

- **MULTITOO**
- **STATION (A, B, C, D, E)**
- **FITTING**
- **SLITTING TOOLS**
- **SPECIAL**



CK TURRET THICK TURRET TH

WHY SUCE?



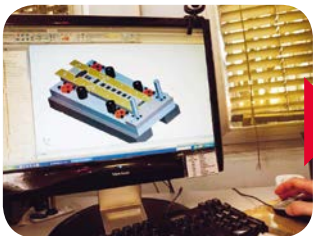
The use of double grinding wheel plants allows for a very low roughness coefficient.



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.





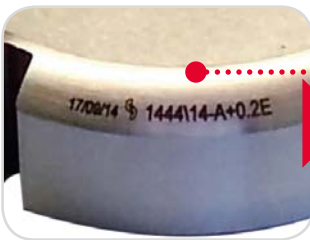
No shape limitation thanks to Wire EDM technology.



Wire EDM load-unload cell.



In warehouse: ready for delivery.

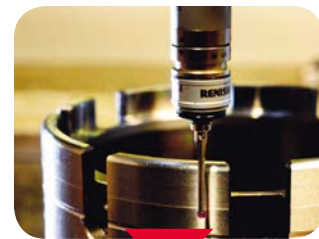
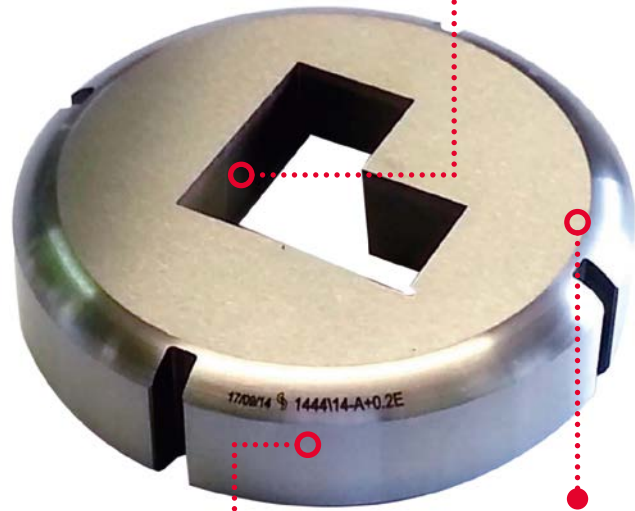
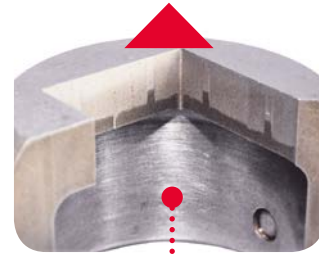


SUCE special ID number.



Manufacturing execution system.

Different lock-slug systems available



Tool testing: fault free.

THICK TURRET

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)

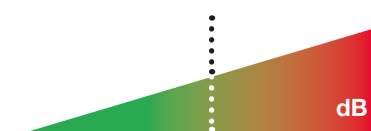


Four ways
Cod 4P



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

PROBUS ALCRN coating , features a unique nanostructure for a substantial decrease of internal stress; is tailored to withstanding cutting temperatures of up to 1050° C.

A distinguishing feature of PROBUS coating is the improved wear performance at the cutting edge of the tool. Uniform distribution of mechanical forces in the vicinity of the cutting edge provides an additional advantage. This property puts PROBUS ahead of other coatings, making it excel in applications where similar AlCrN coatings provide only modest lifetime improvements.



STRUCTURE	Micro Hardness (HV 0.05)	Friction coefficient (100 cr6)	Thickness (micron)	Deposition temperature (°C)	Max temperature (max°C)	Colour
Multilayer	3.000	0.5	2 - 4	450 - 500	1050	Grey

GEMINUS

The double coating is obtained by overlaying the traditional TiCN with Movic self-lubricating coating. The TiCN 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 TiCN coating ensures a higher wear resistance.

A further improvement of the TiCN 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

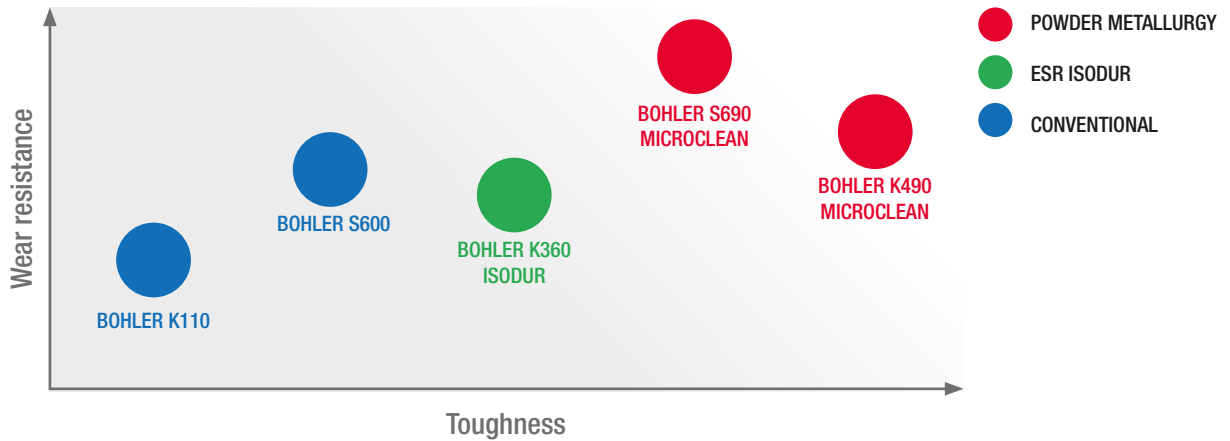
COATING	COPPER	ALUMINUM	MILD STEEL	GALVANIZED STEEL	STAINLESS STEEL
PROBUS	X	X	X	XX	XXX
GEMINUS	XX	XX	X	XXX	XX
LEVATUS	XXX	XXX	X	X	X

NEEDLESS	RECOMMENDED	HIGHLY RECOMMENDED
X	XX	XXX

BEST TOOLS CAN ONLY BE FORMED OUT OF THE BEST STEEL

Tool users has been demanding higher and higher standards of their tools to prolong service life and reduce costs; the tool material itself, in addition to the tool design, is a success factor which is often under-appreciated. It can significantly influence the tool life and therefore the cost effectiveness of your production.

For each of the demands of blanking and cutting, Bohler has an optimal solution in its product range. The range contains everything from standard materials to high-performance powder metallurgical steels.



LINE	TRUMPF	THICK TURRET	SALVAGNINI	MURATEC
PUNCH SIZE 0	HSS / PSM	-	-	-
PUNCH	ISODUR / PSM	ISODUR / PSM	ISODUR / PSM	ISODUR
INSERT BLADES	HSS / PSM	HSS / PSM	-	-
DIE	HWS / ISODUR	HWS / ISODUR	ISODUR / PSM	HWS

HSS - S600

M2 is the “standard” and most widely used industrial HSS. It has small and evenly distributed carbides giving high wear resistance, Tungsten-alloyed molybdenum high-speed steel with high hardness excellent cutting properties, outstanding compressive strength and good toughness.

S600 Chemical composition

CARBONIUM	CHROMIUM	MOLYBDENUM	VANADIUM	TUNGSTEN
0.90 %	4,10 %	5.0 %	1,80 %	3.50 %

D2 – K110

K110 is a high-carbon, high-chromium tool steel alloyed with molybdenum and vanadium characterized by: High abrasive wear resistance, High compressive strength, Good through-hardening properties, High stability in hardening and good resistance to tempering-back.

D2 steel is an air hardening, high-carbon, high-chromium tool steel. It has high wear and abrasion resistant properties. It is heat treatable and will offer a hardness in the range 59-62 HRC

D2 K110 Chemical composition

CARBONIUM	CHROMIUM	MOLYBDENUM	SILICIUM	VANADIUM	MANGANESE
1.55 %	11.30 %	0.75 %	0.30%	0,75 %	0.30 %

THICK TURRET

ISODUR

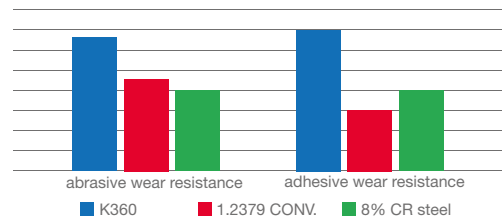
A tough, "LONG DISTANCE RUNNER" with an optimum chemical composition

ESR electro slug remelting: a tried and tested remelting technology developed by Bohler gives the material the homogeneity it needs. A prerequisite for the best performance. ESR Manufacture improved service life due:

- Least possible inclusion content
- Lower micro and macro segregation
- Good homogeneity and higher degree of purity
- A homogeneous structure throughout the entire cross-section and bar length
- Producing larger bar dimensions at a constant carbide distribution
- Uniform correction of dimensions
- A broad range of application due to a high degree of toughness

K360 Chemical composition	
Carbonium	1.25 %
Chromium	8.75 %
Molybdenum	2.70 %
Vanadium	1.18 %

The tough, wear resistance allrounder



The new K360 isodur is a further development of the 8% chromium steels and has been developed to meet the needs of customers now more than ever.

High toughness and, a remarkably high compressive strength, together with good resistance make this steel a real problem solver.

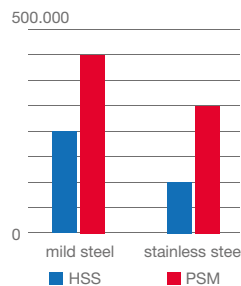
This steel is particularly outstanding when adhesive and abrasive wear resistance are necessary; it allows a considerable increase in performance, your productivity will increase and your costs per part will be reduced.

POWDER STEEL METALLURGY

Today Suce provides, in addition to the traditional HSS punches, of new variety of tools, Trumpf style and Thick turret style made in powder steel metallurgical.

HIGHEST METALLURGICAL PURITY	GOOD DIMENSIONAL STABILITY	FINEST CARBIDE DISTRIBUTION	HIGH DEGREE OF HARDNESS	MAXIMUM WEAR RESISTANCE	HIGHER TOUGHNESS	HIGH COMPRESSIVE STRENGTH

The first sharpening



Graphic shows nr of hits before first sharpening punching mild and stainless steel with HSS and PSM tool. Tool tested square 6mm

One of them is **K490**.

Research shows that the **K490 Microclean**, thanks to its chemical composition, is the best steel in the punching market. If you compare it with other powder steels, for example M4 and PM23, you will find that it assures twice the toughness with the same wear resistance.

This new material is characterized by:

- **A high adhesive and abrasive wear resistance** More hits between regrind operations increases tool life, wear resistance double than traditional HSS M2
- **A high toughness** reduces risk of breaking the punch.

K490 Chemical composition

Carbonium	1.40 %
Chromium	6.40 %
Molybdenum	1.50 %
Vanadium	3.70 %
Tungsten	3.50 %

CPOH plus Chemical composition

Carbonium	1.0 %
Chromium	8.0 %
Molybdenum	2.50 %
Vanadium	0.3 %

In the catalogue **POWDER STEEL PUNCHES** are marked in **RED**, available items:
















Trumpf Gr0 D6 D10.5	Trumpf Multitool 5 - 10	Trumpf Gr1	Thick turret Mate ultra style	Thick turret Smart staz.A Wilson	B station Smart, Mate Wilson	Trumpf blade Thick turret Slitting blade

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. 10 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;
- j) delivery time trumpf and thick turret tooling: 2/3 days standard, 5/7 coating tools, some items are available in stock;

THICK TURRET

MODEL	PAGE	COMPATIBILITY		BENEFITS	THICKNESS LIMITS	OIL LUBRICATION	POWDER STEEL
DESCRIPTION		PUNCH STYLE	STRIPPER STYLE				
A station standard open guide	25	THICK TURRET OLD STYLE	MATE ULTRATEC®	Quick stripper change Grind life with punch driver	3		
A station econo line	24	THICK TURRET OLD STYLE	CLOSE GUIDE	Best price	3		
A station heavy dute	31	SUCE DESIGN	MATE ULTRATEC®	Recommended when thickness exceeds 3 mm	6		
A station with lubrication open guide	27	THICK TURRET OIL LUBRICATION STYLE	MATE ULTRATEC®	Quick stripper change Grind life with punch driver	3		
A station lubrication solid guide	26	THICK TURRET OIL LUBRICATION STYLE	CLOSE GUIDE	Best price Grind life with punch driver	3		
A station smart	28	SUCE DESIGN	MATE ULTRATEC®	Grind life Quick punch and stripper change	3		
A station smart 2/3	29 - 30	MATE ULTRATEC®	MATE ULTRATEC®	Grind life Quick punch and stripper change	3 MS 2.5 SS		
A station wilson style	41	WILSON HP, WLS, S90	WILSON HP, WLS, S90	Grind life	3		
B station open guide	33	THICK TURRET OLD STYLE	MATE AND WILSON	Quick stripper change Grind life with punch driver	4/6		
B station econo line	32	THICK TURRET OLD STYLE	CLOSE GUIDE	Best price	4		
B station semi open	34	THICK TURRET OLD STYLE	MATE AND WILSON	Semi-open guide ensures greater stability of stripper Quick stripper change Grind life with punch driver	4/6		
B station open guide with lubrication	36	THICK TURRET OIL LUBRICATION STYLE	MATE AND WILSON	Quick stripper change Grind life with punch driver	4/6		
B station with lubrication	35	THICK TURRET OIL LUBRICATION STYLE	SOLID GUIDE	Best price Grind life with punch driver	4/6		
B station smart	37	MATE ULTRATEC WILSON HP, WLS, S90	MATE AND WILSON	Grind life Quick punch and stripper change	5		
B station smart 2	38	MATE ULTRATEC WILSON HP, WLS, S90	MATE AND WILSON	Semi-open guide ensures greater stability of stripper Grind life Quick punch and stripper change	5		
B station wilson style	41	WILSON HP, WLS, S90	WILSON HP, WLS, S90	Grind life Quick stripper change	6		

ULTRATEC® IS A TRADEMARK OF MATE PRECISION TOOLING INC., HP IS A TRADEMARK OF WILSON TOOL INTERNATIONAL INC.

MODEL	PAGE	COMPATIBILITY		BENEFITS	THICKNESS LIMITS	OIL LUBRICATION	POWDER STEEL
DESCRIPTION		PUNCH STYLE	STRIPPER STYLE				
C station	39	THICK TURRET OLD STYLE	THICK TURRET OLD STYLE, MATE ULTRA XT	Best price	6	*	
C station smart	41	WILSON	WILSON	Grind life	6		
C station with lubrication	40	THICK TURRET ORIGINAL OIL LUBRICATION STYLE	THICK TURRET ORIGINAL OIL LUBRICATION STYLE	—	6		
C station mate style	39	THICK TURRET OLD STYLE - MATE	MATE ULTRATEC®	—	6		
D station	39	THICK TURRET OLD STYLE	THICK TURRET OLD STYLE, MATE ULTRA XT	Best price	6	*	
D station smart	41	WILSON	WILSON	Grind life	6		
D station with lubrication	40	THICK TURRET ORIGINAL OIL LUBRICATION STYLE	THICK TURRET ORIGINAL OIL LUBRICATION STYLE	—	6		
D station mate style	39	THICK TURRET OLD STYLE - MATE	MATE ULTRATEC®	—	6		
E station	39	THICK TURRET OLD STYLE	THICK TURRET OLD STYLE, MATE ULTRA XT	Best price	6	*	
E station with lubrication	40	THICK TURRET ORIGINAL OIL LUBRICATION STYLE	THICK TURRET ORIGINAL OIL LUBRICATION STYLE	—	6		
E station smart	41	WILSON	WILSON	Grind life	6		
Sitting tool C, D, E Station AMADA, MATE and WILSON STYLE	51	THICK TURRET ORIGINAL STYLE MATE WILSON	—	Saving of over 80% cost of material	3		

ULTRATEC® IS A TRADEMARK OF MATE

ULTRA XT IS A TRADEMARK OF MATE

* With adjustable guide

LOOK AT THE COLORED SYMBOL AND CHOOSE THE PROPER A AND B PUNCH HOLDER



It takes long time to assembly and disassembly.



Pack spring assembly allows to save time , after adjusting the punch at the right length tighten the screw with an allen key.

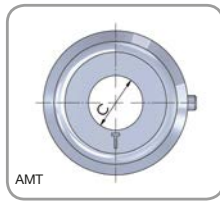


Best option to save time , pack spring assembly and button on the punch holder allow to adjust and lock the punch while assembly.



