



## SUCE IS.....

*Since its inception in the 1950s as a small, but ambitious new business, SUCE has transformed itself over the years into a high-quality structured company specializing in the production of tools and dies. Ever-attentive to market developments and new technologies in this very particular sector, SUCE has also made a name for itself in the specialized fields of tools for punching machines, offering superior quality products and services. It is committed to finding innovative solutions to satisfy an increasingly international customer base.*

*SUCE's technical and competent staff, supported by the latest 2D and 3D design systems, and utilizing the most superior materials and surface coatings available, facilitates the provision of equipment and tooling which in turn provides the greatest efficiency and productivity. SUCE's productive versatility is clearly demonstrated quite by the sheer extent of the items created by the business.*

*In this catalogue you can find standard and special tools for Amada, Trumpf, Euromac, Prima Power, Salvagnini, LVD, Muratec Murata Wiedemann, Durma, Ermaksan, Danobat, Boschert, Tailift, Rainer, Tecnology FPL, Haco.*

*SUCE is an important reference point in this specialized market area, and has is able to offer the latest solutions for the needs and the expectations of its customers.*

***SUCE would be delighted to support your company as the preferred specialist in this field.***



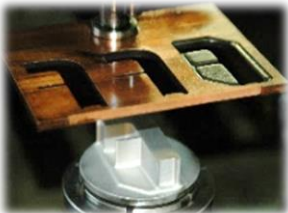
WHY SUCE?



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



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



No shape limitation thanks to EDM technology



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



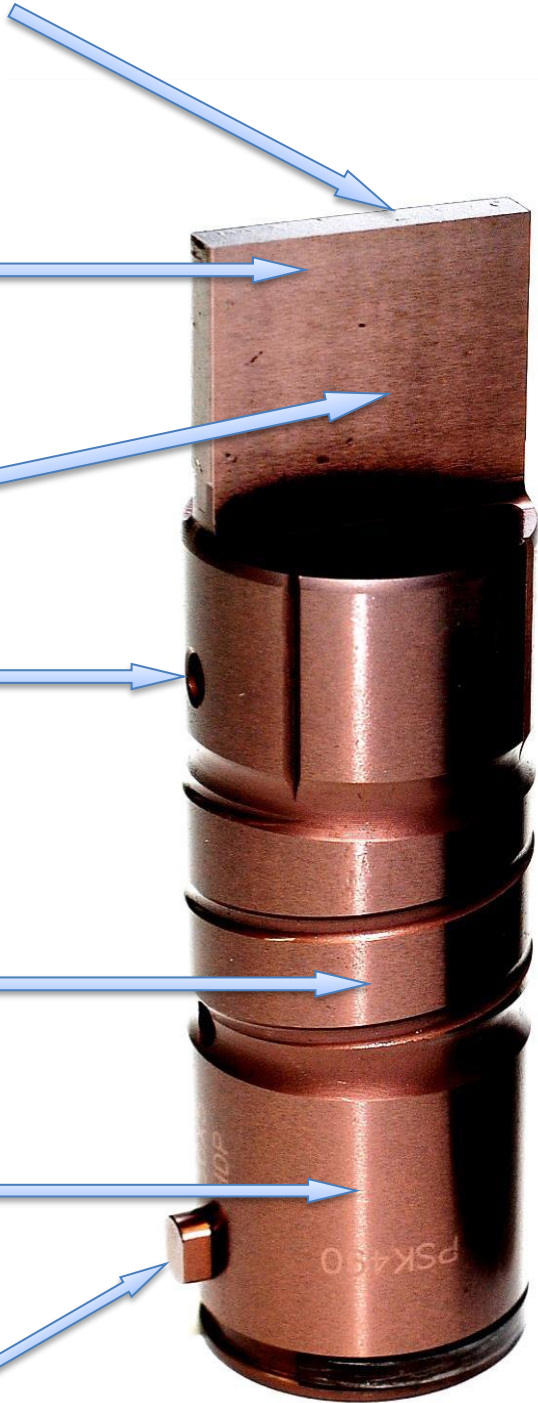
The use of the best steel available on the market by SUCE tools ensures a high standard quality and a long tool life.



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



Quality control





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



No shape limitation thanks to Wire EDM technology



Different lock-slug systems available



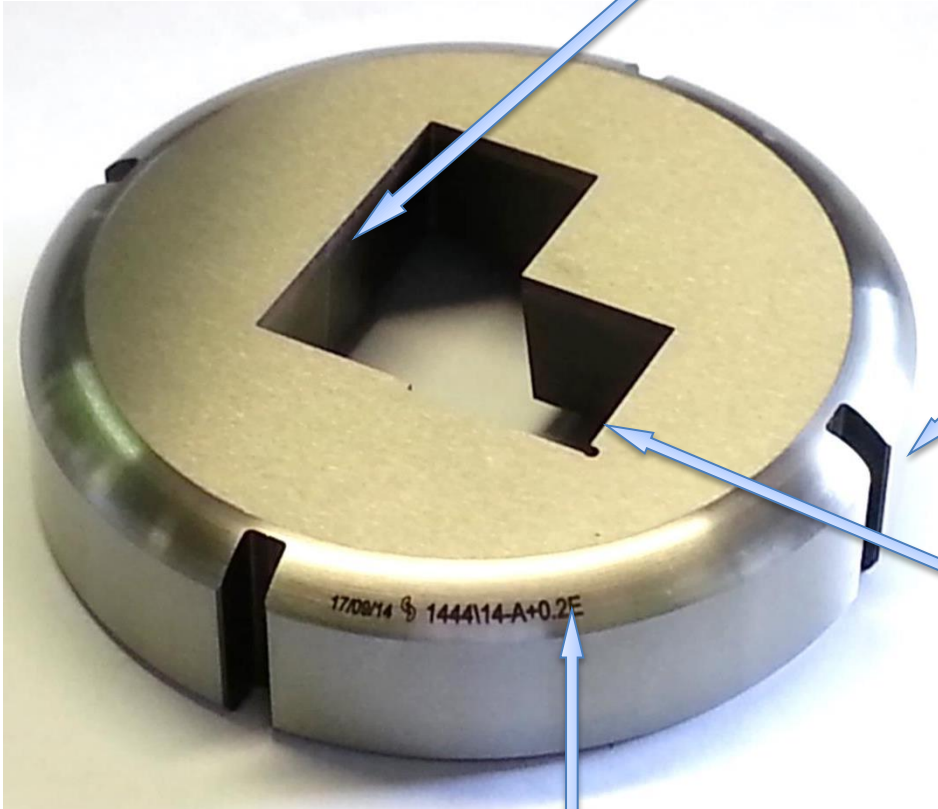
Wire EDM load-unload cell



Tool testing: fault free



Tool testing: fault free



In ware house: ready for delivery

SUCES special id.number

Manufacturing execution system



## Die clearance

Die clearance is the total space between die and punch.

A correct clearance between the punch and the die assures normal wear of the tool and punching without defect such as: burrs on the piece in the case of excessive clearance and premature wearing of the tool and increased punching force in the case 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 – 0,5
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.

## Dies lock slug

SUCE lock slug dies eliminate slug pulling. This condition manifests where 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 piece 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.

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



Lock slug **AS** best option when thickness > 2.5mm

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 3mm, minimum cl for AS system is 0.15mm. 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>2.5mm



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 0,2mm 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:

$$\text{perimeter of the shape (mm)} \times \text{thickness (mm)} \times 4/5 \times \text{shear strength}^*$$

\*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 (mm)	Thickness (mm)					
	1-1,5	2	3	4	5	6
1	0,75	0,9	1	1	1	1
1,5*	0,5	0,6	0,7	0,95	1	1
3**	0,5	0,5	0,5	0,6	0,7	0,75

\* standard shear height thick turret style

\*\* standard shear height Trumpf style

## The shear options

Double valley Cod 3P	Roof top Cod V	Inverted roof top Cod VR	Whisper Cod W	Four ways Cod 4P
Best option when shape is long, but susceptible to breakage	Best option when punching force is high, punching surface 75%	Best option for nibbling but inverted stresses could cause breakage	Recommended only for blanking (turret machine)	Recommended for round and square

Punches are flat, above shear are available upon request ;each type of sharpening reduces noise up to 50%



## General rules

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

- a) the punching surface must not be lower than 60% of the used punch surface, isn't recommended to punch the edge of the sheet less than 2.5 times material thickness
- b) in case of nibbling, minimum feed must be  $0,5 \times$  thickness , smaller round punch with thickness 1mm is 4mm , smaller round punch with thickness 2mm is 6mm , smaller round punch with thickness 3mm is 8mm.
- c) before exceeding tons capability calculate punching force with formula on page 6.
- 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 2.5mm.
- 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, such as TICN, HDP, FNC 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 0.25mm, constant radius on the corner of the dies ensures proper wear and a uniform burr.
- l) delivery time trumpf and thick turret tooling: 2/3 days standard, 5/7 coating tools, some items are available in stock.



<b>S H A P E S</b>					
	T	S1	S1R	S2	S2R
	C=	A=	A= R1=	A= B=	A= B= R1=
S3	S4	S5	S6	S7	S8
A=	A=	A= B= R1=	A= C=	A= B=	A= B= C=
					D=
S9	S10	S11	S12	D1	D2
A= B=	A= C=	A= C=	A= B= C=	A= B= C=	A= B= R1=
				R1=	R2= R3= R4=
D3	D4	D5	D6	D7	D8
A= B= R1=	A= B= C=	A= B=	A= R1= R2=	A= R1= R2=	A= B= R1=
B=	D= R1= B=			R3=	R2= R3= R4=
C1	C2	C3	C4	C5	C6
A= B= R=	A= B= R=	A= B= R1=	A= R1= R2=	A= B= R1=	A= B= R1=
		R2= R3= R4=	R3=	R2=	R2= R3=
C7	C8	F6	F7	F8	F9
A= B= C=	A= B= C=	A= B= C=	A= B= C=	A= B= C=	A= B= C=
D= R1= R2=		D= B=	D=		
F10	F11	F12	F13	F15	F16
A= C= R1=	A= B= C=	A= B= C=	A= B= C=	A= B= C=	A= B= C=
				D= R1=	D=

Round : T

Standard shape:

S1 , S1R , S2 , S2R , S3 , S4 , S5 , S6 , S7 , S8 , S9 , S10 , S11 , S12

Special 1:

D1 , D2 , D3 , D4 , D5 , D6 , D7 , D8

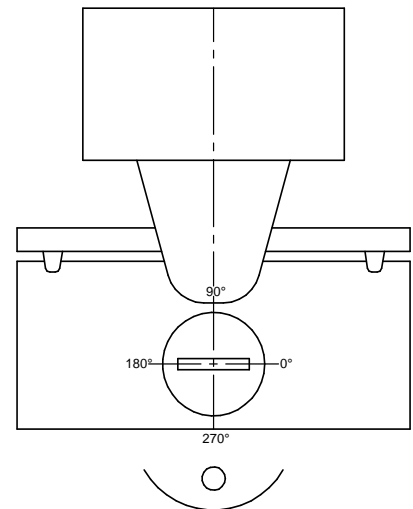
Special 0:

C1 , C2 , C3 , C4 , C5 , C6 R>2.9mm , C7 , C8

Special 2:

C1 , C2 , C3 , C4 , C5 , C6 R<2.9mm , F6 , F7 , F8 , F9 , F10 , F11 , F12 , F13 , F15 , F16

A and B pin die reference Thick turret



Amada diagram





# 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

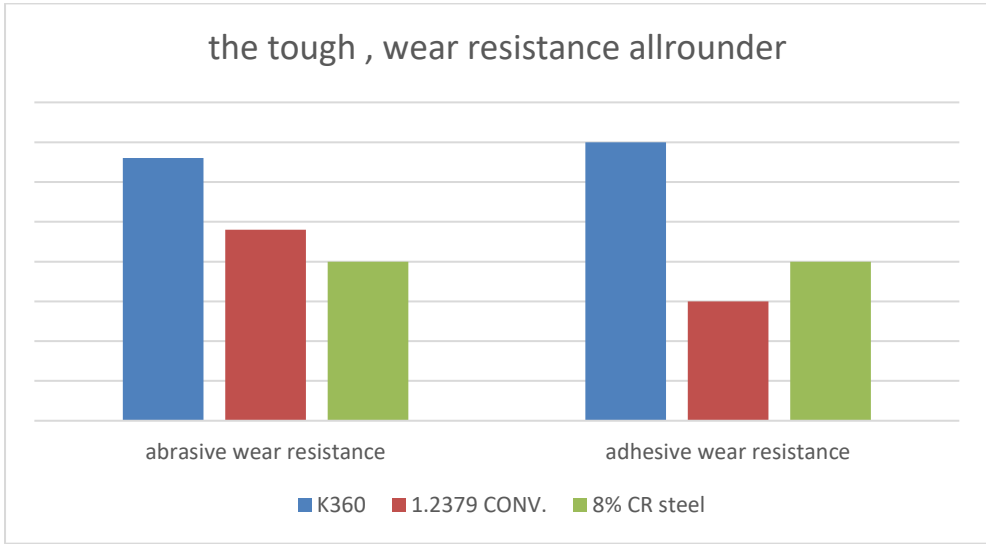
ESR Manufacture improved service life due:

- 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:**

<b>Carbonium</b>	<b>1,25%</b>
<b>Chromium</b>	<b>8,75%</b>
<b>Molybdenum</b>	<b>2,70%</b>
<b>Vanadium</b>	<b>1,18%</b>



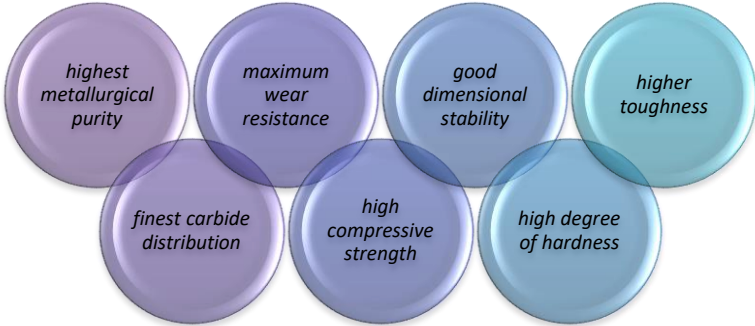
The new K360 isodur is a further development of the 8% chromium steels and has been developed to meet the needs of customers now more than ever. High toughness and, a remarkably high compressive strength , together with good resistance make this steel a real problem solver.

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.



**K490 Chemical composition:**

<b>Carbonium</b>	<b>1,40%</b>
<b>Chromium</b>	<b>6,40%</b>
<b>Molybdenum</b>	<b>1,50%</b>
<b>Vanadium</b>	<b>3,70%</b>
<b>Tungsten</b>	<b>3,50%</b>

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

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



<b>Trumpf</b> Gr0 D6 D10.5	<b>Trumpf</b> Multitool 5 – 10	<b>Trumpf</b> Gr1	<b>Thick turret</b> Smart staz.A Wilson s90	<b>Thick turret</b> Mate ultra style	<b>Thick turret</b> Mate ultra style Wilson s90 style	<b>Trumpf blade</b> Thick turret Slitting blade
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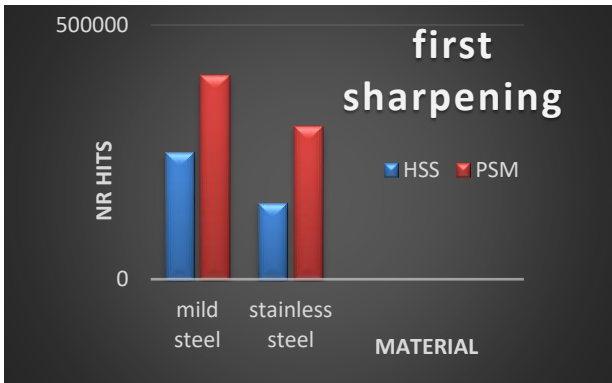
**Test result**

In order to ensure the best choice of steel for our tools, are carried out periodically punching test with punching machine



**200.000 hits**  
stainless steel  
AISI 304  
it doesn't need to be sharpened!

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



## Coating

## HDP ACTION

## high density plasma

Among other innovations brought by the HDP technology is a very versatile coating which can be widely used for various applications. HDP was developed to find a universal solution for the most traditional machining processes and to guarantee a constant yield and best performance of the tools.



Available with punches:

**Trumpf, Amada, Finn Power, Euromac, Lvd, Rainer, Salvagnini, Tecnology, Wiedemann, Boschert, Tailift, Danobat, Durma, Ermaksan...**

Test result



Coating is intact after 125.000 hits nibbling 1mm stainless steel

### CHARACTERISTICS:

- Extraordinary toughness** - this is the strong point of this coating and makes it versatile and particularly suitable for various applications
- Adhesion to the surface** - the HDP technology makes it possible to obtain maximum adherence of the coating to the surface and makes the "tool/coating" combination become a whole.
- Microhardness** - the very compact HDP Red layer, with a thickness of only 3 microns, gives a hardness which represents a solid barrier against wear and guarantees a unique performance.
- Low friction coefficient** - this is another important characteristic, which becomes evident thanks to the glossy layer. The low friction coefficient has been made possible thanks to the HDP technology which makes the application of coatings almost "dropletfree" (residual macro-particles on the surface). If they are not removed, these droplets affect the surface roughness.

Structure	MicroHardness (HV 0.05)	Friction coefficient (100 cr6)	Thickness (micron)	Deposition temperature (°C)	Max temperature (max°C)	Colour
Multilayer	3.800	0.25	1-3	480	400	RED

Add ons pag.69



## Coating

## Double coating FNC

The double coating is obtained by overlaying the traditional TiCN with Movic self-lubricating coating.



MOVIC is a self-lubricating and anti-adhesive coating based on MoS<sub>2</sub> (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.

Available with punches:

**Trumpf, Amada, Finn Power, Euromac, Lvd, Rainer, Salvagnini, Tecnology, Wiedemann, Boschert, Tailift, Danobat, Durma, Ermaksan...**

## SPECIFICATIONS:

- Self-lubricating single-phase coating based on MoS<sub>2</sub>.
- "Soft" coating with very low coefficient of friction (friction coefficient in dry air <0.05).
- Single-layer coating that can be combined with any hard coating.
- Functional Thickness of Coating <0.5 microns.
- Deposition temperature <150 ° C.
- Soft wear residues, lubricants (behavior Fail-safe: no abrasive particles from wear of the coating).
- Excellent running for rough surfaces. (Coating becomes smoother during the running in.)
- Positive transfer of lubricant film on the side in contact.
- can be easily re-covered without removal. If necessary the removal is easily achievable.

