	X

NEEDLESS	RECOMMENDED	HIGHLY RECOMMENDED
X	XX	XXX



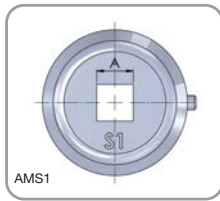
THICK TURRET

THICK TURRET ROUND AND STANDARD



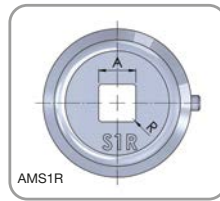
AMS1

C: _____



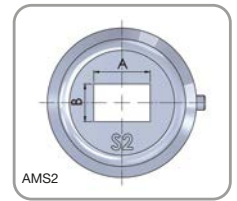
AMS2

A: _____



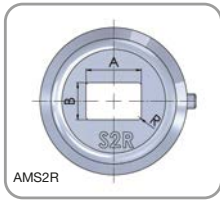
AMS1R

A: _____ R: _____



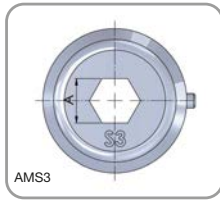
AMS2R

A: _____ B: _____



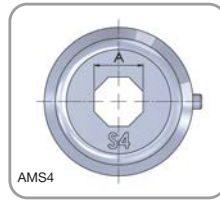
AMS2R

A: _____ B: _____
R: _____



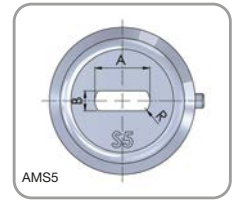
AMS3

A: _____



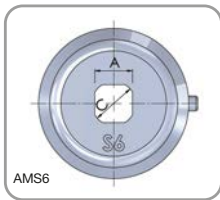
AMS4

A: _____



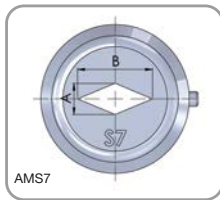
AMS5

A: _____ B: _____
R: _____



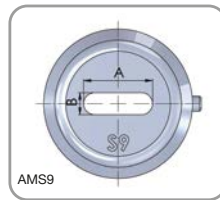
AMS6

A: _____ C: _____



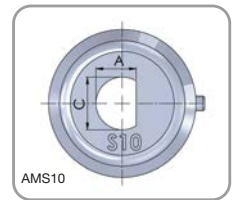
AMS7

A: _____ B: _____



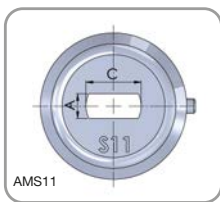
AMS9

A: _____ B: _____



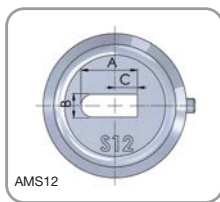
AMS10

A: _____ C: _____



AMS11

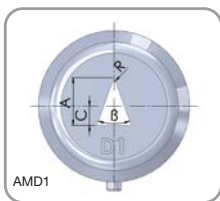
A: _____ C: _____



AMS12

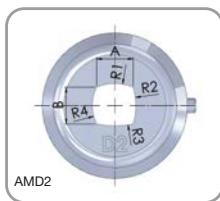
A: _____ B: _____
C: _____

SPECIAL 1



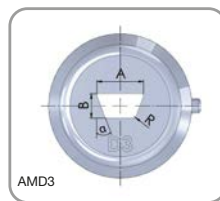
AMD1

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



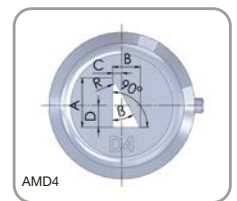
AMD2

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



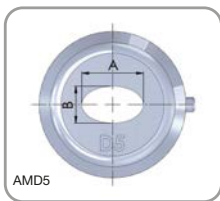
AMD3

A: _____ B: _____
alpha: _____ R: _____



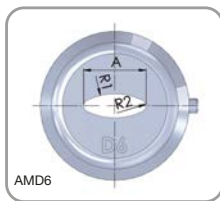
AMD4

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



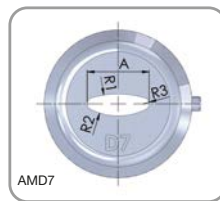
AMD5

A: _____ B: _____



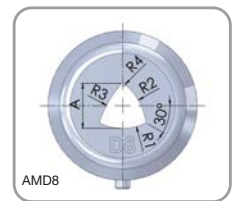
AMD6

A: _____ R1: _____
R2: _____



AMD7

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



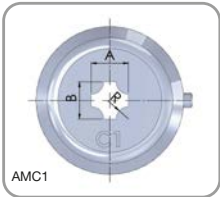
AMD8

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

A AND B PIN DIE REFERENCE

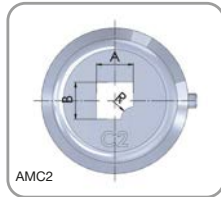


SPECIAL 0



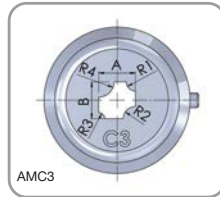
AMC1

A: _____ B: _____
R: _____



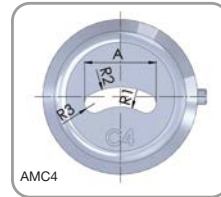
AMC2

A: _____ B: _____
R: _____



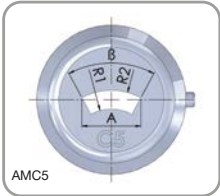
AMC3

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



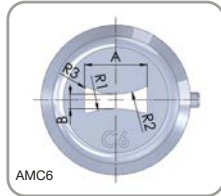
AMC4

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



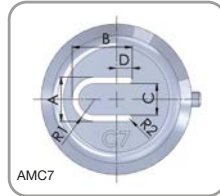
AMC5

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



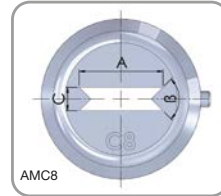
AMC6

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



AMC7