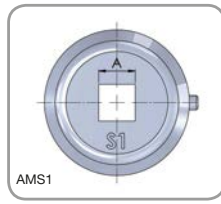
THICK TURRET

THICK TURRET ROUND AND STANDARD



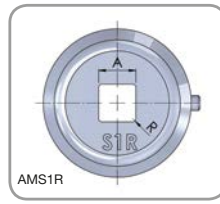
AMT

C: _____



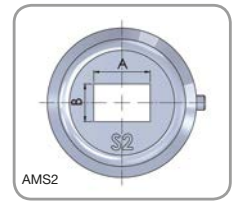
AMS1

A: _____



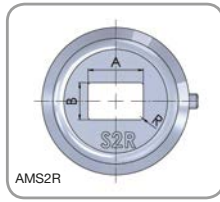
AMS1R

A: _____ R: _____



AMS2

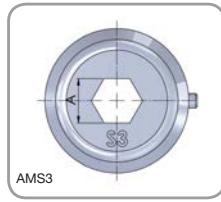
A: _____ B: _____



AMS2R

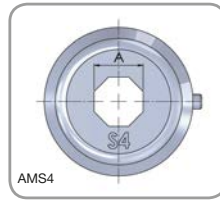
A: _____ B: _____

R: _____



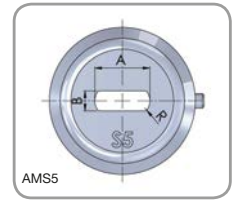
AMS3

A: _____



AMS4

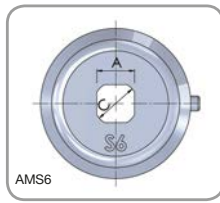
A: _____



AMS5

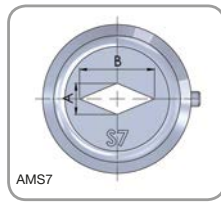
A: _____ B: _____

R: _____



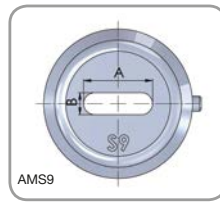
AMS6

A: _____ C: _____



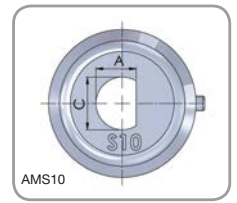
AMS7

A: _____ B: _____



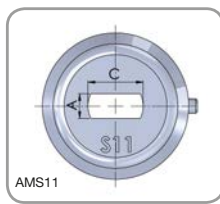
AMS9

A: _____ B: _____



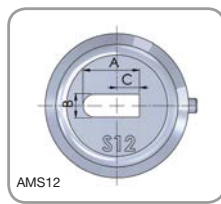
AMS10

A: _____ C: _____



AMS11

A: _____ C: _____

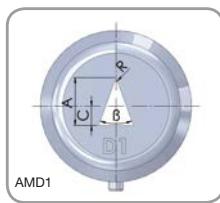


AMS12

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C: _____

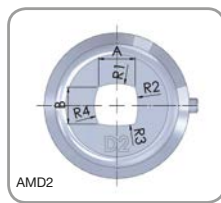
SPECIAL 1



AMD1

A: _____ B: _____

C: _____ R: _____

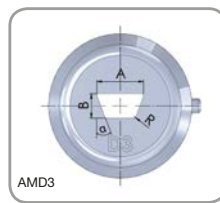


AMD2

A: _____ B: _____

R1: _____ R2: _____

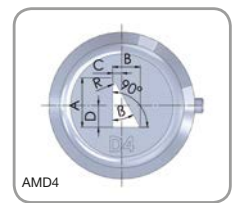
R3: _____ R4: _____



AMD3

A: _____ B: _____

α: _____ R: _____

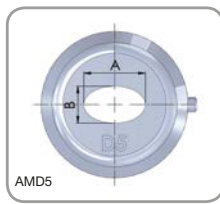


AMD4

A: _____ B: _____

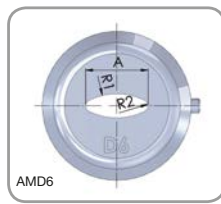
C: _____ D: _____

β: _____ R: _____



AMD5

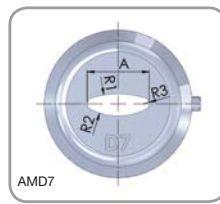
A: _____ B: _____



AMD6

A: _____ R1: _____

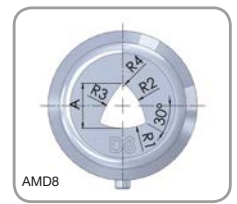
R2: _____



AMD7

A: _____ R1: _____

R2: _____ R3: _____



AMD8

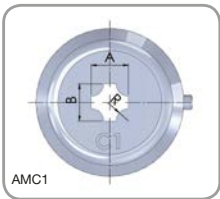
A: _____ R1: _____

R2: _____ R3: _____

R4: _____

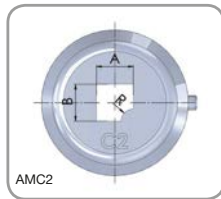
A AND B PIN DIE REFERENCE

SPECIAL 0



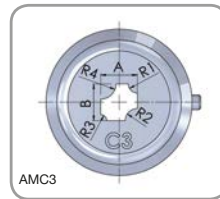
AMC1

A: _____ B: _____
R: _____



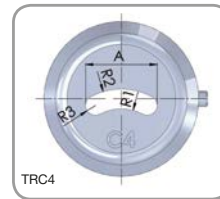
AMC2

A: _____ B: _____
R: _____



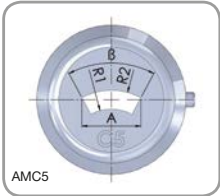
AMC3

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



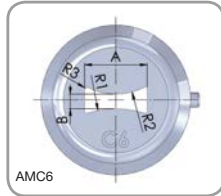
TRC4

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



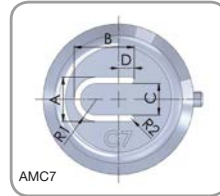
AMC5

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



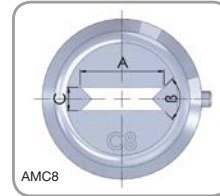
AMC6

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



AMC7

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

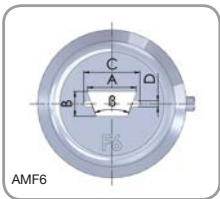


AMC8

A: _____ B: _____
C: _____

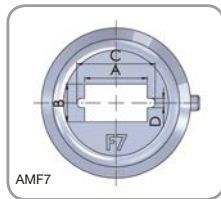
Note:
R<3 price is SPECIAL 2

SPECIAL 2



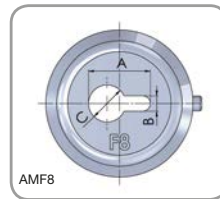
AMF6

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



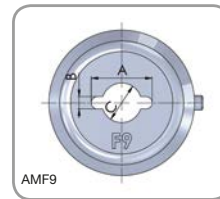
AMF7

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



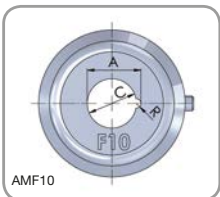
AMF8

A: _____ B: _____
C: _____



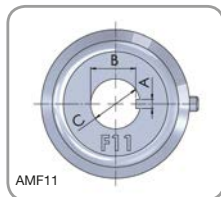
AMF9

A: _____ B: _____
C: _____



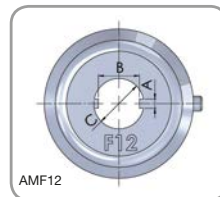
AMF10

A: _____ C: _____
R: _____



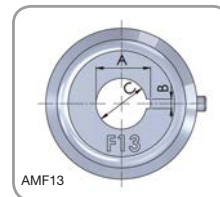
AMF11

A: _____ B: _____
C: _____



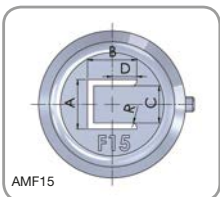
AMF12

A: _____ B: _____
C: _____



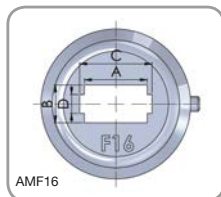
AMF13

A: _____ B: _____
C: _____



AMF15

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



AMF16

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



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 HSS	€	PUNCH PSM	€	STRIPPER	€	ISODUR DIE	€
ROUND	AMA0PSM2006T		AMA0PSM2002T		AMA0PLM20T		AMA0MAM2001T	
STANDARD			AMA0PSM2002S		AMA0PLM20S		AMA0MAM2001S	
SPECIAL 0			AMA0PSM2002C		AMA0PLM20D		AMA0MAM2001D	
SPECIAL 1			AMA0PSM2002D		AMA0PLM20D		AMA0MAM2001D	
SPECIAL 2			AMA0PSM2002F		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	ISODUR PUNCH	€	STRIPPER	€	ISODUR 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	

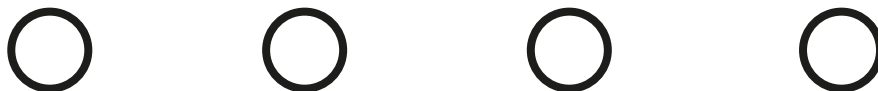
MULTITOOL Mate style 6 - 8 - 24 mm

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	ISODUR PUNCH	€	STRIPPER	€	ISODUR DIE	€	HEAVY DUTY ISODUR 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	€	SHIM Mt 10 - 16 mm	€	SHIM - XMTE6, Mt 6/8 - 24 mm	€	SHIM XMTE12.7	€
0.1 mm	AMA0MAM20SP10		AMA0MAM16SP10		AMA0MAM24SP01		AMA0MAM10SP01	
0.2 mm	AMA0MAM20SP20		AMA0MAM16SP20		AMA0MAM24SP02		AMA0MAM10SP02	
0.5 mm	AMA0MAM20SP60		AMA0MAM16SP60		AMA0MAM24SP05		AMA0MAM10SP05	



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	ISODUR PUNCH	€	ISODUR PUNCH ADJUSTABLE	€	STRIPPER	€	ISODUR DIE	€	HEAVY DUTY ISODUR 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 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

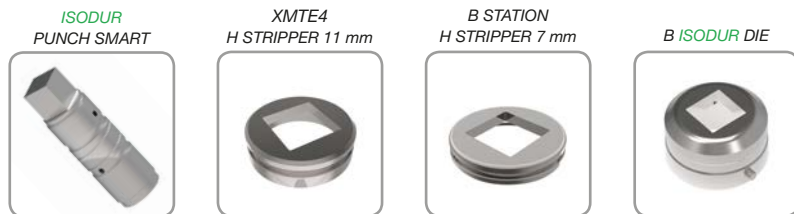


ITEM	ISODUR PUNCH	€	ISODUR PUNCH ADJUSTABLE	€	PUNCH HEAD	€	STRIPPER	€	ISODUR DIE	€
ROUND	AMA0PUM1006T		AMA0PUM10B6T		AMA0TEM10		AMA0PLM10T		AMA0MAM1001T	
STANDARD	AMA0PUM1006S		AMA0PUM10B6S		AMA0TEM10		AMA0PLM10S		AMA0MAM1001S	
SPECIAL 0	AMA0PUM1006C		AMA0PUM10B6C		AMA0TEM10		AMA0PLM10D		AMA0MAM1001D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

Coating	PROBUS	GEMINUS	LEVATUS

EUROMAC 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	ISODUR PUNCH SMART	€	STRIPPER XMTE4	€	STRIPPER B STATION	€	B ISODUR DIE	€
ROUND	AMB1IPLNL6T		AMB1PLM4T		AMB1PLWTT		AMB1MAT006T	
STANDARD	AMB1IPLNL6S		AMB1PLM4S		AMB1PLWTS		AMB1MAT006S	
SPECIAL 0	AMB1IPLNL6C		AMB1PLM4D		AMB1PLWTD		AMB1MAT006D	
SPECIAL 1	AMB1IPLNL6D		AMB1PLM4D		AMB1PLWTD		AMB1MAT006D	
SPECIAL 2	AMB1IPLNL6F		AMB1PLM4D		AMB1PLWTD		AMB1MAT006D	

Coating	PROBUS	GEMINUS	LEVATUS

THICK TURRET

PRIMA POWER MULTITOOL

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



ITEM	PUNCH HSS	€	STRIPPER	€	ISODUR 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



ITEM	PUNCH HSS	€	STRIPPER	€	ISODUR DIE	€
ROUND	AMA0PUM806T		AMA0PLM8T		AMA0MAM801T	
STANDARD	AMA0PUM806S		AMA0PLM8S		AMA0MAM801S	
SPECIAL 0	AMA0PUM806C		AMA0PLM8D		AMA0MAM801D	
SPECIAL 1	AMA0PUM806D		AMA0PLM8D		AMA0MAM801D	
SPECIAL 2	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



ITEM	ISODUR PUNCH	€	STRIPPER	€	ISODUR 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



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

Coating	PROBUS		GEMINUS		LEVATUS	
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ERMAKSAN MULTITool 6 ERMAK-BIEMMETI

Data
Max size 22 mm

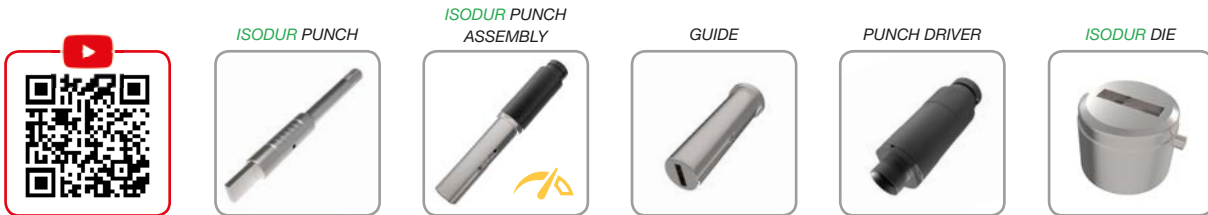


ITEM	PUNCH	€	STRIPPER	€	ISODUR DIE	€
ROUND	AMAOPUM22B6T		AMAOPLM22T		AMAOMAM2401T	
STANDARD	AMAOPUM22B6S		AMAOPLM22S		AMAOMAM24B1S	
SPECIAL 0	AMAOPUM22B6C		AMAOPLMM2D		AMAOMAM24B1D	
SPECIAL 1	AMAOPUM22B6D		AMAOPLMM2D		AMAOMAM24B1D	
SPECIAL 2	AMAOPUM22B6F		AMAOPLMM2D		AMAOMAM24B1D	

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	ISODUR PUNCH	€	ISODUR PUNCH ASSEMBLY	€	GUIDE	€	PUNCH DRIVER	€	ISODUR DIE	€
ROUND	AMMTPU2206T		AMMTPA2206T		AMMTGU22T		AMMT6 - 22LL		AMAOMAM2401T	
STANDARD	AMMTPU2206S		AMMTPA2206S		AMMTGU22S		AMMT6 - 22LL		AMAOMAM24B1S	
SPECIAL 0	AMMTPU2206C		AMMTPA2206C		AMMTGU22D		AMMT6 - 22LL		AMAOMAM24B1D	
SPECIAL 1	AMMTPU2206D		AMMTPA2206D		AMMTGU22D		AMMT6 - 22LL		AMAOMAM24B1D	
SPECIAL 2	AMMTPU2206F		AMMTPA2206F		AMMTGU22D		AMMT6 - 22LL		AMAOMAM24B1D	

Coating	PROBUS		GEMINUS		LEVATUS	
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DURMA MULTITool

Data:
Max size 24.00 mm
Max size die is 24.4 mm



ITEM	ISODUR PUNCH	€	STRIPPER	€	ISODUR DIE	€
ROUND	AMAOPUM24B6T		AMAOPLM24BT		AMAOMAM2401T	
STANDARD	AMAOPUM24B6S		AMAOPLM24BS		AMAOMAM24B1S	
SPECIAL 0	AMAOPUM24B6C		AMAOPLM24BD		AMAOMAM24B1D	
SPECIAL 1	AMAOPUM24B6D		AMAOPLM24BD		AMAOMAM24B1D	
SPECIAL 2	AMAOPUM24B6F		AMAOPLM24BD		AMAOMAM24B1D	

Coating	PROBUS		GEMINUS		LEVATUS	
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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



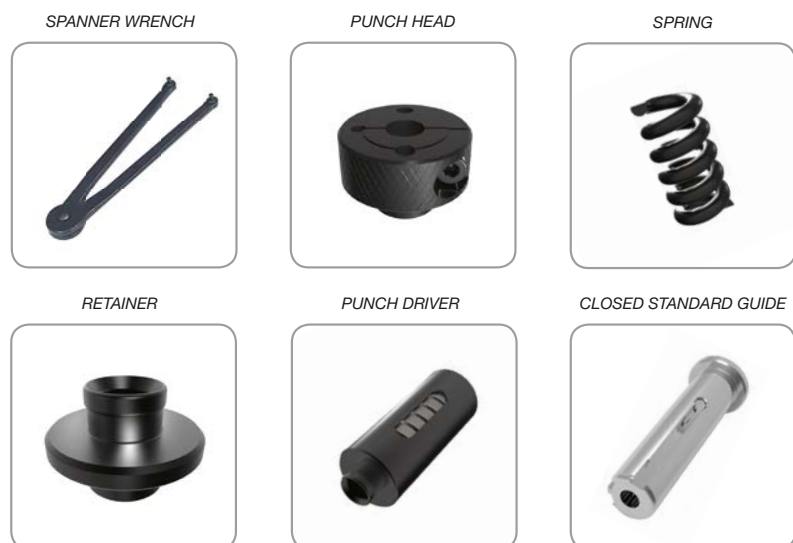
ITEM	ISODUR PUNCH	€	ISODUR PUNCH ASSEMBLY	€	ISODUR PUNCH ASSEMBLY LONG LIFE	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMA1PUT006T		AMA1PATE06T		AMA1PATEL6T		AMA1MAT001T		AMA1MAT006T	
STANDARD	AMA1PUT006S		AMA1PATE06_**		AMA1PATEL6_**		AMA1MAT001S*		AMA1MAT006S*	
SPECIAL 0	AMA1PUT006C		AMA1PATE06C		AMA1PATEL6C		AMA1MAT001D		AMA1MAT006D	
SPECIAL 1	AMA1PUT006D		AMA1PATE06D		AMA1PATEL6D		AMA1MAT001D		AMA1MAT006D	
SPECIAL 2	AMA1PUT006F		AMA1PATE06F		AMA1PATEL6F		AMA1MAT001D		AMA1MAT006D	