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



## MULTITOOL Index



- P18 - multitool style Mate 20-8 & 24-8 , 10-16 , 6\_8-24 , die shims
- P19 - multitool style Mate XMTE6 , XMTE12.7 , XMTE4 for EUROMAC
- P20 - PRIMAPOWVER MT20Ri , MT8Ri , MT3Ri , PASS style MT8Ri3-16
- P21 - PRIMAPOWVER MT8Ri3-16 , ERMAKSAN multitool 6-22mm , DURMA multitool 6-24



## THICK TURRET Index



- *P22 - A station old style open guide*
- *P23 - A station old style ECONO LINE , Heavy duty*
- *P24 - A station A.B. lubrication style*
- *P25 - A station SMART style*
- *P26 - A station SMART2 style*
- *P27 - A station Wilson style*
- *P28 - B station old style open guide*
- *P29 - B station ECONO LINE*
- *P30 - B station old style semi-open guide*
- *P31 - B station A.B. lubrication style open guide*
- *P32 - B station A.B. lubrication style close guide*
- *P33 - B station SMART ,ultrat. Mate style open guide*
- *P34 - B station SMART2 ,ultrat. Mate style semi-open guide*
- *P35 - B station Wilson style S90, ABS , WLS style , punch chuck rd10.5mm*
- *P36 - C station Amada old style , standard guide assembly*
- *P37 - C station quick adjustable guide assembly*
- *P38 - C station SMART Wilson S90 style , SMART guide assembly*
- *P39 - C station A.B. lubrication style , MATE ult.style*
- *P40 - D station Amada old style , standard guide assembly*
- *P41 - D station quick adjustable guide assembly*
- *P42 - D station SMART Wilson S90 style , SMART guide assembly*
- *P43 - D station A.B. lubrication style , MATE ult.style*
- *P44 - E station Amada old style , standard guide assembly*
- *P45 - E station quick adjustable guide assembly, A.B. lubrication style*
- *P46 - E station SMART Wilson S90 style , SMART guide assembly*
- *P47 - dies close to clamp , adaptors , urethan ejectors , brush dies*
- *P48 - slitting tool*
- *P49 - vice regrind equipment Amada original style , WILSON style , shims , pins , turret caliber*
- *P50 - disc spring , clips , punch holder keys , fixture equipment*
- *P51 - Vulcano Schiavi multitool 6A, 2A2B , 4B*

Add ons pag.69



### THICK TURRET SPECIAL TOOLING Index



- *P52 forming tool request guide*
- *P53 forming tool request guide*
- *P54 forming tool request guide*
- *P55 countersink , marking tool*
- *P56 engraving and deburring tool*
- *P57 emboss down*
- *P58 emboss up*
- *P59 extrusion up*
- *P60 cluster*
- *P61 cluster*
- *P62 louver , continuous louver*
- *P63 lance up , bridge up*
- *P64 knock out*
- *P65 hinge , thread form, bridges for thread*
- *P66 offset and rib tool , beading tool*
- *P67 logo*
- *P68 order form*
- *P69 add on*
- *P70 sales condition*



MODEL	PAGE	COMPATIBILITY	BENEFITS		THICKNESS LIMITS	OIL LUBRICATION	POWDER STEEL
DESCRIPTION		PUNCH STYLE	STRIPPER STYLE				
A STATION STANDARD OPEN GUIDE	22	THICK TURRET OLD STYLE	MATE ULTRATEC®	Fast stripper set up	3		
A STATION ECONO LINE	23	THICK TURRET OLD STYLE	CLOSE GUIDE	Competitively price	3		
A STATION HEAVY DUTY	23	SUCE DESIGN	MATE ULTRATEC®	Recommended when thickness exceeds 3mm	6		
A STATION WITH LUBRICATION OPEN GUIDE	24	THICK TURRET OIL LUBRICATION STYLE	MATE ULTRATEC®	Fast stripper set up	3	✓	
A STATION WITH LUBRICATION SOLID GUIDE	24	THICK TURRET OIL LUBRICATION STYLE	CLOSE GUIDE	Competitively price	3	✓	
A STATION SMART	25	SUCE DESIGN	MATE ULTRATEC®	Grind life Fast punch and stripper set up	3	✓	✓
A STATION SMART2	26	MATE ULTRATEC®	MATE ULTRATEC®	Grind life Fast punch and stripper set up	3 MS 2.5 SS	✓	✓
A STATION WILSON STYLE	27	WILSON HP , WLS , S90	WILSON HP , WLS , S90	Grind life	3	✓	✓
B STATION OPEN GUIDE	28	THICK TURRET OLD STYLE	MATE AND WILSON	Fast stripper set up	4/6		
B STATION ECONO LINE	29	THICK TURRET OLD STYLE	CLOSE GUIDE	Competitively price	4		
B STATION SEMI OPEN	30	THICK TURRET OLD STYLE	MATE AND WILSON	Semi-open guide ensures greater stability of stripper Fast stripper set up	4/6		
B STATION OPEN GUIDE WITH LUBRICATION	31	THICK TURRET OIL LUBRICATION STYLE	MATE AND WILSON	Fast stripper set up	4/6	✓	
B STATION WITH LUBRICATION	32	THICK TURRET OIL LUBRICATION STYLE	SOLID GUIDE	Competitively price	4/6	✓	
B STATION SMART	33	MATE ULTRATEC WILSON HP , WLS , S90	MATE AND WILSON	Grind life Fast punch and stripper set up	5	✓	✓
B STATION SMART2	34	MATE ULTRATEC WILSON HP , WLS , S90	MATE AND WILSON	Semi-open guide ensures greater stability of stripper Grind life Fast punch and stripper set up	5	✓	✓
B STATION WILSON STYLE	35	WILSON HP , WLS , S90	WILSON HP , WLS , S90	Grind life Fast stripper set up	6	✓	✓

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

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





MODEL	PAGE	COMPATIBILITY		BENEFITS	THICKNESS LIMITS	OIL LUBRICATION	POWDER STEEL
<b>DESCRIPTION</b>		<b>PUNCH STYLE</b>	<b>STRIPPER STYLE</b>				
C STATION	36-37	THICK TURRET OLD STYLE	THICK TURRET OLD STYLE	Competitively priced	6	* ✓	
C STATION SMART	38	WILSON	WILSON	Grind life	6	✓	
C STATION WITH LUBRICATION	39	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	40-41	THICK TURRET OLD STYLE	THICK TURRET OLD STYLE	Competitively priced	6	* ✓	
D STATION SMART	42	WILSON	WILSON	Grind life	6	✓	
D STATION WITH LUBRICATION	43	THICK TURRET ORIGINAL OIL LUBRICATION STYLE	THICK TURRET ORIGINAL OIL LUBRICATION STYLE		6	✓	
D STATION MATE STYLE	43	THICK TURRET OLD STYLE - MATE	MATE ULTRATEC®		6		
E STATION	44-45	THICK TURRET OLD STYLE	THICK TURRET OLD STYLE	Competitively priced	6	* ✓	
E STATION WITH LUBRICATION	45	THICK TURRET ORIGINAL OIL LUBRICATION STYLE	THICK TURRET ORIGINAL OIL LUBRICATION STYLE		6	✓	
E STATION SMART	46	WILSON	WILSON	Grind life	6		
SLTTING TOOL C D E STATION MATE STYLE	48	THICK TURRET ORIGINAL STYLE - MATE		Saving of over 80% cost of material	3		✓

ULTRATEC® IS A TRADEMARK OF MATE

\* WITH ADJUSTABLE GUIDE



**MULTITOOL Mate style 20-8 & 24-8mm**

Data:  
Max size 8,00mm  
  
Regrinding life: Punch 1mm , Die 0,5mm  
Regrinding life\*: Punch 2mm , Die 1,5mm  
  
\*with Euromac MTE10



	item	PUNCH HSS	€	PUNCH PSM	€	STRIPPER	€	DIE ISODUR	€
ROUND		AMAOPSM2006T		AMAOPSM2002T		AMAOPLM20T		AMA0MAM2001T	
STANDARD				AMAOPSM2002S		AMAOPLM20S		AMA0MAM2001S	
SPECIAL 0				AMAOPSM2002C		AMAOPLM20D		AMA0MAM2001D	
SPECIAL 1				AMAOPSM2002D		AMAOPLM20D		AMA0MAM2001D	
SPECIAL 2				AMAOPSM2002F		AMAOPLM20D		AMA0MAM2001D	

Coating	HDP	FNC
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**MULTITOOL Mate style 10-16mm**

Data:  
Max size 16,00mm  
  
Regrinding life: Punch 1mm , Die 0,5mm



	item	PUNCH ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND		AMAOPUM1606T		AMAOPLM16T		AMA0MAM1601T	
STANDARD		AMAOPUM1606S		AMAOPLM16S		AMA0MAM1601S	
SPECIAL 0		AMAOPUM1606C		AMAOPLM16D		AMA0MAM1601D	
SPECIAL 1		AMAOPUM1606D		AMAOPLM16D		AMA0MAM1601D	
SPECIAL 2		AMAOPUM1606F		AMAOPLM16D		AMA0MAM1601D	

Coating	HDP	FNC
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**MULTITOOL Mate style 6-8-24mm**

Data:  
Max size 24,00mm  
  
Regrinding life: Punch 1mm , Die 0,5mm  
Regrinding life\*: Punch 2mm , Die 1,5mm  
\*with Euromac MTE10



	item	PUNCH ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND		AMAOPUM2406T		AMAOPLM24T		AMA0MAM2401T	
STANDARD		AMAOPUM2406S		AMAOPLM24S		AMA0MAM2401S 0°-90°135°	
SPECIAL 0		AMAOPUM2406C		AMAOPLM24D		AMA0MAM2401D 0°-90°135°	
SPECIAL 1		AMAOPUM2406D		AMAOPLM24D		AMA0MAM2401D 0°-90°135°	
SPECIAL 2		AMAOPUM2406F		AMAOPLM24D		AMA0MAM2401D 0°-90°135°	

Coating	HDP	FNC
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**DIE SHIMS**

	item	Set n.24 pz Mt 24-8mm	€	Set n.10 pz Mt 10-16mm	€	Set n.6 pz Mt 6/8-24mm	€
0,1mm		AMA0MAM20SP10		AMA0MAM16SP10		AMA0MAM24SP01	
0,2mm		AMA0MAM20SP20		AMA0MAM16SP20		AMA0MAM24SP02	
0,5mm		AMA0MAM20SP60		AMA0MAM16SP60		AMA0MAM24SP05	

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**EUROMAC MULTITOOL XMTE6**

Mate style XMTE6 24mm  
 Data:  
 Regrinding life:  
 Punch 2.6mm , \*Adjustable 9mm  
 Die 1,5mm  
 Max size 24,00mm,  
 Max size die is 24.4mm



item	PUNCH ISODUR	€	PUNCH ADJUSTABLE ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND	AMA0PUM24C6T		AMA0PUM24D6T		AMA0PLM24CT		AMA0MAM2401T	
STANDARD	AMA0PUM24C6S		AMA0PUM24D6S		AMA0PLM24CS		AMA0MAM24B1S	
SPECIAL 0	AMA0PUM24C6C		AMA0PUM24D6C		AMA0PLM24CD		AMA0MAM24B1D	
SPECIAL 1	AMA0PUM24C6D		AMA0PUM24D6D		AMA0PLM24CD		AMA0MAM24B1D	
SPECIAL 2	AMA0PUM24C6F		AMA0PUM24D6F		AMA0PLM24CD		AMA0MAM24B1D	



PUNCH CHUCK	€	PUNCH HEAD	€
AMA0PP24		AMA0TEM24	
PUNCH MAX DIM 10,4	€		
AMB105PST006T			

Coating	PUNCH INSERT HDP	PUNCH INSERT FNC	HDP	FNC
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**EUROMAC MULTITOOL XMTE12.7**

Mate style XMTE12.7 mm  
 Data:  
 Regrinding life:  
 Punch 2.6mm  
 Punch adjustable\* 9mm  
 Die 1,5mm  
 Max size 12,70mm  
 Max size die is 13.2mm  
 \*only keyed station



item	PUNCH ISODUR	€	PUNCH ISODUR ADJUSTABLE	€	PUNCH HEAD	€	STRIPPER	€	DIE ISODUR	€
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	HDP	FNC
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**EUROMAC MULTITOOL XMTE4**

Mate style XMTE4 4B 31.7mm  
 Data:  
 Regrinding life:  
 Punch 8mm , Die 2,5mm  
 Max size 31,70mm  
 Max tonnage: 22tons



item	PUNCH SMART ISODUR	€	STRIPPER XMTE4	€	STRIPPER STD B	€	B DIE ISODUR	€
ROUND	AMB1IPLLN6T		AMB1PLMT4T		AMB1PLWTT		AMB1MAT006T	
STANDARD	AMB1IPLLN6S		AMB1PLMT4S		AMB1PLWTS		AMB1MAT006S	
SPECIAL 0	AMB1IPLLN6D		AMB1PLMT4D		AMB1PLWTD		AMB1MAT006D	
SPECIAL 1	AMB1IPLLN6C		AMB1PLMT4D		AMB1PLWTD		AMB1MAT006D	
SPECIAL 2	AMB1IPLLN6F		AMB1PLMT4D		AMB1PLWTD		AMB1MAT006D	



**PRIMA POWER MULTITOOL**

Wilson style MT20Ri , MT20i 8mm

Data:  
Max size 8mm



item	PUNCH HSS	€	STRIPPER	€	DIE ISODUR	€
ROUND	AMAOPUM2006T		AMAOPLM20T		AMA0MAM2001T	
STANDARD	AMAOPUM2006S		AMAOPLM20S		AMA0MAM2001S	
SPECIAL 0	AMAOPUM2006C		AMAOPLM20D		AMA0MAM2001D	
SPECIAL 1	AMAOPUM2006D		AMAOPLM20D		AMA0MAM2001D	
SPECIAL 2	AMAOPUM2006F		AMAOPLM20D		AMA0MAM2001D	

Coating  HDP  FNC

**PRIMAPOWER MULTITOOL**

Wilson style MT8Ri , MT8i 16mm

Data:  
Max size 16mm



item	PUNCH HSS	€	STRIPPER	€	DIE ISODUR	€
ROUND	AMAOPUM806T		AMAOPLM8T		AMA0MAM801T	
STANDARD	AMAOPUM806S		AMAOPLM8S		AMA0MAM801S	
SPECIAL 0	AMAOPUM806C		AMAOPLM8D		AMA0MAM801D	
SPECIAL 1	AMAOPUM806D		AMAOPLM8D		AMA0MAM801D	
SPECIAL 2	AMAOPUM806F		AMAOPLM8D		AMA0MAM801D	

Coating  HDP  FNC

**PRIMAPOWER MULTITOOL**

Wilson style MT3Ri 31.7mm

Data:  
Max size 31.7mm



item	PUNCH ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND	AMB1IPWT06T		AMAOPLMT3T		AMB1MAMT306T	
STANDARD	AMB1IPWT06S		AMAOPLMT3S		AMB1MAMT306S	
SPECIAL 0	AMB1IPWT06C		AMAOPLMT3D		AMB1MAMT306D	
SPECIAL 1	AMB1IPWT06D		AMAOPLMT3D		AMB1MAMT306D	
SPECIAL 2	AMB1IPWT06F		AMAOPLMT3D		AMB1MAMT306D	

Coating  HDP  FNC

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**PRIMAPOWER MULTITOOL MT8Ri3-16**

Data:  
Max size 16,00mm  
Max thickness 4ms , 3ss



	item	PUNCH ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND		AMMTPU8RI06T		AMMTPLM8T		AMA0MAM1601T	
STANDARD		AMMTPU8RI06S		AMMTPLMTS		AMA0MAM1601S	
SPECIAL 0		AMMTPU8RI06C		AMMTPLMTD		AMA0MAM1601D	
SPECIAL 1		AMMTPU8RI06D		AMMTPLMTD		AMA0MAM1601D	
SPECIAL 2		AMMTPU8RI06F		AMMTPLMTD		AMA0MAM1601D	

Coating **HDP**  **FNC**

**ERMAKSAN MT6 - 22**

Max 22mm  
Max thickness:  
3mm  
Max punching  
force 9Kn ,  
Grinding life mm:  
Punch 6, Die 0,5



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

**DURMA MULTITOOL**

Data:  
Max size 24,00mm, max size die is 24.4mm



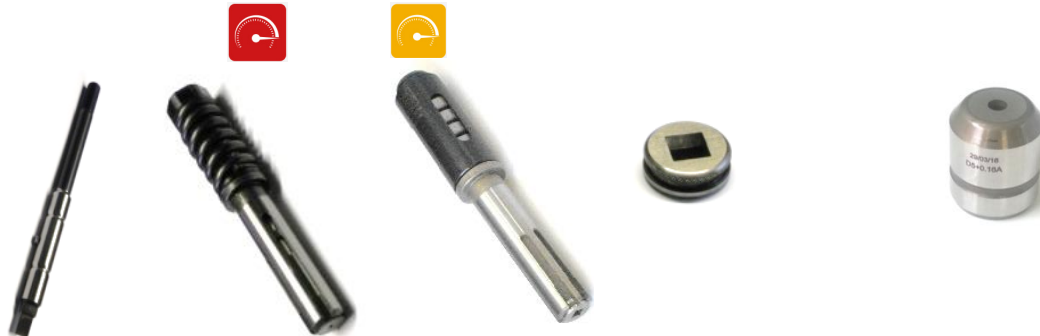
	item	PUNCH ISODUR	€	STRIPPER	€	DIE ISODUR	€
ROUND		AMA0PUM24B6T		AMA0PLM24BT		AMA0MAM2401T	
STANDARD		AMA0PUM24B6S		AMA0PLM24BS		AMA0MAM24B1S	
SPECIAL 0		AMA0PUM24B6C		AMA0PLM24BD		AMA0MAM24B1D	
SPECIAL 1		AMA0PUM24B6D		AMA0PLM24BD		AMA0MAM24B1D	
SPECIAL 2		AMA0PUM24B6F		AMA0PLM24BD		AMA0MAM24B1D	