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

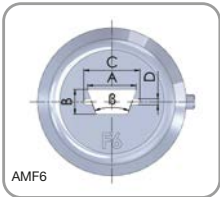


AMC8

A: _____ B: _____
C: _____

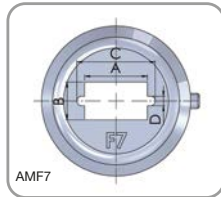
Note:
R<3 price is SPECIAL 2

SPECIAL 2



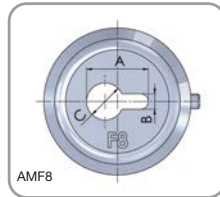
AMF6

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



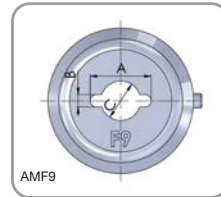
AMF7

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



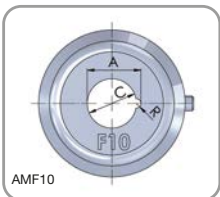
AMF8

A: _____ B: _____
C: _____



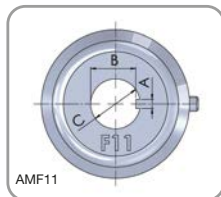
AMF9

A: _____ B: _____
C: _____



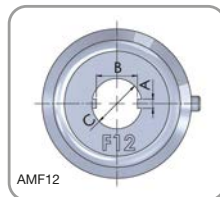
AMF10

A: _____ C: _____
R: _____



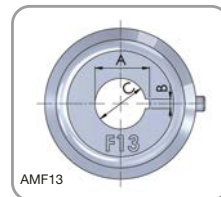
AMF11

A: _____ B: _____
C: _____



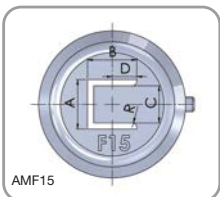
AMF12

A: _____ B: _____
C: _____



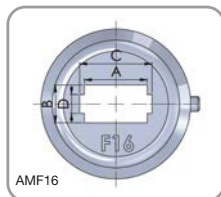
AMF13

A: _____ B: _____
C: _____



AMF15

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



AMF16

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

A AND B PIN DIE REFERENCE

THICK TURRET



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		AMA0MAM2401S 0°- 90° 135°		AMA0MAM24TP1S	
SPECIAL 0	AMA0PUM2406C		AMA0PLM24D		AMA0MAM2401D 0°- 90° 135°		AMA0MAM24TP1D	
SPECIAL 1	AMA0PUM2406D		AMA0PLM24D		AMA0MAM2401D 0°- 90° 135°		AMA0MAM24TP1D	
SPECIAL 2	AMA0PUM2406F		AMA0PLM24D		AMA0MAM2401D 0°- 90° 135°		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 MULTITOOLOO 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	1.PUNCH CHUCK	€	2.PUNCH MAX DIM 10.4	€	PUNCH HEAD	€
	AMA0PP24		AMB105PST006T		AMA0TEM24	

Coating	PROBUS PUNCH INSERT	GEMINUS PUNCH INSERT	PROBUS	GEMINUS	LEVATUS

EUROMAC MULTITOOLOO 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

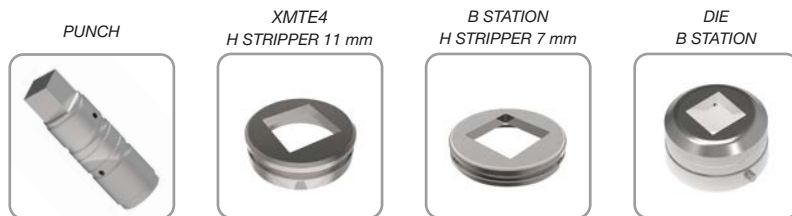


ITEM	PUNCH	€	PUNCH ADJUSTABLE	€	PUNCH HEAD	€	STRIPPER	€	DIE	€
ROUND	AMA0PUM1006T		AMA0PUM10B6T		AMA0TEM10		AMA0PLM10T		AMA0MAM1001T	
STANDARD	AMA0PUM1006S		AMA0PUM10B6S		AMA0TEM10		AMA0PLM10S		AMA0MAM1001S	
SPECIAL 0	AMA0PUM1006C		AMA0PUM10B6C		AMA0TEM10		AMA0PLM10D		AMA0MAM1001D	
SPECIAL 1	AMA0PUM1006D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

Coating	PROBUS	GEMINUS	LEVATUS

EUROMAC MULTITOOLOO 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

THICK TURRET



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

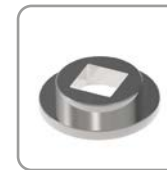
PUNCH WITH PIN



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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ERMAKSAN MULTITool 6 ERMAK-BIEMMETI