* for Amada machines square dies pin 0°-135° code: HWS AMA1MAT001Q, ISODUR AMA1MAT006Q

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

Coating	PROBUS		GEMINUS		LEVATUS	

FITTING

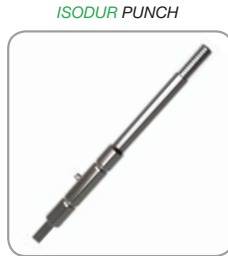


PUNCH HEAD	€	SPRING	€	RETAINER	€	PUNCH DRIVER max thickness 3 mm	€	CLOSED STANDARD GUIDE	€
AMA1TERA		AMA1MST0		AMA1RIT0		AMA1LLGIO		ROUND - AMA1GUT0T	
								SHAPE 0° - 90° - AMA1GUT0S	
								SQUARE 0° - 135° - AMA1GUT0Q	
								SPC 0° - 90° - AMA1GUT0D	



A STATION STANDARD, OPEN GUIDE

Max 12.70 mm, Max thickness: 3 mm
 Grinding life mm: Std Punch 2.5, Long life Punch 6
 Die 2.5



ITEM	ISODUR PUNCH	€	ISODUR PUNCH ASSEMBLY	€	ISODUR PUNCH ASSEMBLY LONG LIFE	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMA1PUT006T		AMA1PAT306T		AMA1PAL306T		AMA1PLTUT		AMA1MAT001T		AMA1MAT006T	
STANDARD	AMA1PUT006S		AMA1PAT306S		AMA1PAL306S		AMA1PLTUS		AMA1MAT001S*		AMA1MAT006S*	
SPECIAL 0	AMA1PUT006C		AMA1PAT306C		AMA1PAL306C		AMA1PLTUD		AMA1MAT001D		AMA1MAT006D	
SPECIAL 1	AMA1PUT006D		AMA1PAT306D		AMA1PAL306D		AMA1PLTUD		AMA1MAT001D		AMA1MAT006D	
SPECIAL 2	AMA1PUT006F		AMA1PAT306F		AMA1PAL306F		AMA1PLTUD		AMA1MAT001D		AMA1MAT006D	

* for Amada machines square dies pin 0°-135° code: HWS AMA1MAT001Q, ISODUR AMA1MAT006Q

Coating	PROBUS		GEMINUS		LEVATUS	

FITTING



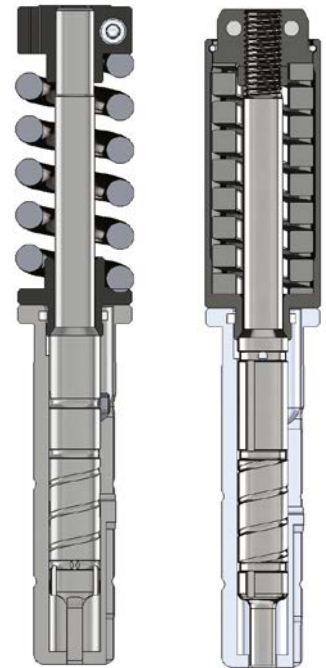
SPANNER WRENCH	€	PUNCH HEAD	€	SPRING	€	RETAINER	€	PUNCH DRIVER max thickness 3 mm	€	OPEN STANDARD GUIDE	€
AMABSW		AMA1TERA		AMA1MST0		AMA1RIT0		AMA1LLGIO		ONLY ROUND AMA1GUA2T	
										SHAPE 0° - 90° - 135° AMA1GUL2S	

THICK TURRET



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	ISODUR PUNCH	€	ISODUR PUNCH ASSEMBLY	€	ISODUR PUNCH ASSEMBLY LONG LIFE	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMA1PUAB06T		AMA1PATAE6T		AMA1PALAE6T		AMA1MAT001T		AMA1MAT006T	
STANDARD	AMA1PUAB06S		AMA1PATAE6_**		AMA1PALAE6_**		AMA1MAT001S*		AMA1MAT006S*	
SPECIAL 0	AMA1PUAB06C		AMA1PATAE6C		AMA1PALAE6C		AMA1MAT001D		AMA1MAT006D	
SPECIAL 1	AMA1PUAB06D		AMA1PATAE6D		AMA1PALAE6D		AMA1MAT001D		AMA1MAT006D	
SPECIAL 2	AMA1PUAB06F		AMA1PATAE6F		AMA1PALAE6F		AMA1MAT001D		AMA1MAT006D	

* for Amada machines square dies pin 0°-135° code: HWS AMA1MAT001Q, ISODUR AMA1MAT006Q

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

Coating	PROBUS		GEMINUS		LEVATUS	

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	



A STATION OIL LUBR. OPEN GUIDE

Max 12.70 mm, Max thickness: 3 mm
Grinding life mm: Std Punch 2.5, Long life Punch 6
Die 2.5



ITEM	ISODUR PUNCH	€	ISODUR PUNCH ASSEMBLY	€	ISODUR PUNCH ASSEMBLY LONG LIFE	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMA1PUAB06T		AMA1PATAB6T		AMA1PALLB6T		AMA1PLTMT		AMA1MAT001T		AMA1MAT006T	
STANDARD	AMA1PUAB06S		AMA1PATAB6S		AMA1PALLB6S		AMA1PLTMS		AMA1MAT001S*		AMA1MAT006S*	
SPECIAL 0	AMA1PUAB06C		AMA1PATAB6C		AMA1PALLB6C		AMA1PLTMD		AMA1MAT001D		AMA1MAT006D	
SPECIAL 1	AMA1PUAB06D		AMA1PATAB6D		AMA1PALLB6D		AMA1PLTMD		AMA1MAT001D		AMA1MAT006D	
SPECIAL 2	AMA1PUAB06F		AMA1PATAB6F		AMA1PALLB6F		AMA1PLTMD		AMA1MAT001D		AMA1MAT006D	

* for Amada machines square dies pin 0°-135° code: HWS AMA1MAT001Q, ISODUR AMA1MAT006Q

Coating	PROBUS		GEMINUS		LEVATUS	

FITTING



PUNCH HEAD	€	SPRING	€	RETAINER		PUNCH DRIVER max thickness 3 mm	€	OPEN STANDARD GUIDE	€
AMA1TERA		AMA1MST0		AMA1RIT0		AMA1LLGIO		ONLY ROUND AMA1GUA2T	
								SHAPE / SQ 0° - 90° - 135° AMA1GUA2S	

THICK TURRET



A STATION SMART

Max 12.70 mm, Max thickness: 3 mm
Grinding life mm: Punch 6, Die 2.5



ITEM	PUNCH				PUNCH ASSEMBLY				STRIPPER	€
	ISODUR	€	PSM	€	ISODUR	€	PSM	€		
ROUND	AMA1IP16T06T		AMA1IP16T04T		AMA1PANS06T		AMA1PANS04T		AMA1PLTMT	
STANDARD	AMA1IP16T06S		AMA1IP16T04S		AMA1PANS06S		AMA1PANS04S		AMA1PLTMS	
SPECIAL 0	AMA1IP16T06C		AMA1IP16T04C		AMA1PANS06C		AMA1PANS04C		AMA1PLTMD	
SPECIAL 1	AMA1IP16T06D		AMA1IP16T04D		AMA1PANS06D		AMA1PANS04D		AMA1PLTMD	
SPECIAL 2	AMA1IP16T06F		AMA1IP16T04F		AMA1PANS06F		AMA1PANS04F		AMA1PLTMD	

Coating	PROBUS		GEMINUS		LEVATUS	

FITTING



ITEM	SMART PUNCH DRIVER (max thickness 3 mm)	€	OPEN SMART GUIDE	€
	AMA1LLNS		ONLY ROUND AMA1GUT2T	
			ROUND & SHAPE 0° - 90° - 135° AMA1GUT2S	



A STATION SMART 2

Max 12.70 mm,
 Max thickness: 3 mm mild steel, 2.5 mm stainless steel
 Grinding life mm: Punch 7, Die 2.5



ITEM	PUNCH				PUNCH ASSEMBLY				STRIPPER	€
	ISODUR	€	PSM	€	ISODUR	€	PSM	€		
ROUND	AMA1IPTM06T		AMA1IPTM04T		AMA1PATU06T		AMA1PATU04T		AMA1PLTUT	
STANDARD	AMA1IPTM06S		AMA1IPTM04S		AMA1PATU06S		AMA1PATU04S		AMA1PLTUS	
SPECIAL 0	AMA1IPTM06C		AMA1IPTM04C		AMA1PATU06C		AMA1PATU04C		AMA1PLTUD	
SPECIAL 1	AMA1IPTM06D		AMA1IPTM04D		AMA1PATU06D		AMA1PATU04D		AMA1PLTUD	
SPECIAL 2	AMA1IPTM06F		AMA1IPTM04F		AMA1PATU06F		AMA1PATU04F		AMA1PLTUD	

Coating	PROBUS		GEMINUS		LEVATUS	

FITTING

SMART2 PUNCH DRIVER *



OPEN SMART2 GUIDE **



ITEM	SMART2 PUNCH DRIVER * (max thickness 3 mm)	€	OPEN SMART2 GUIDE **	€
	AMA1LLTM		ONLY ROUND AMA1GUTUT	
			ROUND & SHAPE 0° - 90° - 135° AMA1GUTUS	

* It works only with Suce guide AMA1GUTU_

** It works only with Suce pack spring AMA1LLTM

THICK TURRET



A STATION SMART 3

Max 12.70 mm,
 Max thickness: 3 mm mild steel, 2.5 mm stainless steel
 Grinding life mm: Punch 7, Die 2.5



PUNCH



PUNCH ASSEMBLY



STRIPPER



ITEM	PUNCH				PUNCH ASSEMBLY				STRIPPER	€
	ISODUR	€	PSM	€	ISODUR	€	PSM	€		
ROUND	AMA1IPTM06T		AMA1IPTM04T		AMA1PAS306T		AMA1PAS304T		AMA1PLTUT	
STANDARD	AMA1IPTM06S		AMA1IPTM04S		AMA1PAS306S		AMA1PAS304S		AMA1PLTUS	
SPECIAL 0	AMA1IPTM06C		AMA1IPTM04C		AMA1PAS306C		AMA1PAS304C		AMA1PLTUD	
SPECIAL 1	AMA1IPTM06D		AMA1IPTM04D		AMA1PAS306D		AMA1PAS304D		AMA1PLTUD	
SPECIAL 2	AMA1IPTM06F		AMA1IPTM04F		AMA1PAS306F		AMA1PAS304F		AMA1PLTUD	
Coating	PROBUS		GEMINUS		LEVATUS					

FITTING

SMART3 PUNCH DRIVER



OPEN SMART3 GUIDE **



ITEM	SMART3 PUNCH DRIVER * (max thickness 3 mm)	€	OPEN SMART3 GUIDE **	€
	AMA1LLNM		ONLY ROUND AMA1GUT2T	
			ROUND & SHAPE 0° - 90° - 135° AMA1GUT2S	

* It works only with Suce guide AMA1GUT2_ ** It works only with Suce pack spring AMA1LLNM, AMA1LLNS



A STATION HEAVY DUTY

Max 12.70 mm, Max thickness: 6 mm
 Grinding life mm: Punch 3.5, Die 2.5
 Radius on corner 0.5



ITEM	ISODUR PUNCH	€	ISODUR PUNCH ASSEMBLY	€	STRIPPER	€	ISODUR DIE	€
ROUND	AMA1PUTR06T		AMA1PATM06T		AMA1PLTMT		AMA1MAT006T	
STANDARD	AMA1PUTR06S		AMA1PATM06S		AMA1PLTMS		AMA1MATP01S	
SPECIAL 0	AMA1PUTR06C		AMA1PATM06C		AMA1PLTMD		AMA1MATP01D	
SPECIAL 1	AMA1PUTR06D		AMA1PATM06D		AMA1PLTMD		AMA1MATP01D	
SPECIAL 2	AMA1PUTR06F		AMA1PATM06F		AMA1PLTMD		AMA1MATP01D	

Coating	PROBUS		GEMINUS		LEVATUS	

FITTING



PUNCH HEAD	€	DISC SPRING 34X16.3X1.5 mm	€	RETAINER	€	OPEN GUIDE	€	OR	€	SEEGER	€
AMA1TETR		NMO060034163A		NEW TOOL: AMA1RITR		RD & SHAPE, AMA1GUTMS 0-90°		ORM10180		SW16X1.2	
				2 mm GRINDED: AMA1RITR2		SQUARE, AMA1GUTMQ 0-135°					
				3.5 mm GRINDED: AMA1RITR35							

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	ISODUR PUNCH	€	ISODUR PUNCH ASSEMBLY	€	ISODUR PUNCH ASSEMBLY LONG LIFE	€	HWS DIE	€	ISODUR DIE	
ROUND	AMB1PUT006T		AMB1PATE06T		AMB1PATEL6T		AMB1MAT001T		AMB1MAT006T	
STANDARD	AMB1PUT006S		AMB1PATE06S		AMB1PATEL6S		AMB1MAT001S*		AMB1MAT006S*	
SPECIAL 0	AMB1PUT006C		AMB1PATE06C		AMB1PATEL6C		AMB1MAT001D		AMB1MAT006D	
SPECIAL 1	AMB1PUT006D		AMB1PATE06D		AMB1PATEL6D		AMB1MAT001D		AMB1MAT006D	
SPECIAL 2	AMB1PUT006F		AMB1PATE06F		AMB1PATEL6F		AMB1MAT001D		AMB1MAT006D	

* for Amada machines square dies pin 0° - 135° code: HWS AMB1MAT001Q, ISODUR AMB1MAT006Q

Coating	PROBUS		GEMINUS		LEVATUS	
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CLOSED GUIDE



FITTING

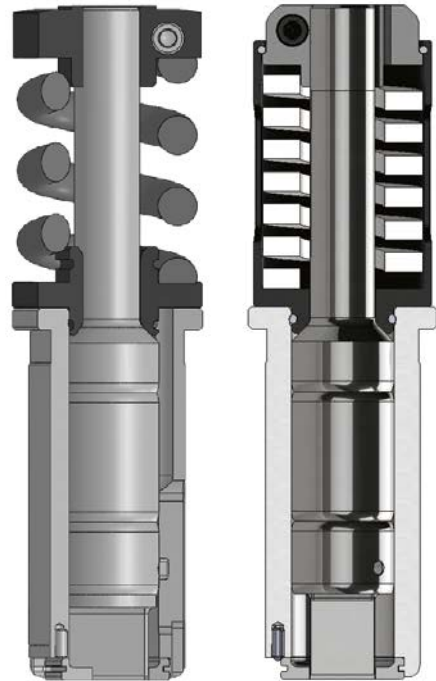


SPANNER WRENCH	€	PUNCH HEAD	€	SPRING	€	REVERSIBLE RETAINER Included OR	€	PUNCH DRIVER max thickness 6 mm	€	CLOSED GUIDE	€
AMABSW		AMB1TERA		AMB1MST0		AMB1RIT0		AMB1LLGIO		RD AMB1GUT0T	
										STD 0° - 90° - 135° AMB1GUT4S	
										SPECIAL 0 - 1 - 2 0° - 90° - 135° AMB1GUT4D	



B STATION STANDARD, OPEN GUIDE

Max 31.70 mm, Max thickness: 4-6 mm
 Grinding life mm: Standard Punch 4, Long life Punch 8
 Die 2.5



ITEM	ISODUR PUNCH	€	ISODUR PUNCH ASSEMBLY	€	STRIPPER	€	ISODUR PUNCH ASSEMBLY LONG LIFE	€	STRIPPER	€
ROUND	AMB1PUT006T		AMB1PAT206T		AMB1PLWTPT		AMB1PALL06T		AMB1PLWTT	
STANDARD	AMB1PUT006S		AMB1PAT206S		AMB1PLWTPS		AMB1PALL06S		AMB1PLWTS	
SPECIAL 0	AMB1PUT006C		AMB1PAT206C		AMB1PLWTPD		AMB1PALL06C		AMB1PLWTD	
SPECIAL 1	AMB1PUT006D		AMB1PAT206D		AMB1PLWTPD		AMB1PALL06D		AMB1PLWTD	
SPECIAL 2	AMB1PUT006F		AMB1PAT206F		AMB1PLWTPD		AMB1PALL06F		AMB1PLWTD	

Coating	PROBUS	GEMINUS	LEVATUS

ITEM	HWS DIE	€	ISODUR DIE	€
ROUND	AMB1MAT001T		AMB1MAT006T	
STANDARD	AMB1MAT001S*		AMB1MAT006S*	
SPECIAL 0	AMB1MAT001D		AMB1MAT006D	
SPECIAL 1	AMB1MAT001D		AMB1MAT006D	
SPECIAL 2	AMB1MAT001D		AMB1MAT006D	



* for Amada machines square dies pin 0° - 135° code: HWS AMB1MAT001Q, ISODUR AMB1MAT006Q

FITTING



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° AMB1GULLS	

THICK TURRET



B STATION STANDARD, SEMI - OPEN GUIDE

Max 31.70 mm, Max thickness: 4-6 mm
Grinding life mm: Standard Punch 4, Long life Punch 8
Die 2.5