Coating **HDP**  **FNC**



**A STATION STANDARD , OPEN GUIDE**

Max 12,70mm , Max thickness: max 3mm , Grinding life mm: Std punch 2,5 Long life punch 6 Die 2,5



item	PUNCH ISODUR	€	PUNCH ISODUR ASSEMBLY	€	PUNCH ISODUR ASSEMBLY LONG LIFE	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMA1PUT006T		AMA1PAT306T		AMA1PAL306T		AMA1PLTMT		AMA1MAT001T		AMA1MAT006T	
STD	AMA1PUT006S		AMA1PAT306S		AMA1PAL306S		AMA1PLTMS		AMA1MAT001S*		AMA1MAT006S*	
SPECIAL 0	AMA1PUT006C		AMA1PAT306C		AMA1PAL306C		AMA1PLTMD		AMA1MAT001D		AMA1MAT006D	
SPECIAL 1	AMA1PUT006D		AMA1PAT306D		AMA1PAL306D		AMA1PLTMD		AMA1MAT001D		AMA1MAT006D	
SPECIAL 2	AMA1PUT006F		AMA1PAT306F		AMA1PAL306F		AMA1PLTMD		AMA1MAT001D		AMA1MAT006D	

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

Coating	HDP	FNC
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**FITTING**




item	PUNCH HEAD	€	SPRING	€	RETAINER	€	PUNCH DRIVER max thickness 3mm	€	OPEN STANDARD GUIDE	€
	AMA1TERA		AMA1MSTO		AMA1RITO		AMA1LLGIO		ONLY ROUND AMA1GUA2T SHAPE 0-90-135° AMA1GUL2S	



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**A STATION ECONO LINE , CLOSE GUIDE**

Max 12,70mm , Max thickness: max 3mm , Grinding life mm: punch 2,5 , Die 2,5



	PUNCH ISODUR	€	PUNCH ISODUR ASSEMBLY	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMA1PUT006T		AMA1PATE06T		AMA1MAT001T		AMA1MAT006T	
STANDARD	AMA1PUT006S		AMA1PATE06S		AMA1MAT001S*		AMA1MAT006S*	
PUNCH HEAD	AMA1TERA							
RETAINER	AMA1RIT0							
SPRING	AMA1MST0							
ROUND GUIDE	AMA1GUT0T							
SHAPE GUIDE 0-90°	AMA1GUT0S							
SQUARE GUIDE 0-135°	AMA1GUT0Q							
SPANNER WRENCH								

AMABSW

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

**A STATION HEAVY DUTY**

Max 12,70mm , Max thickness: max 6mm , Grinding life mm: Punch 3,5 Die 2,5 , 0,5 Radius on corner



item	PUNCH ISODUR	€	PUNCH ISODUR ASSEMBLY	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMA1PTR06T		AMA1PATM06T		AMA1PLTMT		AMA1MAT001T		AMA1MAT006T	
STANDARD	AMA1PTR06S		AMA1PATM06S		AMA1PLTMS		AMA1MATP01S		AMA1MATP06S	
SPECIAL 0	AMA1PTR06C		AMA1PATM06C		AMA1PLTMD		AMA1MATP01D		AMA1MATP06D	
SPECIAL 1	AMA1PTR06D		AMA1PATM06D		AMA1PLTMD		AMA1MATP01D		AMA1MATP06D	
SPECIAL 2	AMA1PTR06F		AMA1PATM06F		AMA1PLTMD		AMA1MATP01D		AMA1MATP06D	

Coating	HDP	FNC
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**A STATION OIL LUBR. OPEN GUIDE**

Max 12,70mm , Max thickness: max 3mm , Grinding life mm: Std punch 2,5 Long life punch 6 Die 2,5



item	PUNCH ISODUR	€	PUNCH ISODUR ASSEMBLY	€	PUNCH ISODUR ASSEMBLY LONG LIFE	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMA1PUAB06T		AMA1PATAB6T		AMA1PALLB6T		AMA1PLTMT		AMA1MAT001T		AMA1MAT006T	
STD	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 pin 0-135° code: HWS AMA1MAT001Q , ISODUR AMA1MAT006Q

**A STATION OIL LUBR. CLOSED GUIDE**

Max 12,70mm , Max thickness: max 3mm , Grinding life mm: Std punch 2,5 Long life punch 6 Die 2,5



item	PUNCH ISODUR	€	PUNCH ISODUR ASSEMBLY	€	PUNCH ASSEMBLY LONG LIFE	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMA1PUAB06T		AMA1PATAE6T		AMA1PALAE6T		AMA1MAT001T		AMA1MAT006T	
STD	AMA1PUAB06S		AMA1PATAE6S		AMA1PALAE6S		AMA1MAT001S*		AMA1MAT006S*	
SPECIAL 0	AMA1PUAB06C		AMA1PATAE6C		AMA1PALAE6C		AMA1MAT001D		AMA1MAT006D	
SPECIAL 1	AMA1PUAB06D		AMA1PATAE6D		AMA1PALAE6D		AMA1MAT001D		AMA1MAT006D	
SPECIAL 2	AMA1PUAB06F		AMA1PATAE6F		AMA1PALAE6F		AMA1MAT001D		AMA1MAT006D	

Coating	HDP	FNC
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**FITTING**



item	PUNCH HEAD	€	SPRING	€	RETAINER	€	PUNCH DRIVER max thickness 3mm	€	CLOSE STANDARD GUIDE	€	OPEN STANDARD GUIDE	€
	AMA1TERA		AMA1MST0		AMA1RIT0		AMA1LLGIO		ROUND AMA1GUAIT		ONLY ROUND AMA1GUA2T	
									SHAPE 0-90 AMA1GUAIS		SHAPE / SQ 0-90-135° AMA1GUA2S	
									SQUARE 0-135° AMA1GUAIQ			
									SPC 0-90° AMA1GUAID			

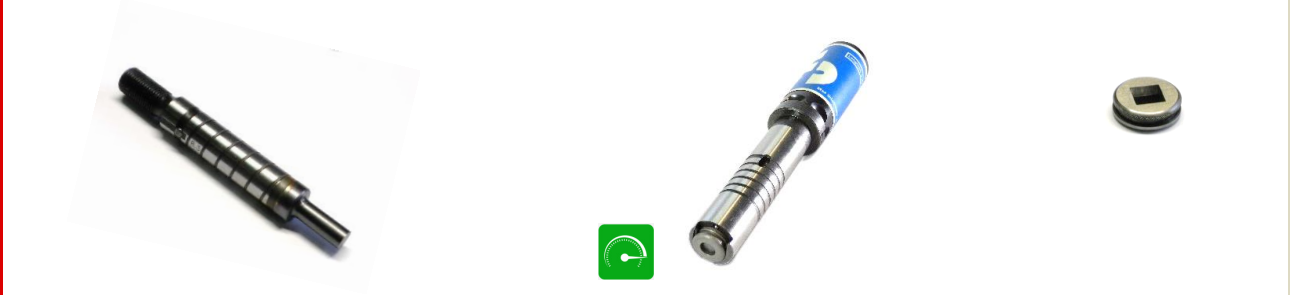
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**A STATION SMART**

Max 12,70mm , Max thickness: max 3mm , Grinding life mm: punch 6 Die 2,5



	PUNCH				PUNCH ASSEMBLY				STRIPPER	
	ISODUR	€	PSM	€	ISODUR	€	PSM	€		€
ROUND	AMA1P16T06T		AMA1P16T04T		AMA1PANS06T		AMA1PANS04T		AMA1PLTMT	
STANDARD	AMA1P16T06S		AMA1P16T04S		AMA1PANS06S		AMA1PANS04S		AMA1PLTMS	
SPECIAL 0	AMA1P16T06C		AMA1P16T04C		AMA1PANS06C		AMA1PANS04C		AMA1PLTMD	
SPECIAL 1	AMA1P16T06D		AMA1P16T04D		AMA1PANS06D		AMA1PANS04D		AMA1PLTMD	
SPECIAL 2	AMA1P16T06F		AMA1P16T04F		AMA1PANS06F		AMA1PANS04F		AMA1PLTMD	

Coating	HDP	FNC
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**FITTING**

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

**DIE**

item	HWS DIE	€	ISODUR DIE	€
	ROUND	AMA1MAT001T		AMA1MAT006T
STANDARD	AMA1MAT001S*		AMA1MAT006S*	
SPECIAL 0	AMA1MAT001D		AMA1MAT006D	
SPECIAL 1	AMA1MAT001D		AMA1MAT006D	
SPECIAL 2	AMA1MAT001D		AMA1MAT006D	

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



**A STATION SMART 2**

Max 12,70mm

Max thickness:

3mm mild steel , 2,5mm 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	HDP	FNC
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**FITTING**



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

\* It works only with Suce guide AMA1GUTU\_ \*\* It works only with Suce pack spring AMA1LLTM

**DIE**



item	HWS DIE	€	ISODUR DIE	€
ROUND	AMA1MAT001T		AMA1MAT006T	
STANDARD	AMA1MAT001S*		AMA1MAT006S*	
SPECIAL 0	AMA1MAT001D		AMA1MAT006D	
SPECIAL 1	AMA1MAT001D		AMA1MAT006D	
SPECIAL 2	AMA1MAT001D		AMA1MAT006D	

\*for Amada machines pin 0-135° code: HWS AMA1MAT001Q , HP AMA1MAT006Q

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A STATION WILSON STYLE



item	PUNCH HP ISODUR	€	PUNCH HP LUBR. ISODUR	€	PSM PUNCH HP	€	PSM PUNCH HP LUBR	€	STRIPPER HP	€
ROUND	AMA1PWS06T		AMA1PWL06T		AMA1PWS04T		AMA1PWL04T		AMA1PLHPT	
STANDARD	AMA1PWS06S		AMA1PWL06S		AMA1PWS04S		AMA1PWL04S		AMA1PLHPS	
SPECIAL 0	AMA1PWS06C		AMA1PWL06C		AMA1PWS04C		AMA1PWL04C		AMA1PLHPD	
SPECIAL 1	AMA1PWS06D		AMA1PWL06D		AMA1PWS04D		AMA1PWL04D		AMA1PLHPD	
SPECIAL 2	AMA1PWS06F		AMA1PWL06F		AMA1PWS04F		AMA1PWL04F		AMA1PLHPD	

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Coating	HDP	FNC
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DIE



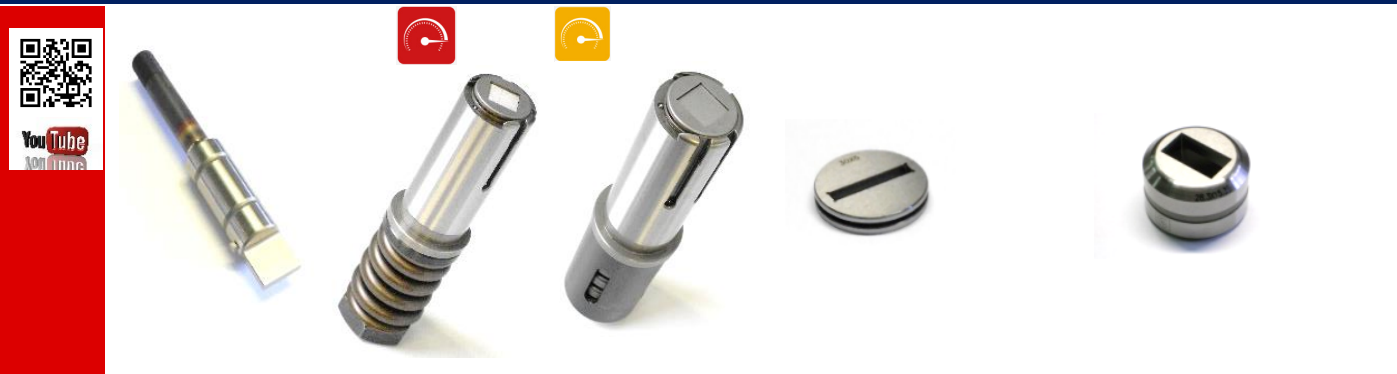
item	HWS DIE	€	ISODUR DIE	€
ROUND	AMA1MAT001T		AMA1MAT006T	
STANDARD	AMA1MAT001S*		AMA1MAT006S*	
SPECIAL 0	AMA1MAT001D		AMA1MAT006D	
SPECIAL 1	AMA1MAT001D		AMA1MAT006D	
SPECIAL 2	AMA1MAT001D		AMA1MAT006D	

\*for Amada machines pin 0-135° code: HWS AMA1MAT001Q, HP AMA1MAT006Q



**B STATION STANDARD , OPEN GUIDE**

Max 31,70mm , Max thickness: max 4/6mm , Grinding life mm: Standard punch 4 , Long life punch 8 ,Die 2,5



item	PUNCH ISODUR	€	PUNCH ISODUR ASSEMBLY	€	PUNCH ISODUR ASSEMBLY LONG-LIFE	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMB1PUT006T		AMB1PAT206T		AMB1PALL06T		AMB1PLWTPT		AMB1MAT001T		AMB1MAT006T	
STANDARD	AMB1PUT006S		AMB1PAT206S		AMB1PALL06S		AMB1PLWTPT		AMB1MAT001S*		AMB1MAT006S*	
SPECIAL 0	AMB1PUT006C		AMB1PAT206C		AMB1PALL06C		AMB1PLWTPD		AMB1MAT001D		AMB1MAT006D	
SPECIAL 1	AMB1PUT006D		AMB1PAT206D		AMB1PALL06D		AMB1PLWTPD		AMB1MAT001D		AMB1MAT006D	
SPECIAL 2	AMB1PUT006F		AMB1PAT206F		AMB1PALL06F		AMB1PLWTPD		AMB1MAT001D		AMB1MAT006D	

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

Coating	€
HDP	ROUND
	SHAPE
FNC	ROUND
	SHAPE

**FITTING**



item	PUNCH HEAD	€	SPRING max thickness 4mm	€	REVERSIBLE RETAINER Includes OR	€	NEW SPRING PUNCH DRIVER max thickness 6mm	€	OPEN STANDARD GUIDE	€
	AMB1TERA		AMB1MST0		AMB1RIT0		AMB1LLGIO		ONLY ROUND AMB1GUABT	
									SHAPE 0-90-135° AMB1GULLS	


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**B STATION ECONO LINE**

Max 31,70mm , Max thickness: 4mm , Grinding life mm: life punch 4 , Die 2,5



item	PUNCH ISODUR	€	PUNCH ISODUR ASSEMBLY CLOSE GUIDE	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMB1PUT006T		AMB1PATE06T		AMB1MAT001T		AMB1MAT006T	
STANDARD	AMB1PUT006S		AMB1PATE06S		AMB1MAT001S		AMB1MAT006S	
PUNCH HEAD	AMB1TERA							
RETAINER	AMB1RITO							
SPRING + COVER	AMB1MST0							
ROUND GUIDE	AMB1GUT0T							
SHAPE GUIDE 0-90°	AMB1GUT0S							
SQUARE GUIDE 0-135°	AMB1GUT0Q							
SPANNER WRENCH								
	AMABSW							

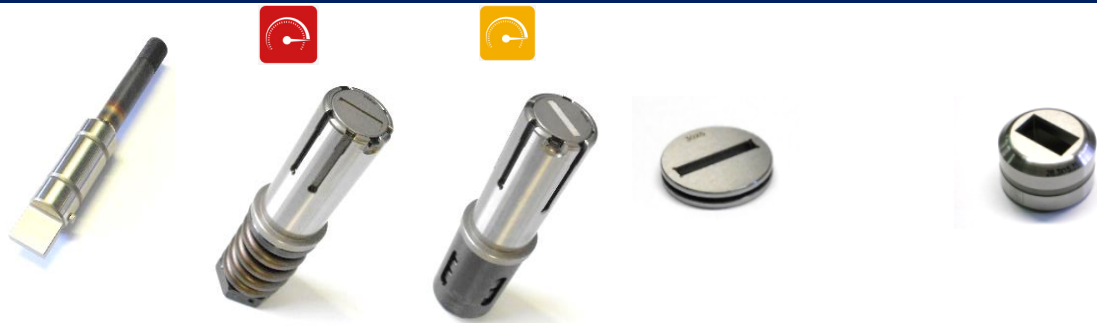
Coating		€
HDP	ROUND	
	SHAPE	
FNC	ROUND	
	SHAPE	

Add ons pag.69



**B STATION STANDARD , SEMI-OPEN GUIDE**

Max 31,70mm, Max thickness: max 4/6mm, Grinding life mm: Standard punch 4, Long life punch 8, Die 2,5



item	PUNCH ISODUR	€	PUNCH ISODUR ASSEMBLY	€	PUNCH ISODUR ASSEMBLY LONG-LIFE	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMB1PUT006T		AMB1PAT306T		AMB1PAL306T		AMB1PLWTT		AMB1MAT001T		AMB1MAT006T	
STANDARD	AMB1PUT006S		AMB1PAT306S		AMB1PAL306S		AMB1PLWTS		AMB1MAT001S*		AMB1MAT006S*	
SPECIAL 0	AMB1PUT006C		AMB1PAT306C		AMB1PAL306C		AMB1PLWTD		AMB1MAT001D		AMB1MAT006D	
SPECIAL 1	AMB1PUT006D		AMB1PAT306D		AMB1PAL306D		AMB1PLWTD		AMB1MAT001D		AMB1MAT006D	
SPECIAL 2	AMB1PUT006F		AMB1PAT306F		AMB1PAL306F		AMB1PLWTD		AMB1MAT001D		AMB1MAT006D	

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

Coating		€
HDP	ROUND	
	SHAPE	
FNC	ROUND	
	SHAPE	

**FITTING**



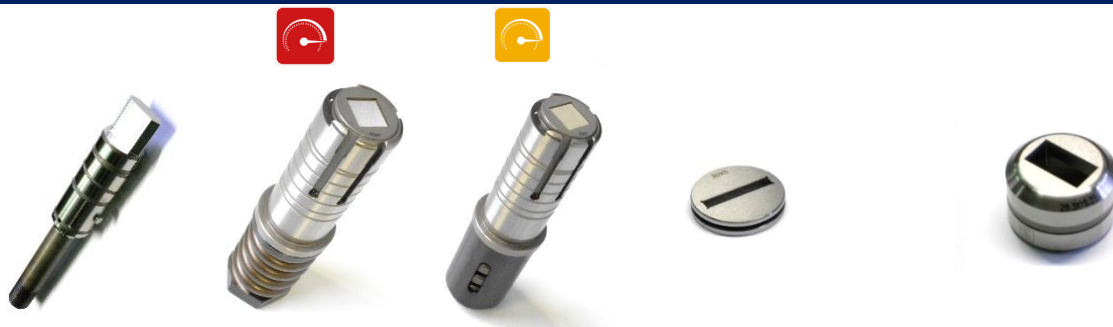
item	PUNCH HEAD	€	SPRING max thickness 4mm	€	REVERSIBLE RETAINER Includes OR	€	NEW SPRING PUNCH DRIVER max thickness 6mm	€	OPEN STANDARD GUIDE Clip included ONLY ROUND	€
	AMB1TERA		AMB1MST0		AMB1RIT0		AMB1LLGIO		AMB1GUT3T  SHAPE 0-90-135° AMB1GUT3S	