Data
Max size 22 mm

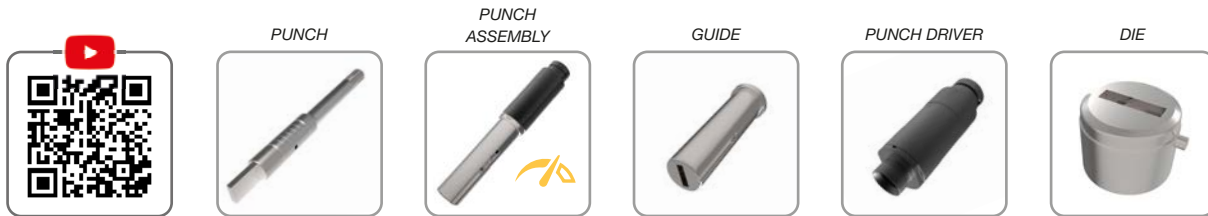


ITEM	PUNCH	€	STRIPPER	€	DIE	€
ROUND	AMAOPUM22B6T		AMA0PLM22T		AMA0MAM2401T	
STANDARD	AMAOPUM22B6S		AMA0PLM22S		AMA0MAM24B1S	
SPECIAL 0	AMAOPUM22B6C		AMA0PLMM2D		AMA0MAM24B1D	
SPECIAL 1	AMAOPUM22B6D		AMA0PLMM2D		AMA0MAM24B1D	
SPECIAL 2	AMAOPUM22B6F		AMA0PLMM2D		AMA0MAM24B1D	

Coating	PROBUS		GEMINUS		LEVATUS	
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ERMAKSAN MT6 - 22

Max 22 mm, Max thickness: 3 mm
Max punching force 9 Kn, Grinding life mm: Punch 6, Die 0.5



ITEM	PUNCH	€	PUNCH ASSEMBLY	€	GUIDE	€	PUNCH DRIVER	€	DIE	€
ROUND	AMMTPU2206T		AMMTPA2206T		AMMTGU22T		AMMT6 - 22LL		AMA0MAM2401T	
STANDARD	AMMTPU2206S		AMMTPA2206S		AMMTGU22S		AMMT6 - 22LL		AMA0MAM24B1S	
SPECIAL 0	AMMTPU2206C		AMMTPA2206C		AMMTGU22D		AMMT6 - 22LL		AMA0MAM24B1D	
SPECIAL 1	AMMTPU2206D		AMMTPA2206D		AMMTGU22D		AMMT6 - 22LL		AMA0MAM24B1D	
SPECIAL 2	AMMTPU2206F		AMMTPA2206F		AMMTGU22D		AMMT6 - 22LL		AMA0MAM24B1D	

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



10/18	PUNCH	€	STRIPPER	€	DIE	€
ROUND	AMAOPUM18B6T		AMA0PLM18BT		AMA0MAM1801T	
STANDARD	AMAOPUM18B6S		AMA0PLM18BS		AMA0MAM18B1S	
SPECIAL 0	AMAOPUM18B6C		AMA0PLM18BD		AMA0MAM18B1D	
SPECIAL 1	AMAOPUM18B6D		AMA0PLM18BD		AMA0MAM18B1D	
SPECIAL 2	AMAOPUM18B6F		AMA0PLM18BD		AMA0MAM18B1D	

Coating	PROBUS		GEMINUS		LEVATUS	
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6/24	PUNCH	€	STRIPPER	€	DIE	€
ROUND	AMAOPUM24B6T		AMA0PLM24BT		AMA0MAM2401T	
STANDARD	AMAOPUM24B6S		AMA0PLM24BS		AMA0MAM24B1S	
SPECIAL 0	AMAOPUM24B6C		AMA0PLM24BD		AMA0MAM24B1D	
SPECIAL 1	AMAOPUM24B6D		AMA0PLM24BD		AMA0MAM24B1D	
SPECIAL 2	AMAOPUM24B6F		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	

THICK TURRET



A STATION STANDARD, 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	AMA1PUT006T		AMA1PATE06T		AMA1PATEL6T		AMA1MAT001T	
STANDARD	AMA1PUT006S		AMA1PATE06_**		AMA1PATEL6_**		AMA1MAT001S*	
SPECIAL 0	AMA1PUT006C		AMA1PATE06C		AMA1PATEL6C		AMA1MAT001D	
SPECIAL 1	AMA1PUT006D		AMA1PATE06D		AMA1PATEL6D		AMA1MAT001D	
SPECIAL 2	AMA1PUT006F		AMA1PATE06F		AMA1PATEL6F		AMA1MAT001D	

* for Amada machines square dies pin 0°-135° code: AMA1MAT001Q

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

Coating	PROBUS	Ø	GEMINUS	Ø	LEVATUS	Ø
		Ø		Ø		Ø
		Ø		Ø		Ø

FITTING



PUNCH HEAD	€	SPRING	€	RETAINER	€	PUNCH DRIVER max thickness 3 mm	€	CLOSED STANDARD GUIDE	€
AMA1TERA		AMA1MST0		AMA1RIT0		AMA1LLGIO		ROUND - AMA1GUT0T	
								SHAPE 0° - 90° - AMA1GUT0S	
								SQUARE 0° - 135° - AMA1GUT0Q	
								SPC 0° - 90° - AMA1GUT0D	



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	

* for Amada machines square dies pin 0°-135° code: AMA1MAT001Q

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

Coating	PROBUS	<input type="checkbox"/>	GEMINUS	<input type="checkbox"/>	LEVATUS	<input type="checkbox"/>
		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>