ISODUR PUNCH



ISODUR PUNCH ASSEMBLY



ISODUR PUNCH ASSEMBLY LONG LIFE



STRIPPER



ITEM	ISODUR PUNCH	€	ISODUR PUNCH ASSEMBLY	€	STRIPPER	€	ISODUR PUNCH ASSEMBLY LONG LIFE	€	STRIPPER	€
ROUND	AMB1PUT006T		AMB1PAT306T		AMB1PLWTPT		AMB1PAL306T		AMB1PLWTT	
STANDARD	AMB1PUT006S		AMB1PAT306S		AMB1PLWTPS		AMB1PAL306S		AMB1PLWTS	
SPECIAL 0	AMB1PUT006C		AMB1PAT306C		AMB1PLWTPD		AMB1PAL306C		AMB1PLWTD	
SPECIAL 1	AMB1PUT006D		AMB1PAT306D		AMB1PLWTPD		AMB1PAL306D		AMB1PLWTD	
SPECIAL 2	AMB1PUT006F		AMB1PAT306F		AMB1PLWTPD		AMB1PAL306F		AMB1PLWTD	

Coating	PROBUS		GEMINUS		LEVATUS	

ITEM	HWS DIE	€	ISODUR DIE	€
ROUND	AMB1MAT001T		AMB1MAT006T	
STANDARD	AMB1MAT001S*		AMB1MAT006S*	
SPECIAL 0	AMB1MAT001D		AMB1MAT006D	
SPECIAL 1	AMB1MAT001D		AMB1MAT006D	
SPECIAL 2	AMB1MAT001D		AMB1MAT006D	

HWS DIE ISODUR DIE



* for Amada machines square dies pin 0° - 135° code: HWS AMB1MAT001Q, ISODUR AMB1MAT006Q

FITTING

SPANNER WRENCH



PUNCH HEAD



SPRING



REVERSIBLE RETAINER



PUNCH DRIVER



SEMI OPEN STANDARD GUIDE

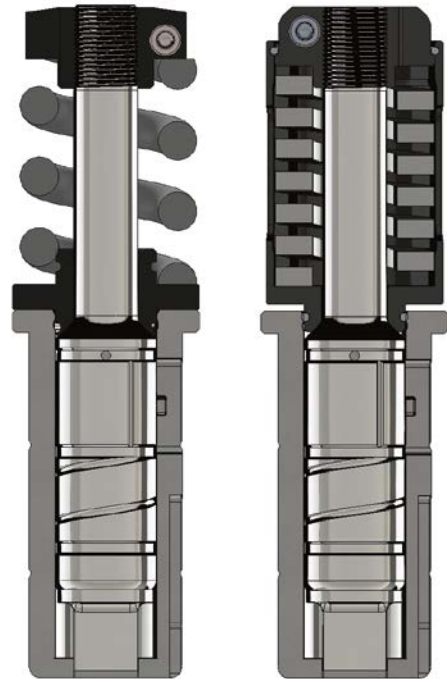


SPANNER WRENCH	€	PUNCH HEAD	€	SPRING max thickness 4 mm	€	REVERSIBLE RETAINER Included OR	€	PUNCH DRIVER max thickness 6 mm	€	SEMI OPEN STANDARD GUIDE Clip included	€
AMABSW		AMB1TERA		AMB1MST0		AMB1RIT0		AMB1LLGIO		ONLY ROUND AMB1GUT3T	
										SHAPE 0° - 90° - 135° AMB1GUT3S	



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



ITEM	ISODUR PUNCH	€	ISODUR PUNCH ASSEMBLY	€	ISODUR PUNCH ASSEMBLY LONG LIFE	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMB1PUAB06T		AMB1PATAE6T		AMB1PALAE6T		AMB1MAT001T		AMB1MAT006T	
STANDARD	AMB1PUAB06S		AMB1PATAE6.**		AMB1PALAE6.**		AMB1MAT001S*		AMB1MAT006S*	
SPECIAL 0	AMB1PUAB06C		AMB1PATAE6C		AMB1PALAE6C		AMB1MAT001D		AMB1MAT006D	
SPECIAL 1	AMB1PUAB06D		AMB1PATAE6D		AMB1PALAE6D		AMB1MAT001D		AMB1MAT006D	
SPECIAL 2	AMB1PUAB06F		AMB1PATAE6F		AMB1PALAE6F		AMB1MAT001D		AMB1MAT006D	

* for Amada machines square dies pin 0° - 135° code: HWS AMB1MAT001Q, ISODUR AMB1MAT006Q
 ** S = Standard 0°-90°; Q = Square 0°-135°

Coating	PROBUS		GEMINUS		LEVATUS	

FITTING



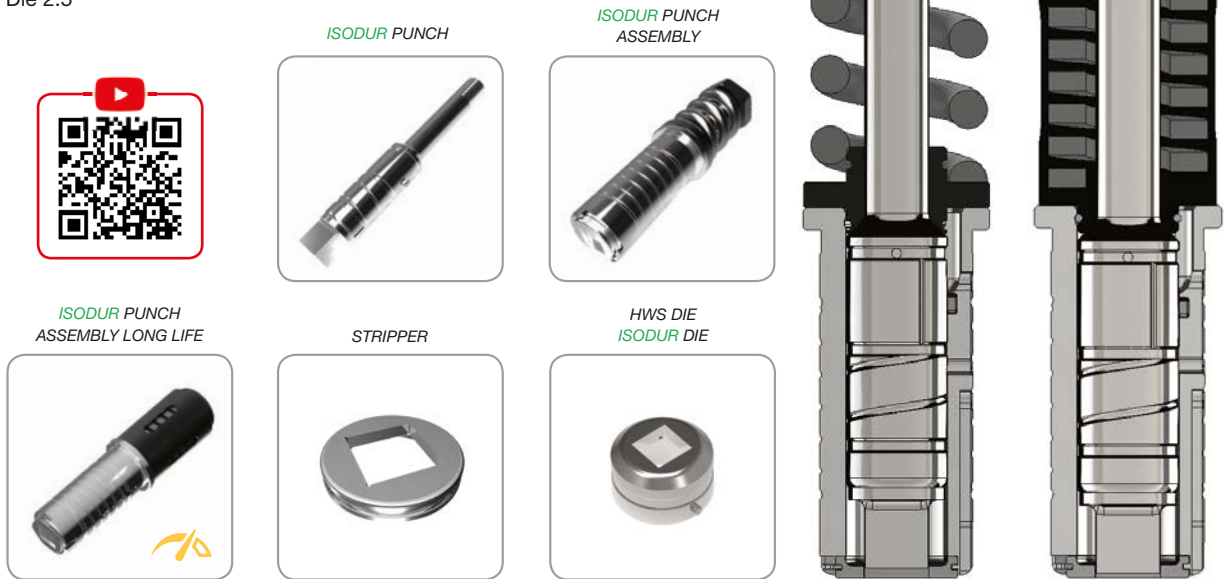
SPANNER WRENCH	€	PUNCH HEAD	€	SPRING	€	REVERSIBLE RETAINER Included OR	€	PUNCH DRIVER max thickness 6 mm	€	CLOSED GUIDE	€
AMABSW		AMB1TERA		AMB1MST0		AMB1RIT0		AMB1LLGIO		AMB1GUAIT	
										STD 0° - 90° AMB1GUAIS	
										SQ 0° - 135° AMB1GUAIQ	
										SPECIAL 0-1-2 - 0° - 90° AMB1GUAID	

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



ITEM	ISODUR PUNCH	€	ISODUR PUNCH ASSEMBLY	€	ISODUR PUNCH ASSEMBLY LONG LIFE	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMB1PUAB06T		AMB1PATAB6T		AMB1PALLB6T		AMB1PLABT		AMB1MAT001T		AMB1MAT006T	
STANDARD	AMB1PUAB06S		AMB1PATAB6S		AMB1PALLB6S		AMB1PLABS		AMB1MAT001S*		AMB1MAT006S*	
SPECIAL 0	AMB1PUAB06C		AMB1PATAB6C		AMB1PALLB6C		AMB1PLABD		AMB1MAT001D		AMB1MAT006D	
SPECIAL 1	AMB1PUAB06D		AMB1PATAB6D		AMB1PALLB6D		AMB1PLABD		AMB1MAT001D		AMB1MAT006D	
SPECIAL 2	AMB1PUAB06F		AMB1PATAB6F		AMB1PALLB6F		AMB1PLABD		AMB1MAT001D		AMB1MAT006D	

Coating	PROBUS		GEMINUS		LEVATUS	

FITTING



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 AMB1GUA2T	
										SHAPE 0° - 90° - 135° AMB1GUABS	



B STATION SMART - OPEN GUIDE

Max 31.70 mm, Max thickness: 5 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



ISODUR PUNCH
AND K490 MICROCL



ISODUR PUNCH AND
K490 MICROCL ASSEMBLY



STRIPPER



ITEM	ISODUR PUNCH AND K490 MICROCL	€	ISODUR PUNCH AND K490 MICROCL ASSEMBLY	€	STRIPPER	€
ROUND	ISODUR AMB1IPLLNL6T		ISODUR AMB1PALIN6T		AMB1PLWTT	
	PSM AMB1IPLLNL4T		PSM AMB1PALIN4T			
STANDARD	ISODUR AMB1IPLLNL6S		ISODUR AMB1PALIN6S		AMB1PLWTS	
	PSM AMB1IPLLNL4S		PSM AMB1PALIN4S			
SPECIAL 0	ISODUR AMB1IPLLNL6C		ISODUR AMB1PALIN6C		AMB1PLWTD	
	PSM AMB1IPLLNL4C		PSM AMB1PALIN4C			
SPECIAL 1	ISODUR AMB1IPLLNL6D		ISODUR AMB1PALIN6D		AMB1PLWTD	
	PSM AMB1IPLLNL4D		PSM AMB1PALIN4D			
SPECIAL 2	ISODUR AMB1IPLLNL6F		ISODUR AMB1PALIN6F		AMB1PLWTD	
	PSM AMB1IPLLNL4F		PSM AMB1PALIN4F			

Coating	PROBUS		GEMINUS		LEVATUS	
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DIE

HWS DIE, ISODUR DIE

ITEM	HWS DIE	€	ISODUR DIE	€
ROUND	AMB1MAT001T		AMB1MAT006T	
STANDARD	AMB1MAT001S*		AMB1MAT006S*	
SPECIAL 0, 1, 2	AMB1MAT001D		AMB1MAT006D	



* for Amada machines pin 0°-135° code: HWS AMB1MAT001Q , ISODUR AMB1MAT006Q

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 5 mm)	€	OPEN GUIDE	€	OPEN GUIDE	€
	AMB1LLGIOPE		ONLY ROUND AMB1GUUNT		RD & SHAPE 0° - 90° - 135° AMB1GUUN	

PUNCH DRIVER



OPEN GUIDE



THICK TURRET



B STATION SMART2 - SEMI OPEN GUIDE

Max 31.70 mm, Max thickness: 5 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



ISODUR PUNCH
AND K490 MICROCL



ISODUR PUNCH AND
K490 MICROCL ASSEMBLY



STRIPPER



ITEM	ISODUR PUNCH AND K490 MICROCL	€	ISODUR PUNCH AND K490 MICROCL ASSEMBLY	€	STRIPPER	€
ROUND	ISODUR AMB1IPLLNL6T		ISODUR AMB1PALIN6T		AMB1PLWTT	
	PSM AMB1IPLLNL4T		PSM AMB1PALIN4T			
STANDARD	ISODUR AMB1IPLLNL6S		ISODUR AMB1PALIN6S		AMB1PLWTS	
	PSM AMB1IPLLNL4S		PSM AMB1PALIN4S			
SPECIAL 0	ISODUR AMB1IPLLNL6C		ISODUR AMB1PALIN6C		AMB1PLWTD	
	PSM AMB1IPLLNL4C		PSM AMB1PALIN4C			
SPECIAL 1	ISODUR AMB1IPLLNL6D		ISODUR AMB1PALIN6D		AMB1PLWTD	
	PSM AMB1IPLLNL4D		PSM AMB1PALIN4D			
SPECIAL 2	ISODUR AMB1IPLLNL6F		ISODUR AMB1PALIN6F		AMB1PLWTD	
	PSM AMB1IPLLNL4F		PSM AMB1PALIN4F			

Coating	PROBUS		GEMINUS		LEVATUS	

DIE

ITEM	HWS DIE	€	ISODUR DIE	€
ROUND	AMB1MAT001T		AMB1MAT006T	
STANDARD	AMB1MAT001S*		AMB1MAT006S*	
SPECIAL 0, 1, 2	AMB1MAT001D		AMB1MAT006D	

HWS DIE, ISODUR DIE



* for Amada machines pin 0°-135° code: HWS AMB1MAT001Q , ISODUR AMB1MAT006Q

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

PUNCH DRIVER



SEMI OPEN GUIDE



STRIPPER CLIP



ITEM	PUNCH DRIVER max thickness 5 mm	€	OPEN GUIDE	€	SEMI OPEN GUIDE	€	STRIPPER CLIP	€
	AMB1LLGIOPE		ONLY ROUND AMB1GUUN2T		RD & SHAPE 0° - 90° - 135° AMB1GUUN2		AMB1SEGNS	



PUNCH AMADA OLD STYLE AND MATE STYLE

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

C STATION ISODUR PUNCH



D STATION ISODUR PUNCH



E STATION ISODUR PUNCH



ITEM	C STATION ISODUR PUNCH	€	D STATION ISODUR PUNCH	€	E STATION ISODUR 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	

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)

C STATION ISODUR PUNCH



D STATION ISODUR PUNCH



E STATION ISODUR PUNCH



ITEM	C STATION ISODUR PUNCH	€	D STATION ISODUR PUNCH	€	E STATION ISODUR 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 ISODUR PUNCH	€	D STATION ISODUR PUNCH	€	E STATION ISODUR 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 WILSON STYLE

Data: Max size
12.7 mm

PUNCH HP
ISODUR



PUNCH HP
LUBRICATED ISODUR



PUNCH HP PSM



PUNCH HP
LUBRICATED PSM



ITEM	A STATION PUNCH HP ISODUR	€	A STATION PUNCH HP LUBRICATED ISODUR	€	A STATION PUNCH HP PSM	€	A STATION PUNCH HP LUBRICATED PSM	€
ROUND	AMA1IPWS06T		AMA1IPWL06T		AMA1IPWS04T		AMA1IPWL04T	
STANDARD	AMA1IPWS06S		AMA1IPWL06S		AMA1IPWS04S		AMA1IPWL04S	
SPECIAL 0	AMA1IPWS06C		AMA1IPWL06C		AMA1IPWS04C		AMA1IPWL04C	
SPECIAL 1	AMA1IPWS06D		AMA1IPWL06D		AMA1IPWS04D		AMA1IPWL04D	
SPECIAL 2	AMA1IPWS06F		AMA1IPWL06F		AMA1IPWS04F		AMA1IPWL04F	

Coating	PROBUS		GEMINUS		LEVATUS	
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PUNCH S90
ISODUR



PUNCH WLS - ABS
ISODUR



PUNCH S90 PSM



PUNCH WLS - ABS
PSM



Data: Max size
31.7 mm

ITEM	B STATION PUNCH S90 ISODUR	€	B STATION PUNCH WLS - ABS ISODUR	€	B STATION PUNCH S90 PSM	€	B STATION PUNCH WLS - ABS PSM	€
ROUND	AMB1IPS906T		AMB1IPWT06T		AMB1IPS904T		AMB1IPWT04T	
STANDARD	AMB1IPS906S		AMB1IPWT06S		AMB1IPS904S		AMB1IPWT04S	
SPECIAL 0	AMB1IPS906C		AMB1IPWT06C		AMB1IPS904C		AMB1IPWT04C	
SPECIAL 1	AMB1IPS906D		AMB1IPWT06D		AMB1IPS904D		AMB1IPWT04D	
SPECIAL 2	AMB1IPS906F		AMB1IPWT06F		AMB1IPS904F		AMB1IPWT04F	

Coating	PROBUS		GEMINUS		LEVATUS	
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C STATION
PUNCH HP



D STATION
PUNCH HP



E STATION
PUNCH HP



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

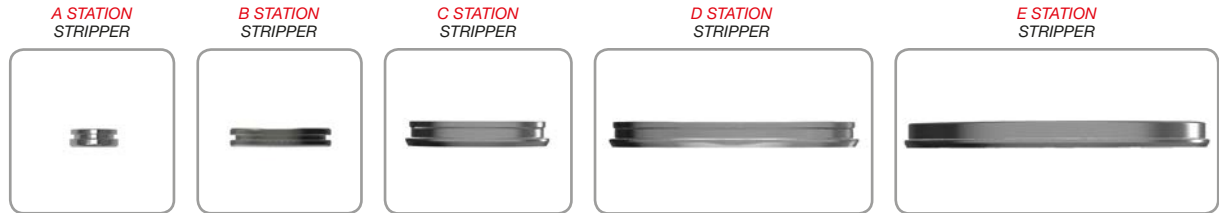
ITEM	C STATION PUNCH HP	€	D STATION PUNCH HP	€	E STATION PUNCH HP	€
ROUND	AMC1PUWT06T		AMD1PUWT06T		AME1PUWT06T	
STANDARD	AMC1PUWT06S		AMD1PUWT06S		AME1PUWT06S	
SPECIAL 0	AMC1PUWT06C		AMD1PUWT06C		AME1PUWT06C	
SPECIAL 1	AMC1PUWT06D		AMD1PUWT06D		AME1PUWT06D	
SPECIAL 2	AMC1PUWT06F		AMD1PUWT06F		AME1PUWT06F	

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

THICK TURRET



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 HWS	€	B STATION DIE HWS	€	C STATION DIE HWS	€	D STATION DIE HWS	€	E STATION DIE HWS	€
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	

ITEM	A STATION DIE ISODUR	€	B STATION DIE ISODUR	€	C STATION DIE ISODUR	€	D STATION DIE ISODUR	€	E STATION DIE ISODUR	€
ROUND	AMA1MAT006T		AMB1MAT006T		AMC1MAT006T		AMD1MAT006T		AME1MAT006T	
STANDARD	AMA1MAT006S		AMB1MAT006S		AMC1MAT006S		AMD1MAT006S		AME1MAT006S	
SQ REF. 0 - 135°	AMA1MAT006Q *		AMB1MAT006Q *		AMC1MAT006Q		AMD1MAT006Q		AME1MAT006Q	
SPECIAL 0-1-2	AMA1MAT006D		AMB1MAT006D		AMC1MAT006D		AMD1MAT006D		AME1MAT006D	
SPECIAL Heavy Duty 0-1-2	AMA1MATP06D		AMB1MATP06D		N.A.		AMD1MATR06S		N.A.	

