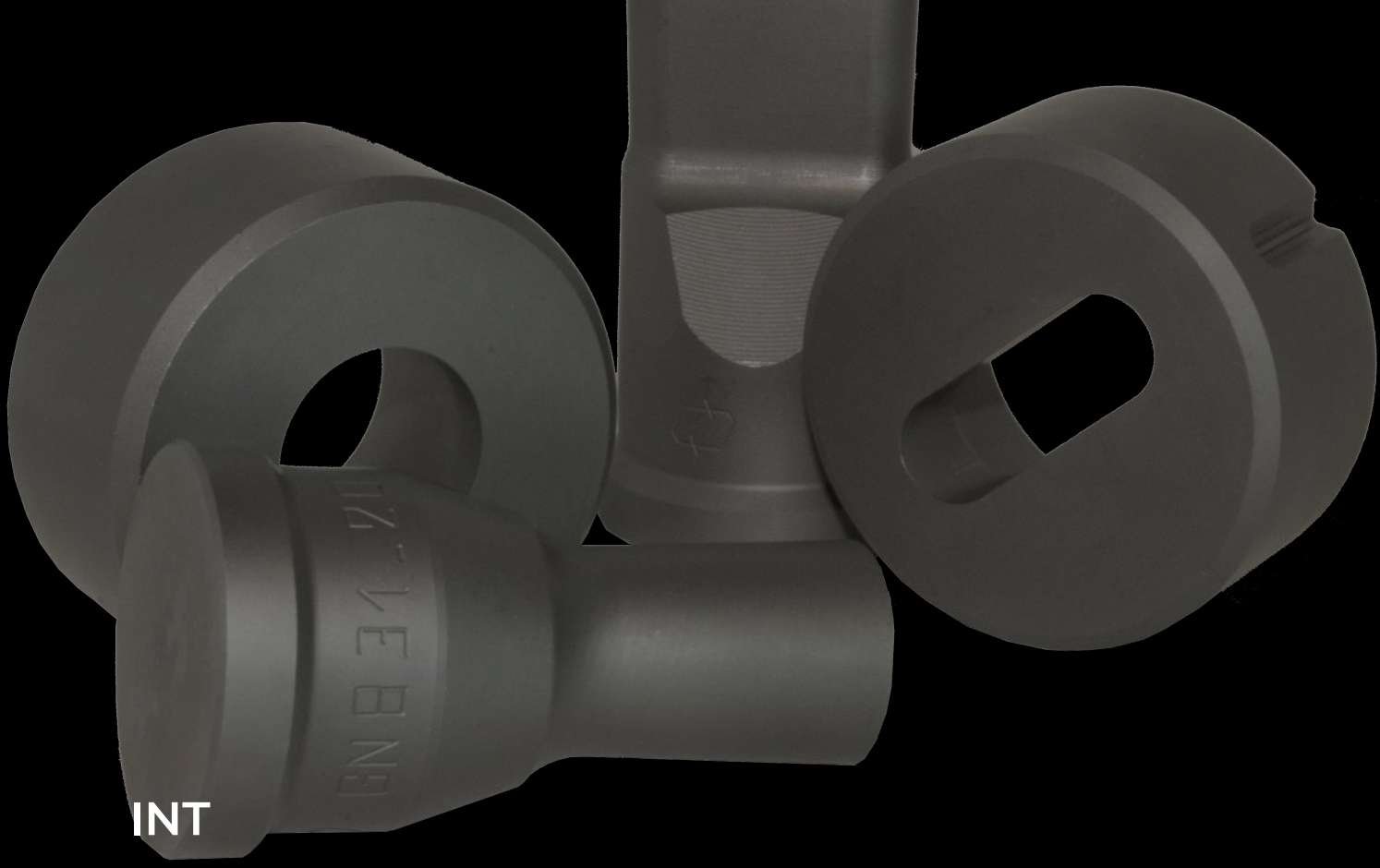




IRON WORKER



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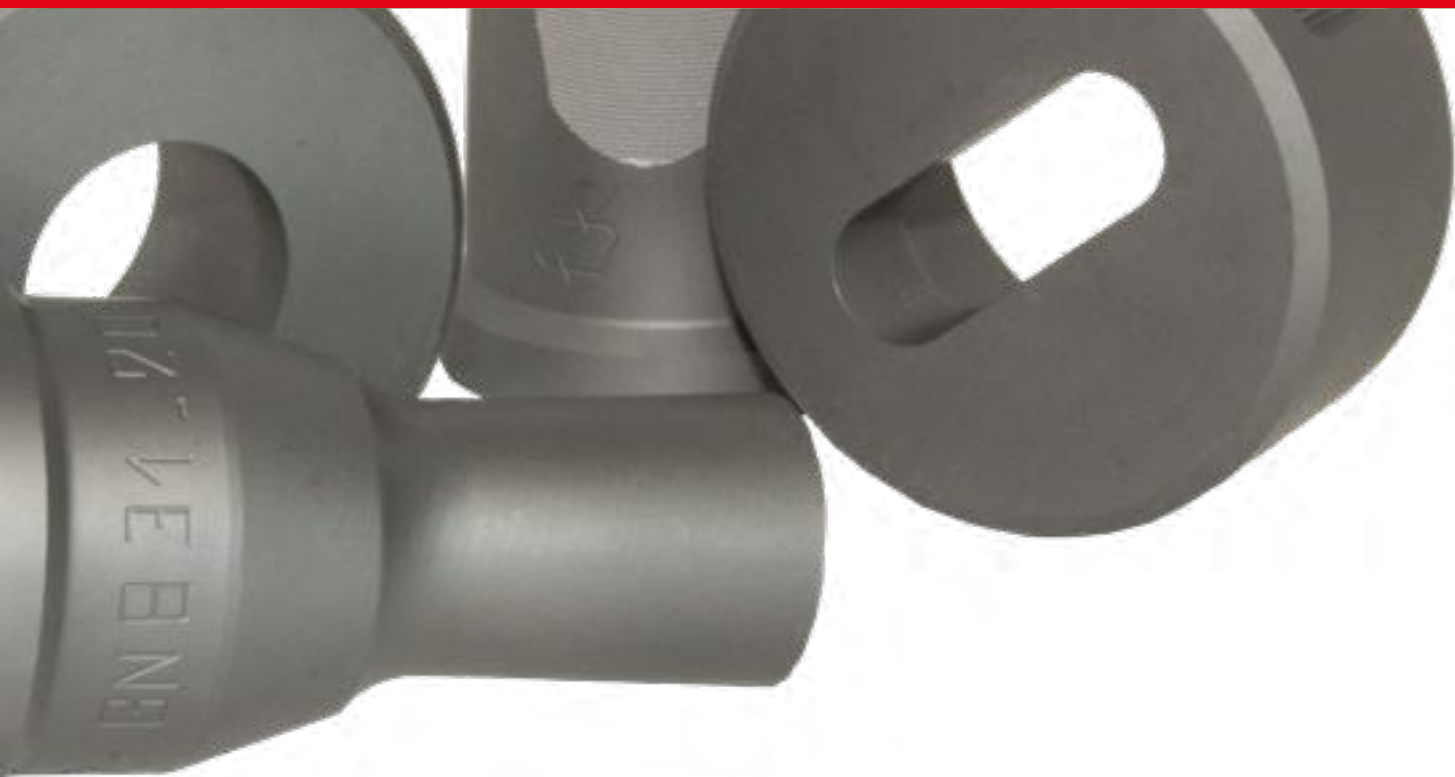
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GEKA



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EQUIPPED GEKA Old generation		
Type	Punch	Die
MICROCROP	GN 5/27 GM 5/30	GM 5
MINICROP MULTICROP HYD 50-70 PUMA 50 - 70 PUMA 11 - 13	GN 5/27 GM 5/30	GM 5
	Big holes GM 11 GM 12 GM 13	GM 11 GM 12 GM 13
HYDRACROP 100 PUMA 100 PUMA 16 PUMA 20	GN 8-19 GN 8-31	GM 5
	Big holes GN 11 GN 12 GN 13	GM 11 GM 12 GM 13
Type	Punch	Die
P.P.50	GN 5/27 G 6	GM 5 MN 2

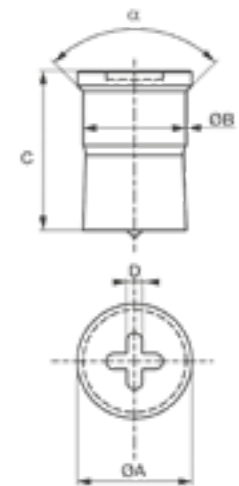
EQUIPPED GEKA New generation		
Type	Punch	Die
BINDICROP HYDRACROP 55 HYDRACROP 80 PUMA 55 PUMA 80	GN 8-19 GN 8-31 GN 8-40	GM 5 GM 8
	Big holes GN 11 GN 12 GN 13	GN 11 GN 12 GN 13
MINICROP MULTICROP HYD 50-70 PUMA 50 - 70 PUMA 11 - 13	GN 8-19 GN 8-31 GN 8-40	GM 5 GM 10
	Big holes GN 11 GN 12 GN 13	GM 11 GM 12 GM 13
HYDRACROP 100 PUMA 100 PUMA 16 PUMA 20	GN 10-26 GN 10-40	GM 5 GM 10
	Big holes GN 11 A GN 12 A GN 13 A	GM 11 GM 12 GM 13

For Geka machines equipped with Pedding tools see pag. 18



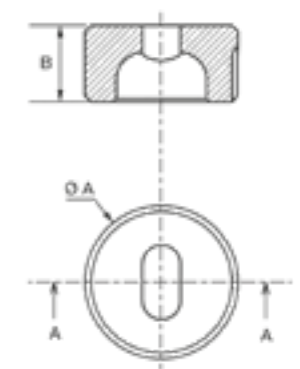
PUNCHES Dimesions

	A (mm)	B (mm)	C (mm)	D (mm)	Degree
GN 5/27	30,50	27,00	52,00	4	60°
GN 5/30	31,50	30,00	52,00	4	60°
GN 6	31,50	28,00	55,50	4	90°
GN 8-19	24,00	19,00	62,00		90°
GN 8-31	35,00	31,00	62,00	6	90°
GN 8-31A	35,00	31,00	87,00	6	90°
GN 8-40	43,50	40,00	62,00	6	60°
GN 10-26	29,50	26,00	71,00	6	90°
GN 10-40	43,50	40,00	71,00	6	60°
GN 11	54,00	50,00	55,00	4-6	90°
GN 12	79,00	75,00	55,00	4-6	90°
GN 13	104,00	100,00	55,00	4-6	90°
GN 11 A	54,00	50,00	70,00	4-6	90°
GN 12 A	79,00	75,00	70,00	4-6	90°
GN 13 A	104,00	100,00	70,00	4-6	90°



DIES Dimensions

	A (mm)	B (mm)
GM 5	50,80	25,40
GM 5 (Scentrata)	50,80	25,40
GM 6	46,04	28,60
GM 6 (Scentrata)	46,04	28,60
GM 8	60,00	32,00
GM 8 (Scentrata)	60,00	32,00
GM 10	73,00	32,00
GM 10 (Scentrata)	73,00	32,00
GM 11	78,00	28,50
GM 12	100,00	28,50
GM 13	125,00	28,50



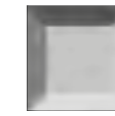
GEKA: Punches



	Standard		Standard		Standard		
GN 5/27	4-27 mm, 1/2 mm step	IPG527RG	4-19 mm, 1 mm step	IPG527QG	5x10 7x14 9x18 11x22 13x26 16x26	6x12 8x16 10x20 12x24 14x26 18x26	IPG527OG
GN 5/30*	28, 29, 30 mm	IPG530RG	20,21 mm	IPG530QG	L max= 30 mm		IPG530OG
GN 6	4-28 mm, 1/2 mm step	IPGN6.RG	4-19 mm, 1 mm step	IPGN6.QG	5x10 7x14 9x18 11x22 13x26 16x28	6x12 8x16 10x20 12x24 14x28 18x28	IPGN6.OG
GN 8-19	4-19 mm, 1/2 mm step	IPG819RG					
GN 8-31	4-31 mm, 1/2 mm step	IPG831RG	4-21 mm, 1 mm step	IPG831QG	5x10 7x14 9x18 11x22 13x26 15x30 17x31 20x31	6x12 8x16 10x20 12x24 14x28 16x31 18x31 22x31	IPG831OG
GN 8-40	32-40 mm, 1 mm step	IPG840RG	22-28 mm, 1 mm step	IPG840QG	10x40 14x40 18x40 22x40 26x40	12x40 16x40 20x40 24x40 28x40	IPG840OG
GN 10-26	5-26 mm, 1 mm step	IP1026RG	7-18 mm, 1 mm step	IP1026QG	5x10 7x14 9x18 11x22 13x26	6x12 8x16 10x20 12x24	IP1026OG
GN 10-40	27-40 mm, 1 mm step	IP1040RG	19-28 mm, 1 mm step	IP1040QG	14x28 18x36 20x40 22x40	16x32 24x40	IP1040OG
GN 11	27-50 mm, 1 mm step	IPGN11RG	20-35 mm, 1 mm step	IPGN11QG	L max= 50 mm		IPGN11OG
GN 12	51-75 1 mm step	IPGN12RG	36-50 mm 1 mm step	IPGN12QG	L max= 75 mm		IPGN12OG
GN 13	76-100 1 mm step	IPGN13RG	51-70 mm 1 mm step	IPGN13QG	L max= 100 mm		IPGN13OG
GN 11 A	27-50 1 mm step	IPG11ARG	20-35 mm 1 mm step	IPG11AQG	L max= 50 mm		IPG11AOG
GN 12 A	51-75 1 mm step	IPG12ARG	36-50 mm 1 mm step	IPG12AQG	L max= 75 mm		IPG12AOG
GN 13 A	76-100 1 mm step	IPG13ARG	51-70 mm 1 mm step	IPG13AQG	L max= 100 mm		IPG13AOG

