

SS-1

SS-2

SS-3

SS-4

SS-5

SS-6

SS-7

SS-8

SS-9

SS-10

SS-87

SS-86

SS-42

SS-40

SS-38

SS-37

SS-36

SS-35

SS-34

SS-33

SS-32

SS-31

EPTM

EXACTA

IRONWORKER

PUNCHES AND DIES

*Made better to last longer,
cut down-time*

WILSON
TOOL

SS-11

SS-12

SS-13

SS-14

SS-15

SS-16

SS-17

SS-18

SS-19

SS-20

SS-21

SS-22

SS-30

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SS-27

SS-26

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SS-24

SS-23

SS-22

EXACTA IRONWORKER TOOLING.

YEARS OF INDUSTRY EXPERIENCE. NOW AVAILABLE GLOBALLY.

In today's market there are many machines that fall into the classification of Ironworker Machines. These multi task machines are used generally in industries requiring the cutting, punching, notching and bending of heavier gauge materials. The styles of punches and dies used in these machines are as varied as the brand names. Exacta ironworker punches and dies are available for the vast majority of today's machines. And, if we do not carry standard products for your particular machine, we will gladly manufacture any custom tooling you may need.

Manufactured at our facility in Toronto, our Exacta ironworker products incorporate years of industry experience and are now available through the global sales and distribution network of the world's leading independent tooling supplier – Wilson Tool.

Call us for your next quote:

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Ontario	416-291-1942
Quebec	514-333-0146

United States

651-286-6001

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Ordering Information

1. **Machine Type and Model**
2. Type of **PART #**
3. **“W”** dimension **“P”** dimension **“A”** dimension etc.
4. **DIE CLEARANCE** or material thickness and type.
5. Are the **DIMENSIONS** looking at the face of the **PUNCH** or **DIE**.
6. **KEYING STYLE** and Direction (if required).

To Order

Wilson Tool International, Inc. United States

Tel (Free): 800-328-9646
 Tel: 651-286-6001
 Fax (Free): 800-222-0002
 Fax: 651-286-5959

Email: sales@wilsontool.com

EXACTA Ontario to British Columbia

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EXACTA Quebec & Maritimes

Tel (Free): 800-361-6810
 Tel: 514-333-0146
 Télécopieur: 514-333-0147

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OSHA WARNING

It is the user's responsibility that the machine and tooling be set up and used in accordance with local and national OSHA laws and ANSI B11.5 standards for safety.



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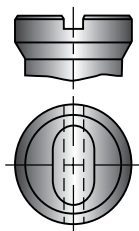
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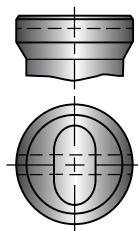
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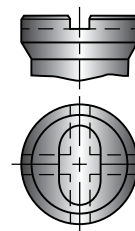
SINGLE "U"
DIRECTION "A"



SINGLE "U"
DIRECTION "B"

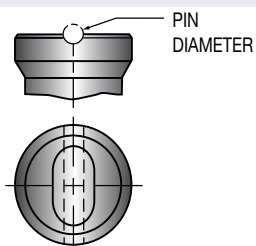


DOUBLE "U"

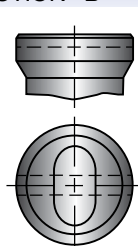


STANDARD "U" SIZES AVAILABLE (MUST ALWAYS BE SPECIFIED)
(1/4) .251 - .253 WIDE x .13-.14 DEEP
(4 mm) .158 - .160 WIDE x .08-.09 DEEP
SPECIAL SIZES AVAILABLE ON REQUEST

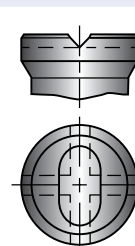
SINGLE "V"
DIRECTION "A"



SINGLE "V"
DIRECTION "B"



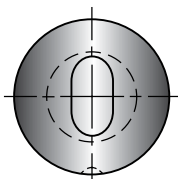
DOUBLE "V"



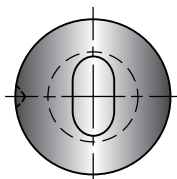
STANDARD "V" SIZES AVAILABLE (MUST ALWAYS BE SPECIFIED)
TO SUIT 3/16 DIAMETER PIN
TO SUIT 5mm DIAMETER PIN
SPECIAL SIZES AVAILABLE ON REQUEST

SPOT DRILLS

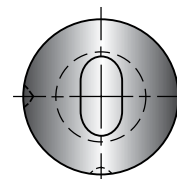
DIRECTION "A"



DIRECTION "B"



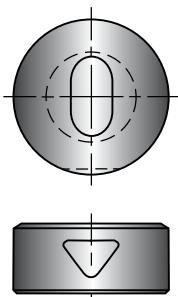
DIRECTION "AB"



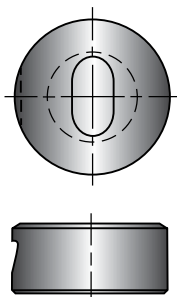
STANDARD SPOT DRILL AVAILABLE (MUST ALWAYS BE SPECIFIED)
3/8 DRILL POINT (HALFWAY UP DIE THICKNESS)
SPECIAL SIZES AVAILABLE ON REQUEST

WHISTLE NOTCH LOCATOR

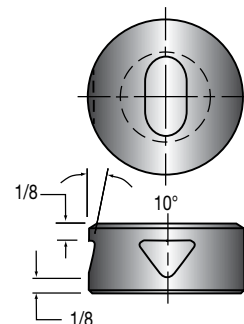
DIRECTION "A"



DIRECTION "B"

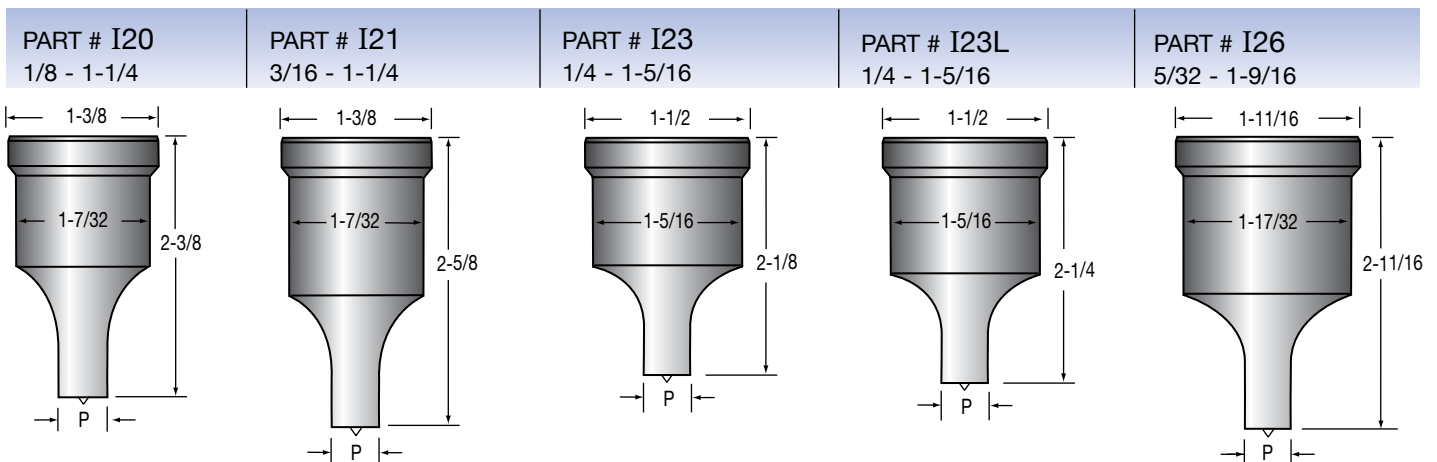
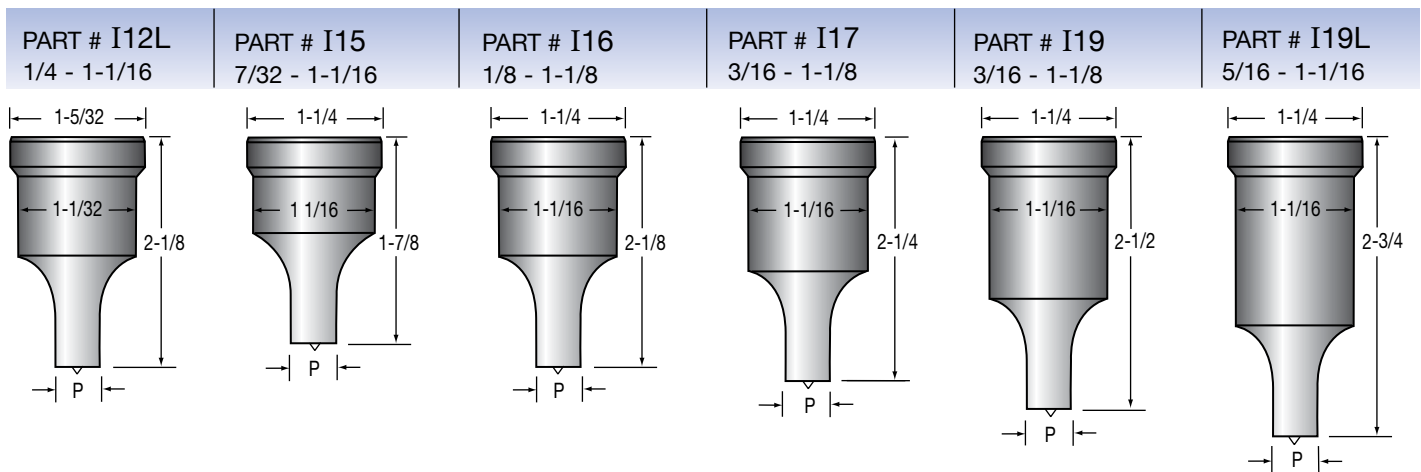
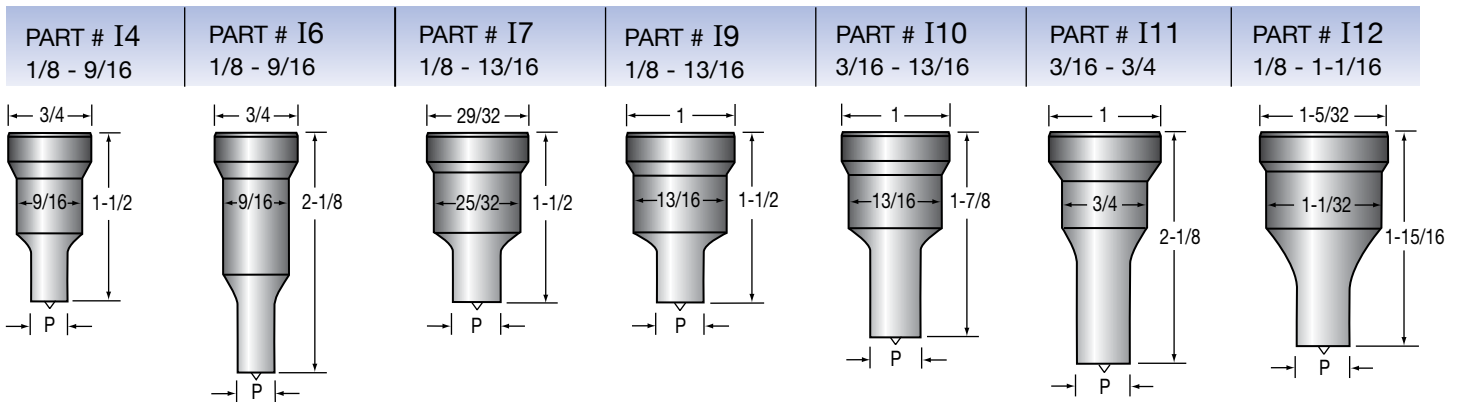


DIRECTION "AB"



ALL STANDARD SHAPED PUNCHES AND DIES ARE STOCKED WITHOUT KEYING OR LOCATORS.
KEYING OR LOCATORS CAN BE SUPPLIED ON REQUEST.

Range in 1/32 Increments



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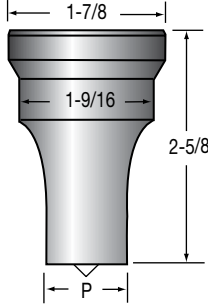
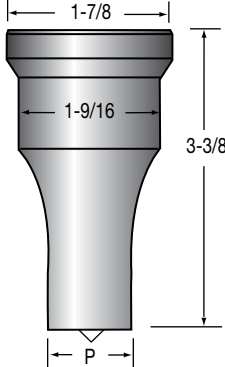
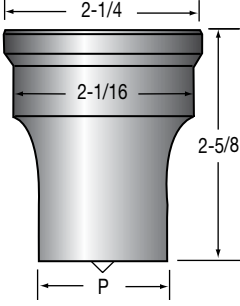
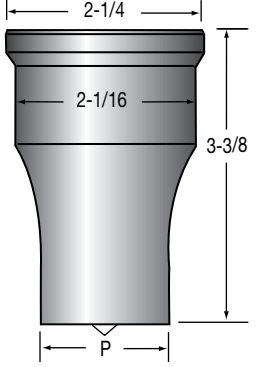
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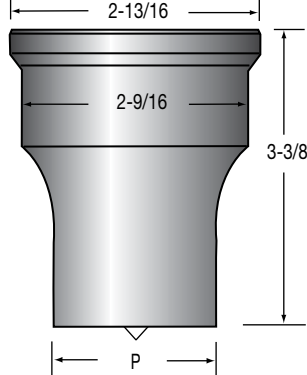
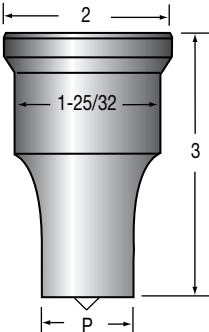
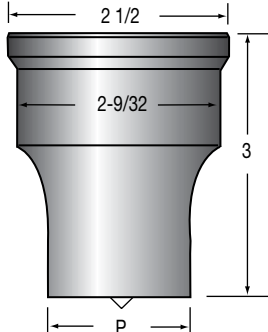
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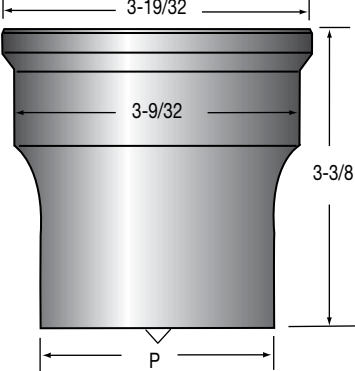
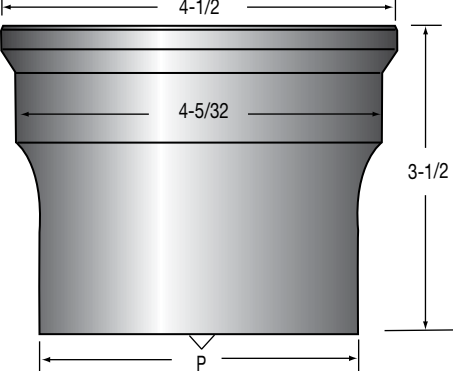
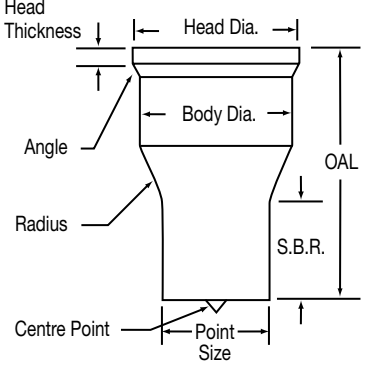
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Range in 1/32 Increments

* MADE TO ORDER

PART # I28* 11/16 - 1-9/16	PART # I29* 11/16 - 1-9/16	PART # I30* 15/16 - 2-1/16	PART # I31* 15/16 - 2-1/16
			

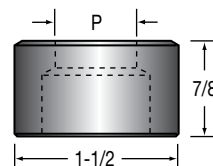
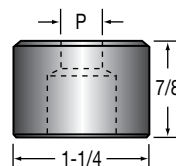
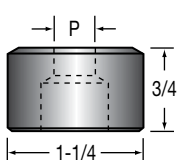
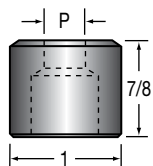
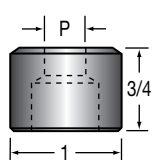
PART # I32* 1-1/16 - 2-9/16	PART # I34* 13/16 - 1-25/32	PART # I37* 1-1/16 - 2-9/32
		