* only Amada machines required holes 0°-135°

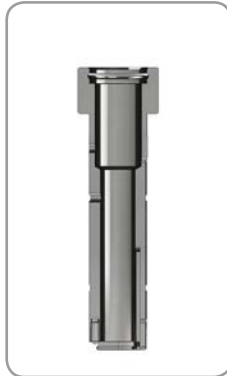


PUNCH HOLDER FOR WILSON STYLE PUNCHES

A STATION PUNCH DRIVER



A STATION OPEN GUIDE



B STATION PUNCH DRIVER



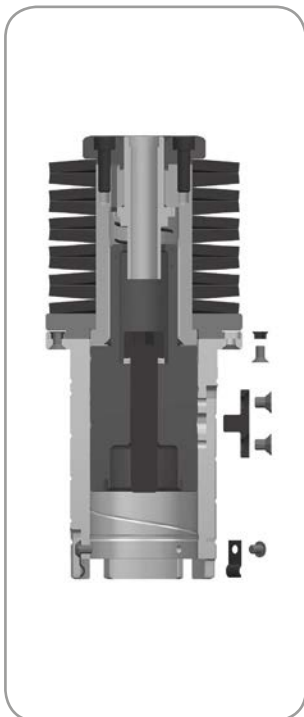
B STATION OPEN GUIDE



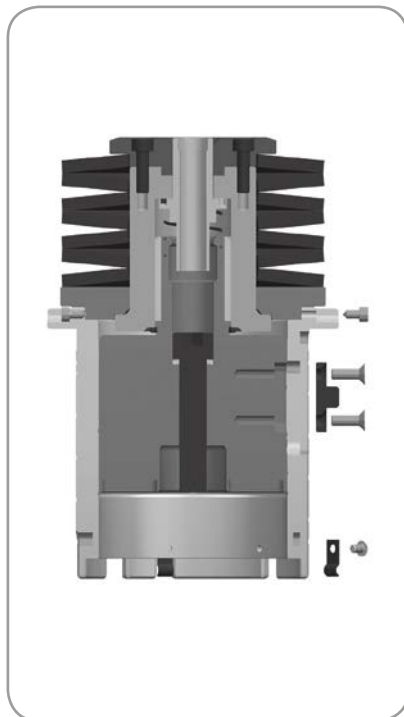
ITEM	A STATION PUNCH DRIVER	€	A STATION OPEN GUIDE	€	B STATION PUNCH DRIVER	€	B STATION OPEN GUIDE	€
	AMA1LLWT		RD € SHAPE 0-90-135° AMA1GUWTS (FOR WLS-ABS AND S90 STYLE)		AMB1LLGIOPE		ONLY RD AMB1GUUNT (FOR WLS-ABS AND S90 STYLE)	
							RD & SHAPE 0°-90°-135° AMB1GUUN (FOR WLS-ABS AND S90 STYLE)	

GUIDE ASSEMBLY FOR WILSON STYLE PUNCHES

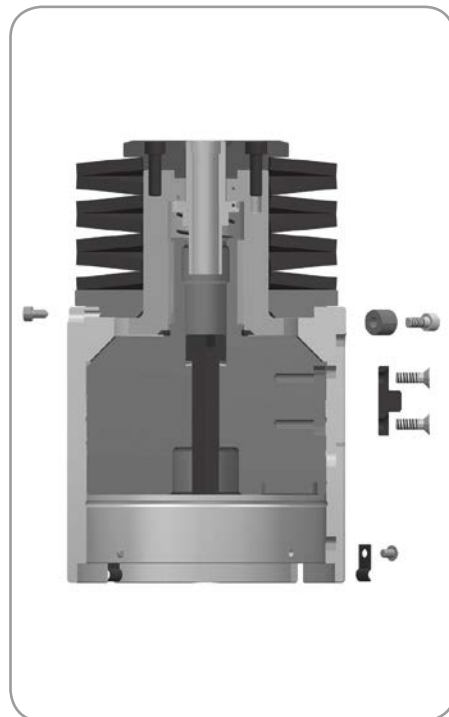
C STATION GUIDE ASSEMBLY



D STATION GUIDE ASSEMBLY



E STATION GUIDE ASSEMBLY



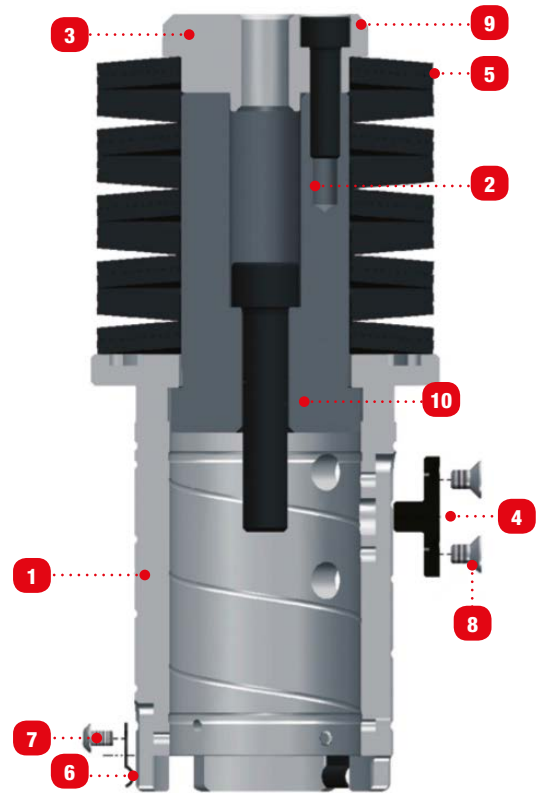
ITEM	C STATION GUIDE ASSEMBLY	€	D STATION GUIDE ASSEMBLY	€	E STATION GUIDE ASSEMBLY	€
	AMC1GALLWT2		AMD1GALLWT2		AME1GALLWT2	



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	NM006009046B	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	

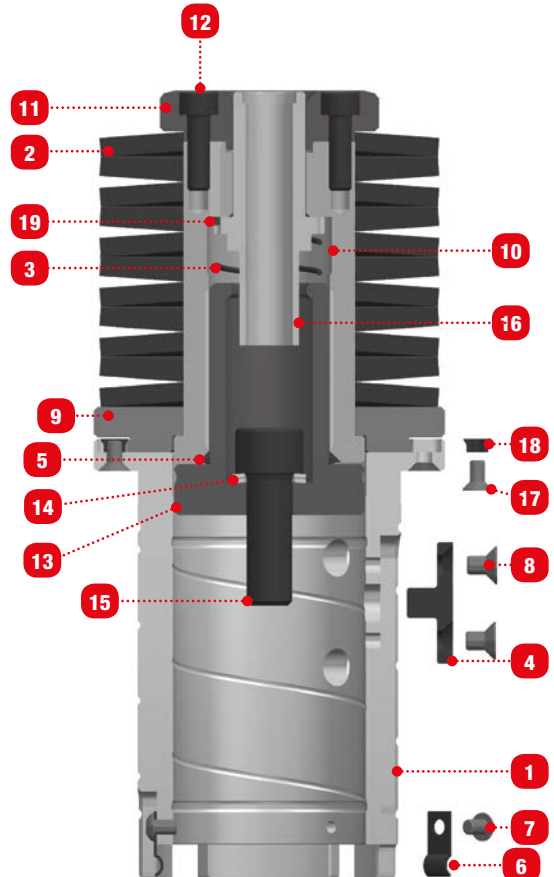


C STATION STANDARD GUIDE ASSEMBLY AMC1GALL2 QUICK ADJUSTABLE LENGTH, WITH LUBRICATION



QTY		COD	DESCRIPTION
19.	2	MAMC1G2PAG	WS DIN 9861/D2.7X71
18.	4	MAMC1G2STA	THREADED PIN LOCKING
17.	4	NVI12AR04008	SCREW UNI5933 M4X8
16.	1	MAMC1G2PUL	PUSH BUTTON
15.	1	NVI05AR12035	SCREW UNI ISO5931/M12X35
14.	2	NRA000000012	ANTI-VIBRATION LOCKING WASHER
13.	1	MAMC1G2PER	PUNCH HOLDER
12.	6	NVI05AR06020	SCREW UNI ISO5931/M6X20
11.	1	MAMC1G2TES	HEAD
10.	1	MAMC1G2INC	DRIVER
9.	1	MAMC1G2SUP	SPRINGS SUPPORT
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.	1	NOR000002125	O-RING/INNBR2125/C31.47-S1.78
4.	1	MAMC1GAT04	PUNCH HOLDER KEY
3.	1	MAMC1G2MOP	SPRING D28X1.5X28
2.	11	NM006009046C	DISC SPRING D90-46-5
1.	1	MAMC1G2T01	GUIDE 0° - 90° - 135°

ITEM	GUIDE ASSEMBLY	€
	AMC1GALL2	



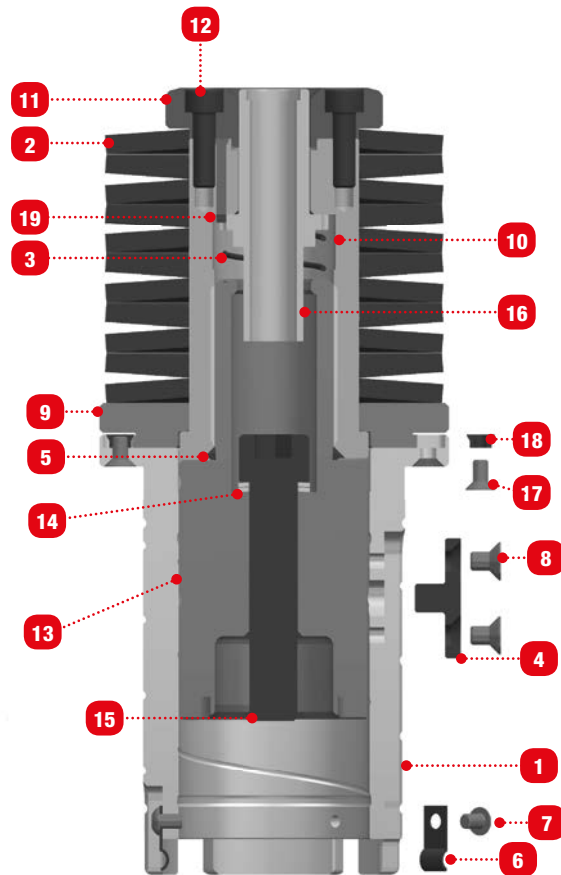


C STATION SMART2
GUIDE ASSEMBLY AMC1GALLWT2
QUICK ADJUSTABLE LENGTH, WITH LUBRICATION



QTY	COD	DESCRIPTION
19.	2	MAMC1G2PAG WS DIN 9861/D2.7X71
18.	4	MAMC1G2STA THREADED PIN LOCKING
17.	4	NV12AR04008 SCREW UNI5933 M4X8
16.	1	MAMC1G2PUL PUSH BUTTON
15.	1	NV900003UNC SCREW ANSI B18.2.1, 1/2"X2.5"
14.	2	NRA000000012 ANTI-VIBRATION LOCKING WASHER
13.	1	MAMC1G2PWT PUNCH HOLDER S90 ADAPTOR
12.	6	NV05AR06020 SCREW UNI ISO5931 M6X20
11.	1	MAMC1G2TES HEAD
10.	1	MAMC1G2PER DRIVER
9.	1	MAMC1G2SUP SPRINGS SUPPORT
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.	1	NOR000002125 O-RING INNBR2125, C31.47-S1.78
4.	1	MAMC1GAT04 PUNCH HOLDER KEY
3.	1	MAMC1G2MOP SPRING D28X1.5X28
2.	11	NMO06009046C DISC SPRING D90-46-5
1.	1	MAMC1G2T01 GUIDE 0° - 90° - 135°

ITEM	GUIDE ASSEMBLY	€
	AMC1GALLWT2	



FITTING

HEX KEY



T - HANDLE EXTRACTOR



ITEM	HEX KEY	€	T - HANDLE EXTRACTOR	€
	AMCECHIAVEM12 for Guide AMC1GALL2		AMD1G2EST	
	AMCECHIAVE for Guide AMC1GALLWT2		AMD1G2EST	

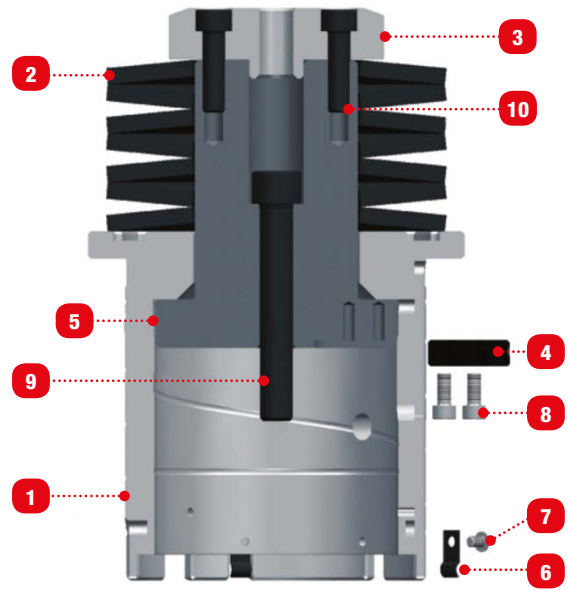
THICK TURRET



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	MAMD1GATO2 PUNCH HOLDER
4.	1	MAMDEGAT04 PUNCH HOLDER KEY
3.	1	MAMD1GATO3 HEAD
2.	7	NM0060012561B DISC SPRING D125-61-6
1.	1	MAMD1GATO1 GUIDE 0° - 90° - 135°

ITEM	GUIDE ASSEMBLY	€
	AMD1GATO	

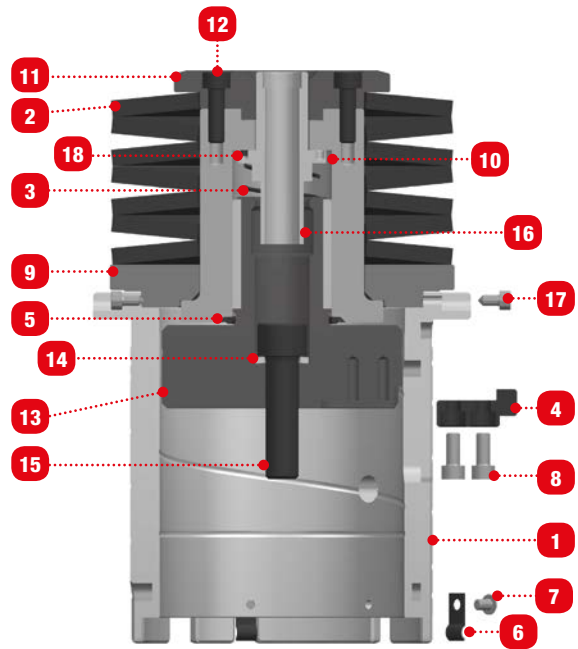


D STATION STANDARD GUIDE ASSEMBLY AMD1GALL2 QUICK ADJUSTABLE LENGTH, WITH LUBRICATION



QTY	COD	DESCRIPTION
18.	2	MAMD1G2PAG WS DIN 9861/D2.7X71
17.	2	MAMD1G2FER SCREW UNI5933 M4X8
16.	1	MAMD1G2PUL PUSH BUTTON
15.	1	NVI05AR12045 SCREW UNI5931 M12X45
14.	2	NRA000000012 ANTI-VIBRATION LOCKING WASHER
13.	1	MAMD1G2PER PUNCH HOLDER S90 ADAPTOR
12.	6	NVI05AR06020 SCREW UNI ISO5931 M6X20
11.	1	MAMD1G2TES HEAD
10.	1	MAMD1G2INC DRIVER
9.	1	MAMD1G2SUP SPRINGS SUPPORT
8.	2	NVI 12 AR 05012 SCREW UNI 5933 M5X8
7.	4	NVI 00 AR 04006 SCREW UNI ISO 7380M4X6 10.9
6.	4	AMCFGAT05 STRIPPER CLIP
5.	1	NOR000003143 O-RING INNBR2125, C31.47-S1.78
4.	1	MAMD1GALLT019 PUNCH HOLDER KEY
3.	1	MAMC1G2MOP SPRING D28X1.5X28
2.	7	NM0060012561B DISC SPRING D125-61-6
1.	1	MAMD1G2T01 GUIDE 0° - 90° - 135°