Add ons pag.69



**B STATION A.B. LUBRICATION STYLE , OPEN GUIDE**

Max 31,70mm , Max thickness: max 4/6mm , Grinding life mm: Std punch 4 , Long life punch 8Die 2,5



item	PUNCH ISODUR	€	PUNCH ISODUR ASSEMBLY	€	PUNCH ISODUR 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	

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

Coating	€	
HDP	ROUND	
	SHAPE	
FNC	ROUND	
	SHAPE	

**FITTING**



item	PUNCH HEAD	€	SPRING max thickness 4mm	€	REVERSIBLE RETAINER Includes OR	€	NEW SPRING PUNCH DRIVER max thickness 6mm	€	OPEN LUBR.GUIDE	€
	AMB1TERA		AMB1MST0		AMB1RIT0		AMB1LLGIO		ONLY ROUND AMB1GUABT  SHAPE 0-90-135° AMB1GUABS	

Add ons pag.69



**B STATION A.B LUBRICATION STYLE , CLOSE GUIDE**

Max 31,70mm , Max thickness: max 4/6mm , Grinding life mm: Std punch 4 , Long life punch 8 , Die 2,5



item	PUNCH ISODUR	€	PUNCH ISODUR ASSEMBLY	€	PUNCH ISODUR ASSEMBLY LONG-LIFE	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMB1PUAB06T		AMB1PATAE6T		AMB1PALAE6T		AMB1MAT001T		AMB1MAT006T	
STANDARD	AMB1PUAB06S		AMB1PATAE6S		AMB1PALAE6S		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 pin 0-135° code: HWS AMB1MAT001Q , ISODUR AMB1MAT006Q

Coating		€
HDP	ROUND	
	SHAPE	
FNC	ROUND	
	SHAPE	

**FITTING**



item	PUNCH HEAD	€	SPRING max thickness 4mm	€	REVERSIBLE RETAINER Includes OR	€	NEW SPRING PUNCH DRIVER max thickness 6mm	€	CLOSE STANDARD GUIDE	€
	AMB1TERA		AMB1MST0		AMB1RIT0		AMB1LLGIO		ONLY ROUND AMB1GUAIT  SHAPE 0-90 AMB1GUAIS  SHAPE 0-135° AMB1GUAIQ	



Add ons pag.69



**B STATION SMART** open guide

Max 31,70mm , Max thickness: 5mm

Grinding punch life with straight before rad 22mm , stripper land 4mm:

- thickness 1mm : 10mm
- thickness 2mm : 9mm
- thickness 3mm : 8mm
- thickness 4mm : 7mm
- thickness 5mm : 6mm

Grinding die life 2,5 mm



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

Coating	HDP	FNC
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**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

**FITTING**



item	NEW SPRING PUNCH DRIVER (max thickness 5mm)	€	OPEN GUIDE	€	OPEN GUIDE	€
	AMB1LLGIOPE		ONLY ROUND AMB1GUUNT		RD & SHAPE 0-90-135° AMB1GUUN	

Add ons pag.69



**B STATION SMART semi open guide**

Max 31,70mm , Max thickness: 5mm

Grinding punch life with straight before rad 22mm , stripper land 4mm:

thickness 1mm : 10mm

thickness 2mm : 9mm

thickness 3mm : 8mm

thickness 4mm : 7mm

thickness 5mm : 6mm

Grinding die life 2,5 mm



item	PUNCH ISODUR AND K490 MICROCL	€	PUNCH ISODUR AND K490 MICROCL ASSEMBLY	€	STRIPPER	€
ROUND	ISODUR AMB1PLLNL6T PSM AMB1IPLNL4T		ISODUR AMB1PANS06T PSM AMB1PANS04T		AMB1PLWTT	
STANDARD	ISODUR AMB1PLLNL6S PSM AMB1IPLNL4S		ISODUR AMB1PANS06S PSM AMB1PANS04S		AMB1PLWTS	
SPECIAL 0	ISODUR AMB1PLLNL6C PSM AMB1IPLNL4C		ISODUR AMB1PANS06C PSM AMB1PANS04C		AMB1PLWTD	
SPECIAL 1	ISODUR AMB1PLLNL6D PSM AMB1IPLNL4D		ISODUR AMB1PANS06D PSM AMB1PANS04D		AMB1PLWTD	
SPECIAL 2	ISODUR AMB1PLLNL6F PSM AMB1IPLNL4F		ISODUR AMB1PANS06F PSM AMB1PANS04F		AMB1PLWTD	

Coating	HDP	FNC
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**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

**FITTING**

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

Add ons pag.69



**B STATION WILSON S90 , WLS , ABS STYLE**



Item	S90 STYLE PUNCH ISODUR	€	WLS ABS PUNCH ISODUR	€	DIE	€	STRIPPER	€
	<b>S90 STYLE PUNCH K490 MICROCL</b>		<b>WLS ABS STYLE PUNCH K490 MICROCL</b>					
ROUND	ISODUR AMB1IPS906T K490 AMB1IPS904T		ISODUR AMB1IPWT06T K490 AMB1IPWT04T		HWS AMB1MAT001T ISODUR AMB1MAT006T		AMB1PLWTT Clip AMB1SEG	
STANDARD	ISODUR AMB1IPS906S K490 AMB1IPS904S		ISODUR AMB1IPWT06S K490 AMB1IPWT04S		HWS AMB1MAT001S* ISODUR AMB1MAT006S*		AMB1PLWTS Clip AMB1SEG	
SPECIAL 0	ISODUR AMB1IPS906C K490 AMB1IPS904C		ISODUR AMB1IPWT06C K490 AMB1IPWT04C		HWS AMB1MAT001D ISODUR AMB1MAT006D		AMB1PLWTD Clip AMB1SEG	
SPECIAL 1	ISODUR AMB1IPS906D K490 AMB1IPS904D		ISODUR AMB1IPWT06D K490 AMB1IPWT04D		HWS AMB1MAT001D ISODUR AMB1MAT006D		AMB1PLWTD Clip AMB1SEG	
SPECIAL 2	ISODUR AMB1IPS906F K490 AMB1IPS904F		ISODUR AMB1IPWT06F K490 AMB1IPWT04F		HWS AMB1MAT001D ISODUR AMB1MAT006D		AMB1PLWTD Clip AMB1SEG	

\*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 4mm MAX SIZE 10.4mm



item	PUNCH	€	PUNCH CHUCK MATE ULTRAT.STYLE , SMART	€	PUNCH CHUCK WILSON STYLE WLS ,ABS	€
ROUND	AMB105PST006T		AMB105PPTLLNL		AMB105PPTLLL	

Coating	PUNCH INSERT	PUNCH B ROUND	PUNCH B SHAPE
HDP			
FNC			



Add ons pag.69

**C STATION STANDARD**

Max 50,80mm , Max thickness: 6mm , Grinding life mm: life punch 8 Die 2,5



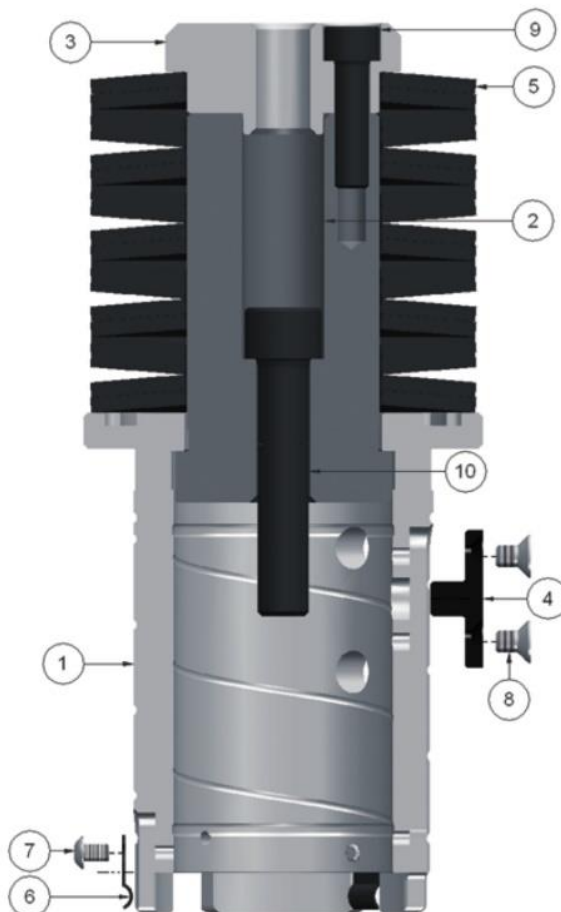
item	PUNCH ISODUR	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€	STANDARD GUIDE ASSEMBLY	€	ADJUSTABLE LUBR.GUIDE ASSEMBLY	€
ROUND	AMC1PUT006T		AMC1PLT0T		AMC1MAT001T		AMC1MAT006T		AMC1GAT0		AMC1GALL2	
STANDARD	AMC1PUT006S		AMC1PLT0S		AMC1MAT001S		AMC1MAT006S		AMC1GAT0		AMC1GALL2	
SPECIAL 0	AMC1PUT006C		AMC1PLT0D		AMC1MAT001D		AMC1MAT006D		AMC1GAT0		AMC1GALL2	
SPECIAL 1	AMC1PUT006D		AMC1PLT0D		AMC1MAT001D		AMC1MAT006D		AMC1GAT0		AMC1GALL2	
SPECIAL 2	AMC1PUT006F		AMC1PLT0D		AMC1MAT001D		AMC1MAT006D		AMC1GAT0		AMC1GALL2	

Coating	HDP	FNC
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**C STATION STANDARD**

**GUIDE ASSEMBLY STANDARD AMC1GAT0**

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



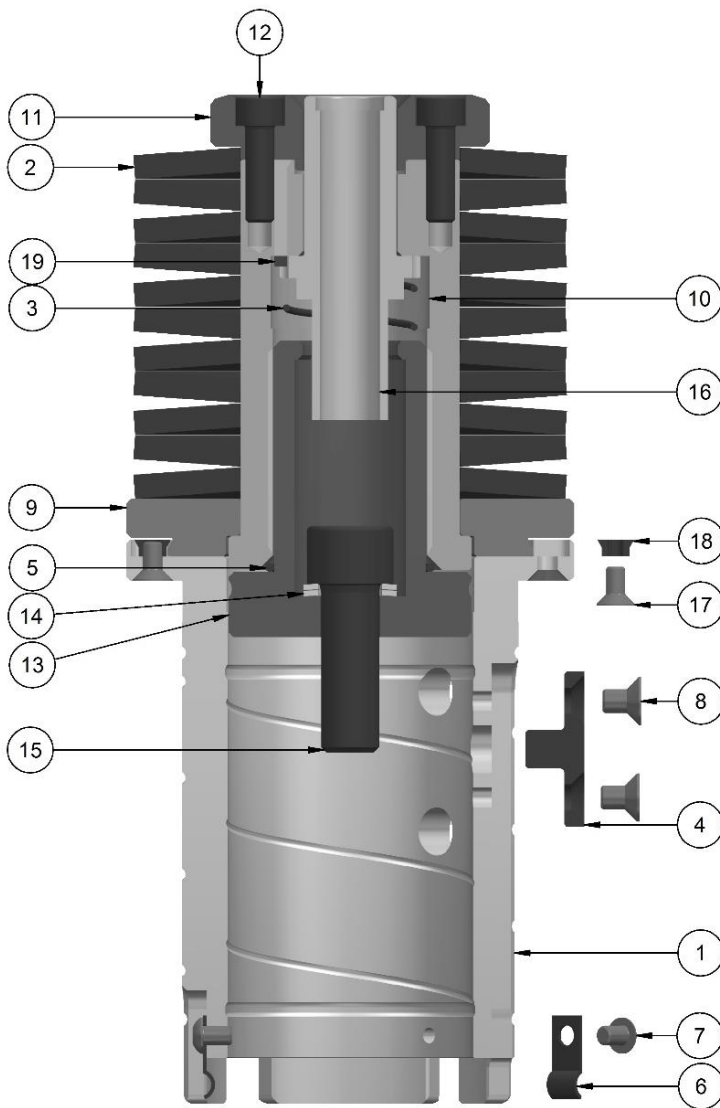
Add ons pag.69



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



REF	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	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°



FITTINGS					
item	HEX KEY		€	T-HANDLE EXTRACTOR	€
	AMCECHIAVEM12			AMD1G2EST	

Add ons pag.69



**C STATION SMART, WILSON STYLE**

Max 50,80mm , Max thickness: 6mm , Grinding life mm: life punch 8 Die 2,5



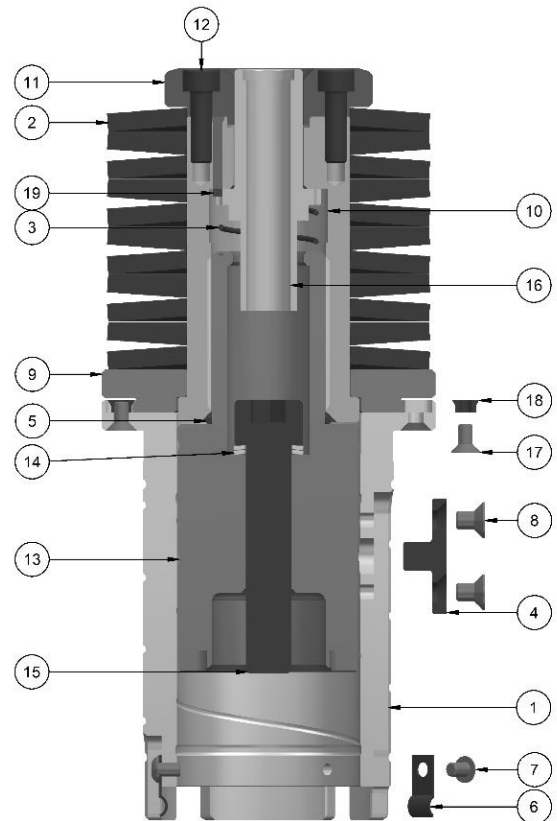
item	PUNCH ISODUR	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€	GUIDE ASSEMBLY ADJUSTABLE - LUBR	€
ROUND	AMC1PUWT06T		AMC1PLWTT		AMC1MAT001T		AMC1MAT006T		AMC1GALLWT2	
STANDARD	AMC1PUWT06S		AMC1PLWTS		AMC1MAT001S		AMC1MAT006S		AMC1GALLWT2	
SPECIAL 0	AMC1PUWT06C		AMC1PLWTD		AMC1MAT001D		AMC1MAT006D		AMC1GALLWT2	
SPECIAL 1	AMC1PUWT06D		AMC1PLWTD		AMC1MAT001D		AMC1MAT006D		AMC1GALLWT2	
SPECIAL 2	AMC1PUWT06F		AMC1PLWTD		AMC1MAT001D		AMC1MAT006D		AMC1GALLWT2	

Coating	HDP	FNC
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**C STATION SMART2  
GUIDE ASSEMBLY STANDARD AMC1GALLWT2  
QUICK ADJUSTABLE LENGTH , WITH LUBRICATION**



REF	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	NVI900003UNC	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	NVI05AR06020	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°



FITTINGS					
item	HEX KEY	€	T-HANDLE EXTRACTOR	€	
	AMCECHIAVE		AMD1G2EST		

Add ons pag.69



**C STATION A.B.LUBRICATION STYLE**

Max 50,80mm , Max thickness: 6mm , Grinding life mm: life punch 8 Die 2,5

\*To specify  
M12 or M14

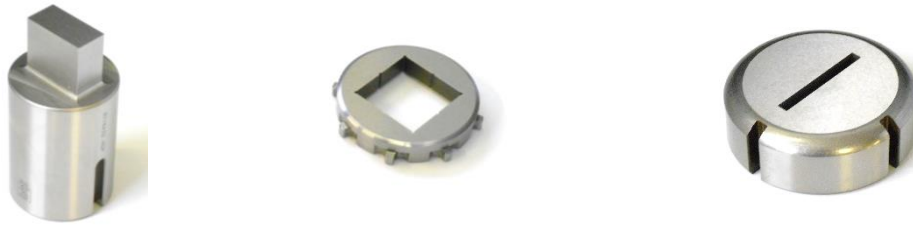


item	PUNCH* ISODUR	€	STRIPPER ALPHA STYLE	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMC1PUAB06T		AMC1PLTLT		AMC1PLTGT		AMC1MAT001T		AMC1MAT006T	
STANDARD	AMC1PUAB06S		AMC1PLTLS		AMC1PLTGS		AMC1MAT001S		AMC1MAT006S	
SPECIAL 0	AMC1PUAB06C		AMC1PLTLD		AMC1PLTGD		AMC1MAT001D		AMC1MAT006D	
SPECIAL 1	AMC1PUAB06D		AMC1PLTLD		AMC1PLTGD		AMC1MAT001D		AMC1MAT006D	
SPECIAL 2	AMC1PUAB06F		AMC1PLTLD		AMC1PLTGD		AMC1MAT001D		AMC1MAT006D	

Coating	HDP	FNC
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**C STATION MATE ULT.STYLE**

Max 50,8mm



item	PUNCH ISODUR	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMC1PUT006T		AMC1PLTMT		AMC1MAT001T		AMC1MAT006T	
STANDARD	AMC1PUT006S		AMC1PLTMS		AMC1MAT001S		AMC1MAT006S	
SPECIAL 0	AMC1PUT006C		AMC1PLTMD		AMC1MAT001D		AMC1MAT006D	
SPECIAL 1	AMC1PUT006D		AMC1PLTMD		AMC1MAT001D		AMC1MAT006D	
SPECIAL 2	AMC1PUT006F		AMC1PLTMD		AMC1MAT001D		AMC1MAT006D	