FITTING



PUNCH HEAD	€	SPRING	€	RETAINER	PUNCH DRIVER max thickness 3 mm	€	CLOSED STANDARD GUIDE	€
AMA1TERA		AMA1MST0		AMA1RIT0	AMA1LLGIO		ROUND AMA1GUAIT	
							SHAPE 0° - 90° - AMA1GUAIS	
							SQUARE 0° - 135° - AMA1GUAIQ	
							SPC 0° - 90° - AMA1GUAID	

THICK TURRET



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



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	∅		∅
				∅		∅
				∅		∅

FITTING

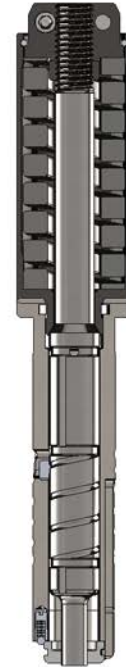


ITEM	SMART3 PUNCH DRIVER (max thickness 4 mm)	€	OPEN SMART3 GUIDE	€
	AMA1LLNM2		ONLY ROUND AMA1GUT3T	
			ROUND & SHAPE 0° - 90° - 225° AMA1GUT3S	



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	AMA1PUT006T		AMA1PUAB06T		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	

Coating	PROBUS	Ø	GEMINUS	Ø	LEVATUS	Ø
		Ø		Ø		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	

THICK TURRET



B STATION ECONO LINE, CLOSED GUIDE

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



ITEM	PUNCH	€	PUNCH ASSEMBLY	€	PUNCH ASSEMBLY LONG LIFE	€	DIE	€
ROUND	AMB1PUT006T		AMB1PATE06T		AMB1PATEL6T		AMB1MAT001T	
STANDARD	AMB1PUT006S		AMB1PATE06S		AMB1PATEL6S		AMB1MAT001S*	
SPECIAL 0	AMB1PUT006C		AMB1PATE06C		AMB1PATEL6C		AMB1MAT001D	
SPECIAL 1	AMB1PUT006D		AMB1PATE06D		AMB1PATEL6D		AMB1MAT001D	
SPECIAL 2	AMB1PUT006F		AMB1PATE06F		AMB1PATEL6F		AMB1MAT001D	

* for Amada machines square dies pin 0° - 135° code: AMB1MAT001Q

Coating	PROBUS		GEMINUS		LEVATUS	

FITTING



SPANNER WRENCH	€	PUNCH HEAD	€	SPRING	€	REVERSIBLE RETAINER Included OR	€	PUNCH DRIVER max thickness 6 mm	€	CLOSED GUIDE	€
AMABSW		AMB1TERA		AMB1MST0		AMB1RIT0		AMB1LLGIO		RD AMB1GUT0T	
										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



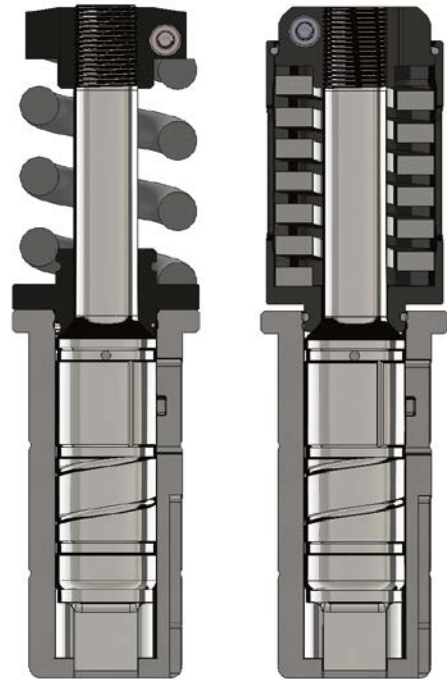
PUNCH ASSEMBLY



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	

* for Amada machines square dies pin 0° - 135° code: AMB1MAT001Q

Coating	PROBUS	GEMINUS	LEVATUS

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		AMB1TERA		AMB1MST0		AMB1RIT0		AMB1LLGIO		AMB1GUAIT	
										STD 0° - 90° AMB1GUAIS	
										SQ 0° - 135° AMB1GUAIQ	
										SPECIAL 0-1-2 - 0° - 90° AMB1GUAID	

THICK TURRET



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



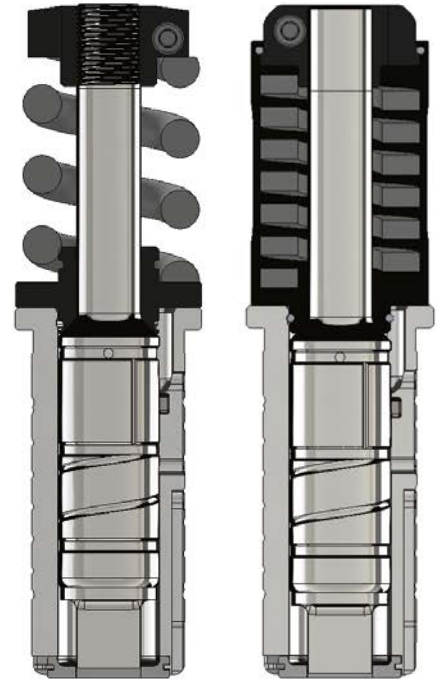
PUNCH ASSEMBLY LONG LIFE



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	

* for Amada machines square dies pin 0° - 135° code: AMB1MAT001Q

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	AMB1PLLNL6T		AMB1PLWTT	
STANDARD	AMB1PLLNL6S		AMB1PLWTS	
SPECIAL 0	AMB1PLLNL6C		AMB1PLWTD	
SPECIAL 1	AMB1PLLNL6D		AMB1PLWTD	
SPECIAL 2	AMB1PLLNL6F		AMB1PLWTD	