ITEM	GUIDE ASSEMBLY	€
	AMD1 GALL2	



FITTING

HEX KEY



T - HANDLE EXTRACTOR



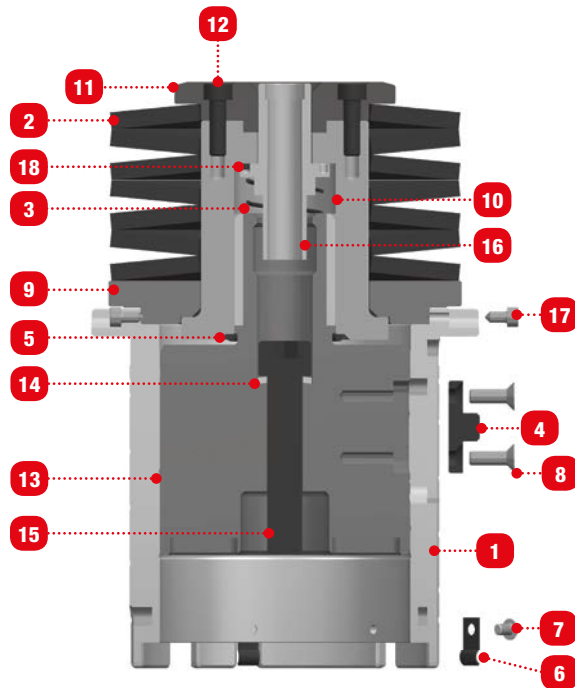
ITEM	HEX KEY	€	T - HANDLE EXTRACTOR	€
	AMCECHIAVEM12		AMD1G2EST	



D STATION SMART2
GUIDE ASSEMBLY AMD1GALLWT2
QUICK ADJUSTABLE LENGTH, WITH LUBRICATION



QTY	COD	DESCRIPTION
18.	2	MAMD1G2PAG WS DIN 9861 D2.7X71
17.	2	MAMD1G2FER SCREW
16.	1	MAMD1G2PUL PUSH BUTTON
15.	1	NV1900003UNC SCREW ANSI B18.2.1 1/2"X2.5"
14.	2	NRA000000012 ANTI-VIBRATION LOCKING WASHER
13.	1	MAMD1G2PWT PUNCH HOLDER S90 ADAPTOR
12.	6	NV105AR06020 SCREW UNI ISO5931 M6X20
11.	1	MAMD1G2TES HEAD
10.	1	MAMD1G2INC DRIVER
9.	1	MAMD1G2SUP SPRINGS SUPPORT
8.	2	NVI 12 AR 05016 SCREW UNI 5933 M5X16
7.	4	NVI 00 AR 04006 SCREW UNI ISO 7380M4X6 10.9
6.	4	AMCFGAT05 STRIPPER CLIP
5.	1	NOR000003143 O-RING INNBR3143 C36.14-S2.62
4.	1	MAMD1G2CHI PUNCH HOLDER KEY
3.	1	MAMC1G2MOP SPRING D28X1.5X28
2.	7	NM0060012561B DISC SPRING D125X61X6
1.	1	MAMD1G2T01 GUIDE 0° -90° - 135°



ITEM	GUIDE ASSEMBLY	€
	AMD1GALLWT2	

FITTING

HEX KEY



T - HANDLE EXTRACTOR



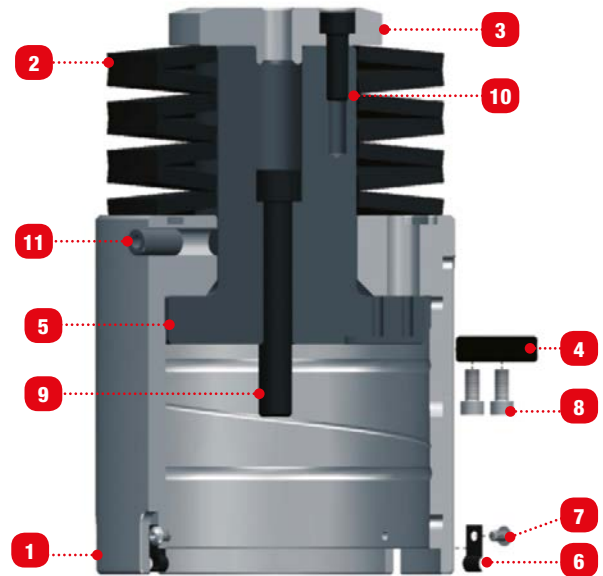
ITEM	HEX KEY	€	T - HANDLE EXTRACTOR	€
	AMCECHIAVE		AMD1G2EST	



**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	NM0060012561B DISC SPRING D125-61-6
1.	1	MAME1GAT01 GUIDE 0° - 90°

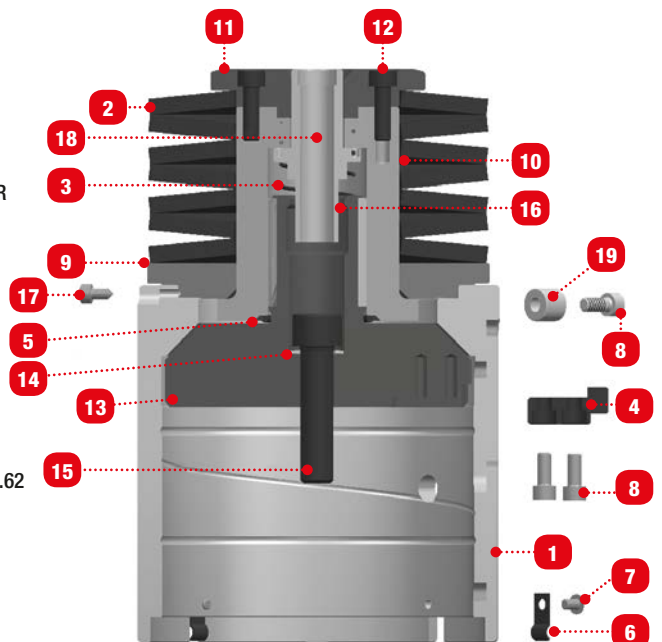
ITEM	GUIDE ASSEMBLY	€
	AME1GATO	



**E STATION STANDARD
GUIDE ASSEMBLY AME1GALL2
QUICK ADJUSTABLE LENGTH, WITH LUBRICATION**

QTY	COD	DESCRIPTION
19.	4	MAME1G2SP PIN HOLDER GUIDE
18.	2	MAMD1G2PAG PUNCH WS DIN9861 2.7X71
17.	4	MAMD1G2FER SCREW
16.	1	MAMD1G2PUL PUSH BUTTON
15.	1	NVI05AR12050 SCREW UNI ISO5931 M12X50
14.	1	NRA000000012 ANTIVIBRATION LOCKING WASHER
13.	1	MAME1G2PER ADAPTOR PUNCH OLD STYLE
12.	6	NVI05AR06020 SCREW UNI ISO5931 M6X20
11.	1	MAMD1G2TES HEAD
10.	1	MAMD1G2INC DRIVER
9.	1	MAME1G2SUP SPRINGS SUPPORT
8.	6	NVI05AR05012 SCREW UNI 5933 M5X12
7.	4	NVI00AR04006 SCREW UNI ISO 7380M4X6
6.	4	AMCFGAT05 STRIPPER CLIP
5.	1	NOR000003143 O - RING INNBR3143 C36.14 - S2.62
4.	1	MAMD1GALLT019 PUNCH HOLDER KEY
3.	1	MAMC1G2MOP SPRING D28X1.5X28
2.	7	NM0060012561B DISC SPRING D125-61-6
1.	1	MAME1G2T01 GUIDE 0° - 90°

ITEM	GUIDE ASSEMBLY	€
	AME1 GALL2	

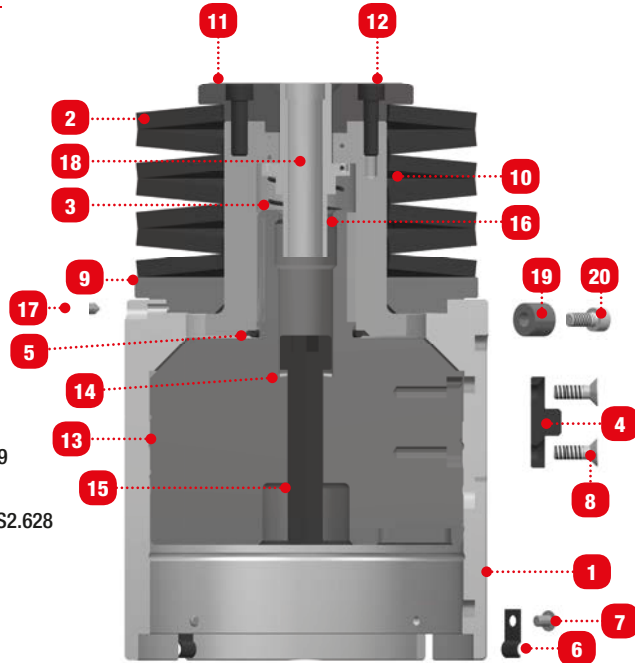




E STATION SMART2

GUIDE ASSEMBLY AME1GALLWT2 - QUICK ADJUSTABLE LENGTH, WITH LUBRICATION

QTY	COD	DESCRIPTION
20.	4	NSP00MR10020 ISO8735 UNI6364A
19.	1	MAME1GALLWT6 S90 WT ADAPTOR
18.	2	NVI03AR04030 PUNCH WS DIN9861 2.7X71
17.	1	NSP060003014 PIN UNI EN28748 Ø3X14
16.	1	MAMD1GALL14 PUSH BUTTON
15.	1	NVI900001 UNC SCREW ANSI B 18.2.1 1/2"x4"
14.	1	MAMD1GALL15 ANTIROTATION PIN
13.	1	MAME1GALLT012 PUNCH HOLDER
12.	4	NVI05AR08025 SCREW UNI ISO5931 M8X25
11.	1	MAMD1GALL2 HEAD
10.	1	MAMD1GALL4 DRIVER
9.	1	MAME1GALL3 SPRINGS SUPPORT
8.	2	NVI 05 AR 05012 SCREW UNI 5933 M5X12
7.	4	NVI 00 AR 04006 SCREW UNI ISO 7380M4X6 10.9
6.	4	AMCFGAT05 STRIPPER CLIP
5.	1	NOR000003143 O - RING INNBR3143 C36.14 - S2.628
4.	1	MAMD1GALLT019 PUNCH HOLDER KEY
3.	1	NMO04000635000185 SPRING
2.	10	NMO060012551A DISC SPRING D125-51-4
1.	1	MAME1GAT01 GUIDE 0° - 90°°



ITEM	GUIDE ASSEMBLY	€
	AME1GALLWT2	

E STATION STANDARD CLOSE TO CLAMP

Max 114.3 mm, Max thickness: 4 mm
Grinding life mm: Punch 8, Die 2.5

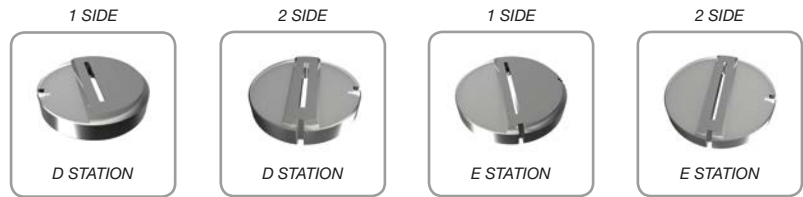


ITEM	PUNCH HOLDER	€	BLADE	€	HWS DIE	€	ISODUR DIE	€	STRIPPER CLOSE TO CLAMP	€	GUIDE ASSEMBLY ADJUSTABLE LUBR	€
	AME1PPLAT0		HSS AME1PULTG06S		AME1MATAP1S		AME1MATAP6S		AME1PLTAP1		AME1GALLAP	
			PSM AME1PULTG02S									
Coating	PROBUS			GEMINUS			LEVATUS					

THICK TURRET

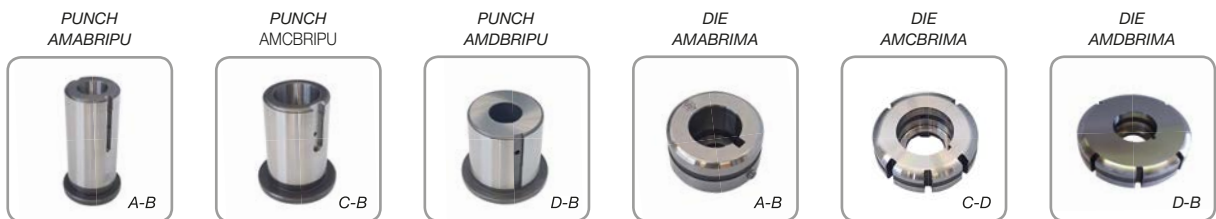


CLOSE TO CLAMP DIES



ITEM	D STATION				E STATION			
	D STATION HWS	€	D STATION ISODUR	€	E STATION HWS	€	E STATION ISODUR	€
1 SIDE	AMD1MATAP1S		AMD1MATAP6S		AME1MATAP1S		AME1MATAP6S	
2 SIDES	AMD1MATAP1D		AMD1MATAP6D		AME1MATAP1D		AME1MATAP6D	

ADAPTORS



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

URETHAN EJECTOR



ITEM	D3	€	D6	€	D10	€
	ES3T0		ES6T0		ES10T0	

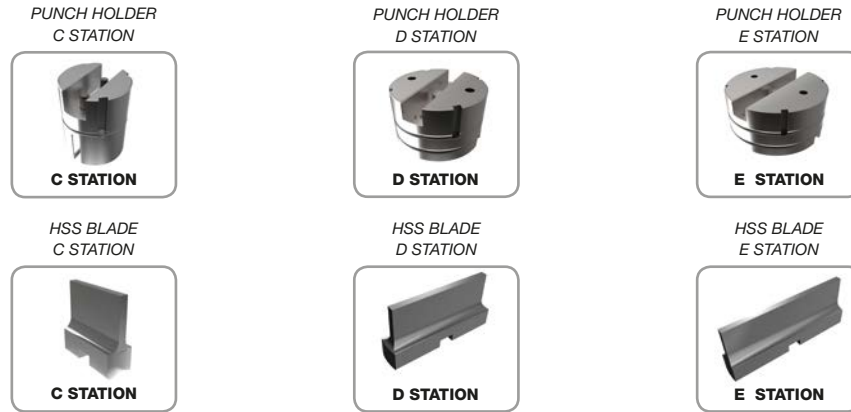
BRUSHES DIES



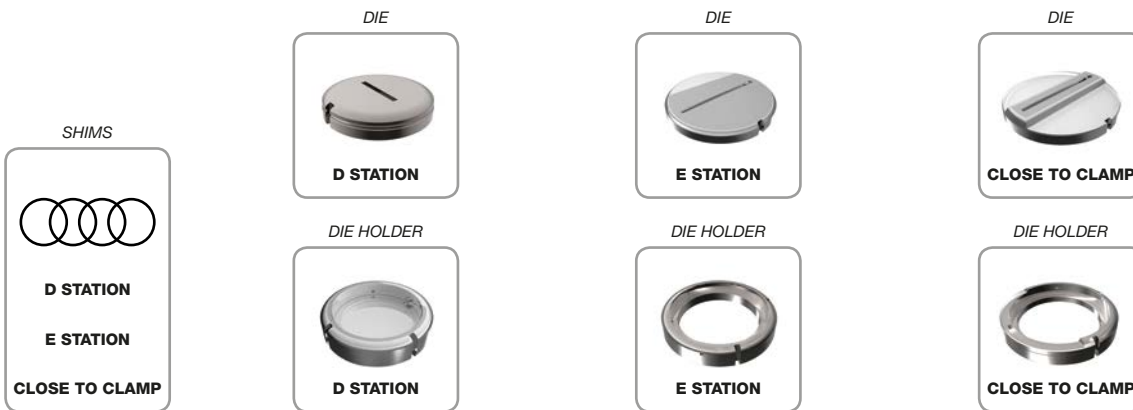
ITEM	A STATION	€	B STATION	€	C STATION	€	D STATION	€	E STATION	€
	AMA1MASP		AMB1MASP		AMC1MASP		AMD1MASP		AME1MASP	



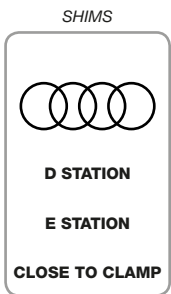
SLITTING TOOLS



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	
	PSM BLADE	€	PSM BLADE	€	PSM BLADE	€
W18 H47.5 AMC1PULTG02S		MATE STYLE W18 H45.5 AMD1PULTG02S		MATE STYLE W18 H45.5 AME1PULTG02S		
Coating	C PROBUS		D PROBUS		E PROBUS	
	C GEMINUS		D GEMINUS		E GEMINUS	
	C LEVATUS		D LEVATUS		E LEVATUS	