Coating	HDP	FNC
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Add ons pag.69



**D STATION STANDARD**

Max 88,90mm , Max thickness: 6mm , Grinding life mm: life punch 8 Die 2,5



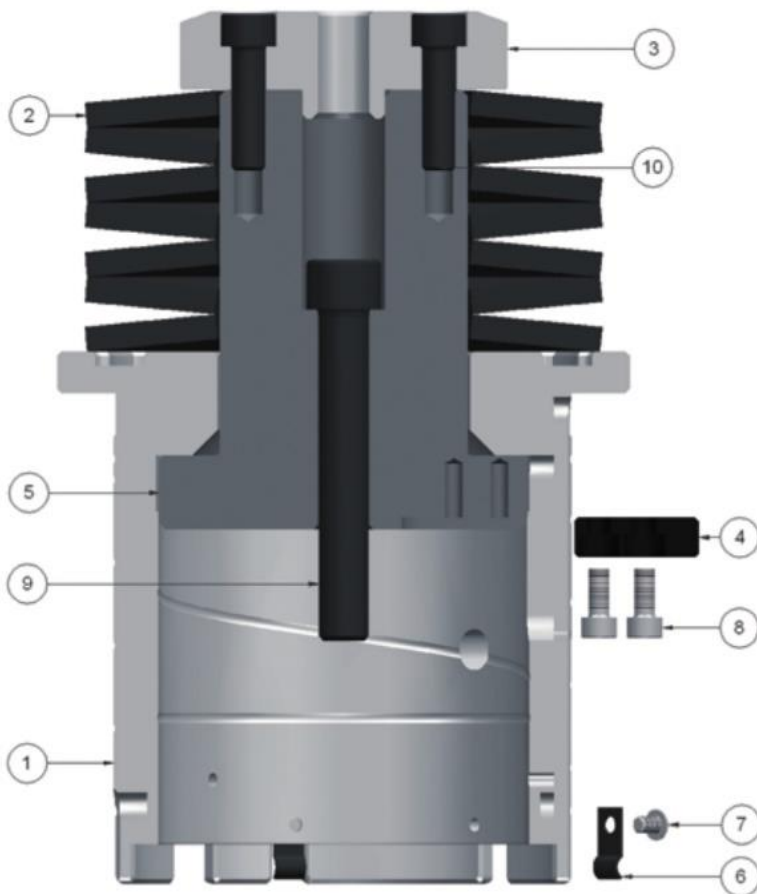
item	PUNCH ISODUR	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€	GUIDE ASSEMBLY STANDARD	€	GUIDE ASSEMBLY ADJUSTABLE LUBR	€
ROUND	AMD1PUT006T		AMD1PLT0T		AMD1MAT001T		AMD1MAT006T		AMD1GAT0		AMD1GALL2	
STANDARD	AMD1PUT006S		AMD1PLT0S		AMD1MAT001S		AMD1MAT006S		AMD1GAT0		AMD1GALL2	
SPECIAL 0	AMD1PUT006C		AMD1PLT0D		AMD1MAT001D		AMD1MAT006D		AMD1GAT0		AMD1GALL2	
SPECIAL 1	AMD1PUT006D		AMD1PLT0D		AMD1MAT001D		AMD1MAT006D		AMD1GAT0		AMD1GALL2	
SPECIAL 2	AMD1PUT006F		AMD1PLT0D		AMD1MAT001D		AMD1MAT006D		AMD1GAT0		AMD1GALL2	

Coating	HDP	FNC
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**D STATION STANDARD**

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

**GUIDE ASSEMBLY STANDARD AMD1GAT0**



Add ons pag.69

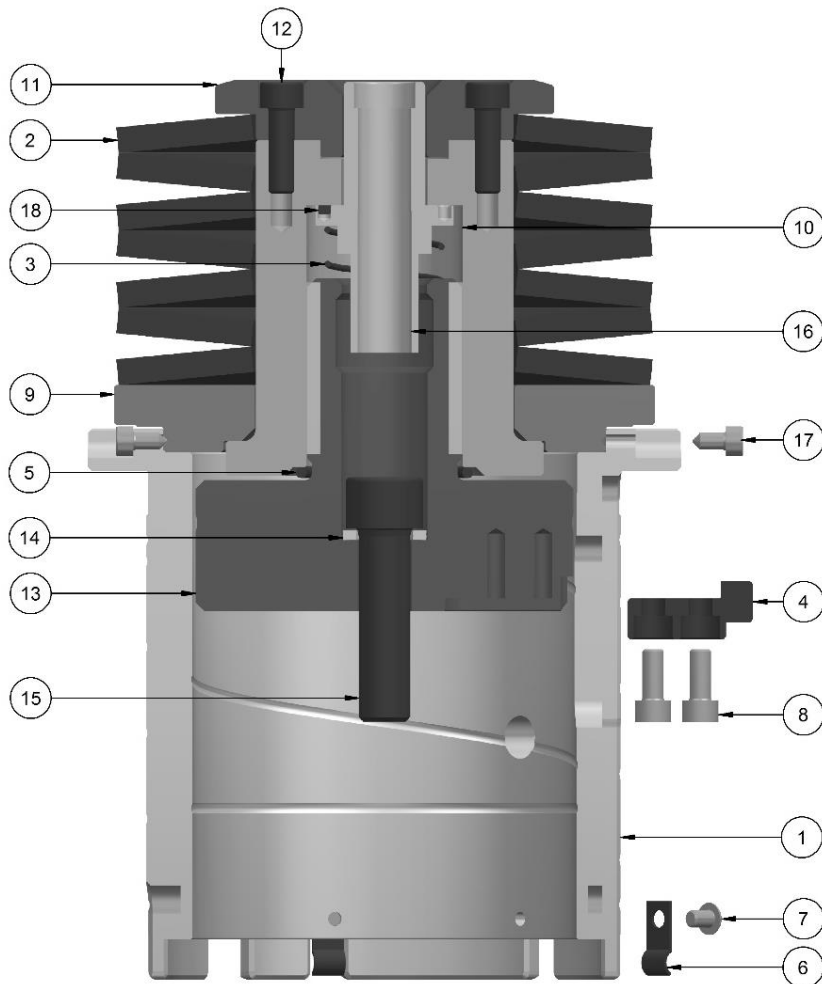




**D STATION STANDARD  
GUIDE ASSEMBLY STANDARD AMD1GALL2  
QUICK ADJUSTABLE LENGTH , WITH  
LUBRICATION**



REF	QTY	COD	DESCRIPTION
18	2	MAMD1G2PAG	WS DIN 9861 D2.7X71
17	2	MAMD1G2FER	SCREW
16	1	MAMD1G2PUL	PUSH BUTTON
15	1	NVI05AR12045	SCREW UNI ISO5931 M12X45
14	2	NRA000000012	ANTI-VIBRATION LOCKING WASHER
13	1	MAMD1G2PER	PUNCH HOLDER
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 5931 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-S2.62
4	1	MAMD1GALLT019	PUNCH HOLDER KEY
3	1	MAMC1G2MOP	SPRING D28X1.5X28
2	7	NMO060012561B	DISC SPRING D125X61X6
1	1	MAMD1G2T01	GUIDE 0-90-135°



FITTINGS					
item	DESCRIPTION	€	DESCRIPTION	€	
	HEX KEY		T-HANDLE EXTRACTOR		
	AMCECHIAVEM12		AMD1G2EST		



**D STATION WILSON STYLE**

Max 88,90mm , Max thickness: 6mm , Grinding life mm: life punch 8 Die 2,5



item	PUNCH ISODUR	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€	GUIDE ASSEMBLY ADJUSTABLE LUBR	€
ROUND	AMD1PUWT06T		AMD1PLWTT		AMD1MAT001T		AMD1MAT006T		AMD1GALLWT2	
STANDARD	AMD1PUWT06S		AMD1PLWTS		AMD1MAT001S		AMD1MAT006S		AMD1GALLWT2	
SPECIAL 0	AMD1PUWT06C		AMD1PLWTD		AMD1MAT001D		AMD1MAT006D		AMD1GALLWT2	
SPECIAL 1	AMD1PUWT06D		AMD1PLWTD		AMD1MAT001D		AMD1MAT006D		AMD1GALLWT2	
SPECIAL 2	AMD1PUWT06F		AMD1PLWTD		AMD1MAT001D		AMD1MAT006D		AMD1GALLWT2	

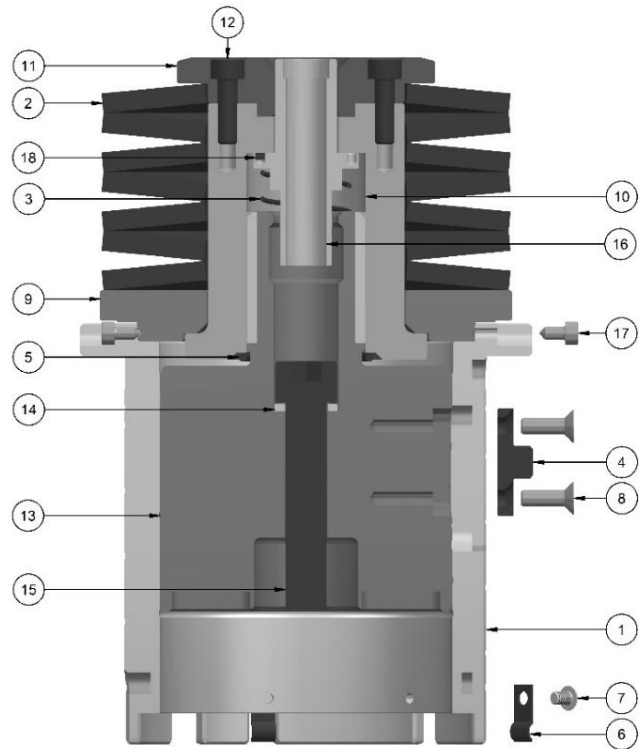
Coating	HDP	FNC
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**D STATION SMART2**

GUIDE ASSEMBLY STANDARD AMD1GALLWT2  
QUICK ADJUSTABLE LENGTH , WITH LUBRICATION



REF	QTY	COD	DESCRIPTION
18	2	MAMD1G2PAG	WS DIN 9861 D2.7X71
17	2	MAMD1G2FER	SCREW
16	1	MAMD1G2PUL	PUSH BUTTON
15	1	NVI900003UNC	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	NVI05AR06020	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	NMO060012561B	DISC SPRING D125X61X6
1	1	MAMD1G2T01	GUIDE 0-90-135°



**FITTINGS**

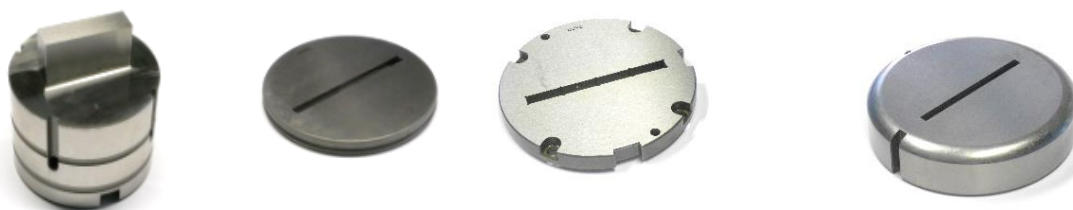
item	HEX KEY	€	T-HANDLE EXTRACTOR	€
	AMCECHIAVE		AMD1G2EST	



**D STATION A.B LUBRICATION STYLE**

Max 88,90mm , Max thickness: 6mm , Grinding life mm: life punch 8 Die 2,5

\*To specify M12 or M14



item	PUNCH* ISODUR	€	STRIPPER ALPHA STYLE	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMD1PUAB06T		AMD1PLTLT		AMD1PLTGT		AMD1MAT001T		AMD1MAT006T	
STANDARD	AMD1PUAB06S		AMD1PLTLS		AMD1PLTGS		AMD1MAT001S		AMD1MAT006S	
SPECIAL 0	AMD1PUAB06C		AMD1PLTLD		AMD1PLTGD		AMD1MAT001D		AMD1MAT006D	
SPECIAL 1	AMD1PUAB06D		AMD1PLTLD		AMD1PLTGD		AMD1MAT001D		AMD1MAT006D	
SPECIAL 2	AMD1PUAB06F		AMD1PLTLD		AMD1PLTGD		AMD1MAT001D		AMD1MAT006D	

Coating	HDP	FNC
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**D STATION MATE ULT. STYLE**

Max 88,90mm



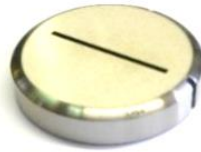
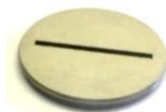
item	PUNCH ISODUR	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
ROUND	AMD1PUT006T		AMD1PLTMT		AMD1MAT001T		AMD1MAT006T	
STANDARD	AMD1PUT006S		AMD1PLTMS		AMD1MAT001S		AMD1MAT006S	
SPECIAL 0	AMD1PUT006C		AMD1PLTMD		AMD1MAT001D		AMD1MAT006D	
SPECIAL 1	AMD1PUT006D		AMD1PLTMD		AMD1MAT001D		AMD1MAT006D	
SPECIAL 2	AMD1PUT006F		AMD1PLTMD		AMD1MAT001D		AMD1MAT006D	

Coating	HDP	FNC
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**E STATION STANDARD**

Max 114,30mm , Max thickness: 6mm , Grinding life mm: life punch 8 Die 2,5



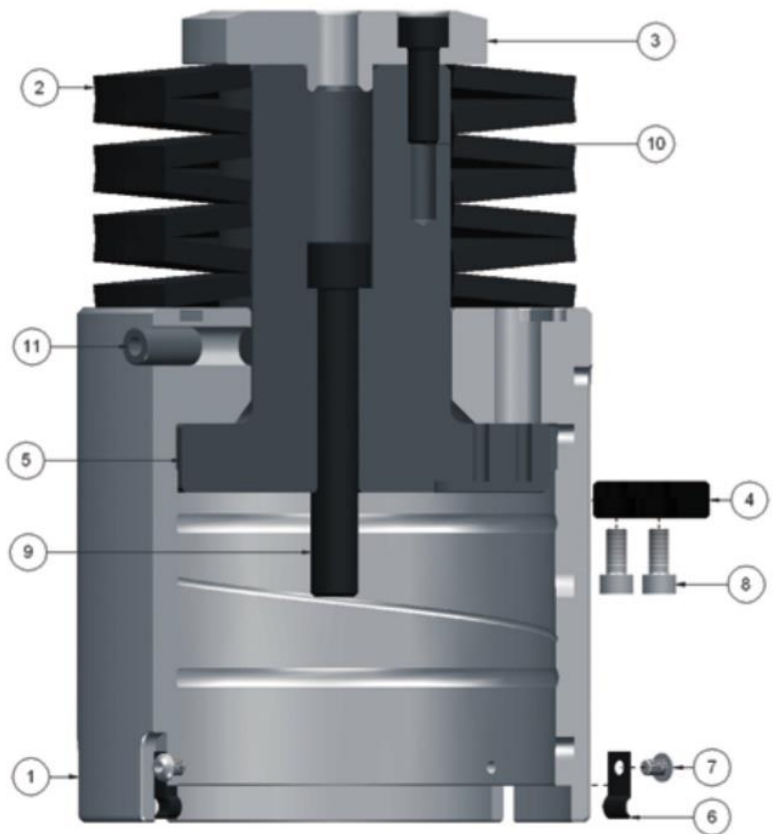
item	PUNCH ISODUR	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€	GUIDE ASSEMBLY STANDARD	€	GUIDE ASSEMBLY ADJUSTABLE LUBR	€
ROUND	AME1PUT006T		AME1PLT0T		AME1MAT001T		AME1MAT006T		AME1GAT0		AME1GALL	
STANDARD	AME1PUT006S		AME1PLT0S		AME1MAT001S		AME1MAT006S		AME1GAT0		AME1GALL	
SPECIAL 0	AME1PUT006C		AME1PLT0D		AME1MAT001D		AME1MAT006D		AME1GAT0		AME1GALL	
SPECIAL 1	AME1PUT006D		AME1PLT0D		AME1MAT001D		AME1MAT006D		AME1GAT0		AME1GALL	
SPECIAL 2	AME1PUT006F		AME1PLT0D		AME1MAT001D		AME1MAT006D		AME1GAT0		AME1GALL	

Coating	HDP	FNC
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**E STATION STANDARD**

**GUIDE ASSEMBLY STANDARD AME1GAT0**

REF	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	4	NVI 00 AR 04006	SCREW UNI ISO 7380M4X6 10.9
6	4	AMCFGAT05	STRIPPER CLIP
5	1	MAME1GAT02	PUNCH HOLDER
4	1	MAMDEGAT04	PUNCH HOLDER KEY
3	1	MAME1GAT03	HEAD
2	7	NMO060012561B	DISC SPRING
1	1	MAME1GAT01	GUIDE 0-90°



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E STATION STANDARD				GUIDE ASSEMBLY STANDARD AME1GALL QUICK ADJUSTABLE LENGTH , WITH LUBRICATION	
REF	QTY	COD	DESCRIPTION		
18	4	NSP00MR10020	ISO8735 UNI6364A		
17	1	NSP060003014	PIN UNI EN28748 Ø3X14		
16	1	MAMD1GALL14	PUSH BUTTON		
15	1	NVI03AR12080	SCREW UNI ISO5931 M12X80		
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 12 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-S2.62		
4	1	MAMD1GALLT019	PUNCH HOLDER KEY		
3	1	NMO04000635000185	SPRING		
2	10	NMO060012551A	DISC SPRING		
1	1	MAME1GAT01	GUIDE 0-90°		

**E STATION AIR BLOW STYLE**  
Max 114,3mm , Max thickness: 6mm , Grinding life mm: life punch 8 Die 2,5

*To specify M12 or M14											
	item	PUNCH*	€	STRIPPER ALPHA STYLE	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€
	ROUND	AME1PUAB06T		AME1PLTLT		AME1PLTGT		AME1MAT001T		AME1MAT006T	
	STANDARD	AME1PUAB06S		AME1PLTLS		AME1PLTGS		AME1MAT001S		AME1MAT006S	
	SPECIAL 0	AME1PUAB06C		AME1PLTLD		AME1PLTGD		AME1MAT001D		AME1MAT006D	
SPECIAL 1	AME1PUAB06D		AME1PLTLD		AME1PLTGD		AME1MAT001D		AME1MAT006D		
SPECIAL 2	AME1PUAB06F		AME1PLTLD		AME1PLTGD		AME1MAT001D		AME1MAT006D		