* Oversized tool that needs a special sleeve diameter 30.2

GEKA: Dies



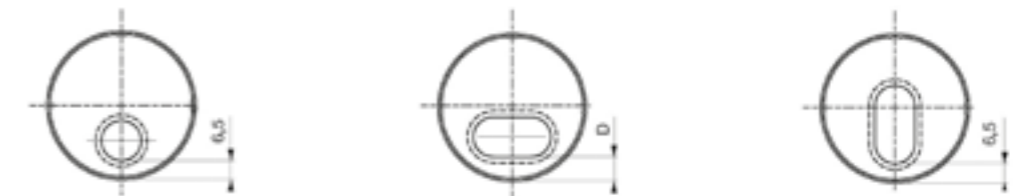
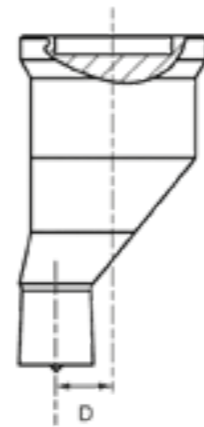
	Standard		Standard		Standard			
GM 6	4-30 mm, 1/2 mm step die clarence 0,2/0,7	IDGM6.RG	4-21 mm, 1 mm step, die clarence 0,2/0,7	IDGM6.QG	die clarence 0,2/0,7: 5x10 6x12 7x14 8x16 9x18 10x20 11x22 12x24 13x26 14x26 16x26 18x26			IDGM6.OG
GM 5	4-31 mm, 1/2 mm step die clarence 0,2/0,7	IDGM5.RG	4-21 mm, 1 mm step, die clarence 0,2/0,7	IDGM5.QG	die clarence 0,2/0,7: 5x10 6x12 7x14 8x16 9x18 10x20 11x22 10x24 13x26 14x26 14x28 15x30 16x26 16x31 17x31 18x26 18x31 20x31			IDGM5.OG
GM 8	32-40 mm, 1/2 mm step max 42,2, die clarence 0,2/0,7	IDGM8.RG	22-28 mm, 1 mm step, die clarence 0,2/0,7	IDGM8.QG	die clarence 0,2/0,7: 10x40 12x40 14x40 16x40 18x40 20x40 22x40 24x40 26x40 28x40			IDGM8.OG
GM 10	5-40 mm, 1/2 mm step die clarence 0,2/0,7 (max 43,2)	IDGM10RG	7-28 mm, 1 mm step, die clarence 0,2/0,7	IDGM10QG	die clarence 0,2/0,7: 5x10 6x12 7x14 8x16 9x18 10x20 11x22 12x24 13x26 14x28 16x32 18x36 20x40 22x40 24x40			IDGM10OG
GM 11	27-50 mm, 1/2 mm step die clarence 0,2/0,7	IDGM11RG	20-35 mm, 1 mm step, die clarence 0,2/0,7	IDGM11QG	L max= 50 mm			IDGM11OG
GM 12	51-70 mm, 1/2 mm step die clarence 0,2/0,7	IDGM12RG	36-50 mm, 1 mm step, die clarence 0,2/0,7	IDGM12QG	L max= 70 mm			IDGM12OG
GM 13	71-100 mm, 1/2 mm step die clarence 0,2/0,7	IDGM13RG	51-70 mm, 1 mm step, die clarence 0,2/0,7	IDGM13QG	L max= 100 mm			IDGM13OG

* Oversized tool that needs a special sleeve diameter 30.2





Nominal Ø (mm)	D (mm)
5,00	15,25
6,00	14,75
7,00	14,25
8,00	13,75
9,00	13,25
10,00	12,75
11,00	12,25
12,00	11,75
13,00	11,25
14,00	10,75
15,00	10,25
16,00	9,75
18,00	8,75
20,00	7,75
22,00	6,75

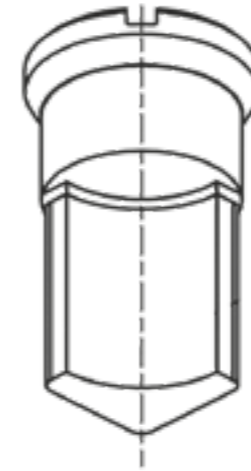
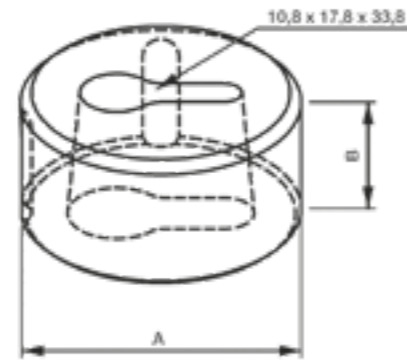
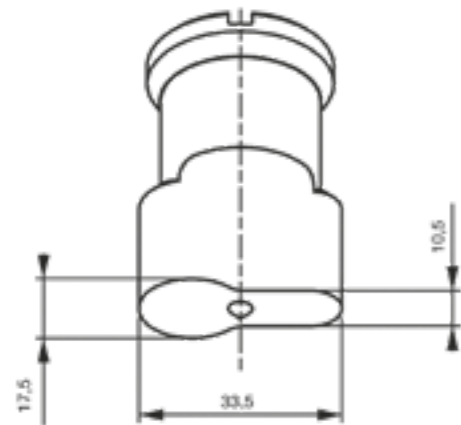


Punches	Standard
GN 5/27	5,00 6,00 7,00 8,00 9,00 IPG527WG
GN 8-31	10,00 11,00 12,00 13,00 14,00 IPG831WG
GN 8-40	15,00 16,00 18,00 20,00 22,00 IPG840WG

Dies	Standard
GM 6	5,70 6,70 7,70 8,70 9,70 IDGM6.WG
GM 5	10,70 11,70 12,70 13,70 14,70 IDGM5.WG
GM 8-40	15,70 16,70 18,70 20,70 22,70 IDG840WG

OFFSET OBROUND available on request! Write to sales@rolleri-punching.com

	Standard	Standard	Standard
GM 8 Offset	5-15 mm , 1/2 mm step die clarence 0,7 IDGM8.WG	die clarence 0,2/0,7 10x40 16x40 22x40 28x40 12x40 18x40 24x40 14x40 20x40 26x40 IDGM8.YG	die clarence 0,2/0,7 10x40 16x40 22x40 28x40 12x40 18x40 24x40 14x40 20x40 26x40 IDGM8.ZG
GM 10 Offset	5-15 mm, 1/2 mm step die clarence 0,7 IDGM10WG	die clarence 0,2/0,7 5x10 8x16 11x22 14x28 20x40 22x40 16x32 12x24 9x18 6x12 7x14 10x20 13x26 18x36 24x40 IDGM10YG	die clarence 0,2/0,7 5x10 8x16 11x22 14x28 20x40 22x40 16x32 12x24 9x18 6x12 7x14 10x20 13x26 18x36 24x40 IDGM10ZG
MN 13 Offset	3-22 mm, 1/2 mm step die clarence 0,2/0,7 IDMNI3WG	D= 6,2x14,7 6,2x25,7 7,2x26,7 8,2x26,7 9,7x14,7 9,7x26,7 10,7x20,7 11,7x22,7 11,7x26,7 12,7x24,7 13,7x26,7 14,7x26,7 16,7x26,7 8,40 12,40 12,90 12,40 8,15 12,15 10,15 9,65 11,15 10,65 10,65 10,65 10,15 IDMNI3YG	D= 6,2x14,7 6,2x25,7 7,2x26,7 8,2x26,7 9,7x14,7 9,7x26,7 10,7x20,7 11,7x22,7 11,7x26,7 12,7x24,7 13,7x26,7 14,7x26,7 16,7x26,7 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 IDMNI3ZG
MN 14 Offset	5-24 mm, 1/2 mm step die clarence 0,2/0,7 IDMNI4WG	D= 6,2x14,7 6,2x25,7 7,2x26,7 8,2x26,7 9,7x14,7 9,7x26,7 10,7x20,7 11,7x22,7 11,7x26,7 12,7x24,7 13,7x26,7 14,7x26,7 16,7x26,7 8,40 12,40 12,90 12,40 8,15 12,15 10,15 9,65 11,15 10,65 10,65 10,65 10,15 IDMNI4YG	D= 6,2x14,7 6,2x25,7 7,2x26,7 8,2x26,7 9,7x14,7 9,7x26,7 10,7x20,7 11,7x22,7 11,7x26,7 12,7x24,7 13,7x26,7 14,7x26,7 16,7x26,7 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 7,65 IDMNI4ZG



Standard Punches	
GN 6	IPGN6.CG
GN 5/27*	IPG527CG
GN 8-40	IPG840CG
GN 10-40	IP1040CG
PN 4*	IPPN4.CG
PN 5*	IPPN5.CG
PN 6	IPPN6.CG

Standard Dies	
GM 5 or 6	IDGM6.CG
GM 5	IDGM5.CG
GM 8	IDGM8.CG
GM 10	IDGM10CG
MN 3/2	IDMN3.CG
MN 2	IDMN2.CG
MN 4	IDMN4.CG

Standard Punches		
GN 6	R5, R10, R14	IPGN6.TG
GN 5/27	R5, R10, R14	IPG527TG
GN 8-31	R10, R15	IPG831TG
GN 8-40	R22	IPG840TG
GN 10-40	R22	IP1040TG

Standard Dies		
GM 5	R5, R10, R14, R15	IDGM5.TG
GM 6	R5, R10, R14	IDGM6.TG
GM 8-40	R22	IDG840TG
GM 10-40	R22	ID1040TG

Other SPECIAL SHAPES are available on request! Write to sales@rolleri-punching.com



Quick Change Punch Sleeve

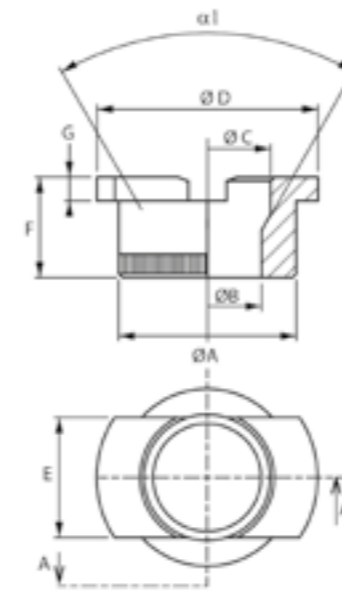
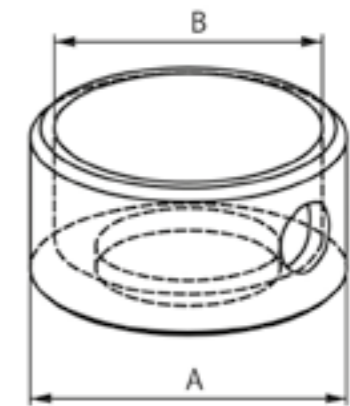
A	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G	α (degree)	Standard
PN 4 Ref. 19 DA PN 4 45	45,00	27,20	32,00	56,00	30,00	25,50	6	60°	WQP445XG
PN 4 S Ref. 19 DA PN 4S 45	45,00	30,20	32,00	56,00	30,00	25,50	6	60°	WQP4S5XG
PN 4 Ref. 19 DA PN 4 49	49,00	27,20	32,00	59,00	30,00	26,00	7	60°	WQP449XG
PN 4 S Ref. 19 DA PN 4S 49	49,00	30,20	32,00	59,00	30,00	26,00	7	60°	WQP4S9XG
PN 5 Ref. 19 DA PN 5	49,00	32,20	36,00	59,00	30,00	29,00	7	60°	WQP5.XG
GN 8-40 Ref. 19 DA GN 8 40	57,00	40,20	44,00	68,00	38,00	25,50	8	60°	WQG840XG
GN 8-31 Ref. 19 DA GN 8 31	57,00	31,20	44,00	68,00	38,00	25,50	8	90°	WQG831XG
GN 10-40 Ref. 19 DA GN 10 40	59,00	40,20	44,00	69,00	38,00	28,00	9	60°	WQG104XG
GN 10-26 Ref. 19 DA GN 10 26	59,00	26,20	44,00	69,00	38,00	28,00	9	90°	WQG102XG

A/B	A (mm)	B (mm)	C (mm)	D (mm)	$\alpha 1$ (degree)	$\alpha 2$ (degree)	Standard
PN 4 / PN 1 Ref. 05 R41	14,60	26,40	30,50	18,00	60°	60°	WRP4-1XG
PN 5 / PN 2 Ref. 05 R52	19,40	31,50	35,50	18,00	60°	60°	WRP5-2XG
GN 8-40 / GN 8-31 Ref. 19 R GN 840 31	31,20	40,00	43,50	24,00	60°	90°	WRG843XG
GN 8-40 / GN 8-19 Ref. 19 R GN 840 19	19,20	40,00	43,50	24,00	60°	90°	WRG841XG
GN 8-31 / GN 8-19 Ref. 19 R GN 831 19	19,20	31,00	35,00	18,00	90°	90°	WRG831XG
GN 8-40 / PN 5 Ref. 19 R GN 840 PN5	32,20	40,00	43,50	24,00	60°	60°	WRG845XG
GN 8-40 / PN 2 Ref. 19 R GN 840 PN2	19,40	40,00	43,50	24,00	60°	60°	WRG842XG
GN 10-40 / GN 10-26 Ref. 19 R GN 1040 26	26,20	40,00	43,50	24,00	60°	90°	WRG142XG