PART # I39* 1-1/2 - 3-9/32	PART # I40* 1-3/4 - 4-5/32	Punch Anatomy
		

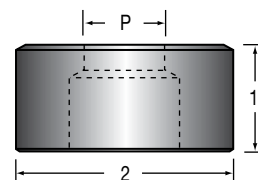
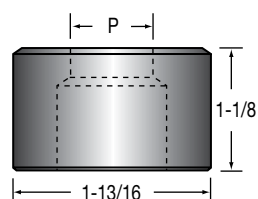
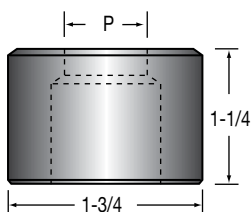
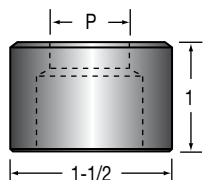
Range in 1/32 Increments

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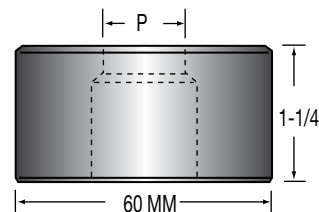
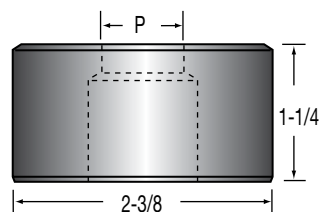
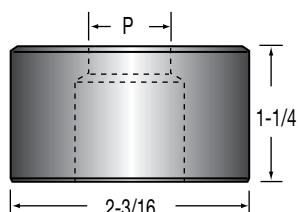
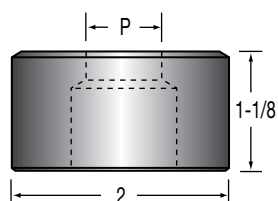
PART # I41* 5/32 - 3/4	PART # I42 5/32 - 25/32	PART # I43,5* 5/32 - 15/16	PART # I43 5/32 - 15/16	PART # I45 5/32 - 1-1/8
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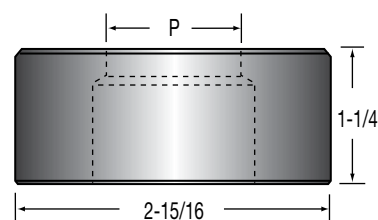
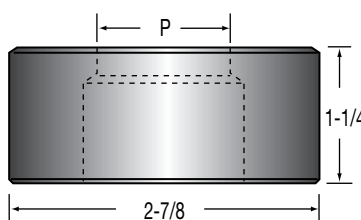
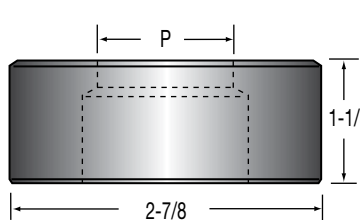
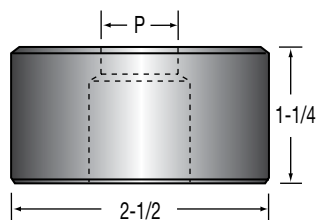
PART # I46 5/32 - 1-3/16	PART # I52 3/16 - 1-1/4	PART # I55 1/8 - 1-3/8	PART # I59 5/32 - 1-7/16
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PART # I60 5/32 - 1-17/32	PART # I61* 5/32 - 1-1/2	PART # I62 3/16 - 1-5/8	PART # I60MM* 1/8 - 1-5/8
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PART # I65 7/32 - 1-11/16	PART # I88* 5/32 - 1-3/4	PART # I89* 5/32 - 1-3/4	PART # I90* 5/32 - 1-7/8
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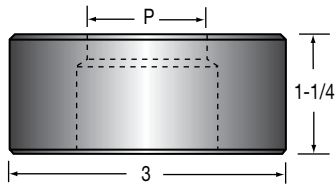
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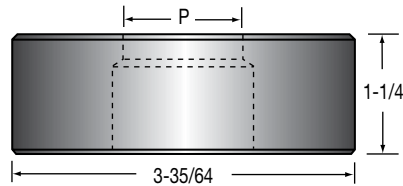
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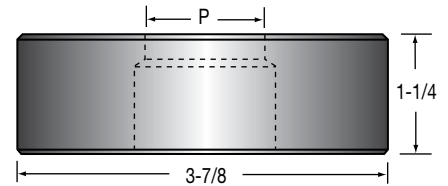
PART # I71*
5/32 - 1-7/8



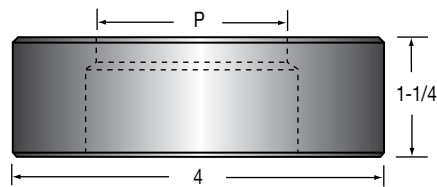
PART # I91MM*
5/32 - 2-9/32



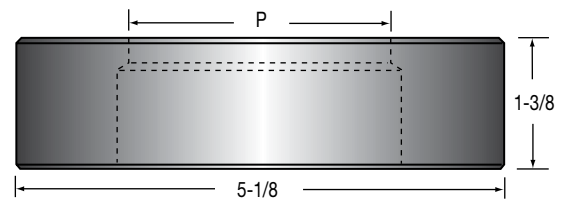
PART # I92*
5/32 - 2-1/2



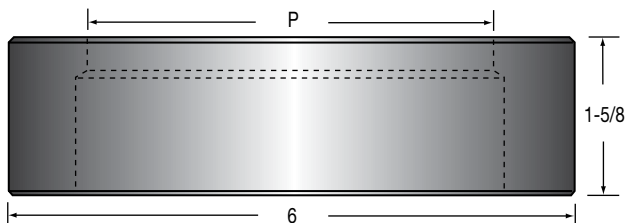
PART # I72*
5/32 - 3



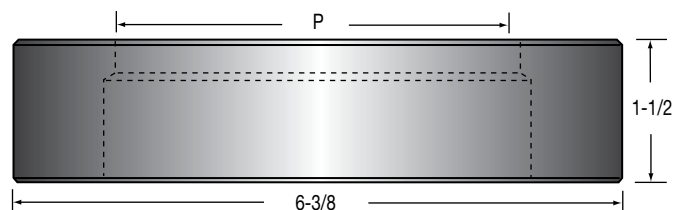
PART # I94*
5/32 - 4



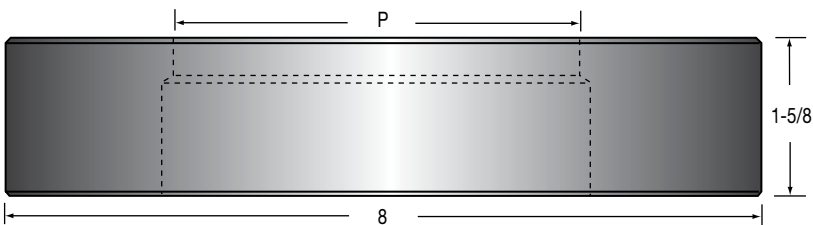
PART # I73*
5/32 - 5



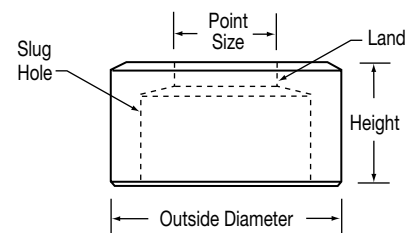
PART # I96*
5/32 - 5



PART # I74*
5/32 - 6-3/4



Die Anatomy





STOCK SQUARE PUNCHES

PART NUMBER

SIZE	IS12	IS16	IS20	IS26
1/4	✓	✓	✓	
9/32	✓	✓	✓	
5/16	✓	✓	✓	
11/32	✓	✓	✓	
3/8	✓	✓	✓	
13/32	✓	✓	✓	✓
7/16	✓	✓	✓	✓
15/32	✓	✓	✓	✓
1/2	✓	✓	✓	✓
17/32	✓	✓	✓	✓
9/16	✓	✓	✓	✓
19/32	✓	✓	✓	✓
5/8	✓	✓	✓	✓
21/32	✓	✓	✓	✓
11/16	✓	✓	✓	✓
23/32	✓	✓	✓	✓
3/4	✓	✓	✓	✓
25/32		✓	✓	✓
13/16			✓	✓
7/8			✓	✓
15/16				✓
1				✓
1-1/16				✓



Represents stock square size



STOCK SQUARE DIES

PART NUMBER

SIZE	IS55	IS58	IS59	IS62
9/32	✓		✓	
5/16	✓	✓	✓	
11/32	✓	✓	✓	
3/8	✓	✓	✓	✓
13/32	✓	✓	✓	✓
7/16	✓	✓	✓	✓
15/32	✓	✓	✓	✓
1/2	✓	✓	✓	✓
17/32	✓	✓	✓	✓
9/16	✓	✓	✓	✓
19/32	✓	✓	✓	✓
5/8	✓	✓	✓	✓
21/32	✓	✓	✓	✓
11/16	✓	✓	✓	✓
23/32	✓	✓	✓	✓
3/4	✓	✓	✓	✓
25/32	✓	✓	✓	✓
13/16	✓	✓	✓	✓
27/32	✓	✓	✓	✓
7/8	✓	✓	✓	✓
29/32	✓	✓	✓	✓
15/16	✓	✓	✓	✓
31/32		✓		
1		✓	✓	✓
1-1/32				
1-1/16				✓
1-3/32				
1-1/8				✓



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PART NUMBER

SIZE	IO12	IO16	IO20	IO26
3/16 x 3/4	✓	✓		
3/16 x 1	✓	✓	✓	✓
7/32 x 7/16	✓	✓	✓	
7/32 x 1	✓	✓	✓	✓
1/4 x 1/2	✓	✓	✓	✓
1/4 x 3/4	✓	✓	✓	✓
1/4 x 1	✓	✓	✓	✓
9/32 x 9/16	✓	✓	✓	✓
9/32 x 3/4	✓	✓	✓	✓
9/32 x 1	✓	✓	✓	✓
5/16 x 1/2	✓	✓	✓	✓
5/16 x 5/8	✓	✓	✓	✓
5/16 x 3/4	✓	✓	✓	✓
5/16 x 1	✓	✓	✓	✓
5/16 x 1-1/16		✓	✓	✓
5/16 x 1-1/4			✓	✓
5/16 x 1-1/2				✓
11/32 x 11/16	✓	✓	✓	✓
11/32 x 1	✓	✓	✓	✓
11/32 x 1-1/4				✓
3/8 x 1/2	✓	✓	✓	✓
3/8 x 3/4	✓	✓	✓	✓
3/8 x 1	✓	✓	✓	✓
3/8 x 1-1/4			✓	✓
3/8 x 1-1/2				✓
13/32 x 13/16	✓	✓	✓	✓
13/32 x 1	✓	✓	✓	✓
13/32 x 1-1/4			✓	✓

PART NUMBER

SIZE	IO12	IO16	IO20	IO26
7/16 x 9/16	✓	✓	✓	✓
7/16 x 3/4	✓	✓	✓	✓
7/16 x 7/8	✓	✓	✓	✓
7/16 x 1	✓	✓	✓	✓
7/16 x 1-1/16	✓	✓	✓	✓
7/16 x 1-1/4			✓	✓
7/16 x 1-1/2				✓
15/32 x 1	✓	✓	✓	✓
1/2 x 3/4	✓	✓	✓	✓
1/2 x 1	✓	✓	✓	✓
1/2 x 1-1/16		✓	✓	✓
1/2 x 1-1/4			✓	✓
1/2 x 1-1/2				✓
17/32 x 1	✓	✓	✓	✓
17/32 x 1-1/16			✓	
17/32 x 1-1/4			✓	✓
17/32 x 1-1/2				✓
9/16 x 3/4	✓	✓	✓	✓
9/16 x 1	✓	✓	✓	✓
9/16 x 1-1/16		✓	✓	✓
9/16 x 1-1/8		✓	✓	✓
9/16 x 1-1/4			✓	✓
9/16 x 1-1/2				✓
5/8 x 1	✓	✓	✓	✓
5/8 x 1-1/4			✓	✓
5/8 x 1-1/2				✓
11/16 x 1	✓	✓	✓	✓
11/16 x 1-1/16		✓	✓	✓

PART NUMBER

SIZE	IO12	IO16	IO20	IO26
11/16 x 1-1/8		✓	✓	✓
11/16 x 1-1/4			✓	✓
11/16 x 1-1/2				✓
3/4 x 1	✓	✓	✓	✓
3/4 x 1-1/4			✓	✓
3/4 x 1-1/2				✓
13/16 x 1	✓	✓	✓	✓
13/16 x 1-1/16		✓	✓	✓
13/16 x 1-1/8		✓	✓	✓
13/16 x 1-1/4			✓	✓
13/16 x 1-1/2				✓
7/8 x 1-1/4			✓	✓
7/8 x 1-1/2				✓
15/16 x 1-1/16		✓	✓	✓
15/16 x 1-1/8		✓	✓	✓
15/16 x 1-1/4			✓	✓
15/16 x 1-1/2				✓
15/16 x 1-9/16				✓
1 x 1-1/4			✓	✓
1 x 1-1/2				✓
1 x 1-9/16				✓
1-1/16 x 1-1/4			✓	✓
1-1/16 x 1-5/16				✓
1-1/16 x 1-1/2				✓
1-1/16 x 1-9/16				✓
1-1/8 x 1-1/2				✓



Represents stock oblong size



PART NUMBER

SIZE	IO55	IO58	IO59	IO62
7/32 x 25/32	✓		✓	
7/32 x 1-1/32	✓		✓	✓
1/4 x 15/32	✓		✓	
1/4 x 1-1/32	✓		✓	✓
9/32 x 17/32	✓	✓	✓	✓
9/32 x 25/32	✓	✓	✓	✓
9/32 x 1-1/32	✓	✓	✓	✓
5/16 x 17/32		✓		
5/16 x 19/32	✓		✓	✓
5/16 x 25/32	✓	✓	✓	✓
5/16 x 1-1/32	✓	✓	✓	✓
11/32 x 17/32	✓		✓	✓
11/32 x 21/32	✓		✓	✓
11/32 x 25/32	✓	✓	✓	✓
11/32 x 1-1/32	✓	✓	✓	✓
11/32 x 1-3/32	✓		✓	✓
11/32 x 1-9/32		✓	✓	✓
11/32 x 1-17/32				✓
3/8 x 23/32	✓		✓	✓
3/8 x 25/32		✓	✓	
3/8 x 1-1/32	✓	✓	✓	✓
3/8 x 1-3/32	✓	✓	✓	✓
3/8 x 1-9/32				✓
3/8 x 1-5/16			✓	✓
13/32 x 17/32	✓		✓	✓
13/32 x 25/32	✓	✓	✓	✓
13/32 x 1-1/32	✓	✓	✓	✓
13/32 x 1-9/32		✓	✓	✓
13/32 x 1-17/32				✓
7/16 x 25/32		✓		
7/16 x 27/32	✓		✓	✓
7/16 x 1-1/32	✓	✓	✓	✓
7/16 x 1-9/32		✓	✓	✓
7/16 x 1-5/16				✓
15/32 x 19/32	✓		✓	✓
15/32 x 25/32	✓	✓	✓	✓
15/32 x 29/32	✓		✓	✓