Coating	PROBUS		GEMINUS		LEVATUS	
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DIE

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

DIE



* for Amada machines pin 0°-135° code: AMB1MAT001Q

B STATION PUNCH HOLDER AND PUNCH INSERT BODY D10,5 WILSON S90, WLS, ABS STYLE

Max thickness 4 mm - Max size 10.4 mm

ITEM	HSS PUNCH	€	PUNCH CHUCK MATE ULTRAT. STYLE, SMART	€	PUNCH CHUCK WILSON STYLE WLS, ABS	€
ROUND	AMB105PST006T		AMB105PPTLLNL		AMB105PPTLLL	
Coating	PROBUS		GEMINUS		LEVATUS	

PUNCH



PUNCH CHUCK



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

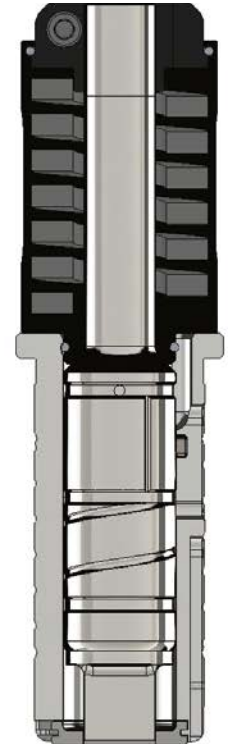


THICK TURRET



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



ITEM	PUNCH	€	PUNCH A. B. LUBR	€	STRIPPER	€	DIE	€
ROUND	AMB1PUT006T		AMB1PUAB06T		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	

* for Amada machines pin 0°-135° code: AMB1MAT001Q

Coating	PROBUS	GEMINUS	LEVATUS

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





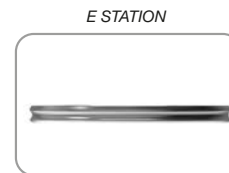
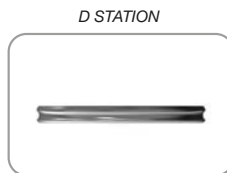
PUNCH AMADA OLD STYLE AND MATE STYLE

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



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



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



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

THICK TURRET



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)



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

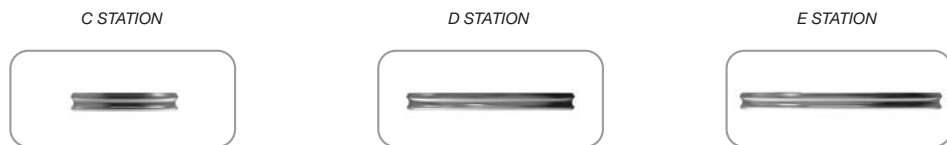
Data: Max size
 C 50.8 mm (Air Blow RD 47 mm)
 D 88.9 mm (Air Blow RD 85.6 mm)
 E 114.3 mm (Air Blow 110.5 mm)

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

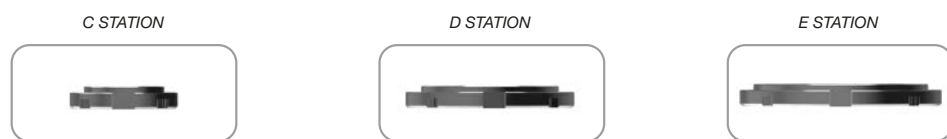
Reduced clearance, grooves for oil



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



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 STYLE

PUNCH HP



PUNCH HP
LUBRICATED



Data: Max size
12.7 mm

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	

PUNCH S90



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	

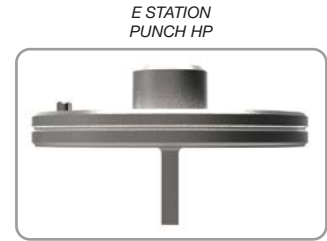
Coating	PROBUS		GEMINUS		LEVATUS	

THICK TURRET



PUNCH WILSON STYLE

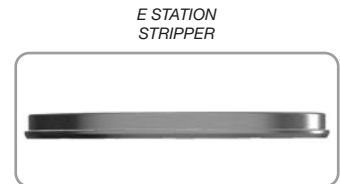
Data: Max size
C 50.8 mm
D 88.9 mm
E 114.3 mm



ITEM	C STATION PUNCH HP	€	D STATION PUNCH HP	€	E STATION PUNCH HP	€
ROUND	AMC1PUWT06T		AMD1PUWT06T		AME1PUWT06T	
STANDARD	AMC1PUWT06S		AMD1PUWT06S		AME1PUWT06S	
SPECIAL 0	AMC1PUWT06C		AMD1PUWT06C		AME1PUWT06C	
SPECIAL 1	AMC1PUWT06D		AMD1PUWT06D		AME1PUWT06D	
SPECIAL 2	AMC1PUWT06F		AMD1PUWT06F		AME1PUWT06F	