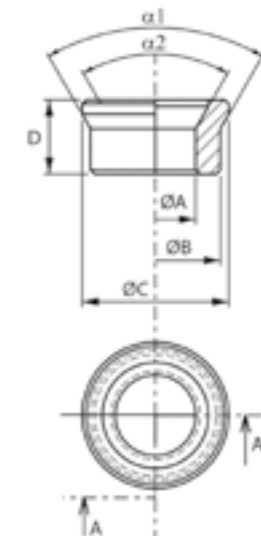


Die Reducing Socket

Die A	Die B	A (mm)	B (mm)	Standard
GM 8	MN 2	60,00	46,04	WS8-2.XG
GM 8	MN 3	60,00	50,80	WS8-3.XG
GM 10	MN 3	73,00	50,80	WS10-3XG
MN 4	MN 2	63,50	46,04	WS4-2.XG
MN 4	MN 3	63,50	50,80	WS4-3.XG
MN 6	MN 2	90,00	46,04	WS6-2.XG
MN 6	MN 3	90,00	50,80	WS6-3.XG
MN 6	MN 4	90,00	63,50	WS6-4.XG



Quick Change Punch Sleeve



Reducing Sleeves

Pins

Simple Pin GEKA
Length: 6 mm



Shouldered Pin GEKA
Length: 6/4 mm





PEDDINGHAUS



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Type	Punch	Die
PEDDICAT 360 PEDDIWORKER 400, 500, 600, 800 PEDDIMASTER 450M, 28/40, 40/60 60/80, 60/100, 80/110 HYDRAULIC 28, 50, 60N, 300, 400, 500, 600 210 SUPER/STANDARD 11, 13 FORAX 15, 25, 45, 65, 150, 250, 450 STANZFIX 225 B/11, 13, 45, 60 225 H/11, 13	Standard PN 1 PN 4 PN 4S	Standard MN 2 MN 13
	Opzionale PN 3 PN 6 PN 7 PN 11	Opzionale MN 2 MN 4 MN 6 MN 20

Type	Punch	Die
PEDDICAT 380 PEDDIWORKER 502, 802 PEDDIMAX 602, 1002 HYDRAULIC 502, 1001 PEDDICAT 361 PEDDYWORKER 501, 801, 1000G PEDDIMASTER 100/160, 110/170, 800/1100, 1100/1700 PEDDIMAX 600, 601, 800, 801, 110/140 HYDRAULIC 100, 301, 501, 800, 1000 210 SUPER 16,20,210 STANDARD 16 FORAX 80, 100, 10000 225 B/16, 20, 80, 100 225 H/15, 20	Standard PN 2 PN 5	Standard MN 3 MN 14
	Optional PN 3 PN 6 PN 7 PN 11	Optional MN 3 MN 4 MN 6 MN 20

Type	Punch	Die
210 SUPER 25 225 B/25, 130 HYDRAULIC 140, 1400	Standard PN 3 PN 6	Standard MN 4
	Optional PN 7 PN 11	Optional MN 4 MN 5 MN 6 MN 20

FRANCE EQUIPPED PEDDY
Old generation

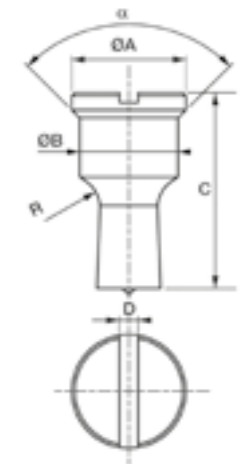
Type	Punch	Die
MICROCROP	PN 1 - PN 4 PN 4S*	MN3
	PN 1 - PN 4 PN 4S*	MN3
MINICROP MULTICROP HYD 50-70 PUMA 50 - 70 PUMA 11 - 13	PN 6 PN 7 PN 11	MN 4 MN 6 GM 13
	PN 2 - PN 5	MN 3
HYDRACROP 100 PUMA 100 PUMA 16 PUMA 20	PN 2 -PN 5	MN 3
	PN 6 PN 7 PN 11	MN 4 MN 6 GM 13

FRANCE EQUIPPED PEDDY
New generation

Type	Punch	Die
BINDICROP HYDRACROP 55 HYDRACROP 80 PUMA 55 PUMA 80	PN 2 PN 5 PG 6	MN 3 GM 8
	PN 7 PN 11	MN 4 MN 6 GM 13
HYDRACROP 110 PUMA 110	PN 2 PN 5 PG 6	MN 3 GM 10
	PN 7 PN 11	MN 4 MN 6 GM 13
HYDRACROP 165 HYDRACROP 220 PUMA 165 PUMA 220	PN 2 PN 5 PG 6	MN 3 GM 10
	PN 7 PN 11	MN 4 MN 6 GM 13

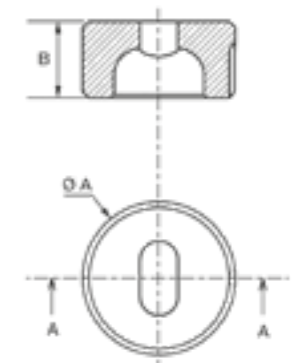
PUNCHES dimensions

	A (mm)	B (mm)	C (mm)	D (mm)	°
PN 1	19,20	14,40	49,20	4	60°
PN 2	25,40	19,20	61,00	4	60°
PN 3	30,50	26,40	71,00	4	60°
PN 4	30,50	26,40	49,20	4	60°
PN 4 S	31,70	30,00	49,20	4	60°
PN 5	35,50	31,50	60,30	4	60°
PG 6	43,50	40,00	60,30	4	60°
PN 6	43,50	39,50	69,50	4	60°
PN 7	65,00	58,50	76,20	4	60°
PN 11	94,50	90,00	76,20	4	60°







Dies dimensions

	A (mm)	B (mm)
MN 2 + 13	46,04	28,60
MN 3 + 14	50,80	25,40
MN 4	63,50	31,70
MN 6	90,00	31,70




PEDDINGHAUS: Punches






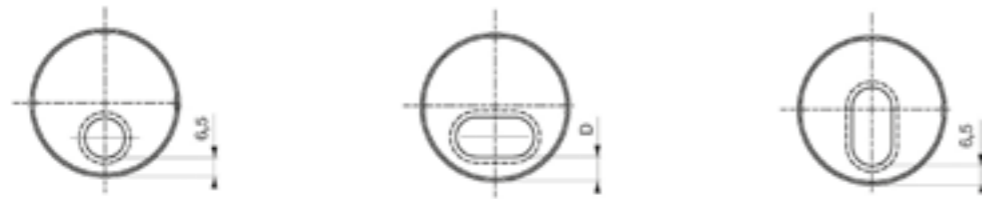
								
	Standard		Standard		Standard			
PN 1	3-14 mm, 1/2 mm step	IPP1.RY	4-10 mm, 1 mm step	IPP1.QY	5,0x10 5,5x10 6,5x12 9,0x14	5,0x14 5,5x14 7,5x14 10,0x14	IPP1.OY	
PN 4	8-27 mm, 1/2 mm step	IPP4.RY	11-19 mm, 1 mm step	IPP4.QY	5,0x10 6,0x12 7,0x14 8,0x16 10,0x20 11,0x22 12,0x24 16,0x26	5,5x19 6,5x18 7,5x25 9,0x18 10,0x26 11,0x26 13,0x26 18,0x26	5,5x25 6,5x26 7,5x26 9,0x26 14,0x26	IPP4.OY
PN 4 S*	28, 29, 30 mm	IPP4.SRY	20, 21 mm	IPP4.SQY	L max= 30 mm			IPP4.SOY
PN 2	4-19 mm, 1/2 mm step	IPP2.RY	4-13 mm, 1 mm step	IPP2.QY	5,0x10 5,5x10 5,5x19 6,0x12 6,5x18 8,0x16 10,0x14	5,0x14 5,5x14 6,5x12 7,0x14 9,0x14	7,5x14 9,0x18	IPP2.OY
PN 5	19,5-32 mm, 1/2 mm step	IPP5.RY	14-22 mm, 1 mm step	IPP5.QY	5,5x25 7,5x21 9,0x26 10,0x26 11,0x26 12,0x30 14,0x26 16,0x31 20,0x31	6,5x26 7,5x26 9,0x30 10,0x30 11,0x30 12,0x24 13,0x26 14,0x28 18,0x26 22,0x31	6,5x30 7,5 x30 10,0x20 11,0x22 12,0x24 13,0x30 16,0x26 18,0x31	IPP5.OY
PN 3	5-26 mm, 1/2 mm step	IPP3.RY	8-18 mm, 1 mm step	IPP3.QY	5,0x10 5,5x14 6,5x12 7,5x14 9,0x14 10,0x14 11,0x22 13,0x26 18,0x26	5,0x14 5,5x19 6,5x18 7,5x21 9,0x18 10,0x20 11,0x26 14,0x26	5,5x10 5,5x25 6,5x26 7,5x26 9,0x26 10,0x26 12,0x24 16,0x26	IPP3.OY
PN 6	26,5-39,5 mm, 1/2 mm step	IPP6.RY	19-28 mm, 1 mm step	IPP6.QY	6,5x30 9,0x30 11,0x30 12,0x35 13,0x35 14,0x35 18,0x31 20,0x31	7,5x30 10,0x30 12,0x30 13,0x30 14,0x28 16,0x31 18,0x36 22,0x31	IPP6.OY	
PN 7	40-58 mm, 1 mm step	IPP7.RY	30, 35, 40 mm	IPP7.QY	11,0x40 13,0x40 16,0x40 18,0x40 20,0x40 22,0x44	12,0x40 14,0x40 16,0x55 18,0x55 20,0x55 22,0x55	IPP7.OY	
PN 11	59-60-65-70 75-80-85-90	IPP11.RY	41-63 mm	IPP11.QY	L max= 90 mm			IPP11.OY

*Oversized tool that needs a special sleeve diameter 30.2

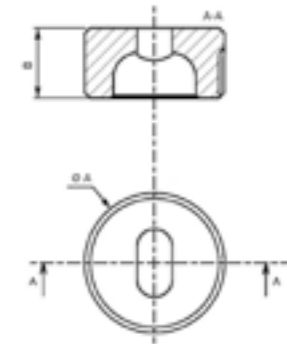
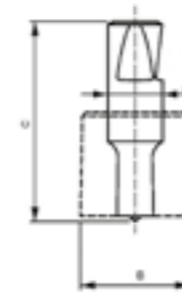
PEDDINGHAUS: Dies



									
	Standard		Standard		Standard				
MN 2	3-30 mm, 1/2 mm step die clarence 0,2/0,7 (max 30,7)	IDM2.RY	4-21 mm, 1 mm step, die clarence 0,2/0,7	IDM2.QY	die clarence 0,2/0,7: 5,0x10 5,0x14 5,5x10 5,5x14 5,5x19 5,5x25 6,0x12 6,5x18 6,5x12 7,5x21 7,5x14 8,0x16 9,0x14 9,0x18 10,0x14 10,0x20 11,0x22 11,0x26 12,0x24 13,0x26 14,0x26 16,0x26 18,0x26			6,5x26 7,0x14 7,5x26 9,0x26 10,0x26	IDM2.OY
MN 3	3-32 mm, 1/2 mm step die clarence 0,2/0,7 (max 33,2)	IDM3.RY	4-23 mm, 1 mm step, die clarence 0,2/0,7	IDM3.QY	die clarence 0,2/0,7: 5,0x10 5,0x14 5,5x10 5,5x14 5,5x19 5,5x25 6,0x12 6,5x12 6,5x18 6,5x26 6,5x30 7,0x14 7,5x14 7,5x21 7,5x26 7,5x30 8,0x16 9,0x14 9,0x18 9,0x26 9,0x30 10,0x14 10,0x20 10,0x26 10,0x30 11,0x26 11,0x30 12,0x24 12,0x30 13,0x26 13,0x30 14,0x26 14,0x28 15,0x30 16,0x26 16,0x31 17,0x31 18,0x26 18,0x31 20,0x31 22,0x31			9,0x26 10,0x26 11,0x30	IDM3.OY
MN 4	26,5-39,5 mm, 1/2 mm step die clarence 0,2/0,7 (max 40,7)	IDM4.RY	17-28 mm, 1 mm step, die clarence 0,2/0,7	IDM4.QY	die clarence 0,2/0,7: 6,5x30 7,5x30 9,0x30 10,0x30 11,0x30 12,0x30 12,0x35 13,0x30 13,0x35 14,0x28 14,0x35 16,0x31 18,0x31 18,0x36 20,0x31 22,0x31			10,0x30 12,0x35 13,0x35 14,0x35	IDM4.OY
MN 5	4-39,5 mm, 1/2 mm step die clarence 0,2/0,7	IDM5.RP	4-28 mm, 1 mm step, die clarence 0,2/0,7	IDM5.QP	L max= 39,5			IDM5.OP	
MN 6	40-65 mm, 1/2 mm step die clarence 0,2/0,7 (max 65,7)	IDM6.RY	30,2; 35,2; 40,2	IDM6.QY	die clarence 0,2/0,7: 11,0x40 12,0x40 13,0x40 14,0x40 16,0x40 16,0x55 18,0x40 18,0x55 20,0x40 20,0x55 22,0x44 22,0x55			18,0x55 20,0x55 22,0x55	IDM6.OY
MN 20	70,2; 70,7; 75,2; 80,2; 85,2; 90,2; 95,2; 100,2 mm	IDM20.RY	45-63	IDM20.QY	L max= 100 mm			IDM20.OY	