Represents stock oblong size

PART NUMBER

SIZE	IO55	IO58	IO59	IO62
15/32 x 1-1/32	✓	✓	✓	✓
15/32 x 1-3/32	✓		✓	✓
15/32 x 1-9/32		✓	✓	✓
15/32 x 1-17/32				✓
1/2 x 25/32		✓		
1/2 x 1-1/32	✓	✓	✓	✓
1/2 x 1-1/16	✓		✓	✓
1/2 x 1-5/16			✓	✓
1/2 x 1-9/32		✓		
17/32 x 25/32	✓	✓	✓	✓
17/32 x 1-1/32	✓	✓	✓	✓
17/32 x 1-3/32	✓		✓	✓
17/32 x 1-9/32		✓	✓	✓
17/32 x 1-17/32				✓
9/16 x 25/32		✓		
9/16 x 13/16	✓		✓	✓
9/16 x 1-1/32	✓	✓	✓	✓
9/16 x 1-1/16	✓		✓	✓
9/16 x 1-3/32			✓	
9/16 x 1-1/8	✓		✓	✓
9/16 x 1-3/16	✓		✓	✓
9/16 x 1-9/32	✓		✓	✓
9/16 x 1-5/16			✓	✓
9/16 x 1-17/32				✓
9/16 x 1-9/16				✓
19/32 x 25/32	✓	✓	✓	✓
19/32 x 1-1/32	✓		✓	✓
19/32 x 1-1/16	✓		✓	✓
19/32 x 1-3/32	✓		✓	✓
19/32 x 1-5/32	✓		✓	✓
19/32 x 1-9/32		✓	✓	✓
19/32 x 1-5/16		✓	✓	✓
19/32 x 1-17/32				✓
19/32 x 1-9/16				✓
5/8 x 13/16	✓		✓	✓
5/8 x 1-1/16	✓		✓	✓



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STOCK - OBLONG DIES

12

✓	Represents stock oblong size
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PART NUMBER

SIZE	IO55	IO58	IO59	IO62
5/8 x 1-1/8	✓		✓	✓
5/8 x 1-3/16	✓		✓	✓
5/8 x 1-5/16			✓	✓
5/8 x 1-9/16				✓
21/32 x 1-1/32	✓	✓	✓	✓
21/32 x 1-9/32		✓	✓	✓
21/32 x 1-17/32				✓
11/16 x 1-1/32		✓		
11/16 x 1-1/16	✓		✓	✓
11/16 x 1-9/32		✓		
11/16 x 1-5/16			✓	✓
11/16 x 1-9/16				✓
23/32 x 1-1/32	✓	✓	✓	✓
23/32 x 1-3/32	✓		✓	✓
23/32 x 1-5/32	✓		✓	✓
23/32 x 1-9/32		✓	✓	✓
23/32 x 1-17/32				✓
3/4 x 1-1/32		✓		
3/4 x 1-1/16	✓		✓	✓
3/4 x 1-1/8	✓		✓	✓
3/4 x 1-3/16	✓		✓	✓
3/4 x 1-9/32		✓		
3/4 x 1-5/16			✓	✓
3/4 x 1-9/16				✓
25/32 x 1-1/32	✓	✓	✓	✓
25/32 x 1-9/32		✓	✓	✓
25/32 x 1-17/32				✓
13/16 x 1-1/32		✓		
13/16 x 1-1/16	✓		✓	✓
13/16 x 1-9/32		✓		
13/16 x 1-5/16			✓	✓
13/16 x 1-9/16				✓
27/32 x 1-1/32	✓	✓	✓	✓
27/32 x 1-3/32	✓		✓	✓
27/32 x 1-5/32	✓		✓	✓
27/32 x 1-9/32		✓	✓	✓
27/32 x 1-17/32				✓
7/8 x 1-1/16	✓		✓	✓

PART NUMBER

SIZE	IO55	IO58	IO59	IO62
7/8 x 1-1/8	✓		✓	✓
7/8 x 1-3/16	✓		✓	✓
7/8 x 1-5/16			✓	✓
7/8 x 1-9/16				✓
29/32 x 1-9/32			✓	✓
29/32 x 1-17/32				✓
15/16 x 1-5/16			✓	✓
15/16 x 1-9/16				✓
31/32 x 1-3/32	✓		✓	✓
31/32 x 1-5/32	✓		✓	✓
31/32 x 1-9/32			✓	✓
31/32 x 1-17/32				✓
1 x 1-1/8	✓		✓	✓
1 x 1-3/16	✓		✓	✓
1 x 1-5/16			✓	✓
1 x 1-9/16				✓
1 x 1-5/8				✓
1-1/32 x 1-9/32			✓	✓
1-1/32 x 1-17/32				✓
1-1/32 x 1-19/32				✓
1-1/16 x 1-5/16			✓	✓
1-1/16 x 1-9/16				✓
1-1/16 x 1-5/8				✓
1-3/32 x 1-9/32			✓	✓
1-3/32 x 1-11/32				✓
1-3/32 x 1-17/32				✓
1-1/8 x 1-5/16			✓	✓
1-1/8 x 1-3/8				✓
1-1/8 x 1-9/16				✓
1-1/8 x 1-5/8				✓
1-5/32 x 1-17/32				✓
1-3/16 x 1-9/16				✓

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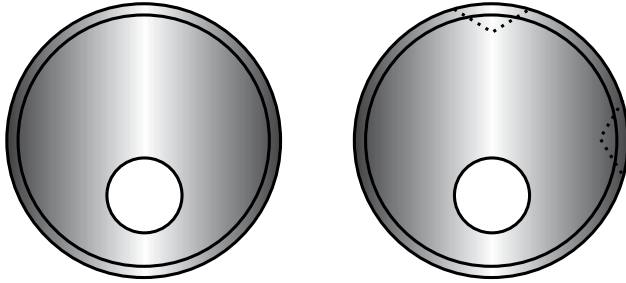
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Style 128 Offset Flat Top (Eccentric) Dies



STOCK ROUND OFFSET DIES
Style 128

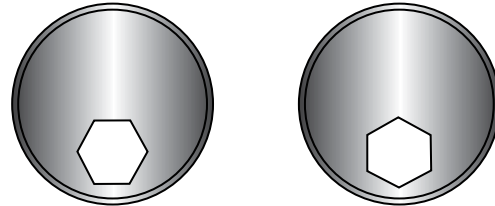
SPOT DRILLS WILL BE SUPPLIED
AS SHOWN (WHEN REQUESTED)

✓	Represents stock round sizes
---	------------------------------

PART NUMBER

SIZE	I55128	I59128	I62128
5/32	✓	✓	✓
3/16	✓	✓	✓
7/32	✓	✓	✓
1/4	✓	✓	✓
9/32	✓	✓	✓
5/16	✓	✓	✓
11/32	✓	✓	✓
3/8	✓	✓	✓
13/32	✓	✓	✓
7/16	✓	✓	✓
15/32	✓	✓	✓
1/2	✓	✓	✓
17/32	✓	✓	✓
9/16	✓	✓	✓
19/32	✓	✓	✓
5/8	✓	✓	✓
21/32	✓	✓	✓
11/16	✓	✓	✓
23/32	✓	✓	✓
3/4	✓	✓	✓
25/32	✓	✓	✓
13/16	✓	✓	✓
27/32	✓	✓	✓
7/8	✓	✓	✓
29/32	✓	✓	✓
15/16	✓	✓	✓
31/32	✓	✓	✓
1	✓	✓	✓
1-1/32	✓	✓	✓
1-1/16		✓	✓
1-3/32		✓	✓
1-1/8		✓	✓

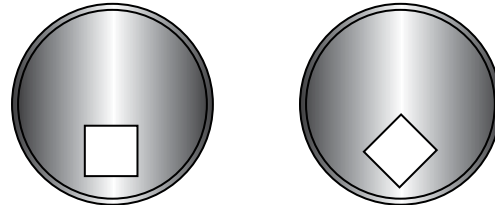
HEXAGON



POSITION A

POSITION B

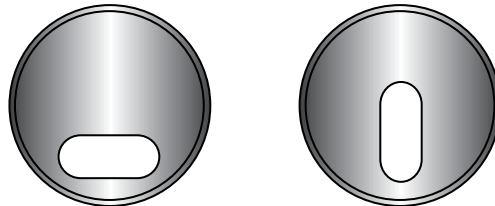
SQUARE



POSITION A

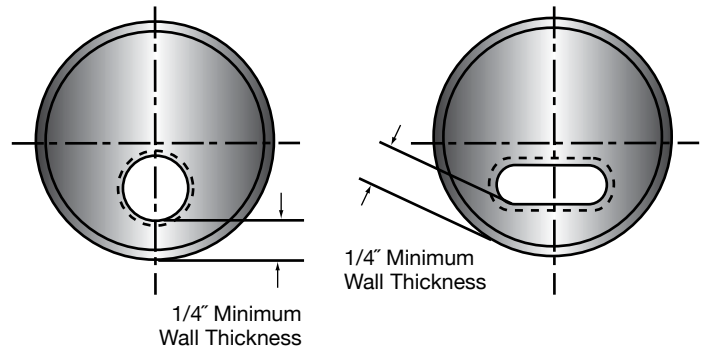
POSITION B

OBLONG



POSITION A
CLEVELAND PUNCH™
POSITION B

POSITION B
CLEVELAND PUNCH™
POSITION A



The Style 128 Offset dies are manufactured with a minimum wall thickness (front hole wall to die outside diameter) of 1/4". Stock round Style 128 offset dies are supplied **without** locators. Locators can be furnish on request.



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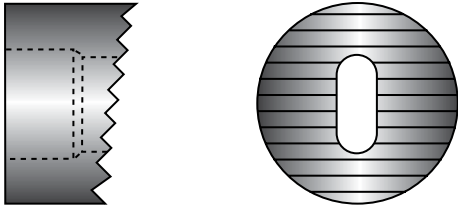
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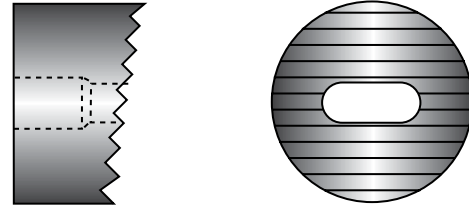
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PERPENDICULAR TO SERRATIONS



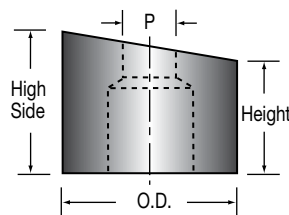
PARALLEL TO SERRATIONS



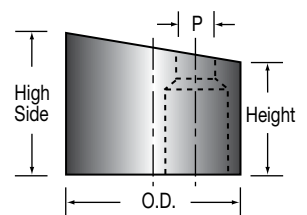
Specialty Ironworker Dies are made to order. Style 129 and Style 241 offset dies, are manufactured with a minimum wall thickness (front hole wall to die outside diameter) of 1/4".

Bevel Smooth Dies are dies designed especially for use in punching structural shapes such as "I" beams, channels and angle iron. Bevel smooth dies are recommended where the material punched is angled or does not have a uniform thickness.

Style 127
Bevel
Smooth
Concentric

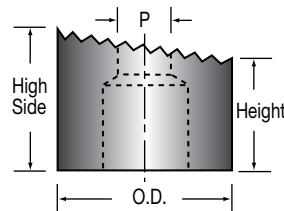


Style 129
Bevel
Smooth
Offset

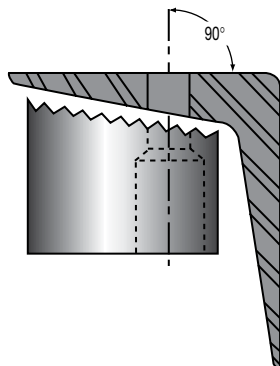
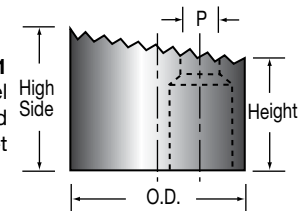


Bevel Serrated Dies perform the same function as bevel smooth dies. Serrated dies are recommended where there is a tendency for the material to slip during punching. The serrated top surface will grab the material more securely and help hold it in place during the punching operation.

Style 218
Bevel
Serrated
Concentric



Style 241
Bevel
Serrated
Offset



Most large structural shapes have a standard angle. All our bevel dies match this angle to ensure that the hole will be perpendicular to the outside surface.

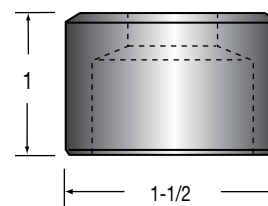
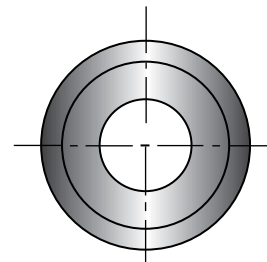
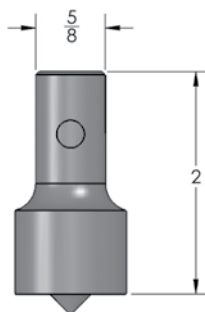
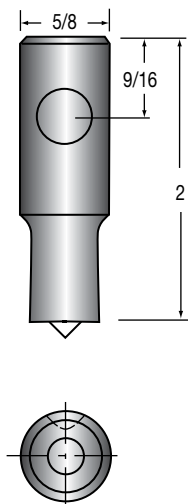
Range in 1/32 Increments

* MADE TO ORDER

PART # I158*
ROUND PUNCH
 1/8 - 5/8

PART # I158K*
ROUND PUNCH
 21/32 - 1

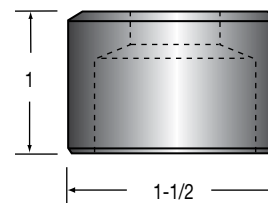
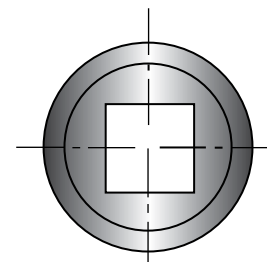
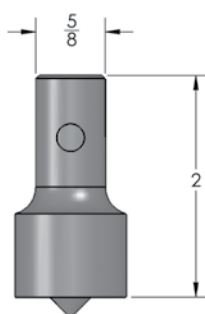
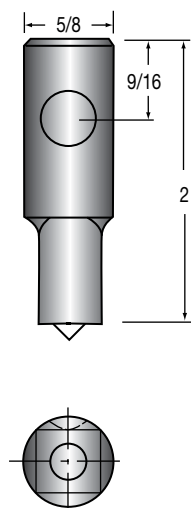
PART # I46
ROUND DIE
 5/32 - 1-3/16



PART # IS158*
SQUARE PUNCH
 7/32 - 7/16

PART # IS158K*
SQUARE PUNCH
 15/32 - 25/32

PART # IS46*
SQUARE DIE
 1/4 - 13/16



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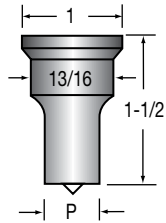
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Range in 1/32 Increments

* MADE TO ORDER

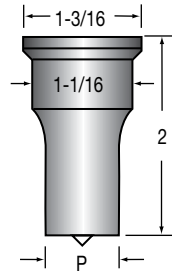
PART # I362*

1/8 - 13/16



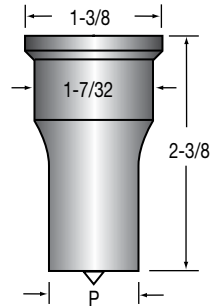
PART # I664*

3/16 - 1-1/8



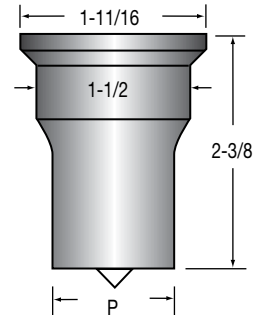
PART # I903*

1/8 - 1-1/4



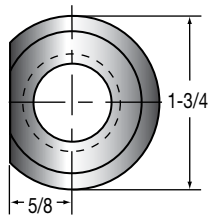
PART # I3T-10220*

3/16 - 1-1/2



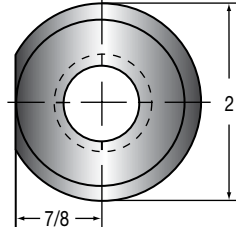
PART # I85350(0)

5/32 - 1-5/32



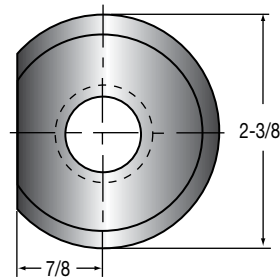
PART # I14020 (1/2)

5/32 - 1-7/32



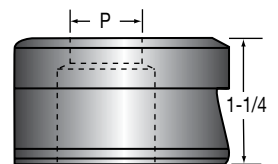
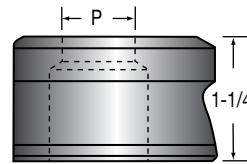
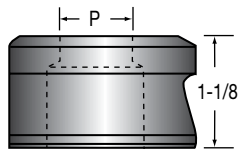
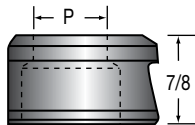
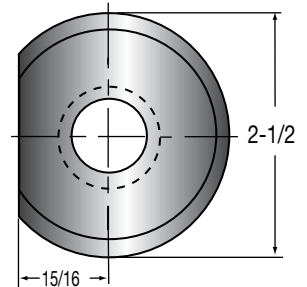
PART # I665 (1-1/2)

5/32 - 1-9/32



PART # I904 (2-1/2)

5/32 - 1-9/16



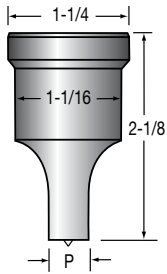
Also available as: oblongs, rectangles, and squares - both punch and die.