Coating	HDP	FNC
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**E STATION WILSON STYLE**

Max 114,30mm , Max thickness: 6mm , Grinding life mm: life punch 8 Die 2,5



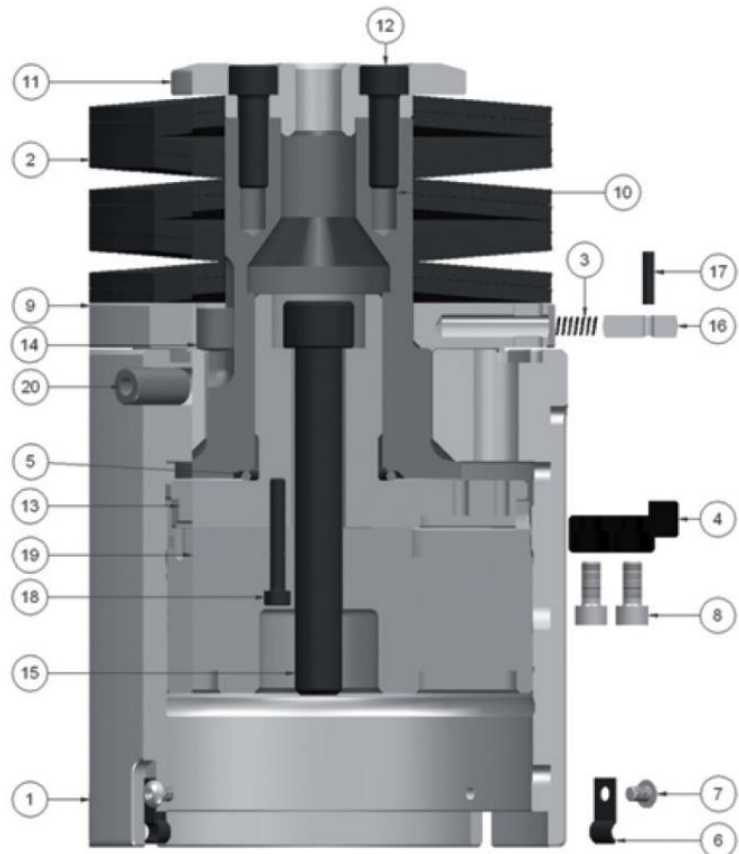
item	PUNCH ISODUR	€	STRIPPER	€	HWS DIE	€	ISODUR DIE	€	GUIDE ASSEMBLY ADJUSTABLE LUBR	€
ROUND	AME1PUWT06T		AME1PLWTT		AME1MAT001T		AME1MAT006T		AME1GALLWT	
STANDARD	AME1PUWT06S		AME1PLWTS		AME1MAT001S		AME1MAT006S		AME1GALLWT	
SPECIAL 0	AME1PUWT06C		AME1PLWTD		AME1MAT001D		AME1MAT006D		AME1GALLWT	
SPECIAL 1	AME1PUWT06D		AME1PLWTD		AME1MAT001D		AME1MAT006D		AME1GALLWT	
SPECIAL 2	AME1PUWT06F		AME1PLWTD		AME1MAT001D		AME1MAT006D		AME1GALLWT	

Coating	HDP	FNC
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**E STATION SMART**

REF	QTY	COD	DESCRIPTION
20	4	NSP00MR10020	ISO8735 UNI6364A
19	1	MAME1GALLWT6	S90 WT ADAPTOR
18	2	NVI03AR04030	SCREW UNI 5933 M4X30
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	NMO04000635000 185	SPRING
2	10	NMO060012551A	DISC SPRING
1	1	MAME1GAT01	GUIDE 0-90°




**GUIDE ASSEMBLY STANDARD AME1GALLWT QUICK ADJUSTABLE LENGTH , WITH LUBRICATION**



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CLOSE TO CLAMP DIES	D STATION				E STATION			
1 SIDE								
	D STATION HWS	€	D STATION ISODUR	€	E STATION HWS	€	E STATION ISODUR	€
	AMD1MATAP1S		AMD1MATAP6S		AME1MATAP1S		AME1MATAP6S	
2 SIDES								
	D STATION HWS	€	D STATION ISODUR	€	E STATION HWS	€	E STATION ISODUR	€
	AMD1MATAP1D		AMD1MATAP6D		AME1MATAP1D		AME1MATAP6D	

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

URETHAN EJECTOR			BRUSH DIE		
	D3	€		A STATION	€
	ES3T0			AMA1MASP	
	D6	€		B STATION	
	ES6T0			AMB1MASP	
D10	€		C STATION		
ES10T0			AMC1MASP		
			D STATION		
			AMD1MASP		
			E STATION		
			AME1MASP		

Plastic material for A and B station , metal for , C D and E station

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SLITTING TOOLS	C STATION	D STATION	E STATION			
<b>BLADE HOLDER , OIL LUBRICATION</b> To specify M12 or M14						
	<b>C STATION PUNCH HOLDER</b> AMC1PPLAT0	€	<b>D STATION PUNCH HOLDER</b> AMD1PPLAT0	€	<b>E STATION PUNCH HOLDER</b> AME1PPLAT0	€
<b>BLADE HSS AND POWDER STEEL METALLURGY</b>						
	<b>HSS BLADE</b> AMC1PULTG06S	€	<b>HSS BLADE</b> AMD1PULTG06S	€	<b>HSS BLADE</b> AME1PULTG06S	€
	<b>PSM BLADE</b> AMC1PULTG02S	€	<b>PSM BLADE</b> AMD1PULTG02S	€	<b>PSM BLADE</b> AME1PULTG02S	€
<b>€ COATING</b>	TICN    HDP    FNC	TICN    HDP    FNC	TICN    HDP    FNC			

SLITTING TOOLS	D STATION	E STATION	E STATION		
<b>DIE HOLDER</b>					
	<b>DIE HOLDER</b> AMD1MAINT2	€	<b>DIE HOLDER</b> AME1MAINT2	€	<b>DIE HOLDER CLOSE TO CLAMP 2 SIDES</b> AME1MAINT2
<b>DIE AVAILABLE SIZE</b>  D STATION 80X5 – 80X6 MAX TH: 1.5 MS – 1.0 SS  E STATION 110X5 – 110X6 MAX TH: 1.5 MS – 1.0 SS					
	<b>DIE</b> TRE1MAT206S	€	<b>DIE</b> AME1IMT2	€	<b>DIE</b> AME1IMT2AP
<b>DIE SHIMS</b>					
	<b>SET SHIMS (0.3 -N.2 0.5 – 1mm)</b> AMD1SETSPMAIN2	€	<b>SET SHIMS (0.3 -N.2 0.5 – 1mm)</b> AME1SETSPMAIN2	€	<b>SET SHIMS (0.3 -N.2 0.5 – 1mm)</b> AME1SETSPMAIN2

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



GRINDING FIXTURE  
THICK TURRET WILSON S90 STYLE  
PUNCH A , B , C , D STATION  
MULTITOOL20- 8 , 10-16 – 6 , 8-2



THICK TURRET STYLE  
AMMOAFF2

€

WILSON STYLE  
AMMOAFF1WT

€

	A STATION	B STATION	C STATION	D STATION	E STATION
PUNCH SHIM					
	(N5 SP2mm) AMA1SETSPPU	(N5 SP2mm) AMB1SETSPPU	(0.3-0.5-1-1.5mm) AMC1SETSPPU	(0.3-0.5-1-1.5mm) AMD1SETSPPU	(0.3-0.5-1-1.5mm) AME1SETSPPU
DIE SHIM					
	(SET 0.5-1-1.5) AMA1SETSPMA	(SET 0.5-1-1.5) AMB1SETSPMA	(SET 0.5-1-1.5) AMC1SETSPMA	(SET 0.5-1-1.5) AMD1SETSPMA	(SET 0.5-1-1.5) AME1SETSPMA

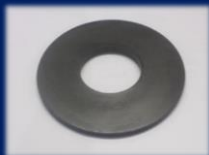
	A STATION ERMAKSAN MT6	A STATION SMART XMTE12.7 XMTE6 B STATION all	A STATION	B STATION	XMTE12.7	MTE6 XMTE6
PUNCH AND DIE PINS						
	AMABSPPUR	AMABSPPU	D4.76X8 NSP02MR47008	D4.76X10 NSP02MR47010	D3X6 NSPM002MR0306	D4X8 NSP02MR0408

TURRET CALIBER	
item	A STATION Single track
	€
AMA1CAAL	
	B STATION Single track
	€
AMB1CAAL	
	C STATION
	€
AMC1CAAL	
	D STATION
	€
AMD1CALL	

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DISC SPRING



DISC SPRING (guide amada standard)	A STATION		B STATION		C STATION		D STATION		E STATION	
		€		€		€		€		€
	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			
2015 DISC SPRING adjustable guide SMART 2					90X46X5 NMO06009046C		125X61X6 NMO060012561B			

STRIPPER CLIPS



STRIPPER CLIP AMCFGAT05 (QTY1)	€
SCREW FOR CLIP NV100AR04006 (QTY1)	€

PUNCH HOLDER KEYS

item	C GUIDE STANDARD & SMART MAMC1GAT04	€	D & E GUIDE STANDARD MAMDEGAT04	€	D & E GUIDE ADJUSTABLE MAMD1GALLT019	€	D GUIDE SMART2 MAMD1G2CHI	€	E GUIDE SMART MAMD1GALLT019	€

FIXTURE EQUIPMENT



item	A , B , C , D and E FIXTURE EQUIPMENT	€
TO ASSEMBLE AND DISASSEMBLE A , B , C , D and E PUNCH ASSEMBLY	AMAAS	



MULTITOOL VULCANO SCHIAVI

6 A



PUNCH HOLDER	€	DIE HOLDER	€	SET	€
AMM6-16SUP		AMM6-16INF		AMM6	

2 A + 2 B



PUNCH HOLDER	€	DIE HOLDER	€	SET	€
AMM4-31.75SUP		AMM4-31.75INF		AMM4	

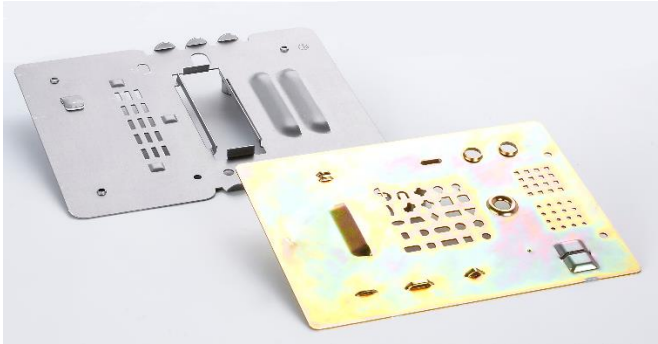
4 B SMART STYLE



PUNCH HOLDER	€	DIE HOLDER	€	SET	€
AMM4B-31.75SUP		AMM4B-31.75INF		AMM4B	



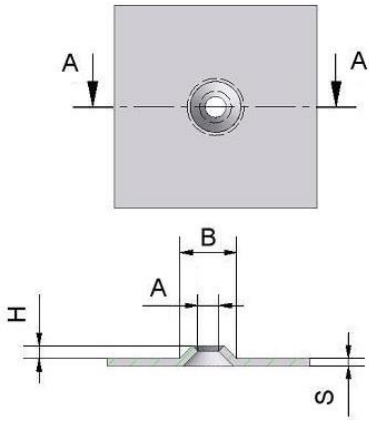
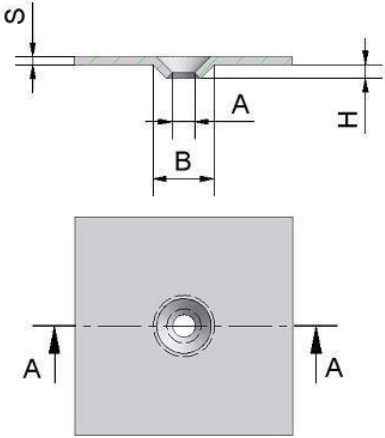
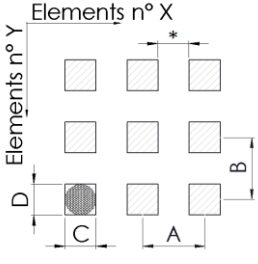
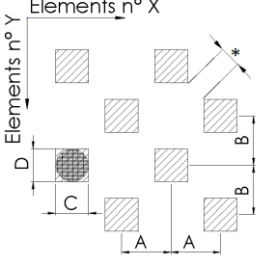
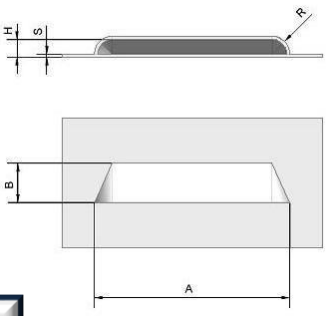
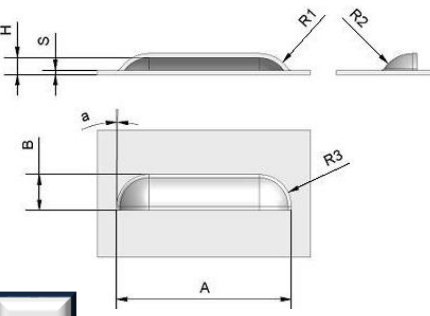
FORMING TOOL REQUEST GUIDE



SKETCH	OPTION 2	TOOL INFORMATION
<p><b>1a</b></p>	<p><b>1b</b></p>	<p><b>COUNTERSINK UP FORM AFTER PRE-PIERCE</b>  <b>THICKNESS: _____ MATERIAL : _____</b></p> <p>A: ____ H: ____ D: ____</p> <p><b>OPTION 2</b>                  A: ____ H: ____ B: ____</p> <p>PREPIERCE DIMENSION: <math>(D_{MAX}-D_{MIN}) * 0.7</math>                  H MAX 85% OF THICKNESS</p>
<p><b>2a</b></p>	<p><b>2b</b></p>	<p><b>EMBOSS ROUND</b>  <b>THICKNESS: _____ MATERIAL : _____</b></p> <p>UP D: ____ H: ____ A: ____ R: ____                  DISTANCE BETWEEN EMBOSES: ____</p> <p><b>OPTION 2 DOWN</b>                  D: ____ H: ____ A: ____ R: ____ S: ____                  DISTANCE BETWEEN EMBOSES: ____</p> <p>SEND A SKETCH IF OTHER FORM WITHIN 50MM OR CLOSE TO SHEET EDGE</p> <p>The presence of many forms within close proximity to one another results in distortion of the sheet.                  The height of the form is limited by the material's capacity for elongation. For this reason it may be necessary to make changes to the original specifications.</p>
<p><b>3a</b></p>	<p><b>3b</b></p>	<p><b>EMBOSS SHAPE</b>  <b>THICKNESS: _____ MATERIAL : _____</b></p> <p>UP B: ____ C: ____ H: ____ A: ____ R: ____                  DISTANCE BETWEEN EMBOSES: ____</p> <p><b>OPTION 2 DOWN</b>                  UP B: ____ C: ____ H: ____ A: ____ R: ____                  DISTANCE BETWEEN EMBOSES: ____</p> <p>SEND A SKETCH IF OTHER FORM WITHIN 50MM OR CLOSE TO SHEET EDGE</p> <p>The presence of many forms within close proximity to one another results in distortion of the sheet.                  The height of the form is limited by the material's capacity for elongation. For this reason it may be necessary to make changes to the original specifications.</p>

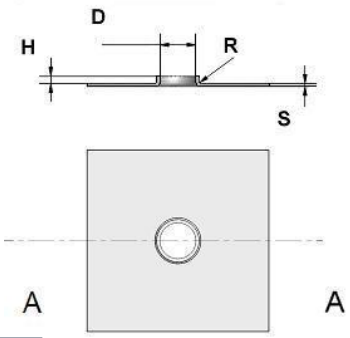
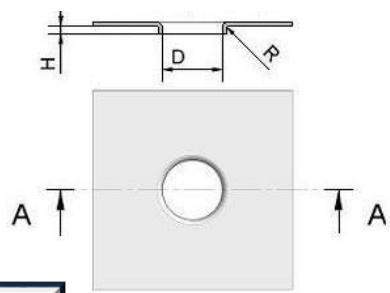
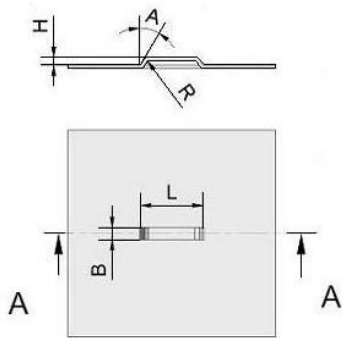
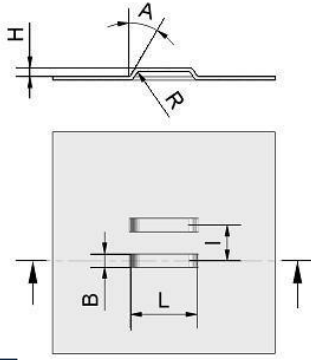
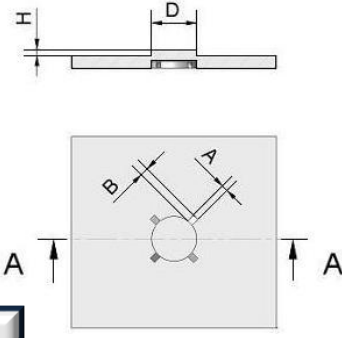
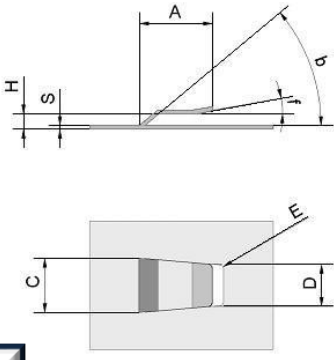