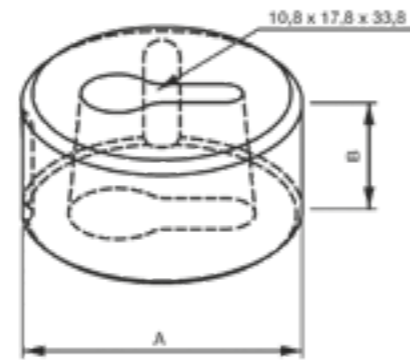
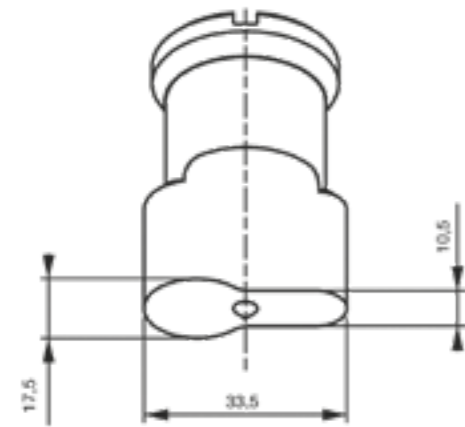
	Standard		Standard		Standard			
MN 13 Offset	3-22 mm, 1/2 mm step die clarence 0,2/0,7	IDMN13WP	D=	IDMN13YP	D=	IDMN13ZP		
			6,2x14,7		8,40		6,2x14,7	7,65
			6,2x25,7		12,40		6,2x25,7	7,65
			7,2x26,7		12,90		7,2x26,7	7,65
			8,2x26,7		12,40		8,2x26,7	7,65
			9,7x14,7		8,15		9,7x14,7	7,65
			9,7x26,7		12,15		9,7x26,7	7,65
			10,7x20,7		10,15		10,7x20,7	7,65
			11,7x22,7		9,65		11,7x22,7	7,65
			11,7x26,7		11,15		11,7x26,7	7,65
12,7x24,7	10,65	12,7x24,7	7,65					
13,7x26,7	10,65	13,7x26,7	7,65					
14,7x26,7	10,65	14,7x26,7	7,65					
16,7x26,7	10,15	16,7x26,7	7,65					
MN 14 Offset	5-24 mm, 1/2 mm step die clarence 0,2/0,7	IDMN14WP	D=	IDMN14YP	D=	IDMN14ZP		
			6,2x14,7		8,40		6,2x14,7	7,65
			6,2x25,7		12,40		6,2x25,7	7,65
			7,2x26,7		12,90		7,2x26,7	7,65
			8,2x26,7		12,40		8,2x26,7	7,65
			9,7x14,7		8,15		9,7x14,7	7,65
			9,7x26,7		12,15		9,7x26,7	7,65
			10,7x20,7		10,15		10,7x20,7	7,65
			11,7x22,7		9,65		11,7x22,7	7,65
			11,7x26,7		11,15		11,7x26,7	7,65
12,7x24,7	10,65	12,7x24,7	7,65					
13,7x26,7	10,65	13,7x26,7	7,65					
14,7x26,7	10,65	14,7x26,7	7,65					
16,7x26,7	10,15	16,7x26,7	7,65					



Punch	A=Ø (mm)	B (mm)	C (mm)
PN 55	15,00	30,00 max	55,00

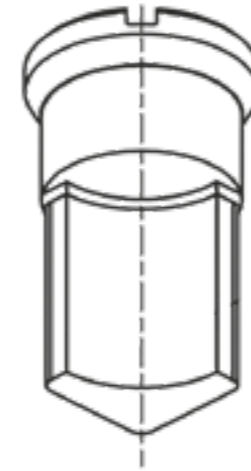
Die	A=Ø (mm)	B (mm)
MN 57	35,00	17,00
MN 3	50,80	25,40

	Standard		Standard		Standard		
Body 15 PN 55	3-15 mm, 1/2 mm step	IPP55.RP	4-10 mm, 1 mm step	IPP55.QP	5,0x10 6,5x12	5,5x14 7,5x14	IPP55.OP
Corpo 15 Thicker PN 55	15,5-20 mm, 1/2 mm step 23 - 24 - 25 - 30	IPP55SRP	11 - 12 - 13 - 14 - 15	IPP55SQP	6,5x18 7,5x21 9,0x18 10,0x20 11,0x22 12,0x24 13,0x26 14,0x28	6,5x26 7,5x26 9,0x26 10,0x26 11,0x26 12,0x30 13,0x30	9,0x30 10,0x30 11,0x30 IPP55SOP
MN 57 For PN55 Punch	3-22mm, 1/2 mm step die clarence 0,2/0,7	IDMN57RP	4-15 mm, 1 mm step die clarence 0,2/0,7	IDMN57QP	die clarence 0,2/0,7: 5,0x10 5,5x14 6,5x12 6,5x18 7,5x14 7,5x21 11,0x22		IDMN57OP
MN 3 For PN55 Punch	4-30 mm, 1/2 mm step die clarence 0,2/0,7	IDMN3XRP	4-15 mm die clarence 0,2/0,7	IDMN3XQP	die clarence 0,2/0,7: 5,0x10 5,5x14 6,5x12 6,5x18 7,5x14 7,5x21 9,0x18 9,0x26 10,0x20 10,0x26 11,0x22 11,0x26 12,0x24 12,0x30 13,0x26 13,0x30 14,0x28		6,5x26 7,5x26 9,0x30 10,0x30 11,0x30 IDMN3XOP



Standard Punches	
PN 4*	IPPN4.CP
PN 5*	IPPN5.CP
PG 6	IPPG6.CP
PN 6	IPPN6.CP
PN 55	IPPN55CP

Standard Dies	
MN 2	IDMN2.CP
MN 3	IDMN3.CP
GM 8	IDGM8.CP
MN 4	IDMN4.CP
MN 3	IDMN3.CP



	Radius	Standard
PN 4	R5, R10, R14	IPPN4.TP
PN 5	R5, R10, R15	IPPN5.TP
PG 6	R22	IPPG6.TP
PN 3	R5, R10, R14	IPPN3.TP
PN 6	R15, R20	IPPN6.TP
PN 7	R25, R30, R35	IPPN7.TP

Standard Dies		
MN 2	R5, R10, R14, R15	IDMN2.TP
MN 3	R5, R10, R14, R15	IDMN3.TP
MN 4	R15, R20	IDMN4.TP
MN 6	R25, R30, R35	IDMN6.TP

Other SPECIAL SHAPES are available on request! Write to sales@rolleri-punching.com

Quick Change Punch Sleeve

A/B	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G	α (degree)	Standard
PN 4 Ref. 05 DA PN 4	45,00	27,20	32,00	56,00	30,00	44,00	8	60°	WQPN4.XP
PN 4 S Ref. 05 DA PN 4S	45,00	30,20	32,00	56,00	30,00	44,00	8	60°	WQPN4SXP
PN 5 Ref. 05 DA PN 5	52,00	32,20	37,00	70,00	35,00	60,00	10	60°	WQPN5.XP
PN 5 S Ref. 05 DA PN 5 A	52,00	32,20	37,00	70,00	35,00	35,00	10	60°	WQPN5AXP

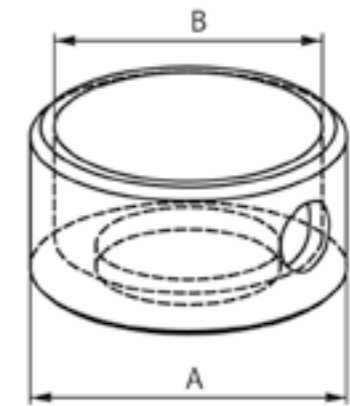
Reducing Sleeves

A/B	A (mm)	B (mm)	C (mm)	D (mm)	$\alpha 1$ (degree)	$\alpha 2$ (degree)	Standard
PN 4 / PN 1 Ref. 05 R41	14,60	26,40	30,50	18,00	60°	60°	WRP4-1XP
PN 5 / PN 2 Ref. 05 R52	19,40	31,50	35,50	18,00	60°	60°	WRP5-2XP
PN 6 / PN 3 Ref. 05 R63	27,20	39,50	43,50	24,00	60°	60°	WRP6-3XP

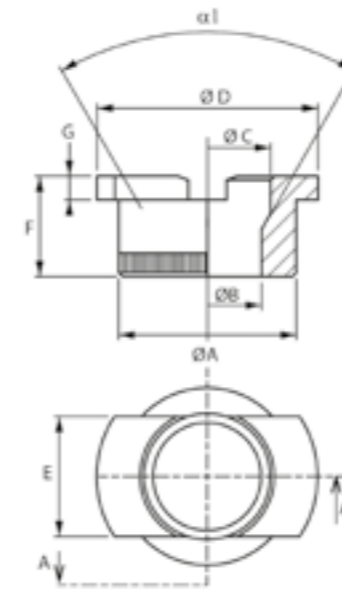


Die Reducing Socket

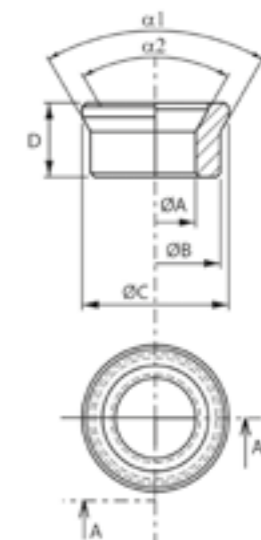
Die A	Die B	A (mm)	B (mm)	Standard
MN 3	MN 57	50,80	35,00	WS3-57XP
MN 4	MN 2	63,50	46,04	WS4-2.XP
MN 4	MN 3	63,50	50,80	WS4-3.XP
MN 6	MN 2	90,00	46,04	WS6-2.XP
MN 6	MN 3	90,00	50,80	WS6-3.XP
MN 6	MN 4	90,00	63,50	WS6-4.XP



Die Reducing Socket



Quick Change Punch Sleeve



Reducing Sleeves

Pin

Pin PEDDY
Lenght: 4 mm





MUBÉA-SUNRISE



Tools Dimensions

30

Punches

31 - 32

Dies

33 - 34

Offset Dies

35

Special Shapes

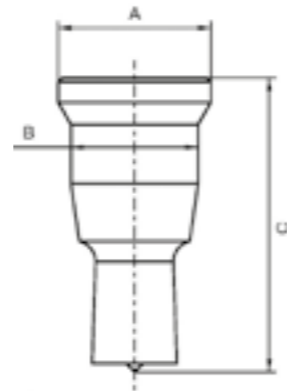
36

Accessories

37

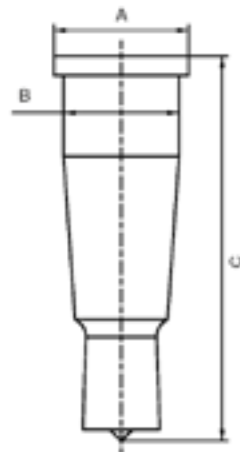


	A (mm)	B (mm)	C (mm)
GR 1	20,00	15,00	39,00
GR 2	36,00	30,00	70,00
GR 3	46,00	40,00	70,00
GR 4	56,00	50,00	70,00
ED 70	50,00	70,00	120,00
ED 100	50,00	100,00	120,00
ED 150	50,00	150,00	120,00
Corpo 15	15,00	30,00 max	55,00
Multiplo	35,00	30,00	100,00
RP 4*	66,00	60,00	70,00
RP 5*	76,00	70,00	70,00
RP 6*	86,00	80,00	70,00
RP 7*	96,00	90,00	70,00
RP 8*	106,00	100,00	70,00

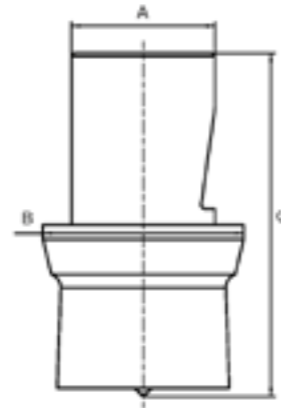


GR and RP punches

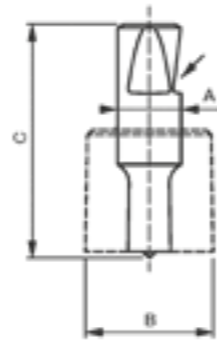
* Only for Sunrise



Multiple Punch



ED Punch

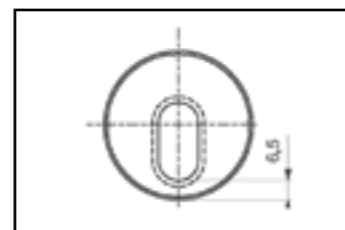
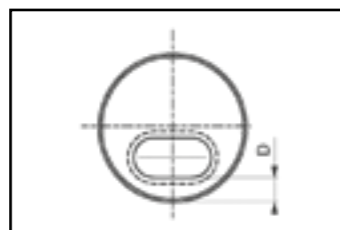
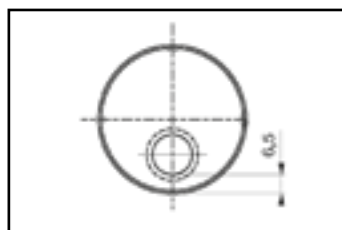
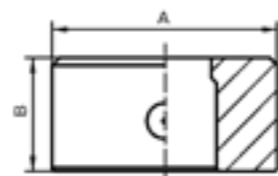