Range in 1/32 Increments

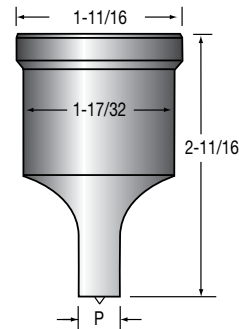
* MADE TO ORDER

PART # I16

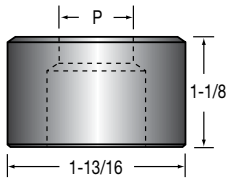
1/8 - 1-1/8

**PART # I26**

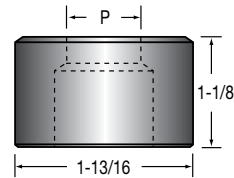
5/32 - 1-9/16

**PART # I55**

1/8 - 1-3/8

**PART # I62**

3/16 - 1-5/8



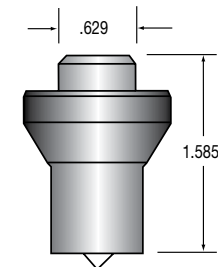
Also available as: oblongs, rectangles, and squares.

ENERPAC™ PUNCHES AND DIES

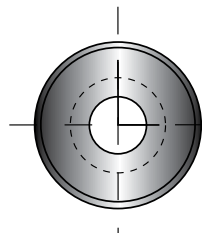
Round Punches and Dies for ENERPAC™, POWER TEAM™ and HUSKIE™ Portable Hydraulic Punches

PART # I105***PUNCH**

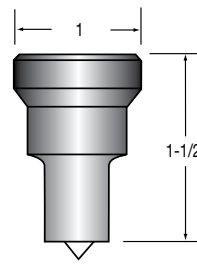
3/16 - 13/16

**PART # I44*****DIE**

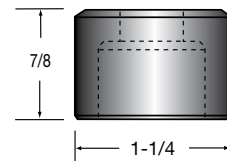
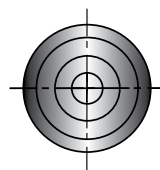
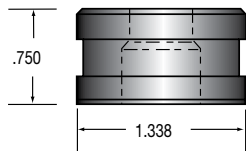
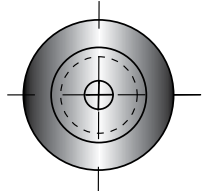
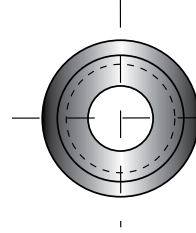
7/32 - 7/8

**PART # I9****PUNCH**

1/8 - 13/16

**PART # I43****DIE**

5/32 - 15/16



Also available as: oblongs and squares



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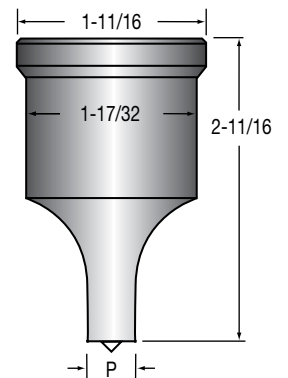
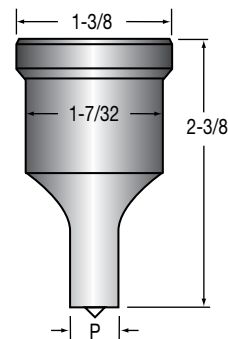
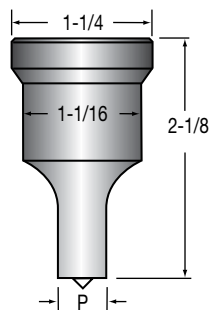
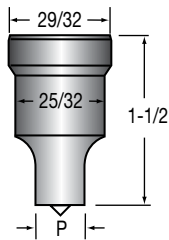
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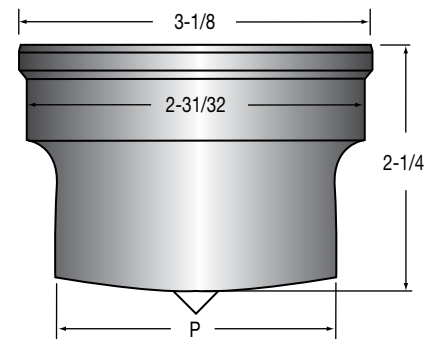
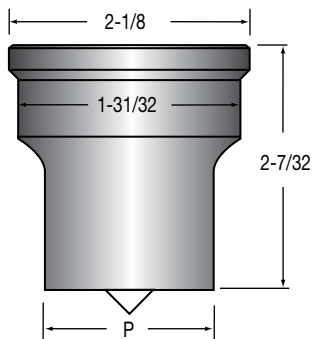
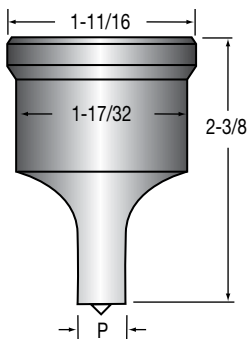
Range in 1/32 Increments

* MADE TO ORDER

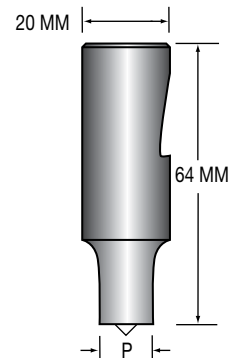
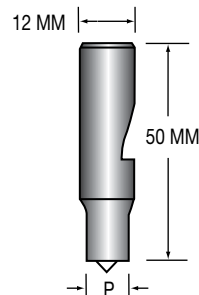
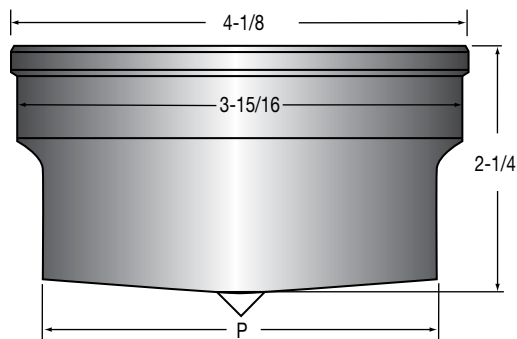
PART # I7 1/8 - 13/16	PART # I16 1/8 - 1-1/8	PART # I20 1/8 - 1-1/4	PART # I26 5/32 - 1-9/16
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PART # I26S* 1/8 - 1-9/16	PART # I30GOS* 1-1/2 - 1-15/16	PART # I39GOS* 1-7/8 - 2-15/16
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PART # I40GOS* 2-7/8 - 3-13/16	IMM12 Straight Shank* 3mm - 12mm	IMM20 Straight Shank* 3mm - 20mm
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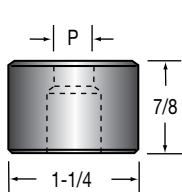


Also available as: oblongs, rectangles, and squares.

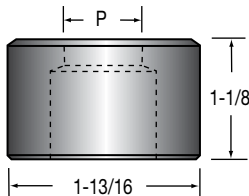
Range in 1/32 Increments

* MADE TO ORDER

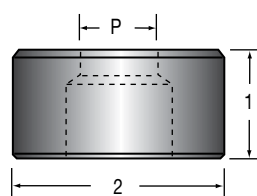
PART # I43
5/32 - 15/16



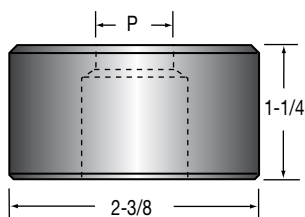
PART # I55
1/8 - 1-3/8



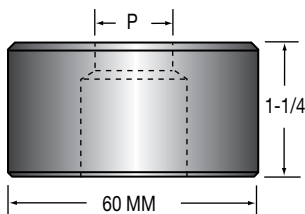
PART # I59
5/32 - 1-7/16



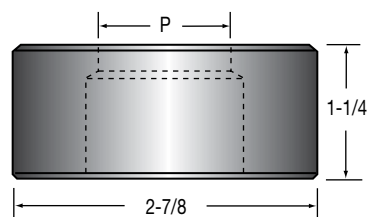
PART # I62
3/16 - 1-5/8



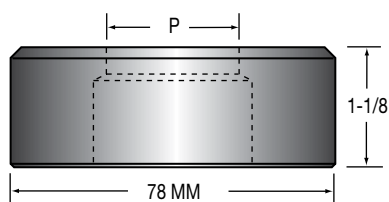
PART # I60MM*
7/32 - 1-5/8



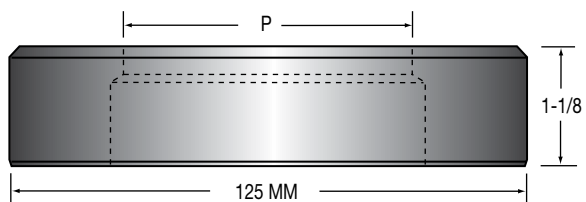
PART # I89*
5/32 - 1-3/4



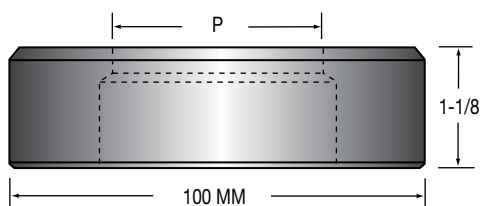
PART # I78MM*
(OVERSIZE)
1-1/2 - 2-5/16



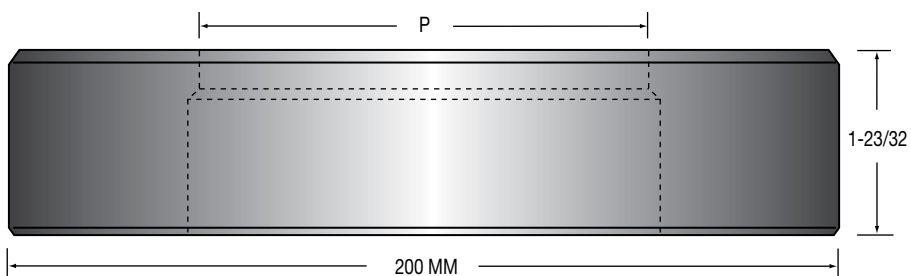
PART # I125MM*
(OVERSIZE)
3 - 4-3/16



PART # I100MM*
(OVERSIZE)
2-1/8 - 3-3/16



PART # I200MM*
(OVERSIZE)
4 - 6-7/16



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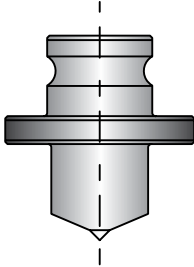
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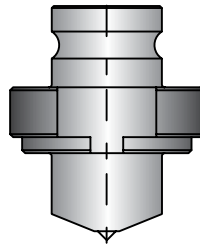
Range in 1/32 Increments

* MADE TO ORDER

PART # I75001P*
PUNCH
5/32 - 7/16



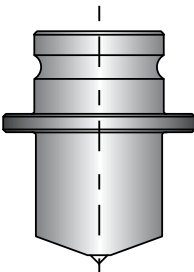
PART # I75002P*
PUNCH
1/4 - 11/16



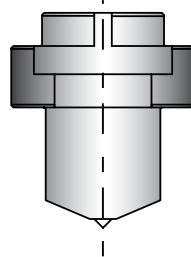
PART # I75003P*
PUNCH
1/4 - 25/32



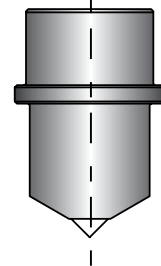
PART # I75004P*
PUNCH
1/4 - 25/32



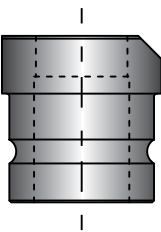
PART # I75005P*
PUNCH
7/16 - 7/8



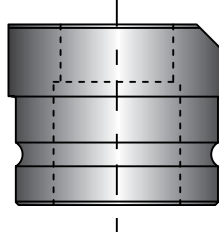
PART # I75006P*
PUNCH
7/16 - 15/16



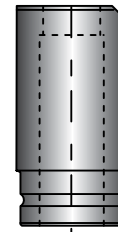
PART # I75001D*
DIE
5/32 - 1/2



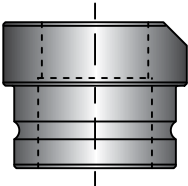
PART # I75002D*
DIE
1/4 - 3/4



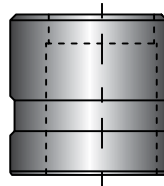
PART # I75003D*
DIE
1/4 - 7/8



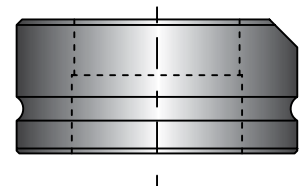
PART # I75004D*
DIE
1/4 - 7/8



PART # I75005D*
DIE
7/16 - 31/32



PART # I75006D*
DIE
7/16 - 1-1/16



14 GA. to 11 GA. = "A" CLEARANCE = 1/32
10 GA. to 3 GA. = "B" CLEARANCE = 1/16
1/4 GA. to 3/8 GA. = "C" CLEARANCE = 3/32
3/8 GA. to 1/2 GA. = "D" CLEARANCE = 1/8

e.g. 75004D 5/8 C (5/8 Punch, Die with 3/32 Clearance)
75004P 5/8

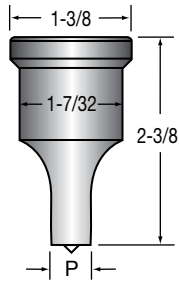
Also available as: oblongs, rectangles, and squares.