ITEM	D STATION		E STATION		E STATION	
DIE HOLDER	DIE HOLDER	€	DIE HOLDER	€	DIE HOLDER CLOSE TO CLAMP 2 SIDES	€
	AMD1MAINT2		AME1MAINT2		AME1MAINT2AP	
DIE AVAILABLE SIZE D STATION 80x5 - 80x6 MAX TH: 1.5 MS - 1.0 SS E STATION 110x5 - 110x6 MAX TH: 1.5 MS - 1.0 SS	DIE	€	DIE	€	DIE	€
	TRE1MAT206S		AME1IMT2		AME1IMT2AP	
DIE SHIMS	SET SHIMS (0.3 - N.2 0.5 - 1 mm)	€	SET SHIMS (0.3 - N.2 0.5 - 1 mm)	€	SET SHIMS (0.3 - N.2 0.5 - 1 mm)	€
	AMD1SETSPMAIN2		AME1SETSPMAIN2		AME1SETSPMAIN2	



THICK TURRET

THICK TURRET



GRINDING FIXTURE AMADA ORIGINAL STYLE PUNCH A, B, C, D, E STATION DIE A, B STATION

THICK TURRET STYLE



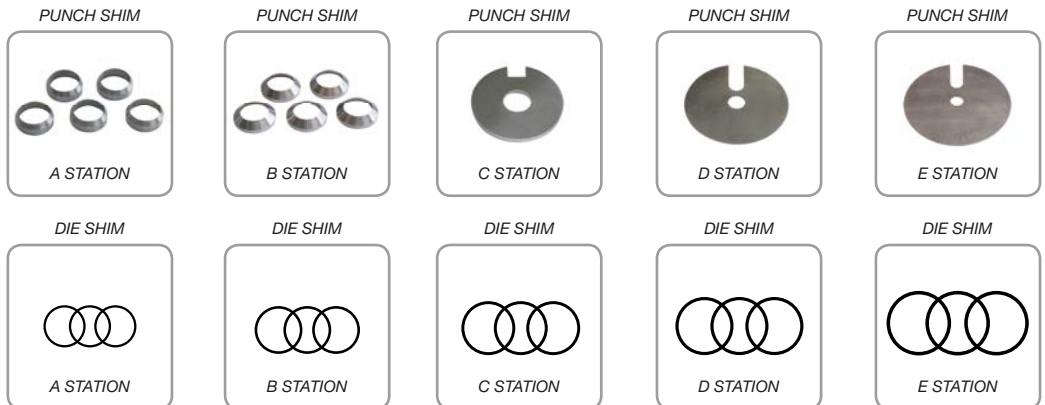
ITEM	THICK TURRET STYLE	€
	AMMOAFF2	

GRINDING FIXTURE THICK TURRET WILSON S90 STYLE PUNCH A, B, C, D STATION MULTITOOL 20 - 8, 10 - 16 - 6, 8 - 2

WILSON STYLE



ITEM	WILSON STYLE	€
	AMMOAFF1WT	



ITEM	A STATION		B STATION		C STATION		D STATION		E STATION		
PUNCH SHIM	(N5 SP2 mm)	€	(N5 SP2 mm)	€	(0.3 - 0.5 - 1 - 1.5 mm)	€	(0.3 - 0.5 - 1 - 1.5 mm)	€	(0.3 - 0.5 - 1 - 1.5 mm)	€	
	AMA1SETSPPU		AMB1SETSPPU		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	

MULTITOOL VULCANO SCHIAVI

6 A



2 A + 2 B



4 B SMART STYLE



ITEM	PUNCH HOLDER	€	DIE HOLDER	€	SET	€
6 A	AMM6 - 16SUP		AMM6 - 16INF		AMM6	
2 A + 2 B	AMM4 - 31.75SUP		AMM4 - 31.75INF		AMM4	
4 B SMART STYLE	AMM4B - 31.75SUP		AMM4B - 31.75INF		AMM4B	



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	

STRIPPER CLIPS



ITEM	STRIPPER CLIP	€	SCREW FOR CLIP	€
	AMCFGAT05 (QTY1)		NV00AR04006 (QTY1)	

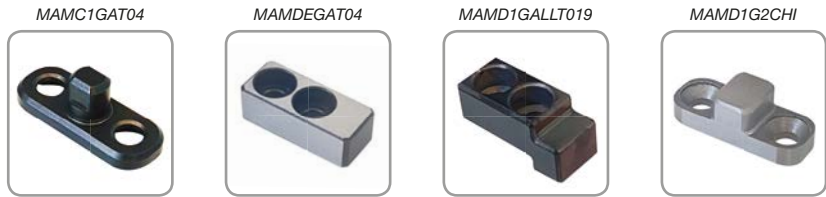
PUNCH LUBRICANT



ITEM	PUNCH LUBRICANT 1 KG	€
	C15M000001	



PUNCH HOLDER KEYS



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

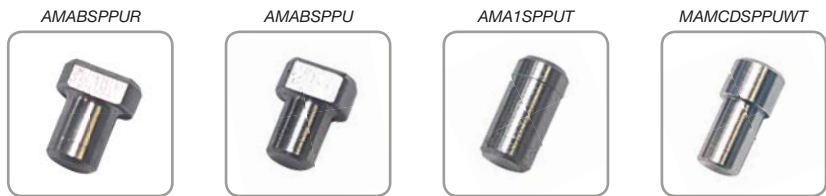
FIXTURE EQUIPMENT

A, B, C, D FIXTURE EQUIPMENT



ITEM	A, B, C, D FIXTURE EQUIPMENT	€
THE EQUIPMENT IS USED FOR DISASSEMBLY AND ASSEMBLY A, B, C AND D PUNCHES	AMADAS	

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

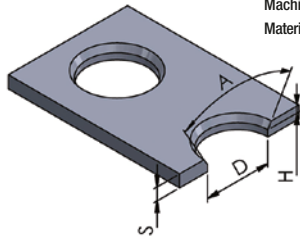


ITEM	A STATION D4.76X8	€	B STATION D4.76X10	€	XMTE12.7 D3X6	€	MTE6 XMTE6 D4X8	€
	NSP02MR47008		NSP02MR47010		NSPMO02MR0306		NSP02MR0408	



FORMING TOOL DATA SHEET

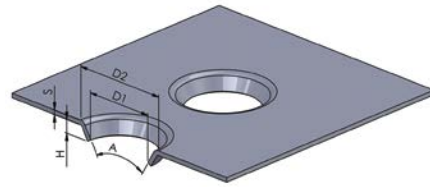
COUNTER SINK DOWN



Machine Model: _____
Material: _____

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

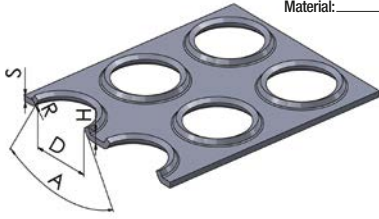
COUNTER SINK DOWN FORMING AFTER PRE PIERCE



Machine Model: _____
Material: _____

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

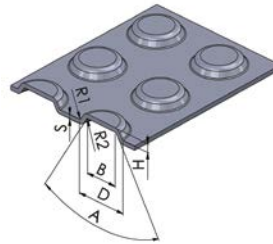
COUNTER SINK UP FORMING AFTER PRE PIERCE



Machine Model: _____
Material: _____

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

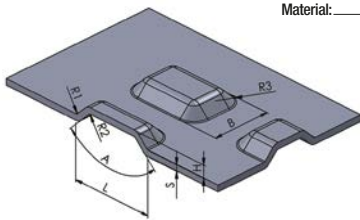
EMBOSS UP ROUND



Machine Model: _____
Material: _____

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

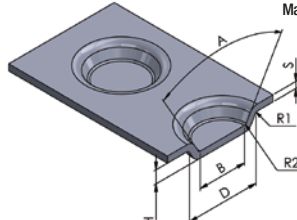
EMBOSS UP RECTANGULAR



Machine Model: _____
Material: _____

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

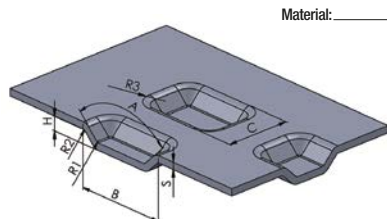
EMBOSS DOWN ROUND



Machine Model: _____
Material: _____

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

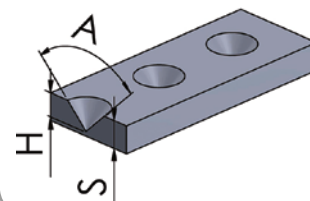
EMBOSS DOWN RECTANGULAR



Machine Model: _____
Material: _____

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

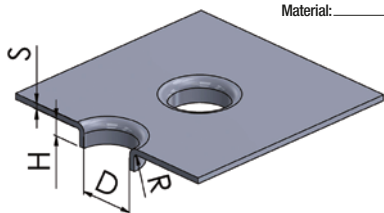
FORM DOWN MARKING TOOL



Machine Model: _____
Material: _____

A: _____
H: _____
S: _____

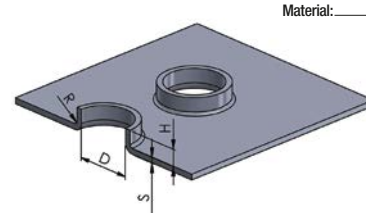
EXTRUSION DOWN ROUND



Machine Model: _____
Material: _____

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

EXTRUSION UP ROUND

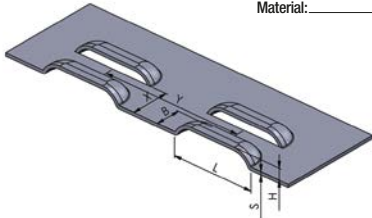


Machine Model: _____
Material: _____

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

LOUVER

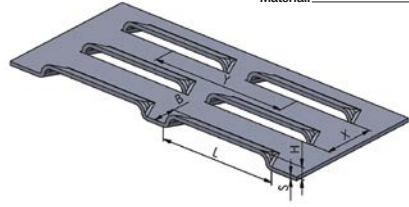
Machine Model: _____
Material: _____



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

LOUVER TRUMPF

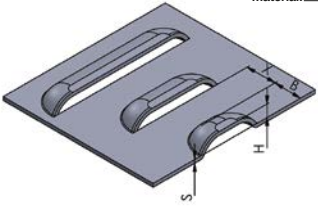
Machine Model: _____
Material: _____



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

CONTINUOUS LOUVER

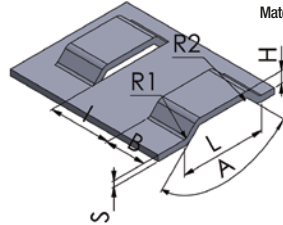
Machine Model: _____
Material: _____



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

BRIDGE UP

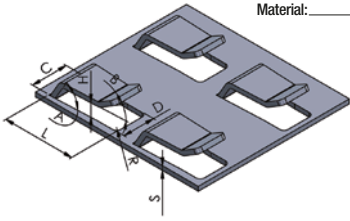
Machine Model: _____
Material: _____



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

LANCE UP_3 BENDS

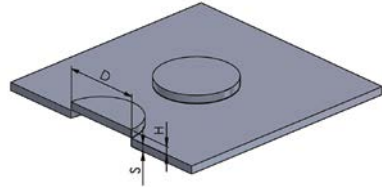
Machine Model: _____
Material: _____



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

SHEAR BUTTON

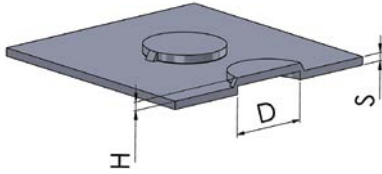
Machine Model: _____
Material: _____



D: _____
H: _____
S: _____

KNOCK OUT UP

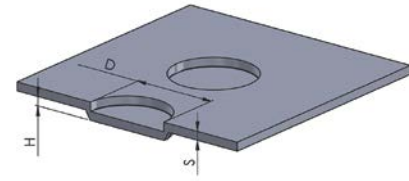
Machine Model: _____
Material: _____



D: _____
H: _____
S: _____

KNOCK-OUT DOWN

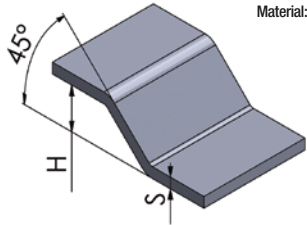
Machine Model: _____
Material: _____



D: _____
H: _____
S: _____

BEND 45°

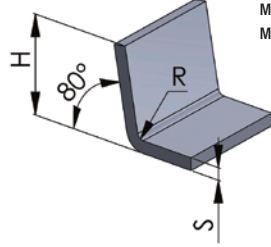
Machine Model: _____
Material: _____



H: _____
S: _____

BEND 80°

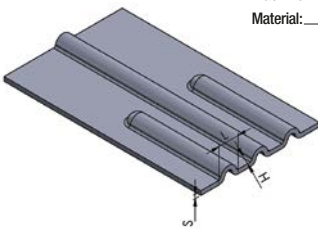
Machine Model: _____
Material: _____



H: _____
R: _____
S: _____

EMBOSS CONTINUOUS

Machine Model: _____
Material: _____



H: _____
L: _____
S: _____

THICK TURRET

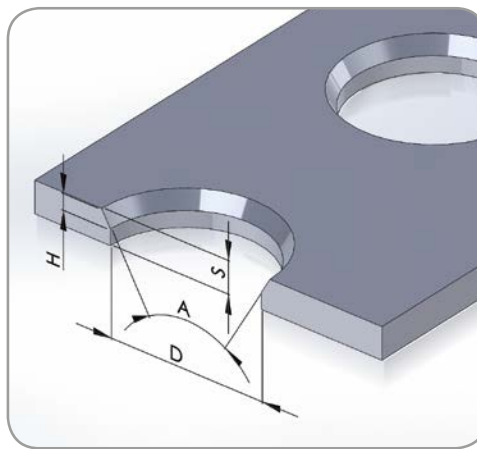
COUNTERSINK DOWN

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	€
A station Dmax 5 Thickness 0.5 - 2 Original old style	AMA1LLGIO		AMA1GUT0T		-		AMA1PUT006D		-		AMA1MAT001T	
B station Dmax 19 Thickness 0.5 - 4 Original old style	AMB1LLGIO		AMB1GUT0T		-		AMB1PUT006D		-		AMB1MAT001T	
B SMART2 station Dmax 19 Thickness 0.5 - 3	AMB1LLGIOPE		AMB1GUUN2T		AMB1PLWTT		AMB1IPLLN6D		-		AMB1MAT001T	
B SMART 2 with repl.inserts Dmax 12 Thickness 0.5 - 3	AMB1LLGIOPE		AMB1GUUN2T		AMB1PLWTT		FLAMB09W2IP		FLAMB09W2PP		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

FORM DOWN MARKING 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:



A station punch assembly and die



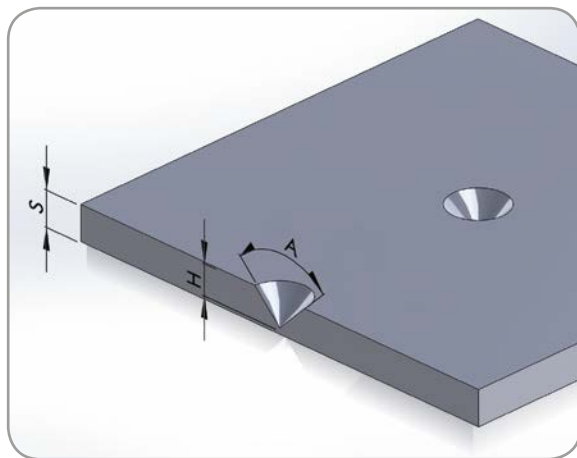
B station punch assembly and die

Custom dimensions (mm)

A:
 H:
 S:



A and B marking inserts



ITEM	PUNCH ASSEMBLY	€	MARKING INSERT	€	DIE HD	€
A STATION	FLAMA23PA		FLAMA23PL		AMB1MAT001T	
B STATION	FLAMB23PA		FLAMB23PL		AMB1MAT001T	

• Included 1 marking insert

ENGRAVING AND DEBURRING TOOL

Material:

Thickness:

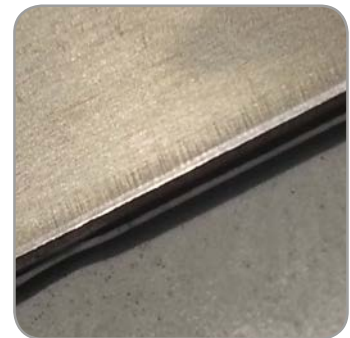
Diamond holder



Diamond 120° and 150°



Springs



ITEM	PUNCH ASSEMBLY WITH SPHERE	€	DIE ASSEMBLY WITH SPHERE		€			
DEBURRING	FLAMB38PAD		FLAMB38MA					
ITEM	PUNCH HOLDER (WITHOUT DIAMONDS)	€	DIAMOND 120° (MS. SS)	€	DIAMOND 150° (GA. AL)	€	DIIE ASSEMBLY WITH SPHERE	€
MARKING	FLAMB38PAM		FLTRB35D120		FLTRB35D150		FLAMB38MA	

B station punch holder



Die with sphere

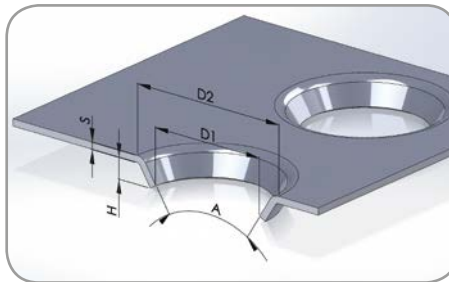
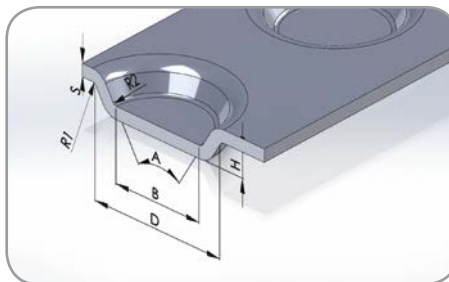