Body 15 Punch

DIES Dimensions

	A (mm)	B (mm)
M 30	30,00	15,00
M 45 - M 45 E	45,00	22,50
M 60 - M 60 E	60,00	30,00
M 80	80,00	40,00
M 110*	110,00	40,00
M 150	150,00	40,00
M 200	200,00	40,00




* Only for Sunrise



	Standard		Standard																																																																																												
GR1 505 - 1	3-15 mm, step 1/2 mm	IPGR1.RM																																																																																													
GR2 505 - 2	15,5-30 mm, step 1/2 mm	IPGR2.RM	<table border="1"> <thead> <tr> <th colspan="2">Standard</th> <th>Standard</th> <th>Standard</th> </tr> </thead> <tbody> <tr><td>5,0x10</td><td>5,0x13</td><td>5,0x15</td><td></td></tr> <tr><td>5,0x20</td><td>5,0x25</td><td>5,5x11</td><td></td></tr> <tr><td>5,5x13</td><td>5,5x15</td><td>5,5x20</td><td></td></tr> <tr><td>5,5x25</td><td>6,5x13</td><td>6,5x15</td><td></td></tr> <tr><td>6,5x20</td><td>6,5x25</td><td>6,5x30</td><td></td></tr> <tr><td>7,0x15</td><td>7,0x20</td><td>7,0x25</td><td></td></tr> <tr><td>7,0x30</td><td>8,0x13</td><td>8,0x16</td><td></td></tr> <tr><td>8,0x20</td><td>8,0x25</td><td>8,0x30</td><td></td></tr> <tr><td>9,0x13</td><td>9,0x18</td><td>9,0x20</td><td></td></tr> <tr><td>9,0x25</td><td>9,0x30</td><td>9,5x13</td><td></td></tr> <tr><td>9,5x15</td><td>9,5x20</td><td>9,5x25</td><td></td></tr> <tr><td>9,5x30</td><td>10,5x15</td><td>10,5x21</td><td></td></tr> <tr><td>10,5x25</td><td>10,5x30</td><td>11,0x15</td><td></td></tr> <tr><td>11,0x20</td><td>11,0x25</td><td>11,0x30</td><td>IPGR2.OM</td></tr> <tr><td>12,0x20</td><td>12,0x25</td><td>12,0x30</td><td></td></tr> <tr><td>13,0x20</td><td>13,0x25</td><td>13,0x30</td><td></td></tr> <tr><td>13,5x20</td><td>13,5x25</td><td>13,5x30</td><td></td></tr> <tr><td>14,0x20</td><td>14,0x25</td><td>14,0x30</td><td></td></tr> <tr><td>16,0x25</td><td>16,0x30</td><td>17,5x25</td><td></td></tr> <tr><td>17,5x30</td><td>19,0x25</td><td>19,0x30</td><td></td></tr> <tr><td>20,5x25</td><td>20,5x30</td><td>22,5x30</td><td></td></tr> <tr><td>24,0x30</td><td>25,5x30</td><td></td><td></td></tr> </tbody> </table>	Standard		Standard	Standard	5,0x10	5,0x13	5,0x15		5,0x20	5,0x25	5,5x11		5,5x13	5,5x15	5,5x20		5,5x25	6,5x13	6,5x15		6,5x20	6,5x25	6,5x30		7,0x15	7,0x20	7,0x25		7,0x30	8,0x13	8,0x16		8,0x20	8,0x25	8,0x30		9,0x13	9,0x18	9,0x20		9,0x25	9,0x30	9,5x13		9,5x15	9,5x20	9,5x25		9,5x30	10,5x15	10,5x21		10,5x25	10,5x30	11,0x15		11,0x20	11,0x25	11,0x30	IPGR2.OM	12,0x20	12,0x25	12,0x30		13,0x20	13,0x25	13,0x30		13,5x20	13,5x25	13,5x30		14,0x20	14,0x25	14,0x30		16,0x25	16,0x30	17,5x25		17,5x30	19,0x25	19,0x30		20,5x25	20,5x30	22,5x30		24,0x30	25,5x30		
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10,5x25	10,5x30	11,0x15																																																																																													
11,0x20	11,0x25	11,0x30	IPGR2.OM																																																																																												
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14,0x20	14,0x25	14,0x30																																																																																													
16,0x25	16,0x30	17,5x25																																																																																													
17,5x30	19,0x25	19,0x30																																																																																													
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24,0x30	25,5x30																																																																																														
GR3 505 - 3	30,5-40 mm, step 1/2 mm	IPGR3.RM	<table border="1"> <thead> <tr> <th colspan="2">Standard</th> <th>Standard</th> <th>Standard</th> </tr> </thead> <tbody> <tr><td>11,0x35</td><td>11,0x40</td><td></td><td></td></tr> <tr><td>13,5x35</td><td>13,5x40</td><td></td><td></td></tr> <tr><td>14,0x35</td><td>14,0x40</td><td></td><td></td></tr> <tr><td>16,0x35</td><td>16,0x40</td><td></td><td></td></tr> <tr><td>17,5x35</td><td>17,5x40</td><td></td><td></td></tr> <tr><td>19,0x35</td><td>19,0x40</td><td></td><td></td></tr> <tr><td>20,5x35</td><td>20,5x40</td><td></td><td></td></tr> <tr><td>22,5x35</td><td>22,5x40</td><td></td><td></td></tr> <tr><td>24,0x40</td><td>25,5x40</td><td></td><td></td></tr> <tr><td>26,0x40</td><td>27,0x40</td><td></td><td></td></tr> </tbody> </table>	Standard		Standard	Standard	11,0x35	11,0x40			13,5x35	13,5x40			14,0x35	14,0x40			16,0x35	16,0x40			17,5x35	17,5x40			19,0x35	19,0x40			20,5x35	20,5x40			22,5x35	22,5x40			24,0x40	25,5x40			26,0x40	27,0x40																																																		
Standard		Standard	Standard																																																																																												
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24,0x40	25,5x40																																																																																														
26,0x40	27,0x40																																																																																														
GR4 505 - 4	40,5-50 mm, step 1/2 mm	IPGR4.RM	<table border="1"> <thead> <tr> <th colspan="2">Standard</th> <th>Standard</th> <th>Standard</th> </tr> </thead> <tbody> <tr><td>11,0x45</td><td>11,0x50</td><td></td><td></td></tr> <tr><td>13,5x50</td><td>17,5x50</td><td></td><td></td></tr> <tr><td>20,5x50</td><td>22,5x50</td><td></td><td></td></tr> <tr><td>24,0x50</td><td>25,5x50</td><td></td><td></td></tr> <tr><td>26,0x50</td><td>27,0x50</td><td></td><td></td></tr> </tbody> </table>	Standard		Standard	Standard	11,0x45	11,0x50			13,5x50	17,5x50			20,5x50	22,5x50			24,0x50	25,5x50			26,0x50	27,0x50																																																																						
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24,0x50	25,5x50																																																																																														
26,0x50	27,0x50																																																																																														
RP 4*	50,5-60 mm, step 1/2 mm	IPRP4.RM	40																																																																																												
RP 5*	60,5-70 mm, step 1/2 mm	IPRP5.RM	45-50																																																																																												
RP 6*	70,5-80 mm, step 1/2 mm	IPRP6.RM	55																																																																																												
RP 7*	80,5-90 mm, step 1/2 mm	IPRP7.RM	60																																																																																												
RP 8*	90,5-100 mm, step 1/2 mm	IPRP8.RM	65-70																																																																																												




MUBÉA-SUNRISE: Punches



								
	Standard		Standard		Standard			
ED70 585 - 1	50,5-70 mm, 1/2 mm step	IPE70.RM	45-50-50	IPE70.QM	L max= 70 mm		IPE70.OM	
ED100 585 - 2	70,5-100 mm, 1/2 mm step	IPE100RM	55-60	IPE100QM	L max= 100 mm		IPE100OM	
ED150 585 - 3	105 110 115 120 125 130 135 140 145 150	IPE150RM	65-70	IPE150QM	L max= 150 mm		IPE150OM	
Punzone Multiplo 509 - 2	5-30 mm, 1/2 mm step	IPMULTRM	5-21 mm, 1 mm step	IPMULTQM	L max= 30 mm		IPMULTOM	
Corpo 15 516	3-15 mm, 1/2 mm step	IPC15.RM	4-10 mm, 1 mm step	IPC15.QM	5,0x10 5,5x11 6,5x13 7,0x15 9,0x13 10,5x15	5,0x13 5,5x13 6,5x15 8,0x13 9,5x13 11,0x15	5,0x15 5,5x15 9,5x15	IPC15.OM
Corpo 15 Maggiore 525	15,5-30 mm, 1/2 mm step	IPC15SRM	11-21 mm, 1/2 mm step	IPC15SQM	5,0x20 5,5x25 6,5x20 7,0x20 8,0x16 8,0x30 9,0x18 9,0x30 9,5x30 10,5x21 11,0x20 12,0x20 13,0x20 13,5x20 14,0x20 16,0x25 17,5x25 19,0x25 20,5x25 22,5x30 24,0x30 25,5x30	5,0x25 6,5x25 7,0x25 8,0x20 9,0x20 9,5x20 10,5x25 11,0x25 12,0x25 13,0x25 13,5x25 14,0x25 16,0x30 17,5x30 19,0x30 20,5x30	5,5x20 6,5x30 7,0x30 8,0x25 9,0x25 9,5x25 10,5x30 11,0x30 12,0x30 13,0x30 13,5x30 14,0x30	IPC15SOM




MUBÉA-SUNRISE: Dies



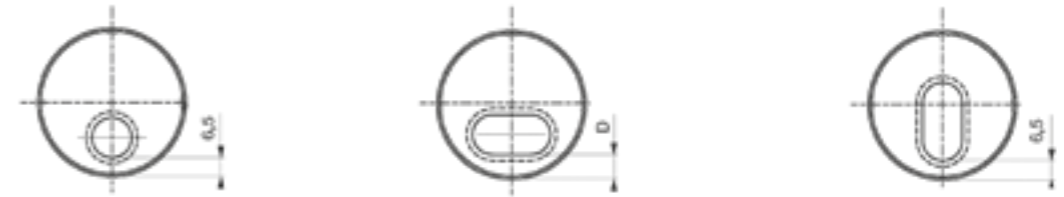
								
	Standard		Standard		Standard			
M30 633	3-15 mm, 1/2 mm step die clarence 0,2/0,7 (max 16,2)	IDM30.RM	4-10 mm, die clarence 0,2/0,7 (max 11,2)	IDM30.QM	5,3x10,3 5,8x11,3 6,0x11,0 6,5x12,0 6,8x13,3 7,5x14,0 8,3x13,3 9,8x13,3 10,0x14,0 10,8x15,3 12,0x16,0	5,3x13,3 5,8x13,3 6,0x14,0 6,5x14,0 6,8x15,3 7,5x16,0 9,0x14,0 9,8x15,3 10,5x14,0 11,3x15,3	5,3x15,3 5,8x15,3 6,0x16,0 6,5x16,0 7,3x15,3 8,0x16,0 9,3x13,3 10,5x16,0 11,5x16,0	IDM30.OM
M45 638	15,5-30 mm, 1/2 mm step die clarence 0,2/0,7 (max 31,7)	IDM45.RM	11-21 mm, die clarence 0,2/0,7 (max 22,2)	IDM45.QM	5,3x20,3 5,8x25,3 6,5x21,0 6,8x25,3 7,3x25,3 7,5x26,0 8,0x26,0 8,3x20,3 9,0x17,0 9,0x31,0 9,3x25,3 9,8x25,3 10,0x19,0 10,0x31,0 10,5x31,0 10,8x30,3 11,3x30,3 11,3x30,3 11,5x31,0 12,0x31,0 12,3x30,3 13,0x31,0 13,3x30,3 13,8x30,3 14,0x31,0 14,3x30,3 14,5x31,0 15,0x31,0 17,0x26,0 17,8x30,3 19,3x25,3 20,0x26,0 20,8x30,3 22,8x30,3 25,0x31,0	5,3x25,3 6,0x21,0 6,5x26,0 6,8x30,3 7,3x30,3 7,5x31,0 8,0x31,0 8,3x25,3 9,0x21,0 9,3x18,3 9,3x30,3 9,8x30,3 10,0x21,0 10,5x21,0 10,8x21,3 11,3x20,3 11,5x22,0 12,0x21,0 12,3x20,3 13,0x21,0 13,3x20,3 13,8x20,3 14,0x21,0 14,3x20,3 14,5x21,0 15,0x21,0 16,3x25,3 17,0x31,0 18,5x26,0 19,3x30,3 20,0x31,0 21,5x26,0 23,5x31,0 25,8x30,3	5,8x20,3 6,0x26,0 6,8x20,3 7,3x20,3 7,5x21,0 8,0x21,0 8,3x16,3 8,3x30,3 9,0x26,0 9,3x20,3 9,8x20,3 10,0x26,0 10,5x26,0 10,8x25,3 11,3x25,3 11,5x26,0 12,0x26,0 12,3x25,3 13,0x26,0 13,3x25,3 13,8x25,3 14,0x26,0 14,3x25,3 14,5x26,0 15,0x26,0 16,3x30,3 17,8x25,3 18,5x31,0 20,8x25,3 21,5x31,0 24,3x30,3 26,5x31,0	IDM45.OM
M60 639	30,5-40 mm, 1/2 mm step die clarence 0,2/0,7 (max 42,2)	IDM60.RM	22-28 mm, die clarence 0,2/0,7 (max 29,2)	IDM60.QM	11,3x35,5 12,0x41,0 14,3x35,3 14,5x41,0 16,3x35,3 17,0x41,0 18,5x36,0 19,3x40,3 20,0x36,0 20,8x40,3 22,8x35,3 23,5x41,0 25,8x40,3 27,0x41,0	11,3x40,3 13,8x35,3 14,3x40,3 15,0x36,0 16,3x40,3 17,8x35,3 18,5x41,0 20,0x41,0 21,5x36,0 22,8x40,3 24,3x40,3 26,3x40,3 27,3x40,3	12,0x36,0 13,8x40,3 14,5x36,0 15,0x41,0 17,0x36,0 17,8x40,3 19,3x35,0 20,8x35,3 21,5x41,0 23,5x36,0 25,0x41,0 26,5x41,0 28,0x41,0	IDM60.OM