Range in 1/32 Increments

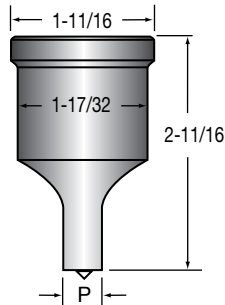
* MADE TO ORDER

PART # I20

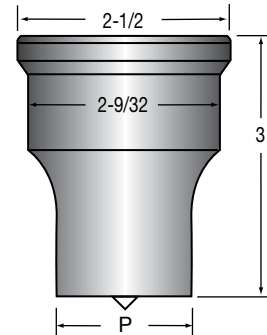
1/8 - 1-1/4

**PART # I26**

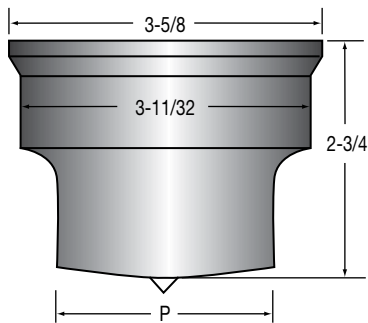
5/32 - 1-9/16

**PART # I37***

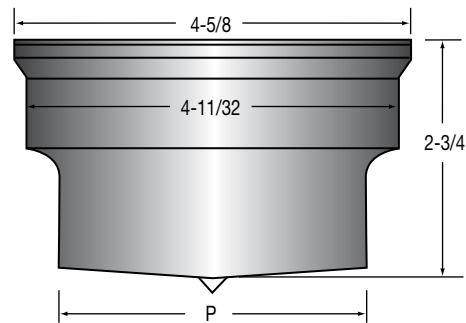
1-1/16 - 2-9/32

**PART # I9010***

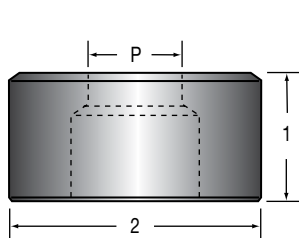
57mm - 85mm (2.244"-3.346")

**PART # I9011***

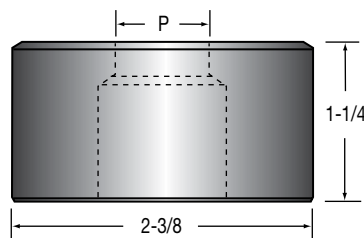
85mm - 110mm (3.346"-4.331")

**PART # I59**

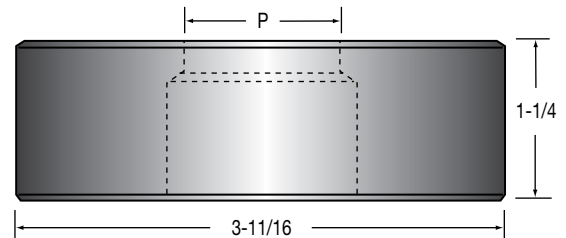
5/32 - 1-7/16

**PART # I62**

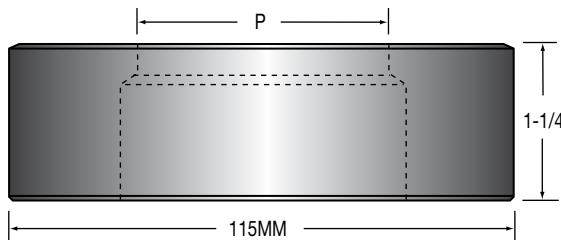
3/16 - 1-5/8

**PART # I9024***

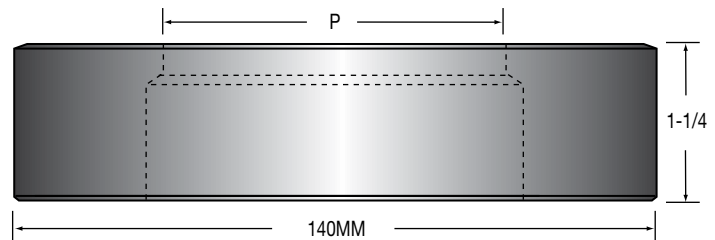
28mm - 57mm (1.102"-2.244")

**PART # I9025***

57mm - 85mm (2.244"-3.346")

**PART # I9026***

85mm - 110mm (3.346"-4.331")



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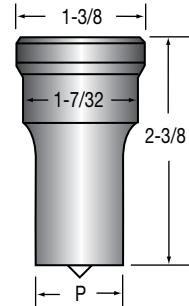
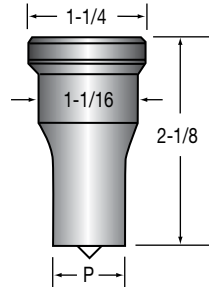
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Range in 1/32 Increments

* MADE TO ORDER

PART # IH1P (I16)
1/8 - 1-1/8

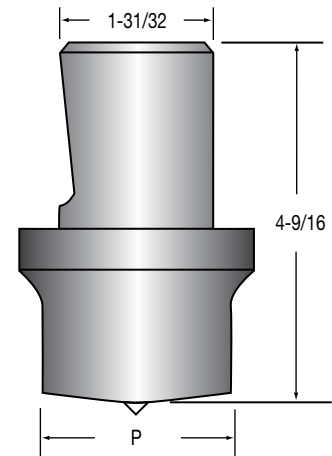
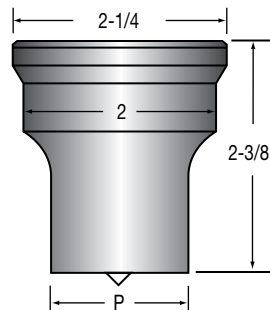
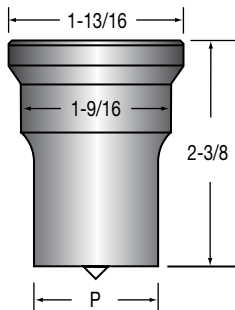
PART # IH2P (I20)
1/8 - 1-1/4



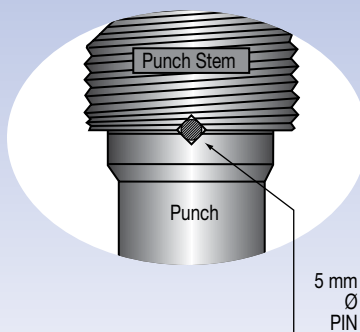
PART # IH3P*
5/32 - 1-9/16

PART # IH4P*
5/32 - 2

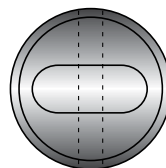
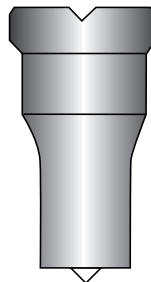
PART # IH5P-1 / IH5P-2*
Style I: 2 - 2-5/8 (NO SHEAR)
Style II: 2-21/32 - 4 (WITH SHEAR)



IH1P, IH2P, IH3P and IH4P shaped punches require a "V" groove. Must be specified at time of order.



V-Groove



STANDARD UNLESS
OTHERWISE SPECIFIED

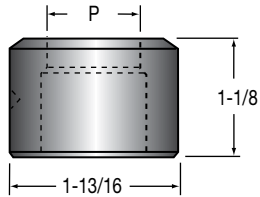
DIRECTION B

Also available as: oblongs, rectangles, and squares.

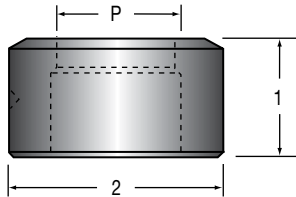
Range in 1/32 Increments

* MADE TO ORDER

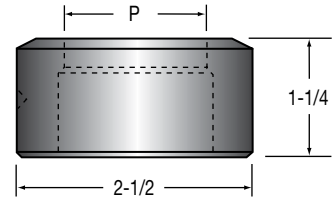
PART # IH1D
(I55) 1/8 - 1-3/8



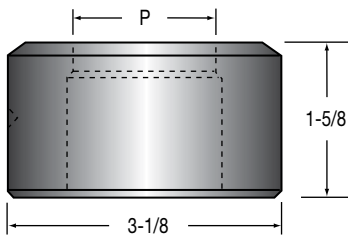
PART # IH2D
(I59) 5/32 - 1-7/16



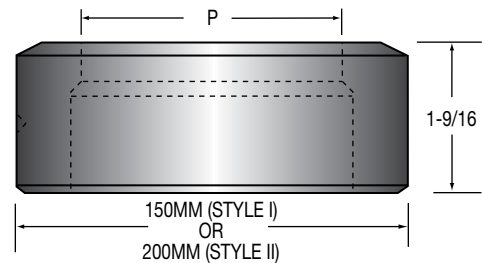
PART # IH3D
(I65) 7/32 - 1-11/16



PART # IH4D*
3/16 - 2-1/16

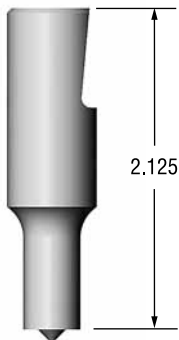


PART # IH5D-1 / IH5D-2*
STYLE I: 2-1/32 - 2-23/32
STYLE II: 2-3/4 - 4-1/16

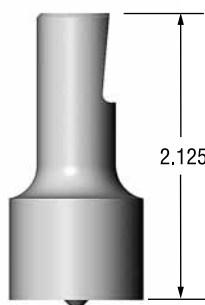


MUBEA™ WEDGE LOCK PUNCH

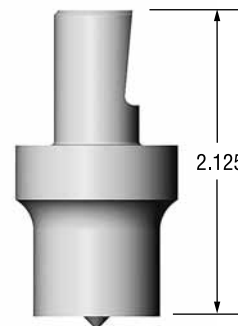
PART # IBF10
RANGE - ROUND
3.0mm - 15.0mm
(.118) - (.590)



PART # IBF10K
RANGE KNOB STYLE - ROUND
15mm - 28mm
(.591) - (1.125)



PART # IBFZ10
RANGE - SHAPE
MIN. "W" 3.0MM (.118)
MAX. "P" 28.0MM (1.125)



Also available as: oblongs, rectangles, and squares.



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Range in 1/32 Increments

*MADE TO ORDER

Stock Round Punches and Dies for NITTO KOHKI™ Portable Hydraulic Punches

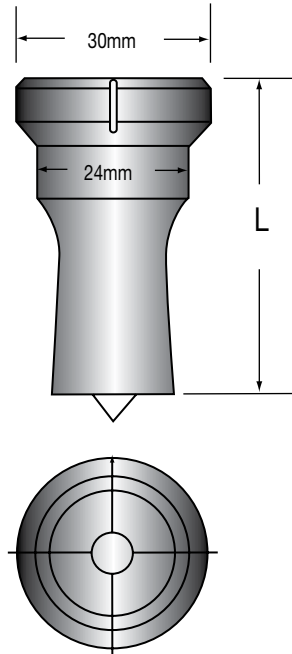
PART NUMBER

SIZE	PUNCH IWSP72	DIES IWSD74
7/32	✓	✓
1/4	✓	
9/32		✓
5/16	✓	✓
11/32	✓	✓
3/8	✓	✓
13/32	✓	✓
7/16	✓	✓
15/32	✓	✓
1/2	✓	✓
17/32	✓	✓
9/16	✓	✓
19/32	✓	✓
5/8	✓	✓
21/32		✓
11/16	✓	✓
23/32		✓
3/4	✓	✓
25/32		✓
13/16	✓	✓
27/32	✓	✓
7/8	✓	✓
29/32	✓	✓
15/16	✓	✓
31/32		✓

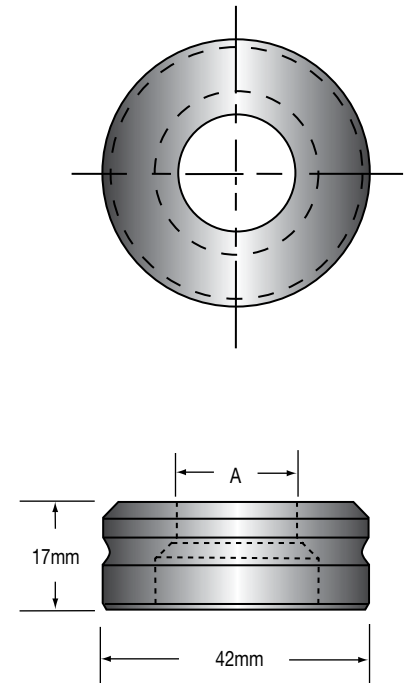
✓	Represents stock round size
---	-----------------------------

NITTO KOHKI™
PUNCHES & DIES
FOR MODELS
A-05-1018 & S06-0318

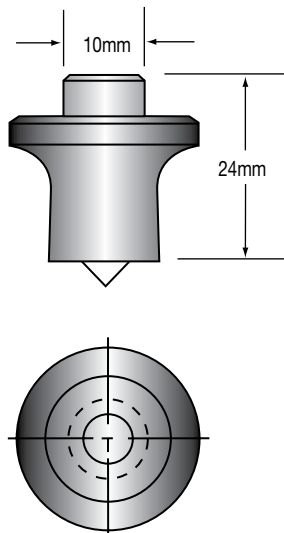
PART # IWSP72 (L = 60)
PART # IWSP75 (L = 57)*
PUNCH



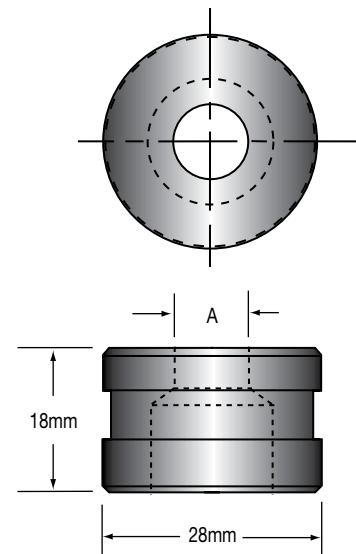
PART # IWSD74
DIE



PART # INK48P*
MINI-PUNCH



PART # INK48D*
DIE

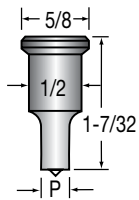


Also available as oblongs.

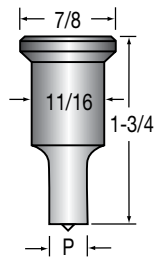
Range in 1/32 Increments

* MADE TO ORDER

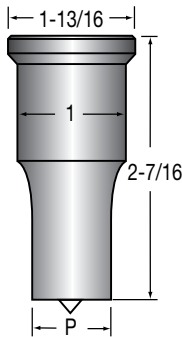
PART # I232
(W7101)
3/32 - 1/2



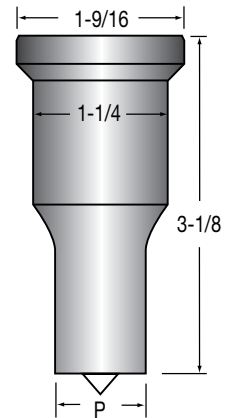
PART # I242
(W7201)
1/8 - 11/16



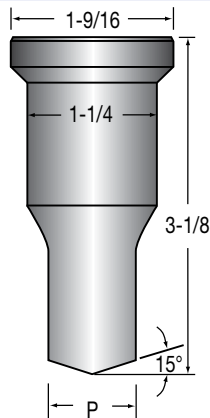
PART # I252
(W7401)
1/8 - 1



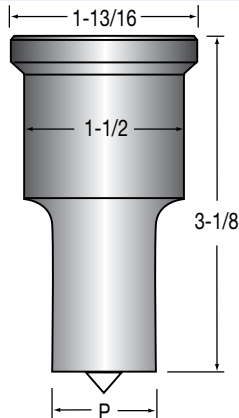
PART # I272
(W7701)
7/32 - 1-1/4



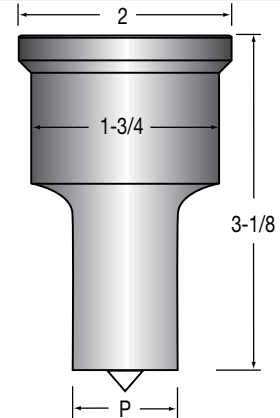
PART # I274
(W7701) CHISEL POINT
7/32 - 1-1/4



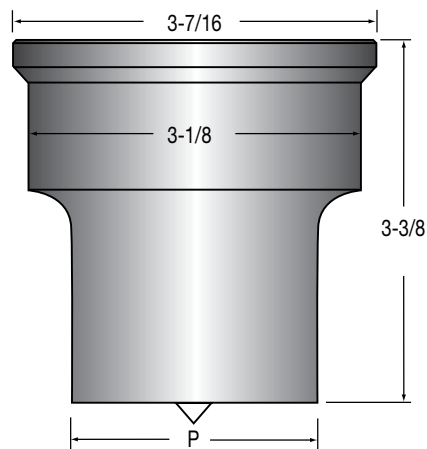
PART # I282*
11/16 - 1-1/2



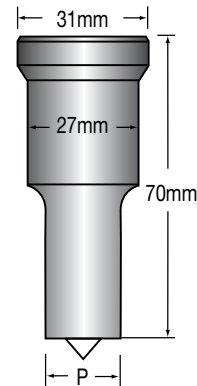
PART # I292*
1 - 1-3/4



PART # I400P*
7/32 - 3



PART # I19L
5/16 - 1-1/16



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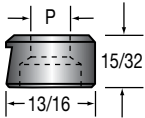
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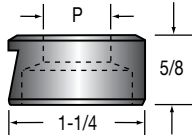
Range in 1/32 Increments

* MADE TO ORDER

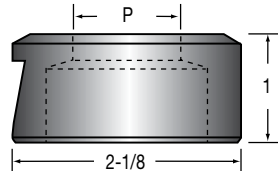
PART # IW7102(N)
WITH WHISTLE NOTCH
7/64 - 37/64