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

STRIPPER WILSON STYLE



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



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	

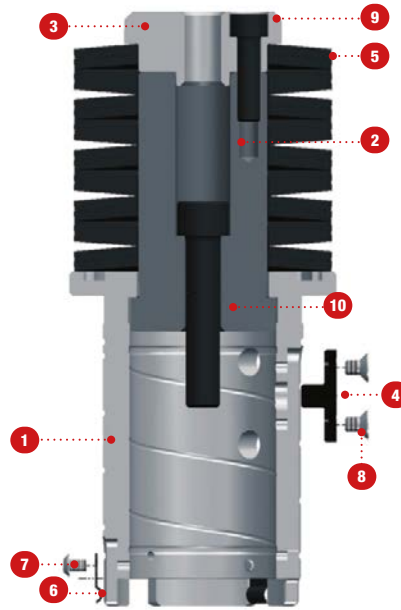
* only Amada machines required holes 0°-135°



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°

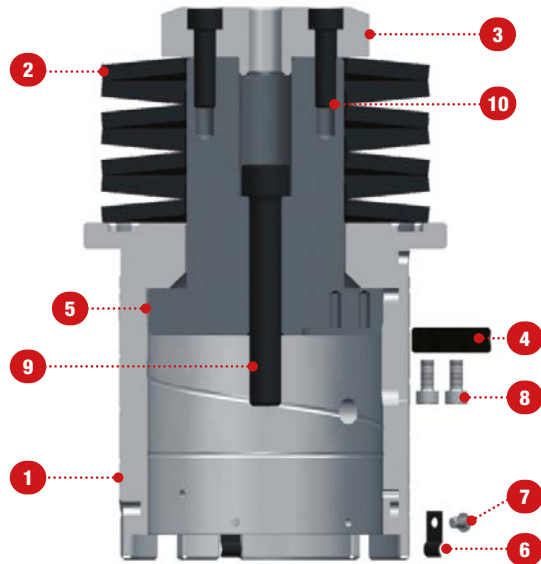
ITEM	GUIDE ASSEMBLY	€
	AMC1GATO	



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°

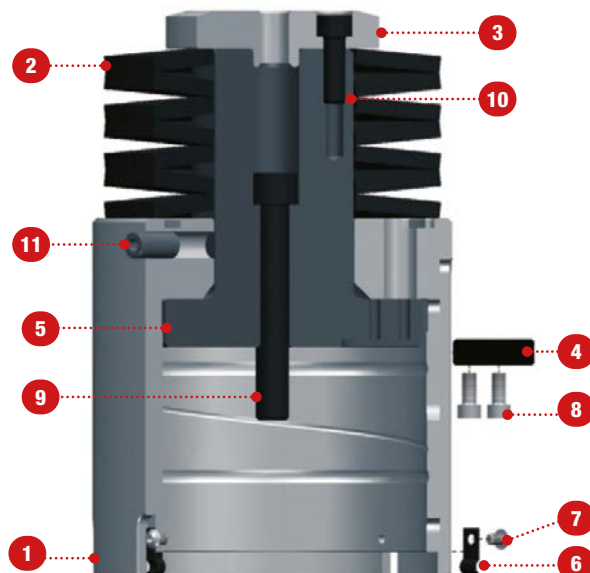
ITEM	GUIDE ASSEMBLY	€
	AMD1GATO	



E STATION STANDARD GUIDE ASSEMBLY AME1GATO

	QTY	COD	DESCRIPTION
11.	4	NSP00MR10020	IS08735 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	



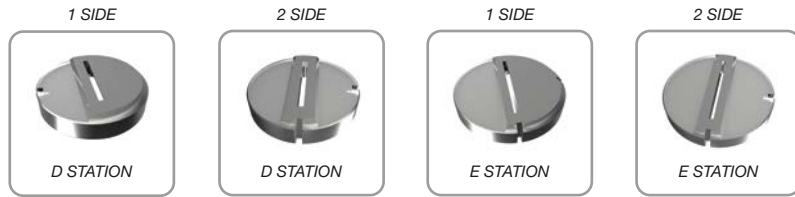
ITEM	GUIDE ASSEMBLY	€
D STATION STD (M12)	AMD1GATM	
D STATION W90	AMD1GATMWT	
D STATION A.B. (M14)	AMD1GATMAB	