MUBÉA-SUNRISE: Dies



			
	Standard		Standard
M80 640	40,5-50 mm, 1/2 mm step die clarence 0,2/0,7 (max 51,2)	IDM80.RM	29-35 die clarence 0,2/0,7 (max 35,7)
			11,3x45,3 12,0x51,0 17,8x50,3 20,8x50,3 23,5x51,0 25,8x50,3 27,0x51,0
			11,3x50,3 13,8x50,3 18,5x51,0 21,5x51,0 24,3x50,3 26,3x50,3 27,3x50,3
			12,0x46,0 14,5x51,0 22,8x50,3 25,0x51,0 26,5x51,0 28,0x51,0
			IDM80.QM
			IDM80.OM
M110*	50-80 mm, 1/2 mm step die clarence 0,2/0,7 (max 81,2)	IDM110RM	40-45 50-55 die clarence 0,2/0,7
			L max= 80 mm
			IDM110QM
			IDM110OM
M150 658 - 1	50-100 mm, 1/2 mm step die clarence 0,2/0,7 (max 100,7)	IDM150RM	40,3; 45,3; 50,3; 55,3; 60,3; 65,3; 70,3
			L max= 100 mm
			IDM150QM
			IDM150OM
M200 658 - 2	105,3; 110,3; 115,3; 120,3; 125,3; 130,3; 135,3; 140,3; 145,3; 150,3	IDM200RM	L max= 150 mm
			IDM200QM
			L max= 150 mm
			IDM200OM

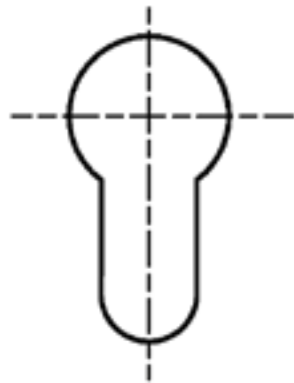
MUBÉA-SUNRISE: Offset Dies



				
	Standard			
M45 E	3-29 mm, 1/2 mm step die clarence 0,2/0,7	5,3x13,3 5,3x15,3 5,8x11,3 5,8x13,3 5,8x15,3 6,0x11,0 6,0x14,0 6,0x16,0 6,5x12,0 6,5x14,0 6,5x16,0 6,8x13,3 6,8x15,3 7,3x15,3	7,5x14,0 7,5x16,0 8,0x16,0 8,3x13,3 8,3x14,0 9,3x13,3 9,8x13,3 9,8x15,3 10,0x14,0 10,5x14,0 10,5x16,0 10,8x15,3 11,3x15,3 11,5x16,0 12,0x16,0	5,3x20,3 5,8x25,3 6,5x21,0 6,8x25,3 7,3x25,3 7,5x26,0 8,0x26,0 8,3x20,3 9,0x17,0 9,0x31,0 9,3x25,3 9,8x25,3 10,0x19,0 10,0x31,0 10,5x31,0 10,8x30,3 11,3x30,3 11,5x31,0 11,5x22,0
			11,5x31,0 5,3x25,3 12,0x21,0 6,0x21,0 6,5x26,0 6,8x30,3 7,3x30,3 7,5x31,0 8,0x31,0 8,3x25,3 9,0x21,0 9,3x18,3 9,3x30,3 9,8x30,3 10,0x21,0 10,5x21,0 10,8x21,3 10,8x30,3 11,3x20,3 11,5x22,0	
			12,0x21,0 12,3x20,3 13,0x21,0 13,3x20,3 13,8x20,3 14,0x21,0 14,3x20,3 14,5x21,0 15,0x21,0 16,3x25,3 16,3x25,3 17,0x31,0 17,0x31,0 18,5x26,0 19,3x30,3 20,0x31,0 20,5x26,0 21,5x26,0 23,5x31,0 25,8x30,3	
			5,8x20,3 6,0x26,0 6,8x20,3 7,3x20,3 7,5x21,0 8,0x21,0 8,3x16,3 8,3x30,3 9,0x26,0 9,3x20,3 9,8x20,3 10,0x26,0 10,5x26,0 10,8x25,3 11,3x25,3 11,5x26,0 12,0x26,0	
			12,3x25,3 13,0x26,0 13,3x25,3 13,8x25,3 14,0x26,0 14,3x25,3 14,5x26,0 15,0x26,0 16,3x30,3 17,8x25,3 18,5x31,0 20,8x25,3 21,5x31,0 24,3x30,3 26,5x31,0	
			IDM45EWM	
			IDM45EYM	
			IDM45EZM	
M60 E		11,3x35,5 12,0x41,0 14,3x35,3 14,5x41,0 16,3x35,3 17,0x41,0 18,5x36,0 19,3x40,3 20,0x36,0 20,8x40,3 22,8x35,3 23,5x41,0 25,8x40,3 27,0x41,0	11,3x40,3 13,8x35,3 14,3x40,3 15,0x36,0 16,3x40,3 17,8x35,3 18,5x41,0 20,0x41,0 21,5x36,0 22,8x40,3 24,3x40,3 26,3x40,3 27,3x40,3	12,0x36,0 13,8x40,3 14,5x36,0 15,0x41,0 17,0x36,0 17,8x40,3 19,3x35,3 20,8x35,3 21,5x41,0 23,5x36,0 25,0x41,0 26,5x41,0 28,0x41,0
			IDM60EYM	
			IDM60EZM	



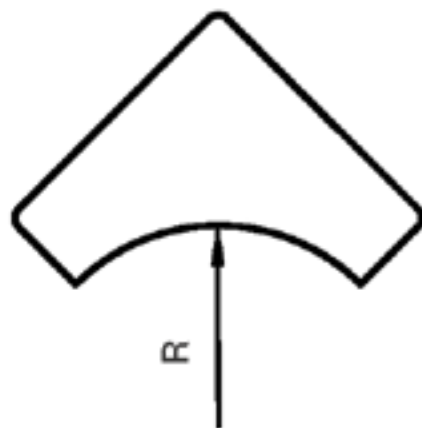
Key Hole



Punches		
GR 2	10,5x17,5x33,5	IPGR2.CM
GR 3	10,5x17,5x33,5	IPGR3.CM

Dies		
M 45	10,8x17,8x33,8	IDM45.CM
M 60	10,8x17,8x33,8	IDM60.CM

Corner Radius Tool



Punches		
GR 2	R 15	IPGR2.TM
GR 3	R 22	IPGR3.TM
GR 4	R 30	IPGR4.TM

Dies		
M 45	R 15	IDM45.TM
M 60	R 22	IDM60.TM
M 80	R 30	IDM80.TM



Punches Reduction

Standard	
GR 2 / GR 1	WQGR21XM
GR 3 / GR 1	WQGR31XM
GR 3 / GR 2	WQGR32XM
GR 4 / GR 2	WQGR42XM
GR 4 / GR 3	WQGR43XM

Dies Reduction

Standard	
M 45 / M 30	WS4530XM
M 60 / M 45	WS6045XM
M 60 / M 30	WS6030XM
M 80 / M 60	WS8060XM
M 80 / M 45	WS8045XM
M 80 / M 30	WS8030XM

Orientation Pin

Standard	
GR 2	WQGR2.XM
GR 3	WQGR3.XM
GR 4	WQGR4.XM

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IMAC/SELFER/ALFRA

Tools Dimensions

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Punches and Dies

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Accessories

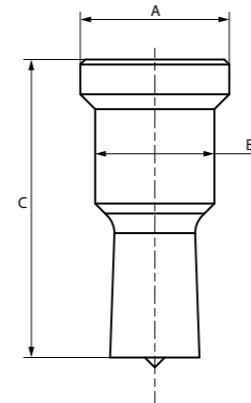
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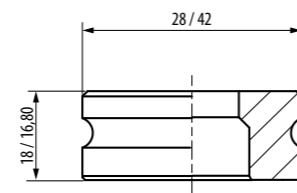
PUNCHES Dimensions

		A (mm)	B (mm)	C (mm)
IMAC	P 18	20,00	18,00	44,30
	P 24	30,00	24,00	60,00
	P 26	30,00	26,00	60,00
	P 70	39,80	31,70	79,50
SELFER	P 24	30,00	24,00	60,00
	P 26	30,00	26,00	60,00
ALFRA	P 24	30,00	24,00	60,00
	P 26	30,00	26,00	60,00



DIES Dimensions

		A (mm)	B (mm)
IMAC	M 32	32,00	19,00
	M 42	42,00	16,80
	M 42	42,00	16,80
	M 40	54,00	25,40
SELFER	M 28	28,00	18,00
	M 42	42,00	16,80
ALFRA	M 28	28,00	18,00
	M 42	42,00	16,80



		Standard		Standard		Standard			
IMAC	AL - 30 AL - 44 AN - 44 Punch P 24	6-24 mm, 1 mm step	IPP24.RI	7-17 mm, 1 mm step	IPP24.QI	6x24 9x24 13x24 18x24	7x24 10x24 14x24 *20x26	8x24 12x24 16x24	IPP24.OI
		25, 26*, 27, 28, 29, 30**	IPP24SRI IPP26.RI	18*, 19, 20, 21**	IPP24SQI IPP26.QI				IPP26.OI
	Die M 42	6-30 mm, 1 mm step	IDM42.RI	7-21 mm, 1 mm step	IDM42.QI	6x24 9x24 13x24 18x24	7x24 10x24 14x24 *20x26	8x24 12x24 16x24	IDM42.OI
	AL - 66 AL - 80 Punch P 70	8-31 mm, step 2 mm	IPP70.RI			14x30 18x30 22x30	16x30 20x30	18x26 22x26	IPP70.OI
	Die M 40	8-31 mm, step 2 mm	IDM40.RI			14x30 18x30 22x30	16x30 20x30	18x26 22x26	IDM40.OI
SELFER	A 11 - 1624 A 07 - 1624 A 06 - 1322 Punch P 24	6-24 mm, 1 mm step	IPP24.RS	7-17 mm, 1 mm step	IPP24.QS	6x24 9x24 13x24 18x24	7x24 10x24 14x24 *20x26	8x24 12x24 16x24	IPP24.OS
		25, 26*, 27, 28, 29, 30**	IPP24SRS IPP26.RS	18*, 19, 20, 21**	IPP24SQS IPP26.QS				IPP26.OS
	Die M 42	6-30 mm, 1 mm step	IDM42.RS	7-21 mm, 1 mm step	IDM42.QS	6x24 9x24 13x24 18x24	7x24 10x24 14x24 *20x26	8x24 12x24 16x24	IDM42.OS
	Adapter			7-21 mm, 1 mm step	IA...QS	6x24 9x24 13x24 18x24	7x24 10x24 14x24 *20x26	8x24 12x24 16x24	IA...OS
	A 05 - 1018 Punch P 24	6-18 mm, 1 mm step	IPP24.RS						
	Die M 28	6-18 mm, 1 mm step	IDM28.RS						
ALFRA PRESS	APS - 70 APS - 120 Punch P 24	6-24 mm, 1 mm step	IPP24.RA	7-17 mm, 1 mm step	IPP24.QA	6x24 9x24 12x24 16x24	7x24 10x24 13x24 18x24	8x24 11x24 14x24 *20x26	IPP24.OA
		25, 26*, 27, 28, 29, 30**	IPP24SRA IPP26.RA	18*, 19, 20, 21**	IPP24SQA IPP26.QA				IPP26.OA
	Die M 42	6-30 mm, 1 mm step	IDM42.RA	7-21 mm, 1 mm step	IDM42.QA	6x24 9x24 13x24 18x24	7x24 10x24 14x24 *20x26	8x24 12x24 16x24	IDM42.OA
	APS - 60 Punch P 24	6-18 mm, 1 mm step	IPP24.RA						
	Die M 28	6-18 mm, 1 mm step	IDM28.RA						

* P 26, ** P 24 S

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	Standard		Standard		Standard	
Punch Locking Nut	Ø 24	WNP24.XR	Ø 26	WNP26.XR	for punch with Ø > 26 mm	WNP24SXR
Punch Locking Key	Ø 24	WKP24.XR	Ø 26	WKP26.XR	Ø 30	WKP24SXR



FICEP CNC

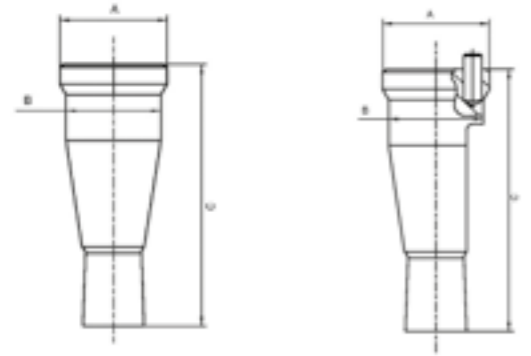


Punches

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Dies

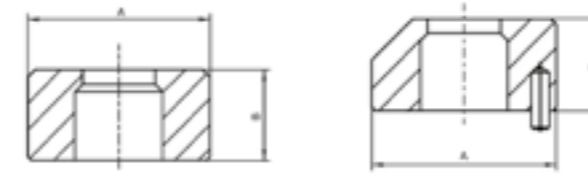
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Straight Punch