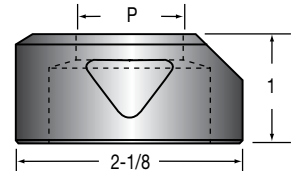
PART # IW7202(N)
WITH WHISTLE NOTCH
9/64 - 45/64



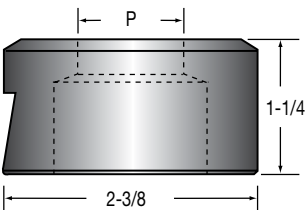
PART # IW7402(N)
WITH WHISTLE NOTCH
9/64 - 1-17/32



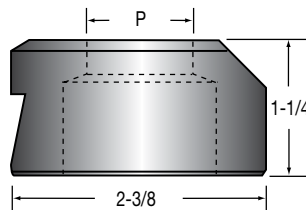
PART # IW7402(NB)
WITH WHISTLE NOTCH AND BEVEL
9/64 - 45/64



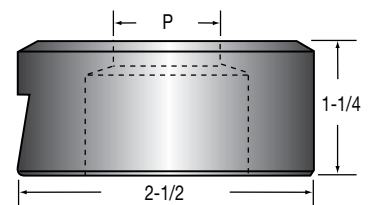
PART # I291F (I62N)



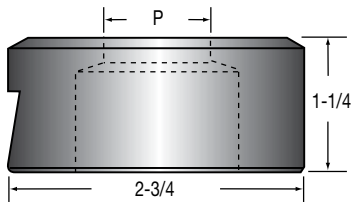
PART # I293F (I62NB)



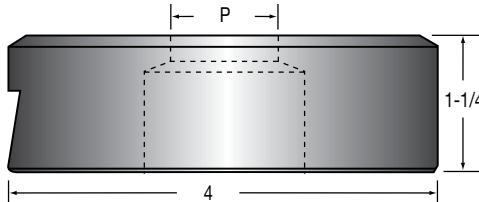
PART # I91 (I65N)
WITH WHISTLE NOTCH
7/32 - 1-11/16



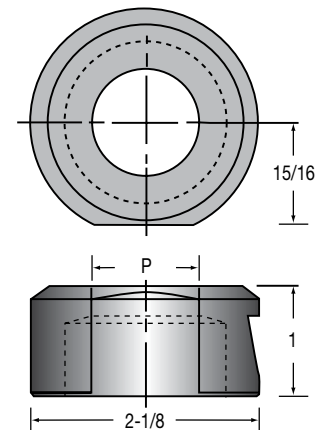
PART # I400D*
7/32 - 1-1/16



PART # I403*
7/32 - 3-1/8



PART # IW7402(NF)
WITH WHISTLE NOTCH FLAT

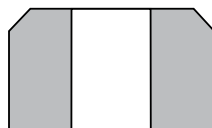


Slug Hole Variations

The standard slug hole is used for common applications. However, the tapered and straight slug holes may be specified for special or heavy duty applications requiring extra strength.



Standard


Straight Thru Hole
(STH)


Tapered

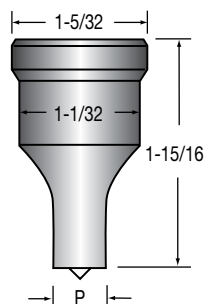
Also available as: oblongs, rectangles, and squares.

Range in 1/32 Increments

* MADE TO ORDER

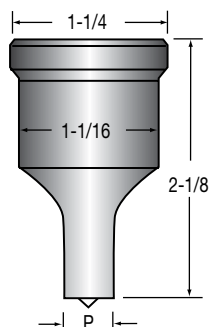
PART # I12

1/8 - 1-1/16



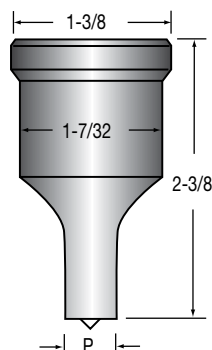
PART # I16

1/8 - 1-1/8



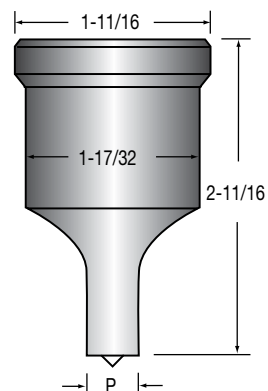
PART # I20

1/8 - 1-1/4



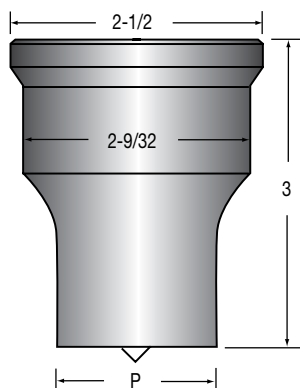
PART # I26

5/32 - 1-9/16



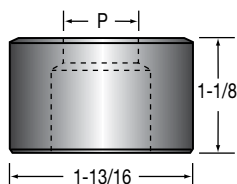
PART # I50*

1-1/2 - 2-9/32



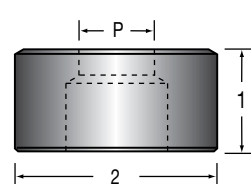
PART # I55

1/8 - 1-3/8



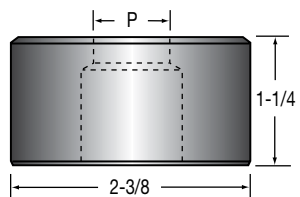
PART # I59

5/32 - 1-7/16



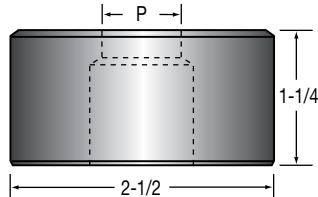
PART # I62

3/16 - 1-5/8



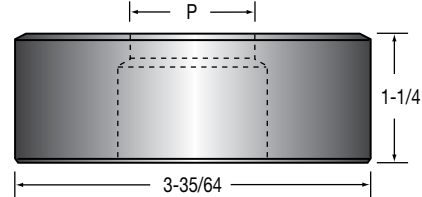
PART # I65

7/32 - 1-11/16



PART # I91MM*

5/32 - 2-9/32



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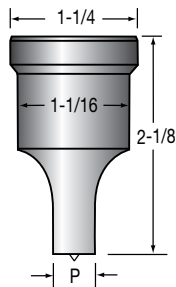
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Range in 1/32 Increments

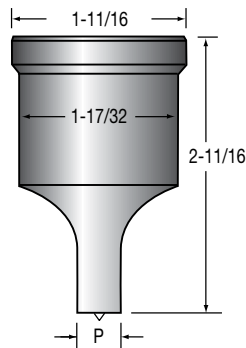
PART # I16

1/8 - 1-1/8



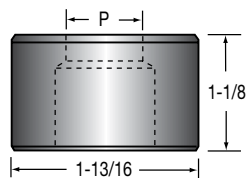
PART # I26

5/32 - 1-9/16



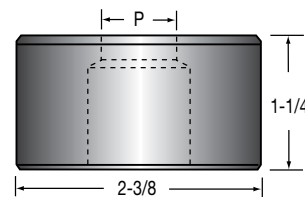
PART # I55

1/8 - 1-3/8



PART # I62

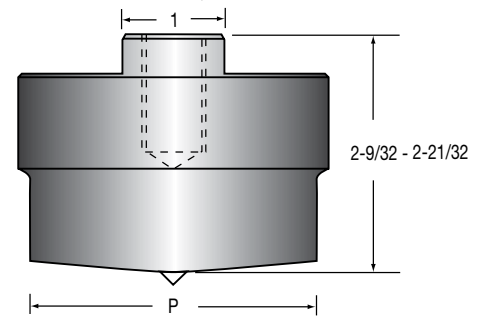
3/16 - 1-5/8



Piranha™ Heavy Duty Punches for over 50 ton applications

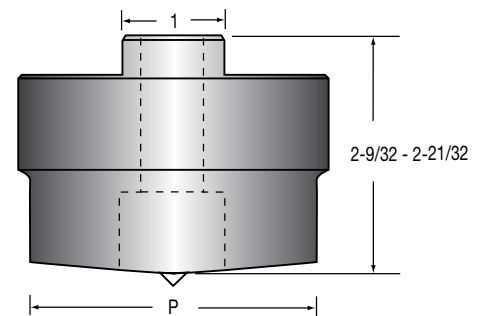
I6670-1

Threaded Style



I6670-2

Bolt On Style



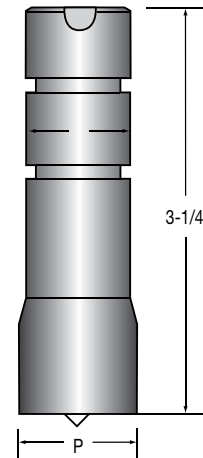
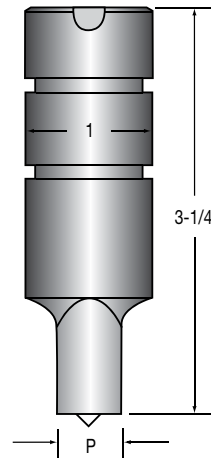
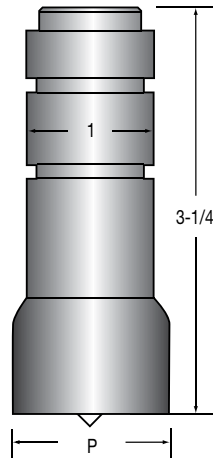
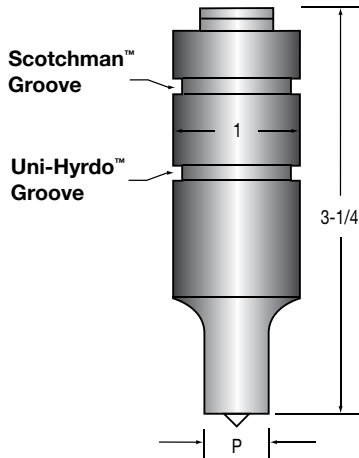
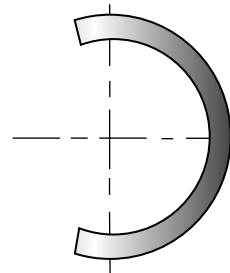
Minimum diameter or width of shape is 1.97

PIRANHA™ ALSO USES W6100 SERIES AND DIES
(28xx all with centre points and H.T. or Criss Cross Shear)

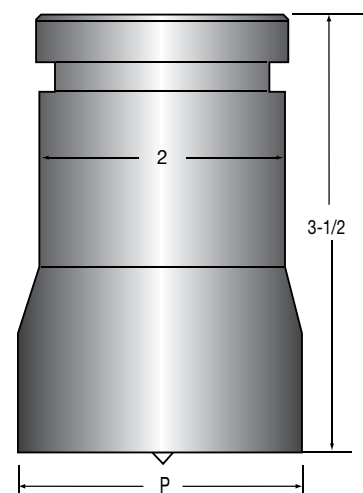
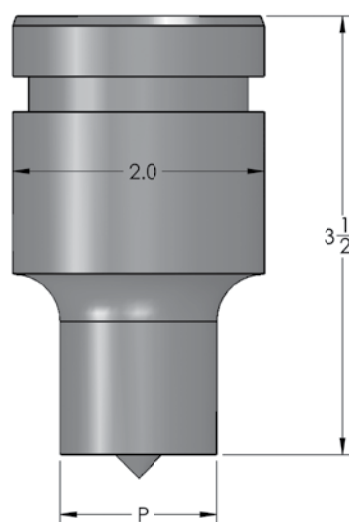
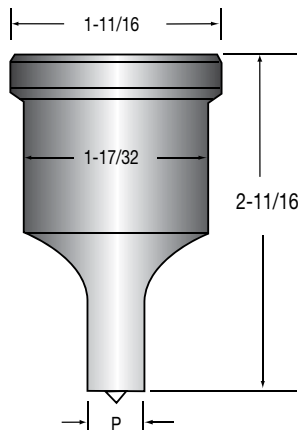
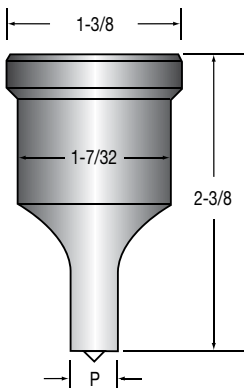
Range in 1/32 Increments

* MADE TO ORDER

ROUND	ROUND	SQUARE/OBLONG	SQUARE/OBLONG
PART # I207-1 Range 1/8 - 1	PART # I207K-1 Above 1 - 1-1/4 I207K-12: 1-9/32-2	PART # IS207-1/IO207-1 MIN. "W" 1/8 RANGE "P" up to 1.0	PART # IS207K-1/IO207K-1 MIN. "W" 1/8 RANGE "P" above 1.0 - 1.25 IS207K-12/IO207K-12: 1-9/32-2

PART # SR429
Snap Ring

PART # I20 1/8 - 1-1/4	PART # I26 5/32 - 1-9/16	PART # Scotchman™ I207-2* 1-19/32 - 2.000	PART # Scotchman™ I207K-2* 2.00 - 4.00
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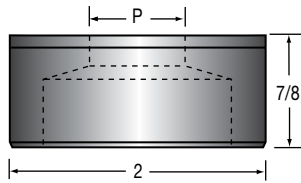
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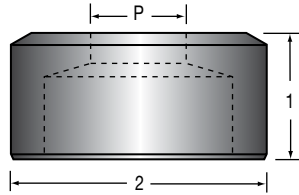
Range in 1/32 Increments

* MADE TO ORDER

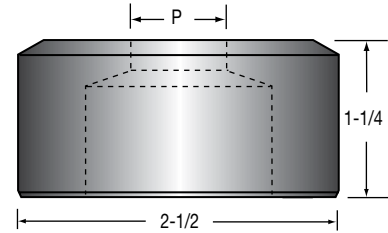
PART # I58
5/32 - 1-1/8



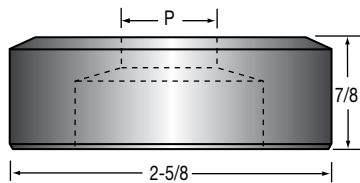
PART # I59
5/32 - 1-7/16



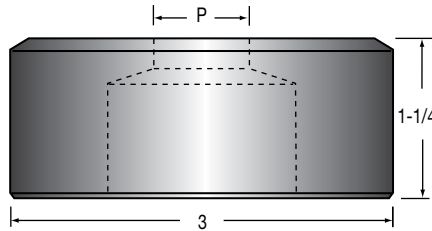
PART # I65
7/32 - 1-11/16



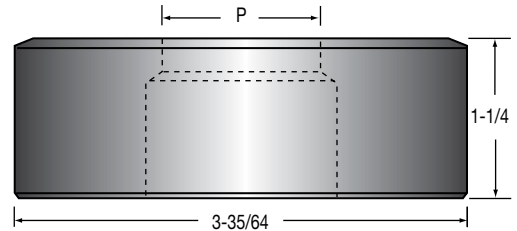
PART # I68*
7/32 - 1-7/8



PART # I71*
5/32 - 1-7/8

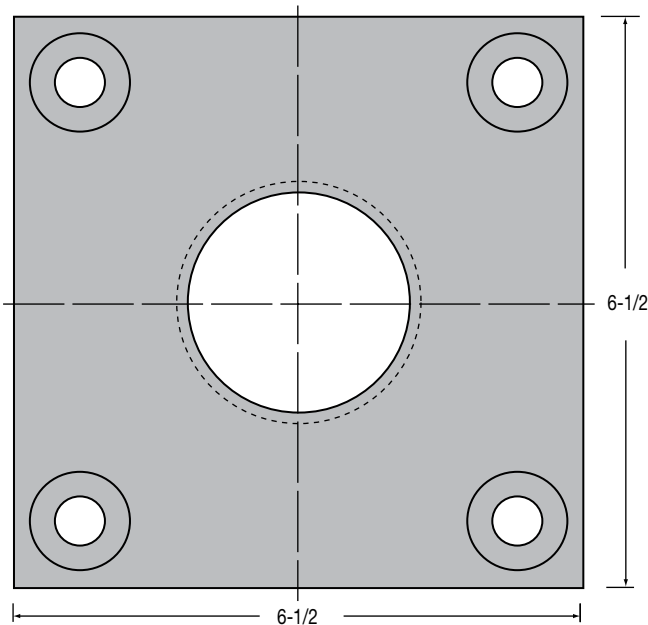


PART # I91MM*
5/32 - 2-9/32

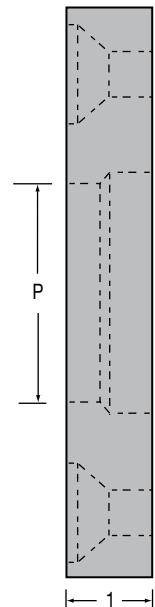
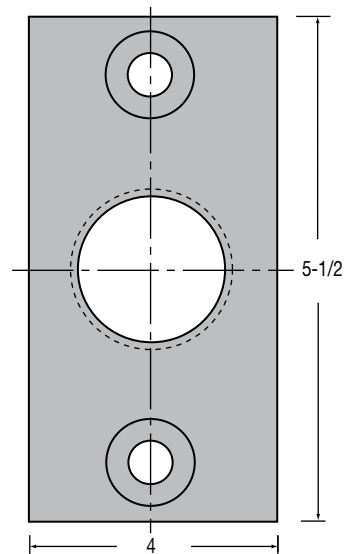


Locators available on request.