FORMING TOOL REQUEST GUIDE

SKETCH	OPTION 2	TOOL INFORMATION
 <p><b>4a</b></p>	 <p><b>4b</b></p>	<p><b>EMBOSS COUNTERSINK UP FORM AFTER PRE-PIERCE</b>  <b>THICKNESS:</b> _____ <b>MATERIAL :</b> _____  <b>A:</b> _____ <b>B:</b> _____ <b>H:</b> _____ <b>S:</b> _____</p> <p><b>OPTION 2 DOWN FORM</b>  <b>A:</b> _____ <b>B:</b> _____ <b>H:</b> _____ <b>S:</b> _____</p> <p>SEND A SKETCH IF OTHER FORM WITHIN 50MM OR CLOSE TO SHEET EDGE</p>
 <p><b>5a</b></p>	 <p><b>5b</b></p>	<p><b>CLUSTER</b>  <b>THICKNESS:</b> _____ <b>MATERIAL</b> _____  RD <input type="checkbox"/> SQUARE <input type="checkbox"/> RECT. <input type="checkbox"/> OBR. <input type="checkbox"/> HEX <input type="checkbox"/></p> <p><b>PATTERN 1</b>  <b>A:</b> _____ <b>B:</b> _____ <b>C:</b> _____ <b>Dø:</b> _____  <b>N ELEMENTS X:</b> _____ <b>Y:</b> _____</p> <p><b>PATTERN 2</b>  <b>A:</b> _____ <b>B:</b> _____ <b>C:</b> _____ <b>Dø:</b> _____</p> <p><small>*minimum distance between holes 2.5 x thickness  We STRONGLY recommend that you avoid punching holes more than once , USE A SINGLE TOOL for the final holes if the total number of holes to be punched is not a multiple of the number of punches in the cluster. Re-punching a previously punched hole dramatically reduces tool lifespan.</small></p>
<p><b>TRUMPF DESIGN</b></p>  <p><b>6a</b></p>	<p><b>THICK TURRET DESIGN</b></p>  <p><b>6b</b></p>	<p><b>LOUVER</b>  <b>THICKNESS:</b> _____ <b>MATERIAL :</b> _____  <b>TRUMPF DESIGN 60X12</b>  <b>A:60 B:12 H:5.5 S:0.8 – 2.5</b>  <b>SPACING X 18mm Y 70mm</b></p> <p><b>OPTION 2 CUSTOMIZED DESIGN:</b>  <b>THICK TURRET STANDARD SIZE</b>  <b>75X15 – 85X15 – 50X10 H5</b>  <b>A:</b> _____ <b>B:</b> _____ <b>H:</b> _____ <b>S:</b> _____  <b>Radius not strictly required</b></p> <p>SEND A SKETCH IF OTHER FORM WITHIN 50MM OR CLOSE TO SHEET EDGE</p>



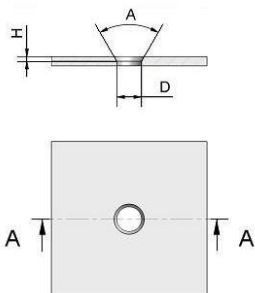
FORMING TOOL REQUEST GUIDE

SKETCH	OPTION 2	TOOL INFORMATION
 <p><b>7a</b></p>	 <p><b>7b</b></p>	<p><b>EXTRUSION</b>                      THICKNESS: _____ MATERIAL : _____                      D: ____ H: ____ R: ____ S: ____  <b>OPTION 2 DOWN FORM</b>                      D: ____ H: ____ R: ____                      H MAX 2.5 TIMES THICKNESS                      SEND A SKETCH IF OTHER FORM WITHIN 50MM OR CLOSE TO SHEET EDGE</p>
 <p><b>8a</b></p>	 <p><b>8b</b></p>	<p><b>BRIDGE</b>                      THICKNESS: _____ MATERIAL : _____                      B: ____ L: ____ H: ____ A: ____ R: ____  <b>OPTION 2 DOUBLE BRIDGE</b>                      B: ____ L: ____ H: ____ A: ____ R: ____ I: ____                      SEND A SKETCH IF OTHER FORM WITHIN 50MM OR CLOSE TO SHEET EDGE</p>
 <p><b>9</b></p>		<p><b>SHEAR BUTTON , KNOCK OUT</b>                      THICKNESS: _____ MATERIAL : _____                      D: ____ H: ____ A: ____ B: ____                      A,B not strictly required                      SEND A SKETCH IF OTHER FORM WITHIN 50MM OR CLOSE TO SHEET EDGE</p>
 <p><b>10</b></p>		<p><b>LANCE</b>                      THICKNESS: _____ MATERIAL : _____                      C: ____ D: ____ E: ____ A: ____ H: ____                      S: ____ f: ____ b: ____                      SEND A SKETCH IF OTHER FORM WITHIN 50MM OR CLOSE TO SHEET EDGE.</p>

COUNTERSINK DOWN



Customer data  
 Machine \_\_\_\_\_  
 Material \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Order \_\_\_\_\_ Offer \_\_\_\_\_  
 A= \_\_\_\_\_ D= \_\_\_\_\_ H= \_\_\_\_\_  
 Order with pre.pierce tool:  
 YES/NO  
 Pre-pierce value:  
 $D_{max} - [(D_{max} - D_{min}) \times 0,7]$



Note and drafts.  
 Specify here the distance of any close deformation



COUNTERSINK DATA

DIN EN ISO 10642 (hexagon socket)

Screw	Upper Ø	Thickness
M3	d7.1	1-3mm
M4	d9.4	1.5-3mm
M5	d11.7	1.5-4mm
M6	d14	2-4mm
M8	d18.5	2-4mm

COUNTERSINK DATA

DIN EN ISO 2009 and 7046-1

Screw	Upper Ø	Thickness
M2.5	D5.9	1-3mm
M3	D6.7	1-3mm
M4	D8.8	1.5-3mm
M5	d10.6	1.5-4mm
M6	d12.7	2-4mm
M8	d16.7	2-4mm



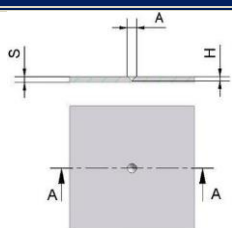
B original old style

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 Dmax19 Thickness 0,5-4 Original old style	AMB1LLGIO €	AMB1GUT0T €	-	AMB1PUT006D €	-	AMB1MAT001T €
B SMART station Dmax19 Thickness 0,5-3	AMB1LLGIOPE €	AMB1GUUN2T €	AMB1PLWTT €	AMB1IPLNL6D €	-	AMB1MAT001T €
B SMART with repl.inserts Dmax12 Thickness 0,5-3	AMB1LLGIOPE €	AMB1GUUN2T €	AMB1PLWTT €	FLAMB09W2IP €	FLAMB09W2PP €	AMB1MAT001T €

FORM DOWN MARKING TOOL



Customer data  
 Machine \_\_\_\_\_  
 Material \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Order \_\_\_\_\_ Offer \_\_\_\_\_  
 A= \_\_\_\_\_  
 S= \_\_\_\_\_  
 H= \_\_\_\_\_



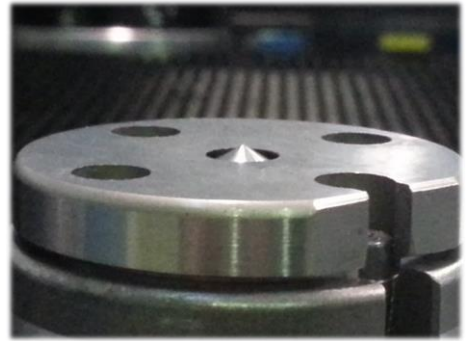
item	PUNCH ASSEMBLY	€	DIE HD	€	SET
A station	FLAMA23PA		AMA1MATP01D		
B station	FLAMB23PA		AMB1MATP01D		



ENGRAVING AND DEBURRING TOOL



Material: \_\_\_\_\_ Thickness: \_\_\_\_\_



Widia and copper tool UPPER KIT



Deburring sphere Upper kit



Die with sphere

item	PUNCH HOLDER	€	MARKING UPPER KIT	€	DEBURRING UPPER SPHERE KIT	€	DIE WITH SPHERE	€
<b>B STATION</b>	FLAMB38PA		FLAMB38MK		FLAMB38DK		FLAMB38MA	



**Tool Holder Kit:**

- Insert the Widia tool in the punch holder
- Put the elastic pin in the hole with the right side of the tool
- The holder kit is ready



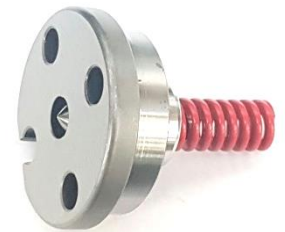
**Tool Holder Kit:**

- Insert the copper tool in the punch holder
- Put the elastic pin in the hole
- The holder kit is ready



**Spring load:**

- Blu spring: 2,1 Kg/mm
- Red spring: 3,6 Kg/mm
- Green spring: 7,1 Kg/mm



**Assembly:**

- Insert the holder kit in the locking ring
- Put the spring on the rear of the holder kit
- Put all the assembled into the guide
- Fit it on the guide with the screw

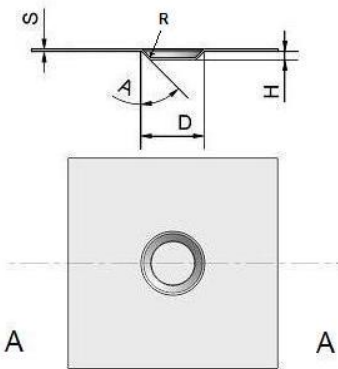




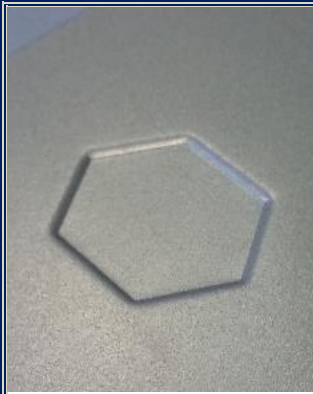
**EMBOSS DOWN**



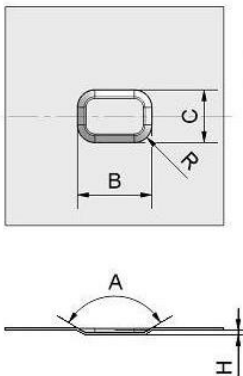
Customer data  
 Machine \_\_\_\_\_  
 Material \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Order \_\_\_\_\_ Offer \_\_\_\_\_  
 A= \_\_\_\_\_ D= \_\_\_\_\_ S= \_\_\_\_\_  
 H top to top = \_\_\_\_\_ R= \_\_\_\_\_



Note and drafts.  
 Specify here the distance of any close deformation



Customer data  
 Machine \_\_\_\_\_  
 Material \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Order \_\_\_\_\_ Offer \_\_\_\_\_  
 Shape \_\_\_\_\_  
 A= \_\_\_\_\_ B= \_\_\_\_\_ C= \_\_\_\_\_  
 H top to top = \_\_\_\_\_ R= \_\_\_\_\_



Note and drafts.  
 Specify here the distance of any close deformation

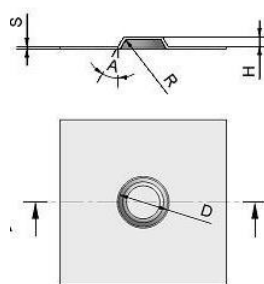
<b>ROUND</b>	<b>item</b>	<b>ECONO LINE</b>	€	<b>DIE</b>	€	<b>SET</b>
<b>B station ROUND</b>		<b>PUNCH ASSEMBLY</b>				
		FLAMB05PA 0-25mm		FLAMB05M		
<b>C station ROUND</b>		FLAMC05PA 25.1-50mm		FLAMC05M		
<b>D station ROUND</b>		FLAMD05PA 50,1-80mm		FLAMD05M		
<b>SHAPE</b>	<b>item</b>	<b>ECONO LINE</b>	€	<b>DIE</b>	€	<b>SET</b>
<b>B station SHAPE</b>		<b>PUNCH ASSEMBLY</b>				
		FLAMB06PA 0-25mm		FLAMB06M		
<b>C station SHAPE</b>		FLAMC06PA 25.1-50mm		FLAMC06M		
<b>D station SHAPE</b>		FLAMD06PA 50,1-80mm		FLAMD06M		



EMBOSS UP



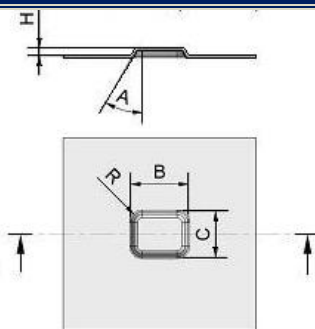
Customer data  
 Machine \_\_\_\_\_  
 Material \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Order \_\_\_\_\_ Offer \_\_\_\_\_  
 A= \_\_\_\_\_ D= \_\_\_\_\_ S= \_\_\_\_\_  
 H top to top = \_\_\_\_\_ R= \_\_\_\_\_



Note and drafts.  
 Specify here the distance of any close deformation



Customer data  
 Machine \_\_\_\_\_  
 Material \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Order \_\_\_\_\_ Offer \_\_\_\_\_  
 A= \_\_\_\_\_ B= \_\_\_\_\_ C= \_\_\_\_\_  
 H top to top = \_\_\_\_\_ R= \_\_\_\_\_



Note and drafts.  
 Specify here the distance of any close deformation



**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

ECONO LINE solid punch and solid die



SMART LINE replaceable parts , die with springs



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

Add ons pag.69



EXTRUSION ROUND UP



	<p>Customer data</p> <p>Machine _____</p> <p>Material _____</p> <p>Thickness _____</p> <p>Order _____ Offer _____</p> <p>D= _____ H= _____</p> <p>S= _____ R= _____</p> <p>FNC coating ____YES/NO</p>		<p>Note and drafts.</p> <p>Specify here the distance of any close deformation</p>	
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Extrusion according to DIN7952

THREAD SIZE	PRE-PUNCH DIAMETER	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

	<p><b>Option 2</b> B station single extrusion 1 hit up forming</p>		<p><b>Option 3</b> D station cluster extrusion 1 hit up forming</p>
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item	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B Station 0-15mm	FLAMB12PA		FLAMB12MA		
C Station 15,1-40mm	FLAMC12PA		FLAMC12MA		
D Station 40,1-60mm	FLAMD12PA		FLAMD12MA		
<b>SPARES</b>	<b>B STATION</b>	<b>€</b>	<b>C STATION</b>	<b>€</b>	<b>D STATION</b>
Upper die	FLAMB03IMS		FLAMC03IMS		FLAMD03IMS
Lower punch	FLAMB12IP		FLAMC12IP		FLAMD12IP
Coating FNC					

Add ons pag.69



CLUSTER

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

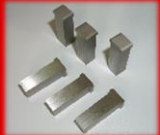
DIE



MATERIAL:  
HWS and  
ISODUR

ROUND  
LOCK SLUG AS

REPLACEABLE PUNCHES



MATERIAL:  
ISODUR  
OPTION PSM

COATINGS



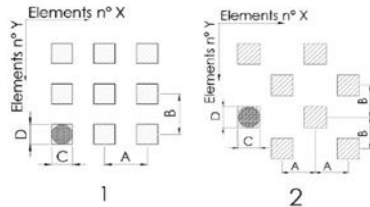
COATING  
AVAILABLE:  
HDP , FNC

C , D , E station cluster data



CUSTOMER INFORMATIONS

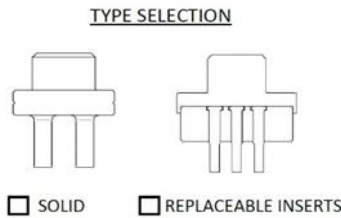
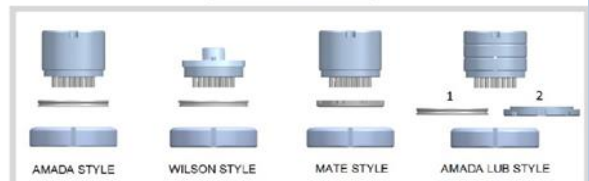
Name : \_\_\_\_\_ Telephone n. : \_\_\_\_\_  
 Machine Model : \_\_\_\_\_ Fax : \_\_\_\_\_  
 Material Type : \_\_\_\_\_ Email : \_\_\_\_\_  
 Material Thickness : \_\_\_\_\_ Address : \_\_\_\_\_



PUNCH DIMENSIONS (mm)

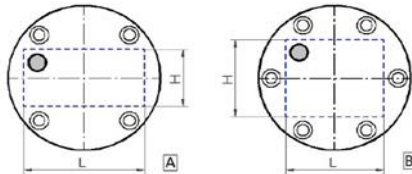
A= \_\_\_\_\_ Round: \_\_\_\_\_ Shape: \_\_\_\_\_  
 B= \_\_\_\_\_ Pattern: \_\_\_\_\_ 1 / 2  
 C= \_\_\_\_\_ Nx= \_\_\_\_\_ Ny= \_\_\_\_\_  
 D= \_\_\_\_\_ TICN Coating: \_\_\_\_\_ YES / NO

MODEL SELECTION



AMADA LUB STYLE model is available with OLD STYLE (1) or AIR BLOW stripper plate (2).

MAX PUNCHING AREA



	SOLID	REPLACEABLE				
		DIAM. [mm]	A		B	
			L [mm]	H [mm]	L [mm]	H [mm]
C STATION	∅50,8	36	17	40	15	
D STATION	∅88,9	70	35	55	45	
E STATION	∅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.