Relieved Punch

	A (mm)	B (mm)	C (mm)
Body 18	21,50	18,00	85,72
Body 39	42,86	38,89	68,26
Body 27	31,75	26,98	85,72
Body 31	34,92	30,95	85,72
Body 39,5	47,62	39,68	85,72
Body 45	50,80	45,24	85,72



Straight Die

Relieved Dies

	A (mm)	B (mm)
M 50.8	50,80	25,40
M 50.8 (Relieved)	50,80	25,40
M 60.3	60,32	31,70
M 60.3 (Relieved)	60,32	31,70
M 73	73,02	31,70
M 73 (Relieved)	73,02	31,70

	Standard		Standard	
Body 18 (Straight)	7-18 mm, 1/2 mm step	IPC18SRF		
Body 39 (Straight)	9-32 mm, 1 mm step	IPC39SRF		
Body 27 (Straight)	6-25 mm, 1/2 mm step	IPC27SRF	L max = 25 mm	IPC27SOF
Body 31 (Straight)	6-30 mm, 1/2 mm step	IPC31SRF	L max = 30 mm	IPC31SOF
Body 31 (Relieved)	6-30 mm, 1/2 mm step	IPC31RRF	L max = 30 mm	IPC31ROF
Body 39,5	28-40 mm, 1 mm step	IPC39SRF	L max = 39 mm	IPC39SOF
Body 45	31-46 mm, 1 mm step	IPC45.RF	L max = 45 mm	IPC45.OF



	Standard		Standard	
M 50.8	8-30 mm, 1/2 mm step die clarence 0,2/0,7	IDM508RF	L max = 30 mm	IDM508OF
M 50.8 (Relieved)	8-30 mm, 1/2 mm step die clarence 0,2/0,7	IDM508DF	L max = 30 mm	IDM508FF
M 60.3	8-39 mm, 1/2 mm step die clarence 0,2/0,7	IDM603RF	L max = 39 mm	IDM603OF
M 60.3 (Relieved)	8-39 mm, 1/2 mm step die clarence 0,2/0,7	IDM603DF	L max = 39 mm	IDM603FF
M 73	8-45 mm, 1/2 mm step die clarence 0,2/0,7	IDM73.RF	L max = 45 mm	IDM73.OF
M 73 (Relieved)	8-45 mm, 1/2 mm step die clarence 0,2/0,7	IDM73.DF	L max = 45 mm	IDM73.FF



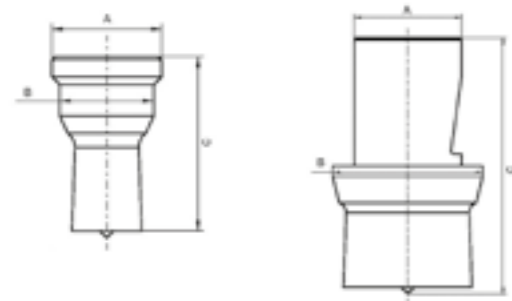


FICEP



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FICEP: Punches



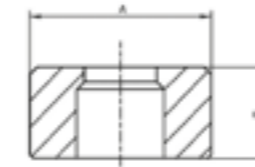
Punch

ED Punch

	A (mm)	B (mm)	C (mm)
Body 28	31,50	28,00	55,00
Body 32	34,90	32,00	60,30
Body 40	46,00	40,00	60,30
Body 51	57,00	51,00	60,30
ED 70 / ED 100	50,00		115,00



FICEP: Dies



Straight Dies

	A (mm)	B (mm)
M 46	46,00	28,60
M 50.8	50,80	25,40
M 63.5	63,50	31,70
M 79,37	79,37	41,27
M 150	150,00	40,00

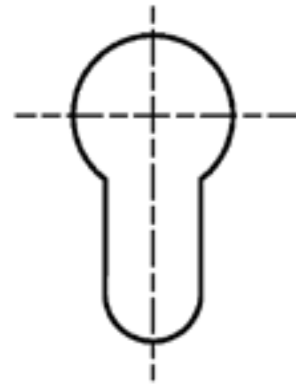


	Standard		Standard		Standard			
Body 28	4-28 mm, 1/2 mm step	IPC28.RF	4-19 mm, 1 mm step	IPC28.QF	4x8 7x14 10x20 13x26 18x28	5x10 8x16 11x22 14x28	6x12 9x18 12x24 16x28	IPC28.OF
Body 32	5-32 mm, 1/2 mm step	IPC32.RF	5-22 mm, 1 mm step	IPC32.QF	5x10 8x16 11x22 14x28 18x32	6x12 9x18 12x24 15x30 20x32	7x14 10x20 13x26 16x32 22x32	IPC32.OF
Body 40	33-40 mm, 1 mm step	IPC40.RF	23-28 mm, 1 mm step	IPC40.QF	L max = 40 mm			IPC40.OF
Body 51	41-50 mm, 1 mm step	IPC51.RF	29-35 mm, 1 mm step	IPC51.QF	L max = 50 mm			IPC51.OF
ED 70	51-70 mm, 1 mm step	IPE70.RF	36-50 mm, 1 mm step	IPE70.QF	L max = 70 mm			IPE70.OF
ED 100	71-100 mm, 1 mm step	IPE100RF	∅ max =100 mm	IPE100QF	L max = 100 mm			IPE100OF

	Standard		Standard		Standard			
					die clarence 0,2/0,7			
M 46 (max ∅=28)	4-28 mm, 1/2 mm step die clarence 0,2/0,7	IDM46.RF	4-19 mm, die clarence 0,2/0,7	IDM46.QF	4x8 7x14 10x20 13x26	5x10 8x16 11x22 14x28 18x28	6x12 9x18 12x24 16x28	IDM46.OF
M 50,8 (max ∅=32)	5-32 mm, 1/2 mm step die clarence 0,2/0,7	ID5083RF	5-22 mm, die clarence 0,2/0,7	ID5083QF	5x10 8x16 11x22 14x28 18x32	6x12 9x18 12x24 15x30 20x32	7x14 10x20 13x26 16x32 22x32	ID5083OF
M 63,5 (max ∅=40)	33-40 mm, 1 mm step die clarence 0,2/0,7	IDM635RF	26-28 mm, die clarence 0,2/0,7	IDM635QF	L max = 40 mm			IDM635OF
M 79,37 (max ∅=50)	41-50 mm, 1 mm step die clarence 0,2/0,7	ID7937RF	30-32 mm, die clarence 0,2/0,7	ID7937QF	L max = 50 mm			ID7937OF
M 150 (max ∅=100)	51-100 mm, 1 mm step die clarence 0,2/0,7	IDM150RF	∅ max =100 mm	IDM150QF	L max = 100 mm			IDM150OF



Key Hole



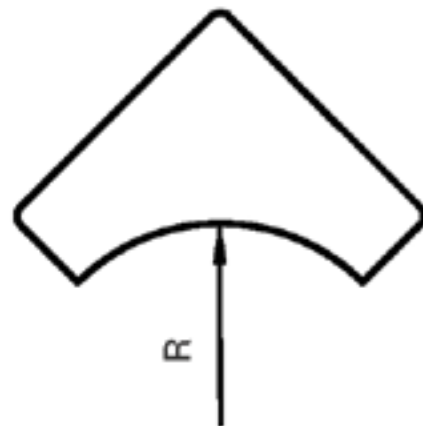
Punch	Size
IP...CF	10,5x17,5x33,5

Die	Size
ID...CF	10,8x17,8x33,8

	Standard	
Punch Locking Nut Body 28	round	WNC28.XF
Punch Locking Nut Body 32	round	WNC32.XF

	Standard
Orientation Pin	WO...XF

Corner Radius Tool



Punch	Radius
IP...TF	R 10
IP...TF	R 15

Die	Radius
IP...TF	R 10
IP...TF	R 15



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KINGSLAND



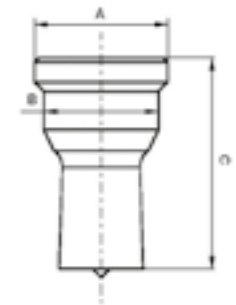
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Machine	Punch	Die
Compact 40, 45,60 Punch 50, 60, 70, 80, 95 Multi 60, 70, 80, 95	9000	9020
	9001	9022
	9004	9023
	9007	9024
	9010	9025
Punch 125, 175 Multi 125, 175	9011	9026
	9006	9020
		9022
		9023
	9009	9024
	9010	9025
	9011	9026



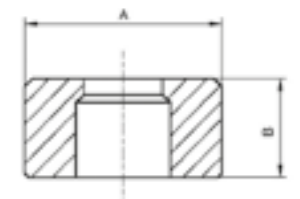
PUNCHES Dimensions

	A (mm)	B (mm)	C (mm)
9000	25,40	19,20	61,20
9001 (9171 9184)	34,90	30,90	60,30
9004 (9172 9185)	44,40	38,00	60,30
9006 (9174 9187)	44,40	39,70	76,00
9007 (9175 9188)	62,50	57,00	60,30
9009 (9177 9190)	62,50	57,00	76,00
9010 (9178 9191)	91,70	85,00	76,00
9011 (9179 9192)	117,70	110,00	76,00



DIES Dimensions

	A (mm)	B (mm)
9020	31,75	19,00
9022	34,60	22,00
9023 (9213 9221)	60,30	31,80
9024 (9214 9222)	93,60	31,80
9025 (9215 9223)	114,90	31,80
9026 (9216 9224)	140,00	31,80
9023 E (9221 EB-EA)	60,30	31,80



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KINGSLAND: Punch



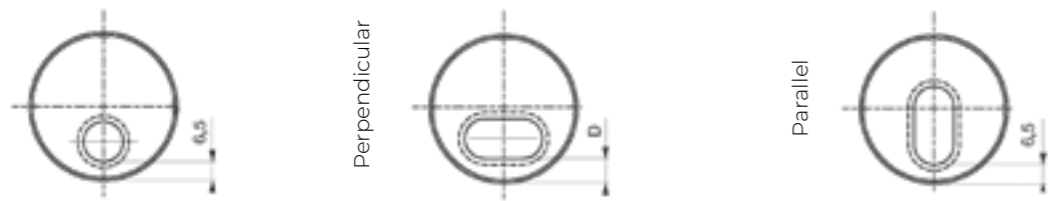
	Standard		Standard		Standard			
9000 Option	9000 4-19 mm, 1/2 mm step	IP9000RK						
9001	9001 4-30 mm, 1/2 mm step	IP9001RK	9171 4-21 mm, 1 mm step	IP9171QK	9184 5x10 6x12 7x14 8x16 9x18 10x20 11x22 12x24 13x26 14x28 15x30			IP9184OK
9004	9004 31-38 mm, 1/2 mm step	IP9004RK	9172 22-26 mm, 1 mm step	IP9172QK	9185 16x32 18x36 24x38 20x38 22x38			IP9185OK
9007	9007 39-57 mm, 1 mm step	IP9007RK	9175 27-40 mm, 1 mm step	IP9175QK	9188 L max= 57 mm			IP9188OK
9010	9010 58-85 mm, 1 mm step	IP9010RK	9178 L max= 85 mm	IP9178QK	9191 L max= 85 mm			IP9191OK
9011	9011 86-110 mm, 1 mm step	IP9011RK	9179 L max= 110 mm	IP9179QK	9192 L max= 110 mm			IP9192OK
9006	9006 5-38 mm, 1 mm step	IP9006RK	9174 L max= 39 mm	IP9174QK	9187 L max= 39 mm			IP9187OK
9009	9009 38-57 mm, 1 mm step	IP9009RK	9177 L max= 57 mm	IP9177QK	9190 L max= 57 mm			IP9190OK
9010	9010 58-85 mm, 1 mm step	IP9010RK	9178 L max= 85 mm	IP9178QK	9191 L max= 85 mm			IP9191OK
9011	9011 86-110 mm, 1 mm step	IP9011RK	9179 L max= 110 mm	IP9179QK	9192 L max= 110 mm			IP9192OK

KINGSLAND: Die



	Standard		Standard		Standard		
9020	9020 4-19 mm, 1/2 mm step die clarence 0,2/0,7	ID9020RK					
9022	9022 4-19 mm, 1/2 mm step die clarence 0,2/0,7	ID9022RK					
9023	9023 4-38 mm, 1/2 mm step die clarence 0,2/0,7	ID9023RK	9213 4-26 mm, die clarence 0,2/0,7	ID9213QK	9221 5x10 6x12 7x14 8x16 9x18 10x20 11x22 12x24 13x26 14x28 15x30 16x32 18x36 20x38 22x38 24x38		ID9221OK
9024	9024 39-57 mm, 1 mm step die clarence 0,2/0,7	ID9024RK	9214 Ø max= 57 mm die clarence 0,2/0,7	ID9214QK	9222 L max= 57 mm die clarence 0,2/0,7		ID9222OK
9025	9025 58-85 mm, 1 mm step die clarence 0,2/0,7	ID9025RK	9215 Ø max= 85 mm die clarence 0,2/0,7	ID9215QK	9223 L max= 85 mm die clarence 0,2/0,7		ID9223OK
9026	9026 86-110 mm, 1 mm step die clarence 0,2/0,7	ID9026RK	9216 Ø max= 110 mm die clarence 0,2/0,7	ID9216QK	9224 L max= 110 mm die clarence 0,2/0,7		ID9224OK