Scotchman™ 6 x 6*
2-1/32 - 4



Scotchman™ 4 x 6*
2-1/32 - 2-1/4



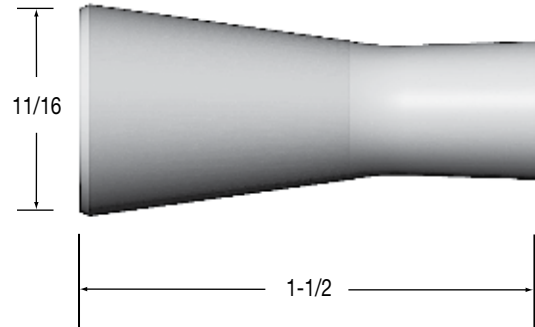
Also available as: oblongs, rectangles, and squares.

PART # I77-50
POINT DIAMETER - 11/32

PART # I77-60
POINT DIAMETER - 13/32

PART # I77-70
POINT DIAMETER - 15/32

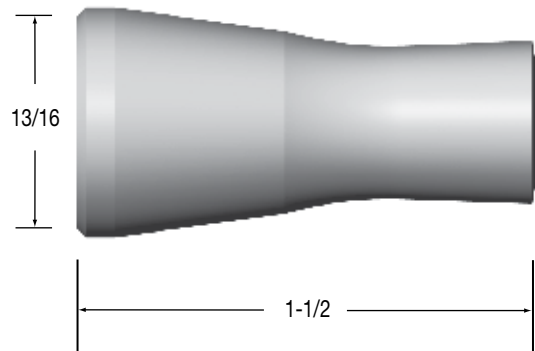
PART # I77-80
POINT DIAMETER - 17/32



PART # I77-90
POINT DIAMETER - 17/32

PART # I77-100
POINT DIAMETER - 19/32

PART # I77-110
POINT DIAMETER - 21/32



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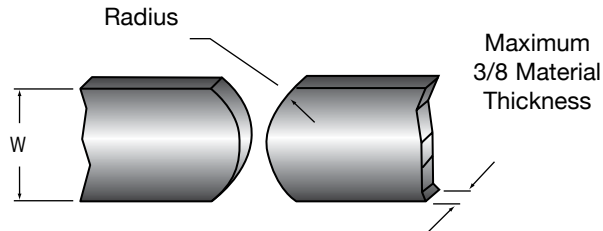
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Toll Free Canada - Québec
Tel: 800-361-6810

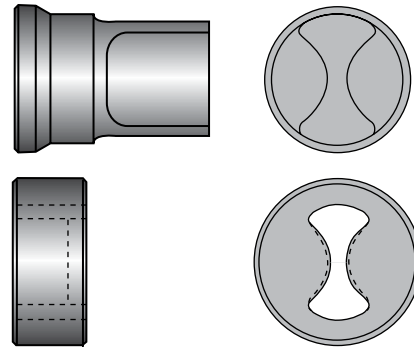
Exacta Website & Email
www.exactapunch.com
info@exactapunch.com

End Trim Tooling

End Trim tooling cuts end radius on flat bar material in one hit. When ordering, please specify part number, radius required, material width, thickness and type.



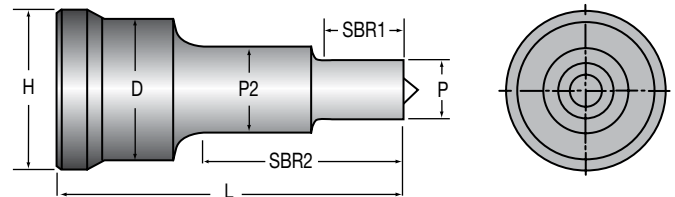
SS-10



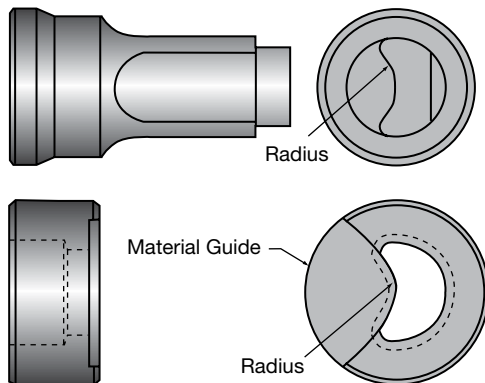
STEPPED POINT PUNCH TOOLING

Stepped Point Punch

Stepped Point punches are used for cutting a hole in hard to reach areas such as angle or channel. When ordering, please specify part number, shape, material thickness type and the dimensions indicated in the diagram.

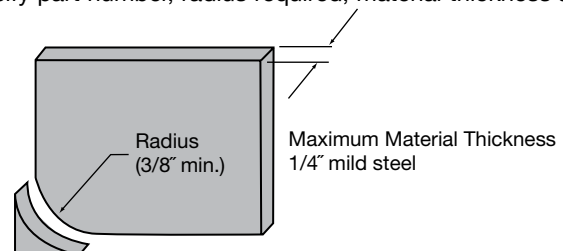


SINGLE CORNER RADIUS TOOLING



Corner Radius

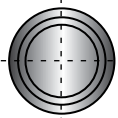
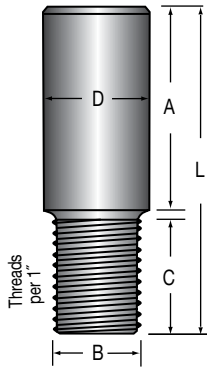
Corner radius tooling cuts a corner radius on material thickness up to 1/4". The die has a built in material guide to locate material. When ordering, please specify part number, radius required, material thickness and type.



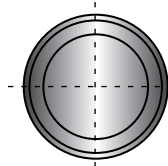
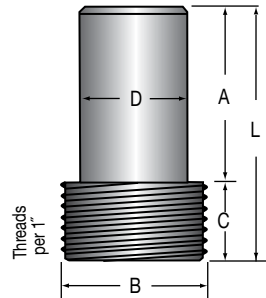
All stems are made to order.

When ordering provide part number and all the dimensions shown as letters in below diagrams or supply drawing or sample.

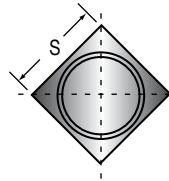
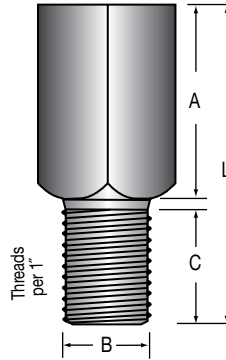
IPS290



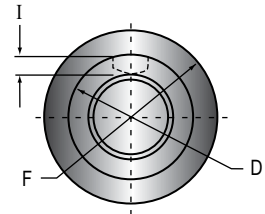
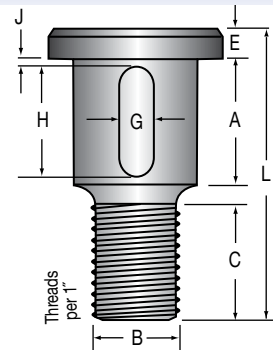
IPS290K



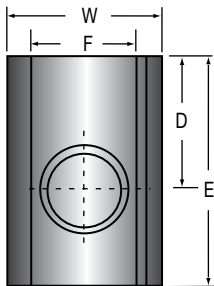
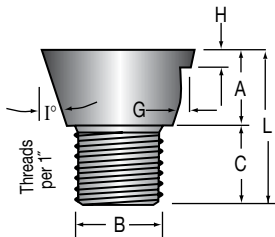
IPS291



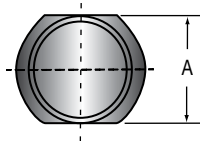
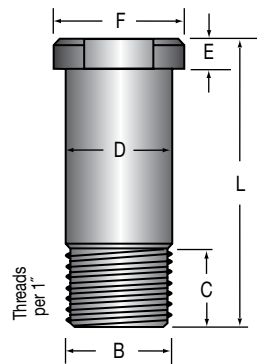
IPS292



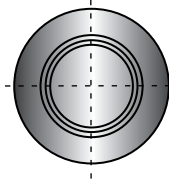
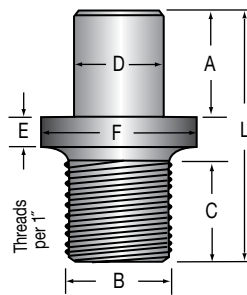
IPS293



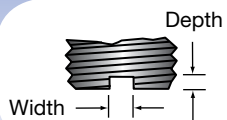
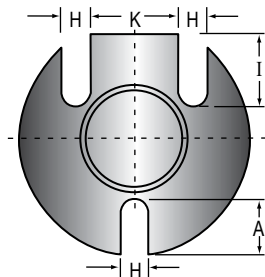
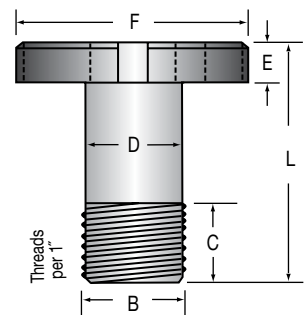
IPS294



IPS295



IPS296



To help eliminate rotational movement of punches we recommend putting keyways in the face of the punch stem. Specify the width and the depth when ordering.



Toll Free U.S.A.
Tel: 800-328-9646
Fax: 800-222-0002

Toll Free Mexico
Tel: 001-800-741-2510
Fax: 001-800-544-2096

Toll Free Canada - Ontario
Tel: 800-268-5573
Fax: 800-668-9314

Toll Free Canada - Québec
Tel: 800-361-6810

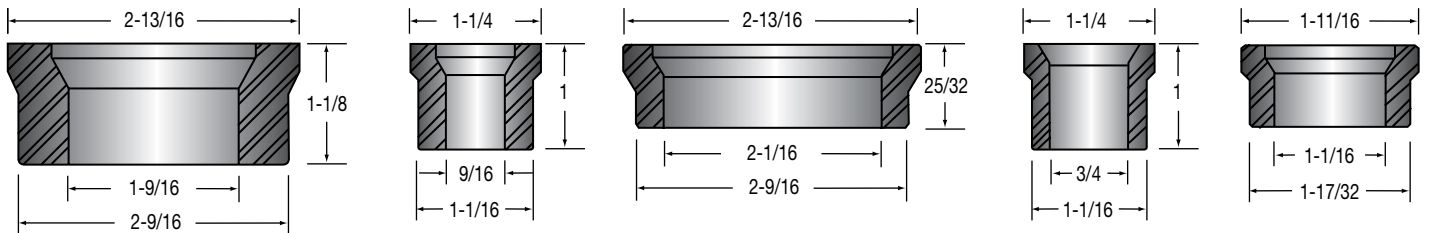
Exactapunch Website & Email
www.exactapunch.com
info@exactapunch.com

Punch Reducing Sleeves*

* MADE TO ORDER

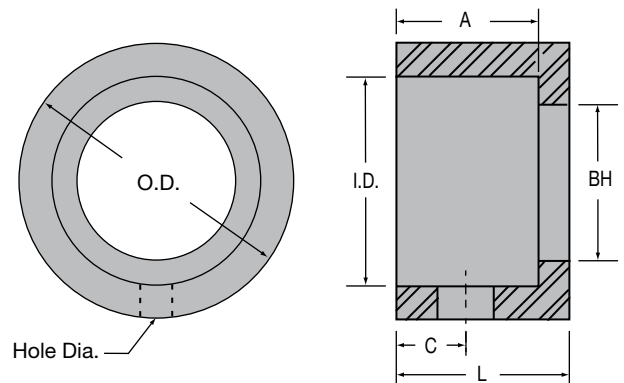
Reducing sleeves allow a wider use of punches using the same coupling nut.

IPRS75 Use with CN-32 coupling nut to hold I28 and I29 punches.	IPRS76 Use with CN-16 to CN-16-6 coupling nut to hold I6 punch.	IPRS77 Use with CN-32 coupling nut to hold I30 and I31 punches.	IPRS78 Use with CN-16 to CN-16-6 coupling nut to hold I11 punch.	IPRS79 Use with CN-26 to CN-26-3 coupling nut to hold I16 17, 19, & 19L punch.
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Die Reducers*

Die reducers allow you to use smaller O.D. dies. The following table gives examples of die reducers. Made to order sizes are available. When ordering please specify dimensions indicated in the diagram.



DIE REDUCERS PART NUMBER

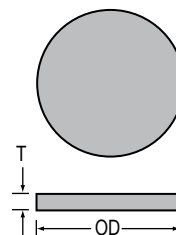
	O.D.	I.D.	BH	A	L	C	Hole Dia.
I62 to I55	2-3/8	1-13/16	1-13/32	1-1/16	1-1/4	7/16	5/8
I62 to I59	2-3/8	2	1-15/32	15/16	1-1/4	9/16	5/8

Punch and Die Shims

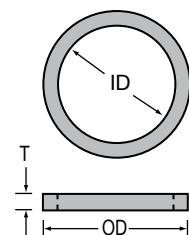
Punch shims are used to extend the overall punch length. Die shims increase the die height. All punch and die reducers and punch and die shims are made to order.

When ordering please specify dimensions indicated in the diagram.

PUNCH SHIM



DIE SHIM



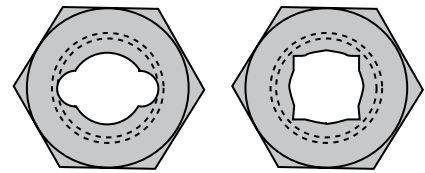
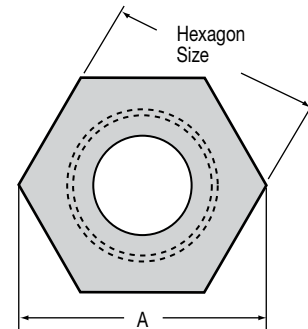
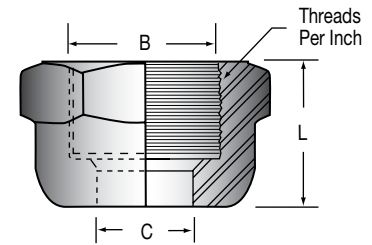
All Coupling Nuts are made to order.