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	

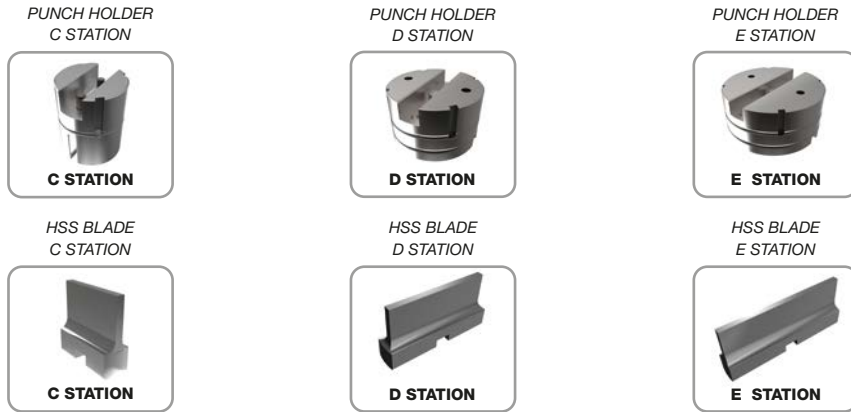
BRUSHES DIES



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

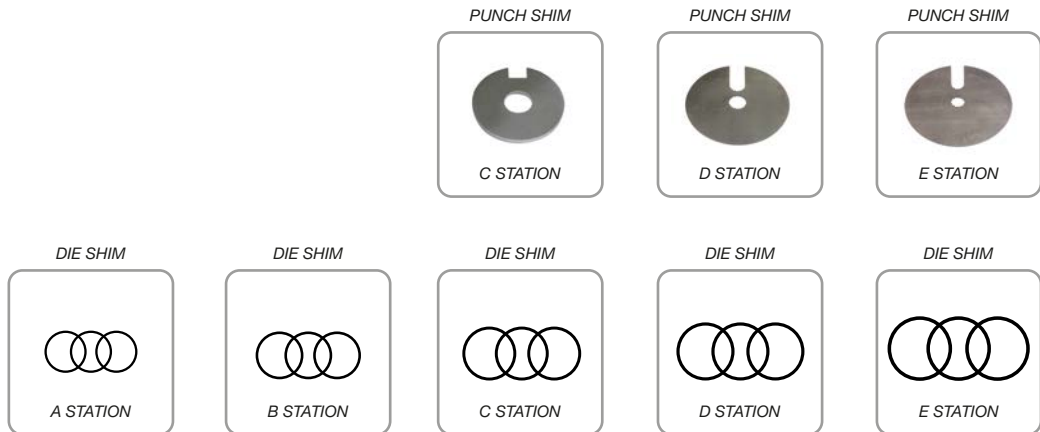


SLITTING TOOLS



ITEM	C STATION		D STATION		E STATION	
BLADE HOLDER, OIL LUBRICATION To specify M12 or M14	C STATION PUNCH HOLDER	€	D STATION PUNCH HOLDER FOR BLADE AMD1PULTG06S	€	E STATION PUNCH HOLDER FOR BLADE AME1PULTG06S	€
	AMC1PPLAT0		AMD1PPLAT0		AME1PPLAT0	
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	



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	

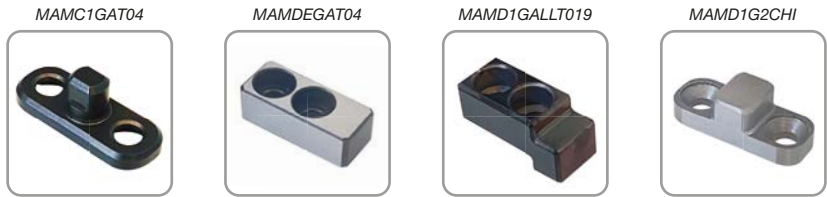
PUNCH LUBRICANT



ITEM	PUNCH LUBRICANT 1 KG	€
	C15M0000001	



PUNCH HOLDER KEYS



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

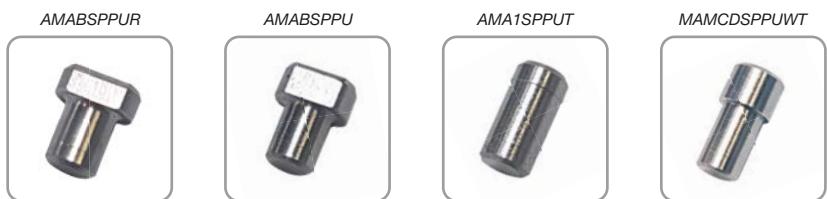
FIXTURE EQUIPMENT

D STATION ADAPTOR FOR PRESSBRAKE MACHINES



ITEM	€
D STATION ADAPTOR FOR PRESSBRAKE MACHINES	AMDAP O.D.

PUNCH PINS



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	



GRINDING MACHINE



Tools sharpening can give back to a punch all features as first purchased. The machine used for regrinding tool is also very important as all our tools (and most of the tool you have in your tool's inventory) are made of High-Quality Special steel, so you must follow some specific procedures to grind these tools in a proper way and prevent them from damaging. You must use coolant when grinding, to prevent punch tip from cracking or damaging, polishing by hand after grinding is necessary to remove burrs on punch edge that is naturally generated by reshaping operation. Always demagnetize tools before taking them to storage. This machine has been specifically designed for punching tools and therefore, it must fulfill some specific requirements in terms of structure, grinding speed and capacity.



Click on the QRCode or scan it to find out more about **our grinding machine and tool sharpening service.**

The machine has been implemented with a software functionality for automatic data exchange using the OPC UA protocol which has the advantage of being an **open standard, ideal for meeting the basic requirements of Industry 4.0.**

Proper sharpened tools give the following advantages:

- Flatter sheets
- Less noise
- Less stress on tool and machine
- Increased holes quality
- Tools lasting longer
- Reduced amount of new tools to be purchased
- Saving money
- Robust construction
- Fully aluminum constructed grinding area
- Sensorless automatic height sensing of tools (never Need any adjustment)
- High Capacity Cooling Tank with triple filtration (40lt)
- Easy To Use Siemens Touch Screen HMI
- Information panel of operations and alarms in progress
- Sliding door with Security switch
- No additional accessories needed for tool clamping
- Straight and angular grinding
- Tool Drawer
- Grinding pressure controlled
- Automatic grinding speed adjustment
- Illuminated Grinding Area
- Security sensor equipped doors
- High Quality Grinding Wheel
- Washing system with water gun



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.

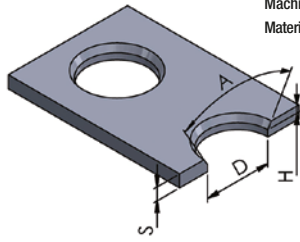


Lenses, nozzles and accessories for laser cutting machines
High quality consumables and accessories for fiber and Co2 laser cutting machines.