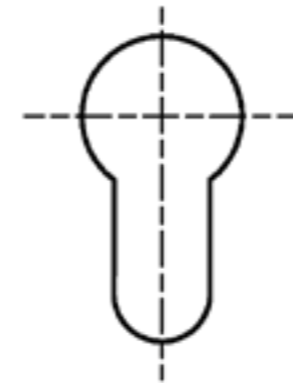


Perpendicular

Parallel

Standard		Standard		Standard		
9023 E	9023 E	ID9023WK	9221 EB	ID9221YK	9221 EA	ID9221ZK

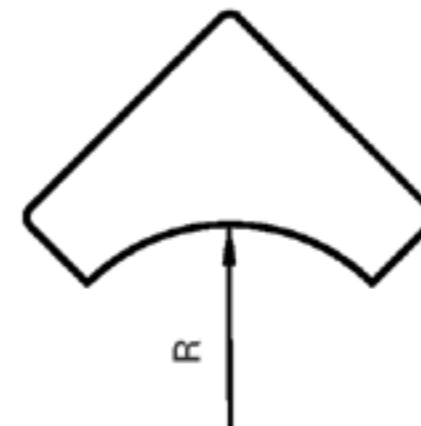
Key Hole



Punches	
9512/6CE (Body 9004)	IP9512CK
9514/6CE (Body 9006)	IP9514CK

Dies	
9516/6CE	ID9516CK

Corner Radius Tool



Punches		
9001	R 10	IP9001TK
	R 15	
9004	R 20	IP9004TK

Dies		
M 45	R 10	ID9023TK
M 60	R 15	
M 80	R 20	



OMERA




Punches

64

Dies

65

OMERA: Punches



	Standard		Standard		Standard	
Body 12 H 50 mm	4-12 mm, 1/2 mm step	IP013RRO				
Body 30 H 50 mm	4-30 mm, 1/2 mm step	IP0130RO	4-21 mm, 1 mm step	IP0130QO	5,0x10 7,0x14 10,0x20 12,0x24 14,0x28 16,0x30 20,0x30	6,0x12 8,0x16 11,0x22 13,0x26 15,0x30 18,0x30 IP0130OO
Body 35 H 65 mm	4-35 mm, 1/2 mm step	IP1365RO	4-24 mm, 1 mm step	IP1365QO	L max = 35 mm IP1365OO	

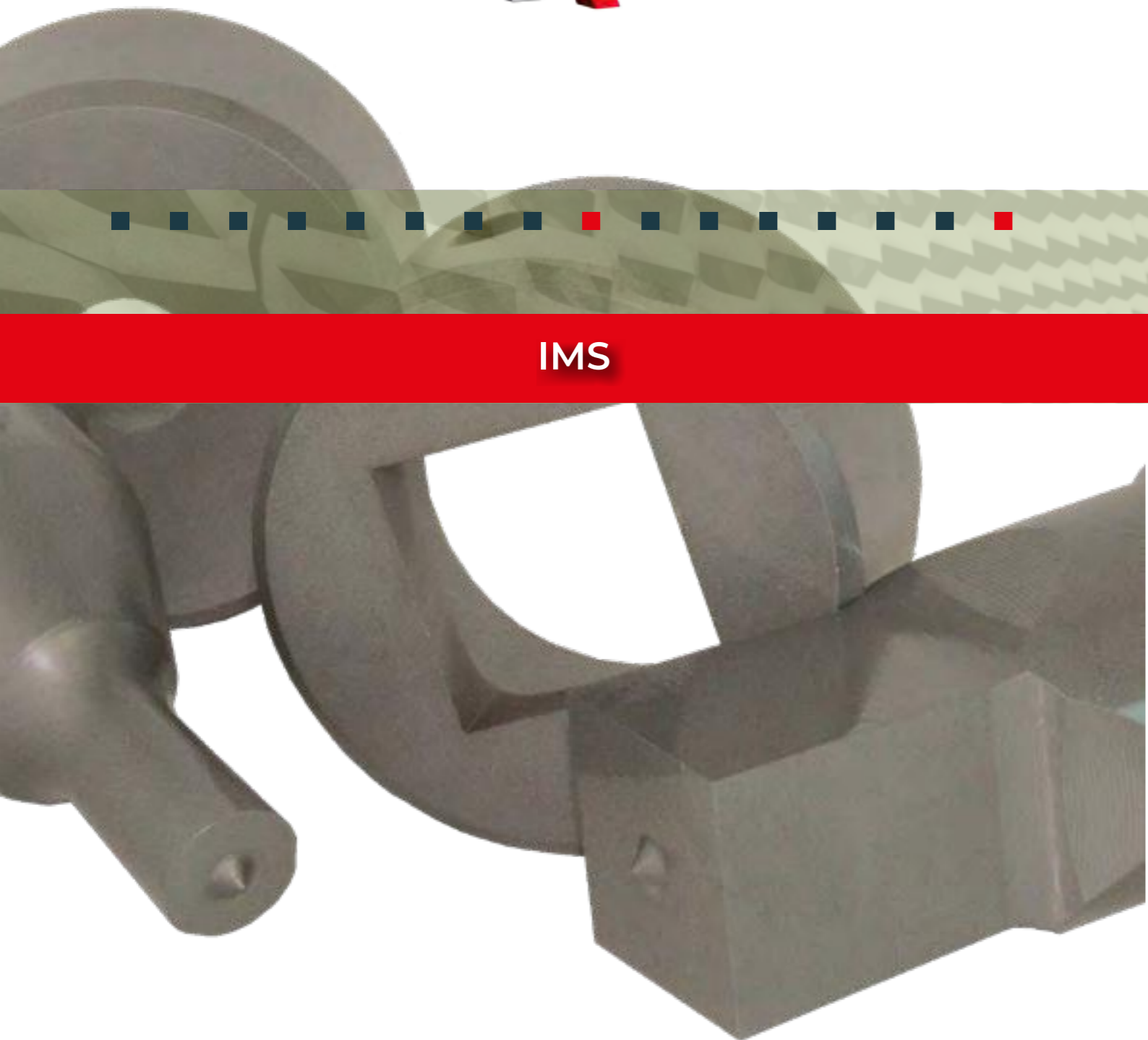
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OMERA: Dies



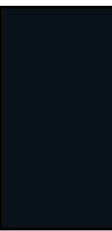
	Standard		Standard		Standard	
Body 45 H 20 mm	4-30 mm, 1/2 mm step die clarence 0,2/0,7	ID1635RO	4-21 mm, 1 mm step die clarence 0,2/0,7	ID1635QO	5,0x10 7,0x14 10,0x20 12,0x24 14,0x28 16,0x30 20,0x30	6,0x12 8,0x16 11,0x22 13,0x26 15,0x30 18,0x30 ID1635OO
Body 55 H 30 mm	4-30 mm, 1/2 mm step die clarence 0,2/0,7	ID1655RO	4-21 mm, 1 mm step die clarence 0,2/0,7	ID1655QO	L max. = 35 mm ID1655OO	
Body 65 Relieved 55 H 30 mm	4-35 mm, 1/2 mm step die clarence 0,2/0,7	ID1665RO	4-24 mm, 1 mm step die clarence 0,2/0,7	ID1665QO	L max. = 35 mm ID1665OO	

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IMS

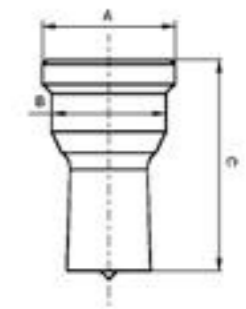
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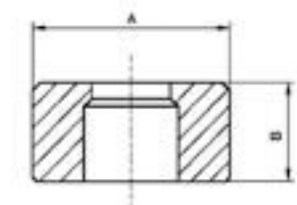
PUNCHES Dimensions

	A (mm)	B (mm)	C (mm)
Body 32	36	32	61
Body 62	65	62	61
Maxi 80	80	80	37



DIES Dimensions

	A (mm)	B (mm)
M 50,8	50,8	25,4
M 79,5	79,5	36,5
M 120	120	25,4



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IMS: Punches



	Standard		Standard		Standard		
Body 32 H 61 mm	5-32 mm, 1/2 mm step	IPPC32RX	4-22 mm, 1 mm step	IPPC32QX	5,0x10 7,0x14 9,0x18 11,0x22 13,0x26 15,0x30 18,0x32	6,0x12 8,0x16 10,0x20 12,0x24 14,0x28 16,0x32 20,0x32	IPPC32OX
Body 62 H 61 mm	33-52 mm, 1/2 mm step	IPPC52RX	23-36 mm, 1 mm step	IPPC52QX	L max = 50 mm		IPPC52OX
Extra size MAXI 80	53-80 mm, 1 mm step	IPPC80RX	37-55 mm, 1 mm step	IPPC80QX			

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IMS: Dies



	Standard		Standard		Standard		
Body 50,8 H 25,4 mm	4-32 mm, 1/2 mm step die clarence 0,2/0,7	IM5080RX	4-22 mm, die clarence 0,2/0,7	IM5080QX	5,0x10 7,0x14 9,0x18 11,0x22 13,0x26 15,0x30 18,0x32	6,0x12 8,0x16 10,0x20 12,0x24 14,0x28 16,0x32 20,0x32	IM5080OX
	die clarence 0.2/0.7						
Body 79,5 H 36,5 mm	33-52 mm, 1/2 mm step die clarence 0,2/0,7	IM7950RX	23-36 mm, die clarence 0,2/0,7	IM7950QX	L max. = 52 mm		IM7950OX
Body 120 H 25,4 mm	52-81 mm, 1 mm step die clarence 0,2/0,7	IMM120RX	37-55 mm, 1 mm step	IMM120QX	L max. = 80 mm		

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Dies Clearance

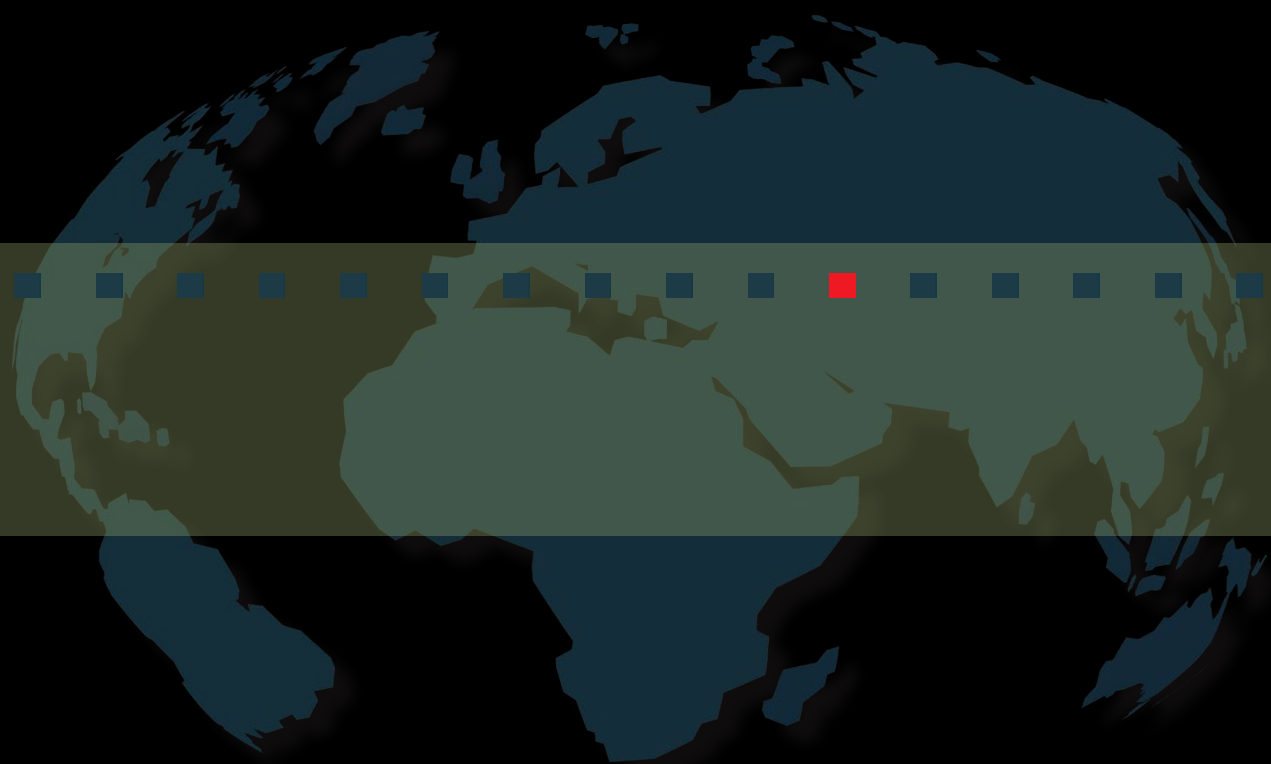
Material Thickness	1 - 2 - 3 - 4	5 - 6 - 7 - 8 - 9	10 - 11 - 12 - 13 - 14	15 - 16 - 17 - 18 - 19	20 - 21 - 22 - 23 - 24 - 25
Die Clearance	0,2 mm	0,7 mm	1,2 mm	1,7 mm	2,2 mm

You can use this table for material with tensile strength of 40kg/mm² (Iron/zinc sheetmetal) or softer. For Stainless steel (or with higher strenght) it's better to use die clearance equal to 20% of material thickness.

We suggest you to use punches with minimum quota bigger than material thickness



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