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

ORDERING SPECIFICATIONS

Order \_\_\_\_\_ Offer \_\_\_\_\_

Item required: \_\_\_\_\_

Number of previous order: \_\_\_\_\_



Data:  
 Minimum size 1.5 x thickness  
 Minimum distance between rounds 2.5 thickness  
 If size C <30mm minimum distance between shapes 3 time thickness  
 if size C >30mm minimum distance between shapes 4 time thickness

Item		B station	Fixed value	€ qty	C station	Fixed value	€ qty	D station	Fixed value	€ qty	E station	Fixed value	€ qty
SOLID PUNCH STYLE	OLD STYLE	AMB1PUT006M		∅ S	AMC1PUT006M		∅ S	AMD1PUT006M		∅ S	AME1PUT006M		∅ S
	A.B.OIL System	AMB1PUAB06M		∅ S	AMC1PUAB06M		∅ S	AMD1PUAB06M		∅ S	AME1PUAB06M		∅ S
	ULTRAT. STYLE	AMB1PLLN6M		∅ S	AMC1PUT006M		∅ S	AMD1PUT006M		∅ S	AME1PUT006M		∅ S
	WILSON STYLE	AMB1IPS9006M (S90) AMB1IPWT06M (WLS)		∅ S	AMC1PUWT06M		∅ S	AMD1PUWT06M		∅ S	AME1PUWT06M		∅ S
REPLACEABLE PUNCH STYLE	OLD STYLE	-			FLAMC21P		∅* S**	FLAMD21P		∅* S**	FLAME21P		∅ S
	A.B.OIL System	-			FLAMC21PAB		∅* S**	FLAMD21PAB		∅* S**	FLAME21PAB		∅ S
	ULTRAT. STYLE	-			FLAMC21P		∅* S**	FLAMD21P		∅* S**	FLAME21P		∅ S
	WILSON STYLE	-			FLAMC21WP		∅* S**	FLAMD21WP		∅* S**	FLAME21WP		∅ S
STRIPPER	OLD STYLE	AMB1PLWTM		∅ S	AMC1PLT0M		∅ S	AMD1PLT0M		∅ S	AME1PLT0M		∅ S
	WILSON STYLE	AMB1PLWTM		∅ S	AMC1PLWTM		∅ S	AMD1PLWTM		∅ S	AME1PLWTM		∅ S
	A.B.OIL system	AMB1PLABM		∅ S	AMC1PLTGM		∅ S	AMD1PLTGM		∅ S	AME1PLTGM		∅ S
	ULTRAT.STYLE	AMB1PLWTM		∅ S	AMC1PLTMM		∅ S	AMD1PLTMM		∅ S	AME1PLTMM		∅ S
DIE	HWS	AMB1MATP01M		∅ S	AMC1MAT001M		∅ S	AMD1MAT001M		∅ S	AME1MAT001M		∅ S
	HP DIE	AMB1MATP06M		∅ S	AMC1MAT006M		∅ S	AMD1MAT006M		∅ S	AME1MAT006M		∅ S
ADD +10% DIE SIZE <3.1mm, ADD +10% STRIPPER SIZE <3.1mm, ADD +15% DIE SPECIAL 0-1-2, ADD +15% STRIPPER SPECIAL 0-1-2 ADD + 20% DIE PERIMETER> 50mm ADD +15% D STATION RENFORCED DIE ADD € + € x qty PUNCH SOLID STYLE, ADD € x qty SPEC.0, ADD € x qty SPEC.1, ADD € x qty SPEC.2 PUNCH REPL.													

E station prices on demand

\*

ROUND size mm	2-3-4-5-6-7-8	10-12	15	Decimal value ex 3.2 max11,9
Add each ∅	€	€	€	€
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	€	€	€	€

Coating

DIAGONAL size mm	2-8	8.1-12	12.1-15	15.1-25
HDP each ∅	€	€	€	€
FNC each ∅	€	€	€	€

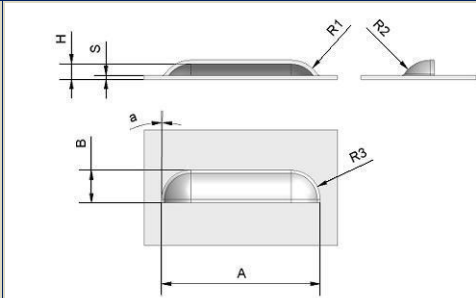
Add ons pag.69



LOUVER

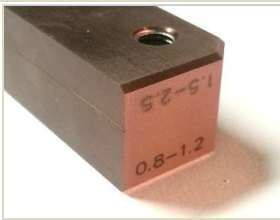


Customer data  
 Machine \_\_\_\_\_  
 Material \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Order \_\_\_\_\_ Offer \_\_\_\_\_  
 A= \_\_\_\_\_ B= \_\_\_\_\_ H= \_\_\_\_\_ S= \_\_\_\_\_  
 a=\* \_\_\_\_\_ R1=\* \_\_\_\_\_ R2=\* \_\_\_\_\_ R3=\* \_\_\_\_\_  
 HDP coating \_\_\_\_\_ YES  
 \*not strictly required  
 STD size  
 C 50x10 H5 , D75x15 85x15 H6



Note and drafts.  
 Specify here the distance of any close deformation

Minimum distance between louvers: X \_\_\_\_\_ Y \_\_\_\_\_



D station punch assembly  
 Standard size 75x15 and 85x15

D station die assembly  
 HDP coating

D station blade HDP coating

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

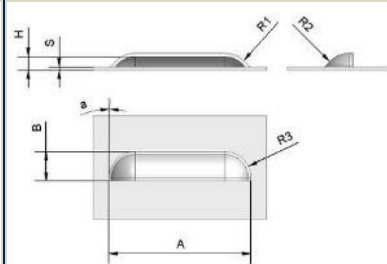
Louver upper pocket

item	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B Station	FLAMB14PA		FLAMB14MA		
C Station std size 50x10mm	FLAMC14PA		FLAMC14MA		
C Station special size	FLAMC14CPA		FLAMC14CMA		
D Station std size 75x15mm	FLAMD14APA		FLAMD14AMA		
D Station std size 85x15mm	FLAMD14BPA		FLAMD14BMA		
D Station special size max L 90mm	FLAMD14CPA		FLAMD14CMA		
E station special size max L 115mm	FLAME14PA		FLAME14MA		

CONTINUOUS LOUVER



Customer data  
 Machine \_\_\_\_\_  
 Material \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Order \_\_\_\_\_ Offer \_\_\_\_\_  
 A= ∞  
 B= \_\_\_\_\_ H= \_\_\_\_\_ S= \_\_\_\_\_  
 R1=\* \_\_\_\_\_ R2=\* \_\_\_\_\_ R3=\* \_\_\_\_\_  
 \*not strictly required  
 HDP coating \_\_\_\_\_ YES



Minimum distance between louvers: \_\_\_\_\_


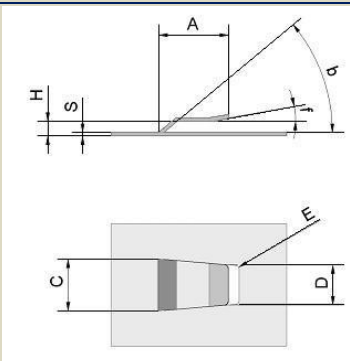

Note and drafts.  
 Specify here the distance of any close deformation



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




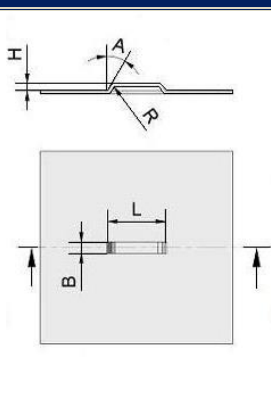
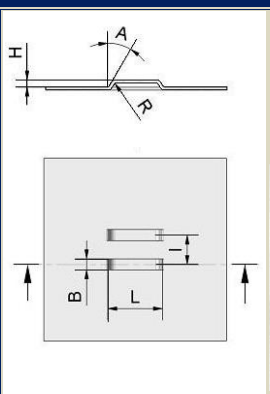

LANCE UP

	Customer data Machine _____ Material _____ Thickness _____ Order _____ Offer _____ A= _____ C= _____ D= _____ E=* _____ H= _____ b= _____ f= _____ *not strictly required		Note and drafts. Specify here the distance of any close deformation	

				
2 BENDS	3 BENDS	REINFORCED	SPECIAL	SNAPLOCK STYLE

item	B STATION MAX A = 15mm	€	B STATION MAX A = 15mm	€	C STATION MAX A = 40mm	€	C STATION MAX A = 40mm	€
	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

	Customer data Machine _____ Material _____ Thickness _____ Order _____ Offer _____ Single / Double _____ B= _____ L= _____ H= _____ A= _____ l= _____ R*= _____ *not strictly required  B minimum: 1.5 x thickness (MS) 2 x thickness (SS)			Note and drafts. Specify here the distance of any close deformation	

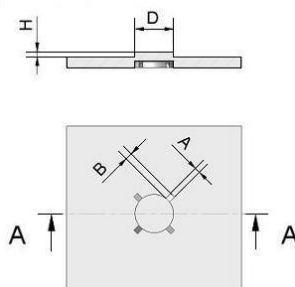
item	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B Station single	FLAMB17PA 0-20mm		FLAMB17MA 0-20mm		
C Station single	FLAMC17PA 20.1-40mm		FLAMC17MA 20.1-40mm		
B Station double	FLAMB18PA 0-20mm		FLAMB18PA 0-20mm		
C Station double	FLAMC18PA 20.1-40mm		FLAMC18PA 20.1-40mm		



**KNOCK-OUT UP**



Customer data  
 Machine \_\_\_\_\_  
 Material \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Order Offer \_\_\_\_\_  
 A= \_\_\_\_\_ D= \_\_\_\_\_  
 H= \_\_\_\_\_ B= \_\_\_\_\_



Note and drafts.  
 Specify here the distance of any close deformation

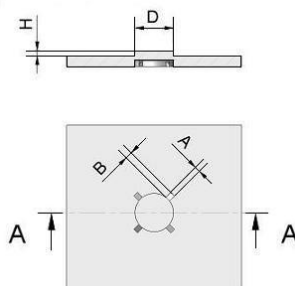


Item	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B station	FLAMB15PA 0-15mm		FLAMB15MA 0-15mm		
C station	FLAMC15PA 15.1-45mm		FLAMC15MA 15.1-45mm		
D station	FLAMD15PA 45.1-65mm		FLAMD15MA 45.1-65mm		
E station	FLAME15PA 65.1-85mm		FLAME15MA 65.1-85mm		

**KNOCK-OUT DOWN**



Customer data  
 Machine \_\_\_\_\_  
 Material \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Order Offer \_\_\_\_\_  
 A= \_\_\_\_\_ D= \_\_\_\_\_  
 H= \_\_\_\_\_ B= \_\_\_\_\_



Note and drafts.  
 Specify here the distance of any close deformation



Item	PUNCH ASSEMBLY	€	DIE ASSEMBLY (with ejector)	€	SET
B station punch assembly , die with ejector	FLAMB27PA		FLAMB27MA		
	PUNCH	€	STRIPPER	€	SET
C station set punch , stripper , die with ejector	AMC1PUT006C		AMC1PLT0T		
D station set punch , stripper , die with ejector	AMD1PUT006C		AMD1PLT0T		
E station set punch , stripper , die with ejector	AME1PUT006C		AME1PLT0T		





**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 1mm size 4 – 5 – 6  
 Thickness 1.5mm 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		

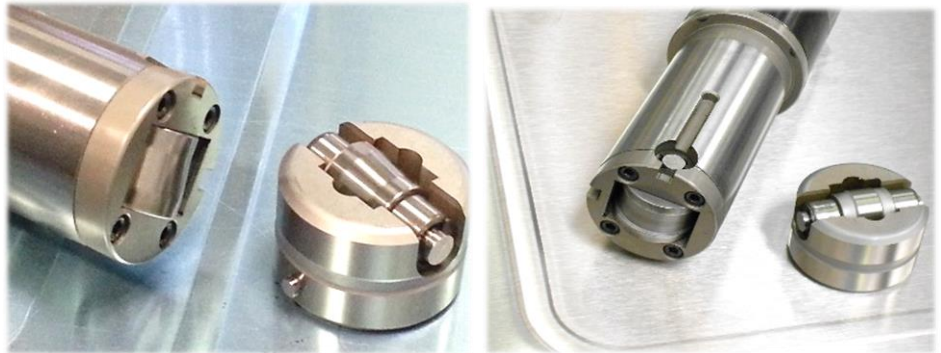
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OFFSET AND RIB TOOL



Max thickness:  
2mm AL , MS  
1.5mm SS  
Min thickness all mat. 0.8mm



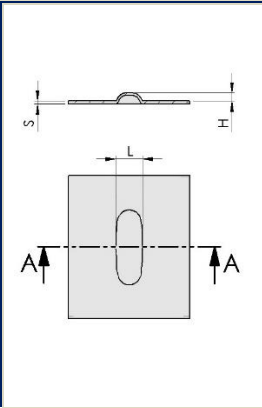
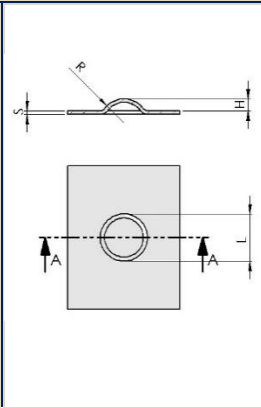
item	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B STATION	FLAMB35PA		FLAMB35MA		

BEADING TOOL  
EMBOSS CONTINUOUS / OFFSET



Customer data  
Machine \_\_\_\_\_  
Material \_\_\_\_\_  
Thickness \_\_\_\_\_  
Order \_\_\_\_\_ Offer \_\_\_\_\_  
Sphere / Obround  
H= \_\_\_\_\_ L= \_\_\_\_\_ R\*= \_\_\_\_\_  
\*not strictly required

Material thickness 0.8-3mm  
Beading height: 2, 3, 4, 5 mm  
Feed 1 – 2 mm



Note and drafts.  
Specify here the distance of  
any close deformation



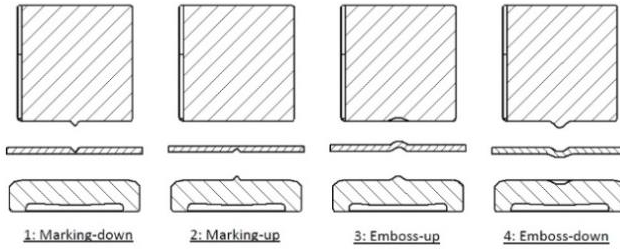
item	PUNCH ASSEMBLY	€	DIE ASSEMBLY	€	SET
B STATION ECONO LINE	FLAMB34PA		FLAMB34MA		
C STATION ECONO LINE	FLAMC34PA		FLAMC34MA		



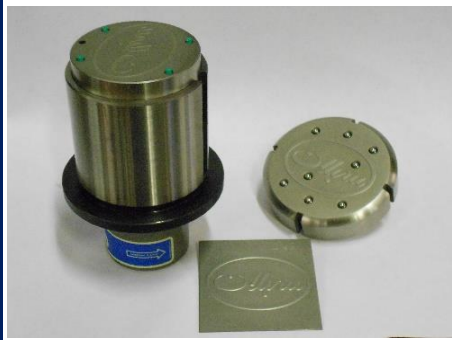
LOGO



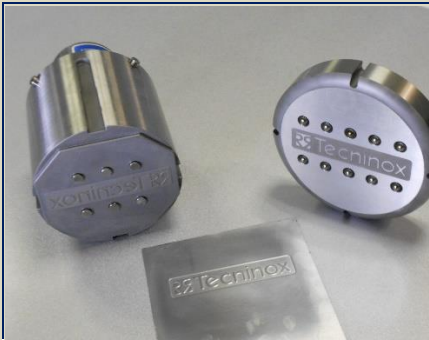
Customer data  
 Machine \_\_\_\_\_  
 Material \_\_\_\_\_  
 Thickness \_\_\_\_\_  
 Order \_\_\_\_\_ Offer \_\_\_\_\_  
 Logo type 1 / 2 / 3 / 4  
 marking depth 0.4-0.6  
 Send dxf,dwg logo file



Note and drafts.  
 Specify here the distance of any close deformation



Punch assembly Smart style replaceable upper die



Puch assembly Econo line style



Marked logo tool econo line style  
 From the top



Marked logo tool econo line style  
 From the bottom



Digital marking



Punch assembly smart style replaceable character

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



**ORDER FORM**

COMPANY:	ORDER / INQUIRY:	MODEL:	DATE:

ITEM	CODE	QTY	SHAPE	SIZE (mm)	DIE CL. (a)	DIE SIZE (b)	OPTION SHEAR	OPTION COATING	THICKNESS (mm) (c)	MATERIAL (d)
<div style="border: 1px solid black; padding: 5px; display: inline-block;">How to order a die :</div>										
DIE	AMB1MAT001S	1	S2 RECT			20.2X10.2				
DIE	AMB1MAT001S	1	S2 RECT	20X10					1.0	MS
DIE	AMB1MAT001S	1	S2 RECT	20X10	0.2					
<div style="border: 1px solid black; padding: 5px; display: inline-block;">How to order a punch :</div>										
PUNCH	AMA1PUT006T	10	T ROUND	10			V	TICN		


FACSIMILE OF ORDER

T C=	A=	A= R=	A= B=	A= B= R=	A=	A=	A= B= R=	A= C=	A= B=	A= B= C=	A= B=	A= C=	A= C=	A= B= C=
										D=				





- a) If you know the clearance fill this column
- b) To fill this column when you know size of die included die clearance
- c) You have to specify thickness in the case that we have to calculate die clearance
- d) You have to specify material in the case that we have to calculate die clearance:  
MS=mild steel , GA=galvanized steel , AL=aluminum , SS = stainless steel , CO=copper




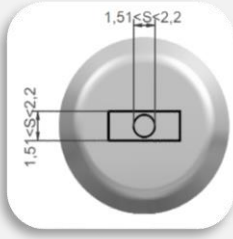


Add on:

Shear option					
					
Type of shear	Roof top	Inverted roof top	Double valley	Whisper*	Four ways
When	Best option when punching force is high , minimum feed 75% of tool lenght	Recommended for nibbling at maximum tonnage But inverted stress could cause breakage	Recommended when punch is longer than 80mm But inverted stress could cause breakage	Best option classic trumpf style to reduce noise and tonnage , max5°	Recommended for punching and nibbling $\varnothing$ and square at maximum tonnage
Code	Cod V	Cod VR	Cod 3P	Cod W	Cod 4P
Add on					

\*only blanking

				
Add on	Die lock slug	Extra Key slot Dies C-D-E std 0-90 sq 0-135° additional key Punch C-D-E	Back taper punch / Jump station +20%	Reduced milled land
When	Best option to prevent the come out of the slug	Special , station without rotation	Recommended for punching thick material , more than 4mm. Needful with punches that work with urethane	To facilitate the fall of the slug; recommended when long side is more than 20 times short side, ex re22x1

				
Add on	Die clearance $< 0.1$ +25%	Punch width size $< 1.5$ +25%	Die size $< 1.5$ +25%	$1,51 < Die\ size < 2,2$ +10%
When				

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## Sales condition

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

### **Delivery :**

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

**Minimum invoice value : €100**

### **Payment :**

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

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

### **Cancellation , returns and complains :**

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

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

### **Credit :**

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



notes

Lined area for notes.





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