- » NOZZLES, LENSES AND PROTECTIVE WINDOWS
- » ACCESSORIES

FORMING TOOL DATA SHEET

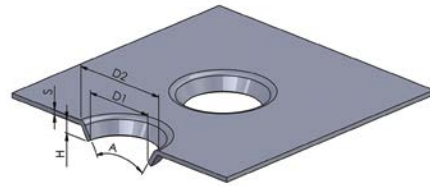
COUNTER SINK DOWN



Machine Model: _____
Material: _____

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

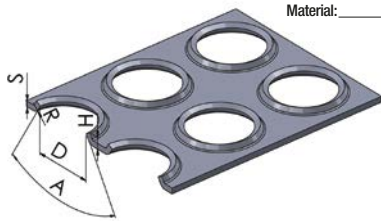
COUNTER SINK DOWN FORMING AFTER PRE PIERCE



Machine Model: _____
Material: _____

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

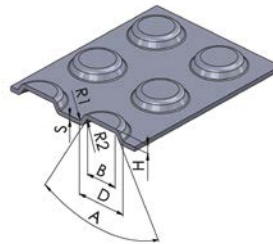
COUNTER SINK UP FORMING AFTER PRE PIERCE



Machine Model: _____
Material: _____

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

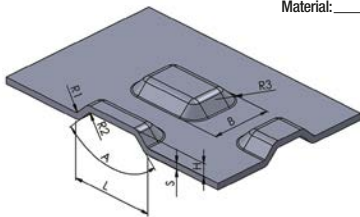
EMBOSS UP ROUND



Machine Model: _____
Material: _____

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

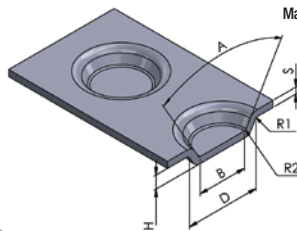
EMBOSS UP RECTANGULAR



Machine Model: _____
Material: _____

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

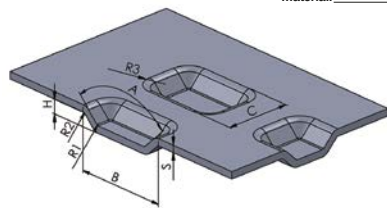
EMBOSS DOWN ROUND



Machine Model: _____
Material: _____

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

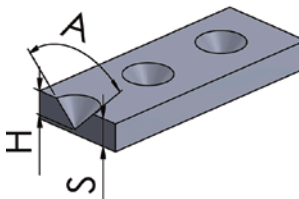
EMBOSS DOWN RECTANGULAR



Machine Model: _____
Material: _____

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

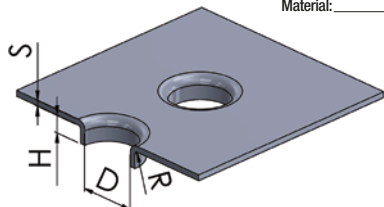
FORM DOWN MARKING TOOL



Machine Model: _____
Material: _____

A: _____
H: _____
S: _____

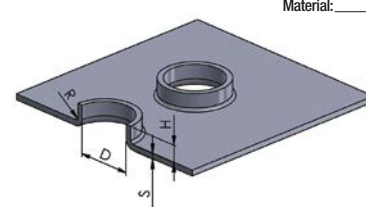
EXTRUSION DOWN ROUND



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

Elements n° X

Elements n° Y

Punch dimensions (mm):

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

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

* See data pag. 40

THICK TURRET

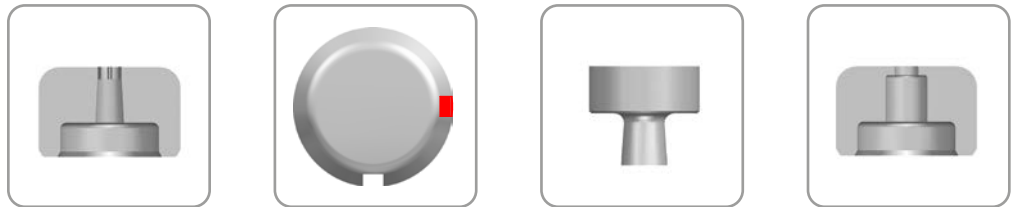
ADD ON

SHEAR OPTION

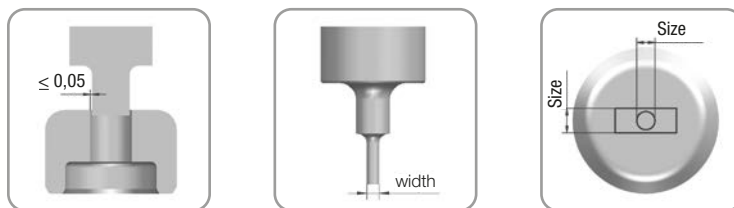


TYPE OF SHEAR	Roof top	Inverted roof top	Double valley	Whisper	Four ways
WHEN	Best option when punching force is high, minimum feed 75% of tool length	Recommended for nibbling at maximum tonnage but inverted stress could cause breakage	Recommended when punch is longer than 80mm But inverted stress could 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		0,5 - 0,99 mm 1 - 1,5 mm	0,7 - 0,99 mm 1 - 1,69 mm 1,7 - 2,7 mm



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