COUPLING NUT NUMBER	HEXAGON SIZE	THREADS PER INCH	A LARGEST O.D.	B THREAD DIAMETER	C BORE	L LENGTH	USE WITH PUNCH FIGURE NUMBER
CN-4	1-5/8	10	1-7/8	1-1/8	.570	1-5/16	I4, I6
CN-7	1-3/4	12	1-15/16	1-1/16	.788	1-3/16	I7
CN-9	1-5/8	10	1-7/8	1-1/8	.843	1-5/16	I9
CN-11	1-5/8	10	1-7/8	1-1/8	.757	1-5/16	I11
CN-12	2	12	2-1/4	1-5/16	1.038	1-1/4	I12
CN-16	2	10	2-5/16	1-3/8	1.070	1-5/8	I15, I16
CN-16-1	2	10	2-5/16	1-3/8	1.070	1-5/16	
CN-16-2	2	10	2-5/16	1-7/16	1.070	1-5/8	I17, I19
CN-16-3	2-1/4	10	2-5/8	1-5/8	1.070	1-5/8	
CN-16-4	2-1/2	12	2-29/32	1-7/8	1.070	1-5/8	I19L
CN-16-5	2-1/2	10	2-7/8	2	1.070	1-5/8	I20, I21
CN-16-6	2-1/4	10	2-5/16	1-13/32	1.093	1-5/8	
CN-20	2-1/4	12	2-5/8	1-9/16	1.228	1-1/2	I20 WITH 1-1/4 PT. SIZE
CN-20-1	2-1/2	12	2-29/32	1-7/8	1.228	1-5/8	
CN-20-2	2-1/2	10	2-7/8	2	1.228	1-5/8	I23
CN-20-3	2-1/4	12	2-5/8	1-9/16	1.255	1-1/2	
CN-20-4	2-1/2	10	2-7/8	2	1.255	1-5/8	I26
CN-23	2-1/2	10	2-7/8	2	1.320	1-5/8	
CN-23-1	2-1/4	10	2-5/8	1-11/16	1.343	1-15/32	I26 WITH 1-9/16 PT. SIZE
CN-26	2-1/2	10	2-7/8	2	1.537	1-5/8	
CN-26-1	2-1/2	12	2-7/8	1-7/8	1.570	1-5/8	I28, I29
CN-26-2	2-1/2	10	2-7/8	2	1.570	1-5/8	
CN-26-3	3-1/2	10	4-1/16	2-5/8	1.570	2-1/8	I30, I31
CN-28	2-1/2	10	2-7/8	2	1.593	1-5/8	
CN-30	3-1/2	10	4-1/16	2-5/8	2.070	2-1/8	I32
CN-32	4	10	4-5/8	3	2.578	2-3/8	
CN-34	3	12	3-1/2	2-1/4	1.812	1-11/16	I34
CN-34-1	3	10	3-1/2	2-1/4	1.812	1-11/16	
CN-37	3-3/4	12	4-21/64	2-3/4	2.288	1-13/16	I37
CN-39	5	8	5-3/4	3-7/8	3.288	2-1/8	I39
CN-40	6	6	6-7/8	4-7/8	4.163	2-3/4	I40

CLOSE CENTRE COUPLING NUTS

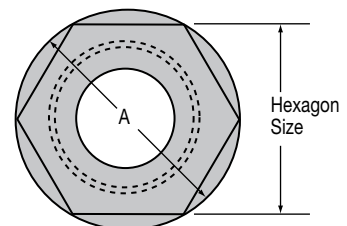
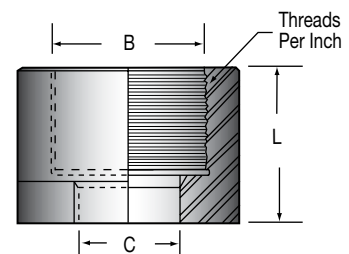
COUPLING NUT NUMBER	HEXAGON SIZE	THREADS PER INCH	A LARGEST O.D.	B THREAD DIAMETER	C BORE	L LENGTH	USE WITH PUNCH FIGURE NUMBER
CCN-4	1-1/4	10	1-7/16	1-1/8	.570	1-5/16	I4, I6
CCN-16	1-5/8	10	1-15/16	1-3/8	1.070	1-5/8	I15, I16, I17, I19, I19L
CCN16-1	1-7/8	10	2-13/16	1-5/8	1.070	1-5/8	
CCN-23	2-3/16	10	2-7/16	1-5/8	1.320	1-5/8	I23

STANDARD COUPLING NUT



CLOSE CENTER COUPLING NUTS

When minimum center distances are required, close center coupling nuts are available.



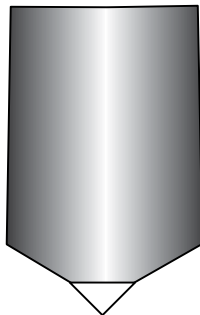
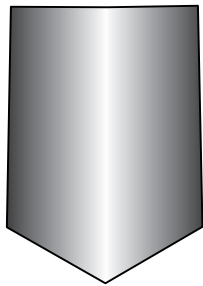
PUNCH END CONFIGURATIONS

Below are our most common punch end configurations. Stock punches are manufactured with a cone point and center.

FLAT FACE For punching thin material, or when you want the slug.	FLAT FACE WITH CENTER POINT For use with thin material when a locator is needed.	CONE POINT WITH CENTER POINT Exact's stock punch end. General purpose use.	CONE POINT For hard material.
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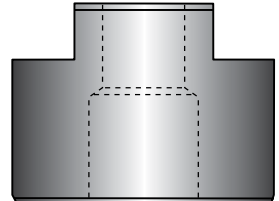
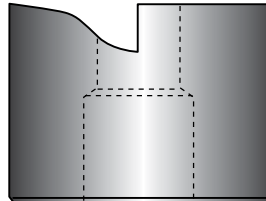
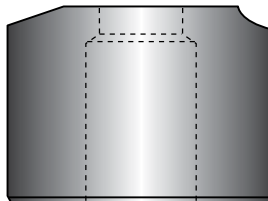
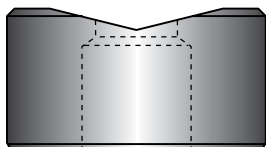
CHISEL POINT Reduce tonnage.	CHISEL POINT WITH CENTER POINT Same as a chisel point, but when a center point is required.	CRISS-CROSS SHEAR To reduce deforming thin material.	CONCAVE SHEAR To reduce deforming thin material.
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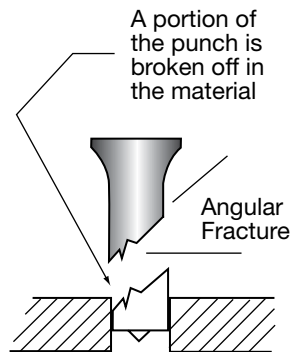
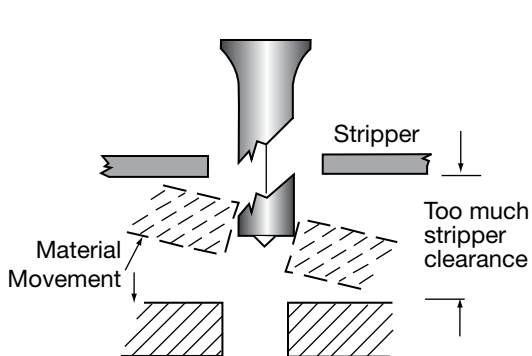
SPECIAL DIE PROFILES

We can manufacture any die profile that you require. When ordering, please supply the die number and a drawing.

EXAMPLES ONLY

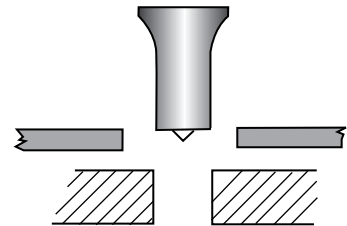


Stripping Failure



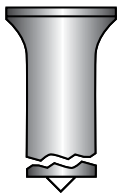
POSSIBLE SOLUTION

Adjust stripper closer to the material.



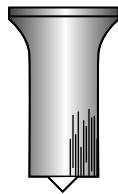
Chipping and Galling

Face Chipping

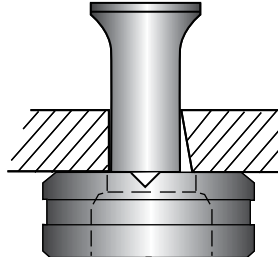


OR

Heavy Galling on One Area



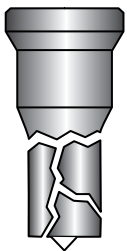
Poor alignment between punch and die, causing the punch to drag



POSSIBLE SOLUTION

Adjust alignment between punch and die. Equal clearance all around.

Compressive Failure

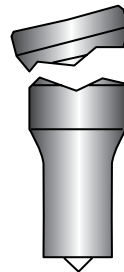


"Compressive Failure" occurs when the compressive strength of the punch has been exceeded and the entire working end shatters. This is caused by attempting to punch extremely hard or thick materials, or complete misalignment of punch and die.

POSSIBLE SOLUTION

Manufacture from premium steel.

Head Breaking Off



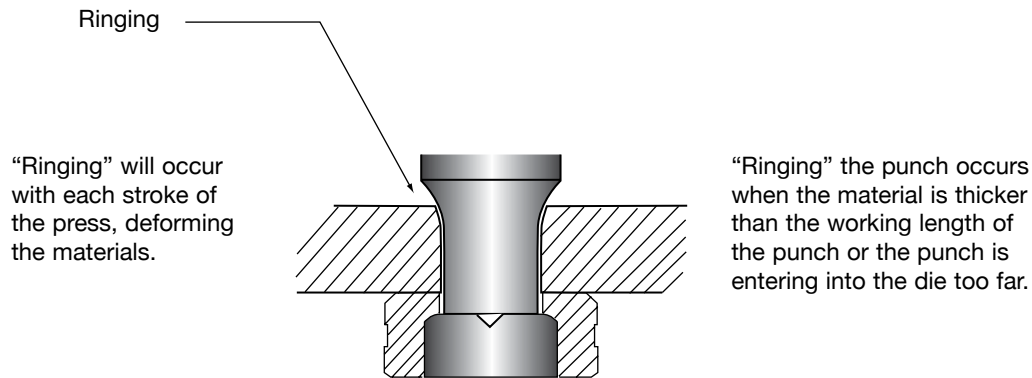
A loose coupling nut, worn punch stem or coupling nut will cause the head to fracture.

POSSIBLE SOLUTION

Re-tighten coupling nut after the first several hits, and periodically throughout the day.

Check the face of the stem. Must be smooth and flat.

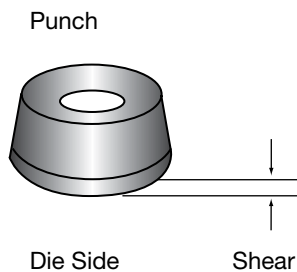
Ringing



POSSIBLE SOLUTION

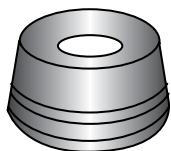
Adjust stroke length to enter into the die a maximum of 1/16"

Check the Slug



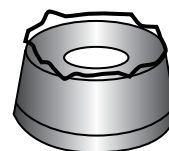
When punching mild steel 1/8" or thicker, the die side of the slug will be dished. The periphery of the slug will be shiny or sheared, for a distance of 10% to 20% of the material thickness.

The punch side will have the center point indentation and a slight burr.



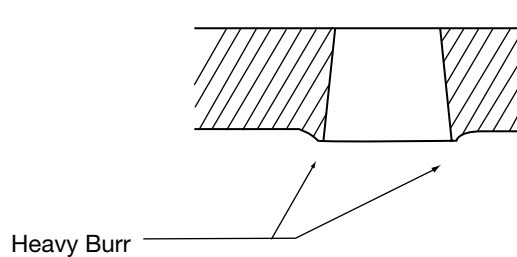
POSSIBLE SOLUTION

Increase punch to die clearance.



POSSIBLE SOLUTION

Check alignment and condition of punch and die.



Heavy burr on die side of material indicates too much clearance between punch and die.

POSSIBLE SOLUTION

Decrease die clearance.

ORDER

Minimum order is \$50.00

CREDIT REQUIREMENTS

All orders are subject to approval by our Credit Department.

If you are a new account, please furnish us with your tax exempt status, a bank reference, three current supplier references and/or your current D&B rating with your first order.

A credit limit will be imposed on new accounts until credit has been established.

PAYMENT TERMS

Terms are net 10 days. Catalog prices are subject to change without notice.

FREIGHT

Orders are shipped F.O.B. from our manufacturing facility.

(International Shipments are Incoterms: Ex Works).

ORDER CANCELLATION

In the event an order is cancelled, an additional charge will be assessed to cover the cost of labor and material.

RETURNED MATERIAL

A handling/restocking fee will be applied to all standard products returned for credit. A return authorization number and shipping instructions must be obtained in advance before an item can be returned.

CLAIMS

All claims or product shortages must be made within 30 days of the invoice date.



Toll Free U.S.A.
Tel: 800-328-9646
Fax: 800-222-0002

Toll Free Mexico
Tel: 001-800-741-2510
Fax: 001-800-544-2096

Toll Free Canada - Ontario
Tel: 800-268-5573
Fax: 800-668-9314

Toll Free Canada - Québec
Tel: 800-361-6810

Exacta Website & Email
www.exactapunch.com
info@exactapunch.com

MILD STEEL PLATE

UP TO 16 GA.	.006 CLEARANCE
15 TO 13 GA.	.010 CLEARANCE
3/32" TO 5/32 "	1/64 CLEARANCE
3/16" TO 15/32 "	1/32 CLEARANCE
1/2" TO 23/32"	1/16 CLEARANCE
3/4" UP TO 1"	3/32 CLEARANCE
1" AND OVER	1/8 CLEARANCE

REQUIRED TONNAGE (MILD STEEL)

HOLE DIA. IN INCHES	20 GA. .036	18 GA. .048	16 GA. .060	14 GA. .075	12 GA. .105	11 GA. .120	10 GA. .135	3/16 .187	1/4 .250	5/16 .312	3/8 .375	1/2 .500
1/8	.35	.47	.59	.74	1.0	1.2						
3/16	.53	.71	.89	1.1	1.6	1.8	2.0	2.8				
1/4	.71	.94	1.2	1.5	2.1	2.4	2.7	3.7	4.9			
5/16	.88	1.2	1.5	1.9	2.6	3.0	3.3	4.6	6.2	7.8		
3/8	1.1	1.4	1.8	2.2	3.1	3.5	4.0	5.5	7.4	9.2	11.1	
7/16	1.2	1.7	2.1	2.6	3.6	4.1	4.6	6.5	8.6	10.8	13.0	17.2
1/2	1.4	1.9	2.4	2.9	4.1	4.7	5.3	7.4	9.8	12.3	14.8	19.7
9/16	1.6	2.1	2.7	3.3	4.7	5.3	6.0	8.3	11.0	13.8	16.6	22.1
5/8	1.8	2.4	2.9	3.7	5.2	5.9	6.6	9.2	12.3	15.4	18.5	24.6
11/16	1.9	2.6	3.2	4.1	5.7	6.5	7.3	10.2	13.5	16.9	20.3	27.1
3/4	2.1	2.8	3.5	4.4	6.2	7.1	8.0	11.1	14.8	18.4	22.1	29.5
13/16	2.3	3.1	3.8	4.8	6.7	7.7	8.6	12.0	16.0	22.0	24.0	32.0
7/8	2.5	3.3	4.1	5.2	7.2	8.3	9.3	12.9	17.2	21.5	25.8	34.4
15/16	2.7	3.5	4.4	5.5	7.7	8.8	10.0	13.8	18.5	23.0	27.7	36.9
1	2.8	3.8	4.7	5.9	8.3	9.4	10.6	14.8	19.7	24.6	29.5	39.4
1-1/2	4.2	5.6	7.0	8.8	12.3	14.1	15.8	22.1	29.5	36.8	44.2	58.9
2	5.6	7.5	9.4	11.7	16.4	18.8	21.1	29.5	39.3	49.1	58.9	78.5
2-1/2	7.1	9.4	11.7	14.7	20.5	23.6	26.4	36.8	49.1	61.4	73.6	98.2
3	8.5	11.3	14.1	17.6	24.6	28.2	31.7	44.2	58.9	73.6	88.4	118
3-1/2	9.9	13.1	16.4	20.5	28.8	32.7	37.0	51.5	68.7	85.9	103	137
4	11.3	15.0	18.8	23.5	32.8	37.6	42.2	58.9	78.5	98.2	118	157
4-1/2	12.7	16.9	21.2	26.4	37.0	42.4	47.5	66.3	88.4	110	133	177
5	14.1	18.7	23.5	29.3	41.1	47.1	52.8	73.6	98.2	123	147	196

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

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