EMBOSS DOWN

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

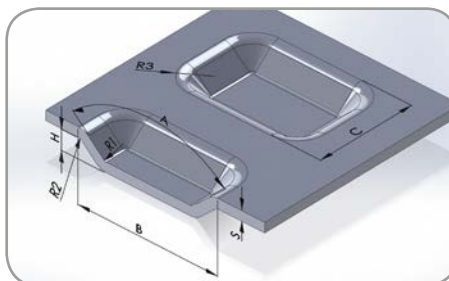
ORDERING SPECIFICATIONS

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



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	
			WILSON style AMD1PUWT06D					

* add price of guide or stripper



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 AMB1PLLNL6F					
			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	
			WILSON style AMD1PUWT06F					

* 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:

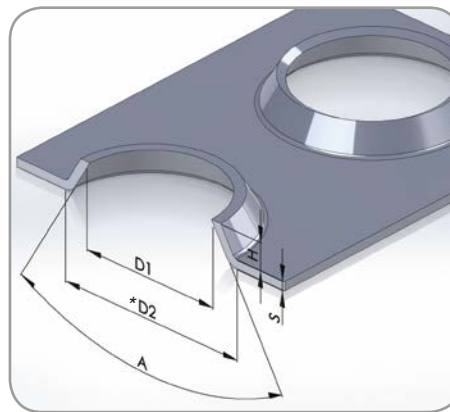
COUNTERSINK AFTER PRE.PIERCE

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

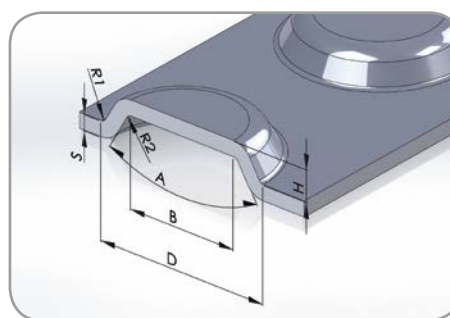
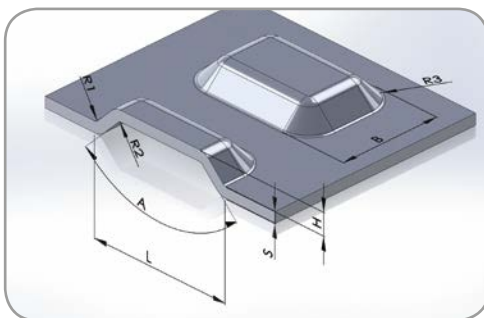
ECONO LINE - Solid Punch and Solid Die



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:



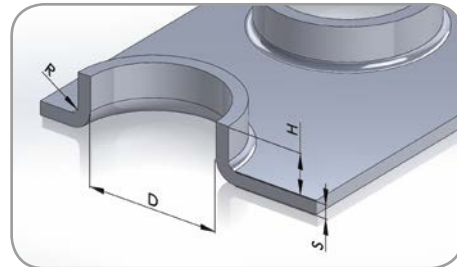
OPTIONS



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 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



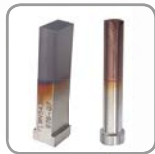
MATERIAL:
HWS and
ISODUR LOCK
SLUG AS

REPLACEABLE PUNCHES

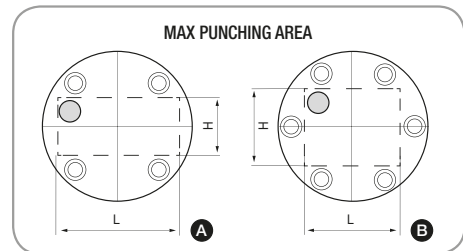


MATERIAL:
ISODUR OPTION
PSM

COATINGS

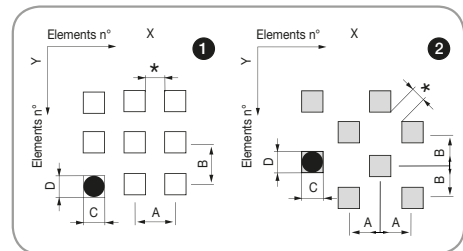


COATING
AVAILABLE:
PROBUS,
GEMINUS,
LEVATUS



	SOLID	REPLACEABLE				
		DIAM (mm)	A		B	
			L (mm)	H (mm)	L (mm)	H (mm)
C STATION	Ø 50.8	36	17	40	15	
DSTATION	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	AMB1PLLNLM		Ø S	AMC1PUT006M		Ø S	AMD1PUT006M		Ø S	AME1PUT006M		Ø S
	WILSON STYLE	AMB1PS9006M (S90) AMB1PWTO6M (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	Ø S	-	-	-	AMC1MAT001M		Ø S	AMD1MAT001M		Ø S	AME1MAT001M		Ø S
	Ø S	AMB1MATP06M		Ø S	AMC1MAT006M		Ø S	AMD1MAT006M		Ø S	AME1MAT006M		Ø S
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.) SOLID PUNCH SPECIAL 0-1-2 ADD € + IF PERIMETER <50 mm € X QTY, IF > 50 mm € X QTY REPLACEABLE INSERT STYLE PUNCH ADD: SPC. 0 € X QTY, SPC.1 € X QTY, SPC. 2 € X QTY (+ 50% IF PERIMETER > 50 mm)													

* ROUND size mm	2 - 3 - 4 - 5 - 6 - 7 - 8	10 - 12	15	20	Decimal value ex 3.2 max 11.9
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 each Ø					

LOUVER

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

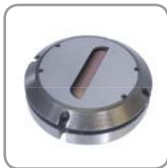
ORDERING SPECIFICATIONS

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



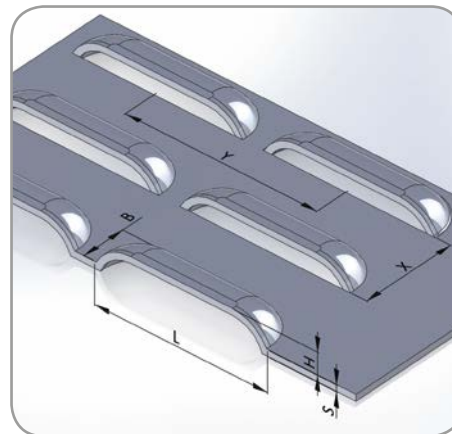
D station blade with
 coating



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

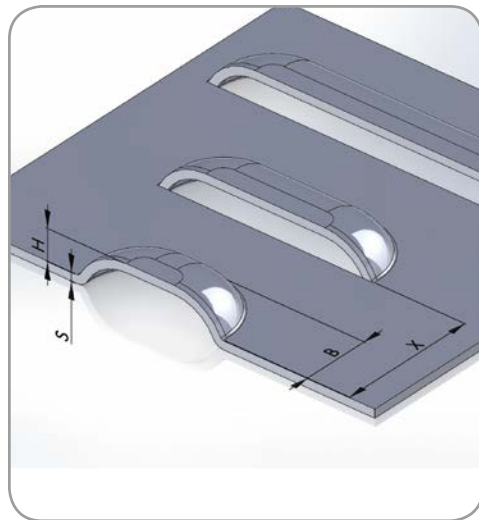
ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B Station	FLAMB14PA		FLAMB14MA		
C Station std size 50x10 mm	FLAMC14PA		FLAMC14MA		
C Station special size	FLAMC14CPA		FLAMC14CMA		
D Station std size 75x15 mm	FLAMD14APA		FLAMD14AMA		
D Station std size 85x15 mm	FLAMD14BPA		FLAMD14BMA		
D Station special size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

CONTINUOUS 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:



Custom dimensions (mm):

B:
 H:
 S:
 X:



ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B Station	FLAMB14PA		FLAMB14MA		
C Station	FLAMC14PA		FLAMC14MA		

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:

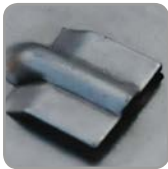
OPTIONS



2 BENDS



3 BENDS



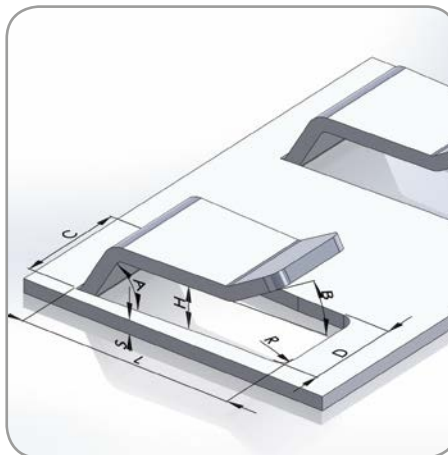
REINFORCED



SPECIAL



SNAPLOCK STYLE



Custom dimensions (mm):

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

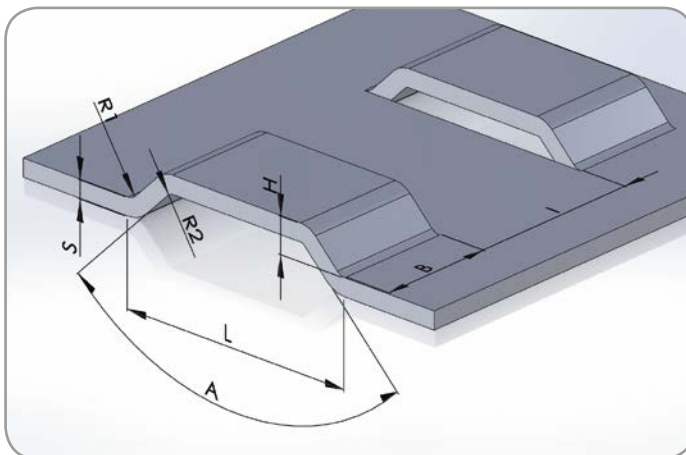
ITEM	B STATION MAX L = 15 mm	€	B STATION MAX L = 15 mm	€	C STATION MAX L = 40 mm	€	C STATION MAX L = 40 mm	€
	PUNCH ASSEMBLY		DIE ASSEMBLY		PUNCH ASSEMBLY		DIE ASSEMBLY	
LANCE STANDARD 1, 2 or 3 BENDS	FLAMB19PA		FLAMB19MA		FLAMC19PA		FLAMC19MA	
REINFORCED LANCE	FLAMB19BPA		FLAMB19BMA		FLAMC19BPA		FLAMC19BMA	

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:
 R1:
 R2:
 S:

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

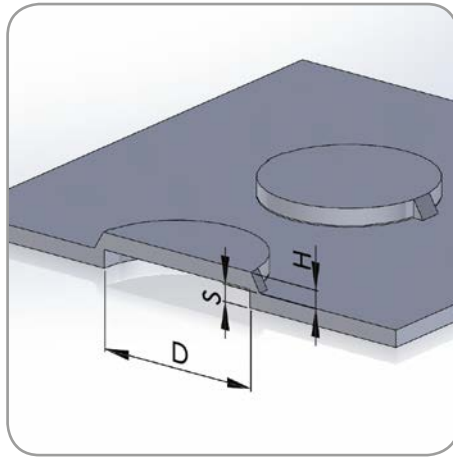
ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B Station single	FLAMB17PA 0 - 20 mm		FLAMB17MA 0 - 20 mm		
C Station single	FLAMC17PA 20.1 - 40 mm		FLAMC17MA 20.1 - 40 mm		
B Station double	FLAMB18PA 0 - 20 mm		FLAMB18MA 0 - 20 mm		
C Station double	FLAMC18PA 20.1 - 40 mm		FLAMC18MA 20.1 - 40 mm		

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

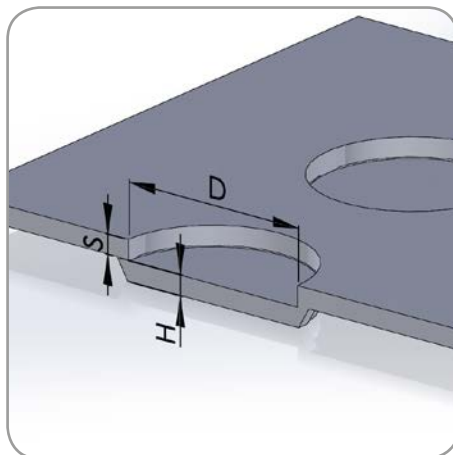


Custom dimensions (mm):

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		

HINGE

Material:

Thickness:

Set of two B station tooling to produce a hinge in four work step. Hinge tool is designed for a specific thickness and diameter.

Available for:

Thickness 1 mm size 4 - 5 - 6

Thickness 1.5 mm size 5 - 6



ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B STATION first	FLAMB36PA		FLAMB36MA		
B STATION second	FLAMB37PA		FLAMB37MA		

THREAD FORM UP

Material:

Thickness:



ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B STATION SMART LINE	FLAMB32PA		FLAMB32MA		

BRIDGES FOR THREAD

Material:

Thickness:



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

THICK TURRET

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:

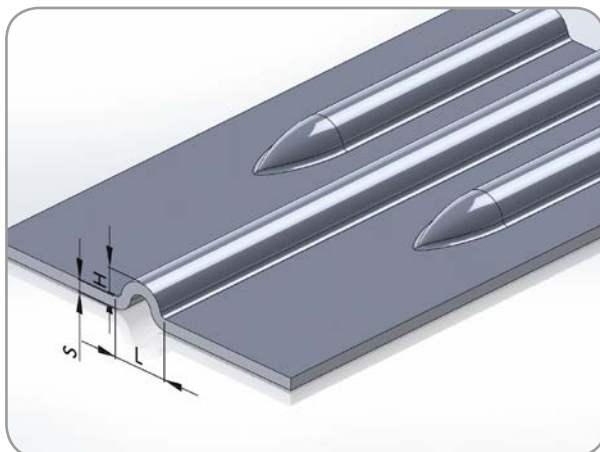
2 mm AL , MS
1.5 mm SS

Min thickness all mat. 0.8 mm



ITEM	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B STATION	FLAMB35PA		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

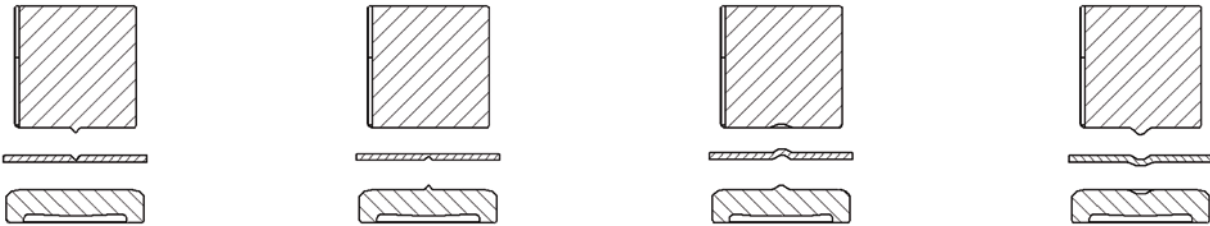
Logo type 1/2/3/4
Marking depth 0.4- 0.6

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:



1. Marking down

2. Marking up

3. Emboss up

4. Emboss down



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		

THICK TURRET

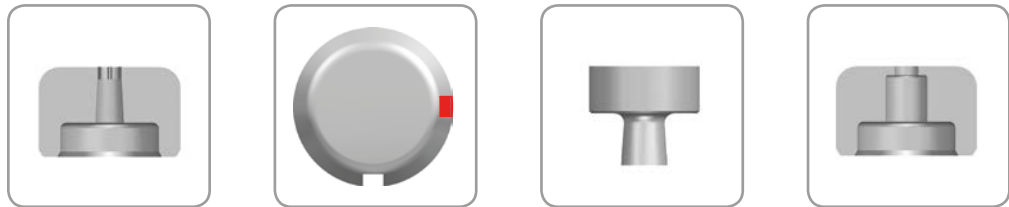
ADD ON

Shear option

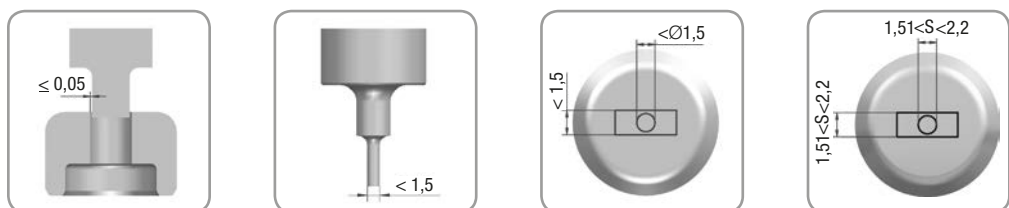


TYPE OF SHEAR	Roof top	Inverted roof top	Double valley	Whisper	Four ways
WHEN	Best option when punching force is high, minimum feed 75% of tool length	Recommended for nibbling at maximum tonnage but inverted stress could cause breakage	Recommended when punch is longer than 80mm But inverted stress could 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	€	€	+ 20%	€
WHEN	Best option to prevent the come out of the slug	Special, machines without rotation (C-D-E thick turret dies keys 0-90 standard shape 0-135 square)	Recommended for punching thick material, more than 4mm. Needful with punches that work with urethane *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 <math>< 0.1</math>	Punch width size <math>< 1.5</math>	Die size <math>< 1.5</math>	1,51 < Die size <math>< 2,2</math>
ADD ON	+25 %	+25 %	+25 %	+10 %