

400 	SS-2 	SS-3 	SS-4 	SS-5 	SS-6 	795 	SS-8 	SS-9 	SS-10
SS-87 	<h1>EXACTA</h1> <h2>THICK TURRET TOOLING</h2> <p>CAT #TT502</p>								SS-11
SS-86 									SS-12
SS-42 									SS-13
SS-40 									SS-14
SS-38 									SS-15
SS-37 									SS-16
SS-36 									SS-17
SS-35 									SS-18
SS-34 									SS-19
SS-33 									SS-20
SS-32 									SS-21
SS-31 									SS-22
SS-30 									SS-23
SS-29 									SS-24
SS-28 									SS-25
SS-27 									SS-26
SS-26 	SS-27 								
SS-25 	SS-28 								
SS-24 	SS-29 								
SS-23 	SS-30 								
SS-22 	SS-31 								



Index

General Information	1	4-1/2" (E) Station Stripping Guide Assemblies	15
1/2" (A) Station Round Tooling	2	Accessories for Thick Turret Punch Presses	16
1/2" (A) Station Shape Tooling	3	Adaptors & Alignment Tools	17
1/2" (A) Station Self Lube Round Tooling	4	Louvre Tooling	18
1/2" (A) Station Self Lube Shape Tooling	5	Knockout Tooling	19
1-1/4" (B) Station Round Tooling	6	Special Tools for Thick Turret Punch Presses	20
1-1/4" (B) Station Shape Tooling	7	Replacement Mate® Style Tooling	21
1-1/4" (B) Station Self Lube Round Tooling	8	Replacement Strippit® Style Tooling	21
1-1/4" (B) Station Self Lube Shape Tooling	9	Replacement Wilson® Style Tooling	22 - 23
2" (C) Station Punches and Dies	10	Finn Power Multi-Tool® - Punches Dies and Strippers	24
2" (C) Station Stripping Guide Assemblies	11	Euromac® Tooling - Punches Dies and Strippers	25
3-1/2" (D) Station Punches and Dies	12	<i>Mate® is a Trademark of Mate Punch and Die Company.</i>	
3-1/2" (D) Station Stripping Guide Assemblies	13	<i>Wilson® is a Trademark of Wilson Tool International.</i>	
4-1/2" (E) Station Punches and Dies	14	<i>Finn Power® is a Trademark of Lillbackan Konepaja.</i>	
		<i>Euromac® is a Trademark of Euromac SRL.</i>	
		<i>Strippit® is a Trademark of L.V.D. Strippit.</i>	

Ordering Information

1. Type of **MACHINE**
2. "**W**" dimension "**P**" dimension "**A**" dimension etc.
3. **DIE CLEARANCE** or material and thickness
4. Are the **DIMENSIONS** looking at the face of the **PUNCH, DIE**, or the part.
5. **KEYING LOCATIONS** or Front of Machine
6. **FORMING** up or down

To Order

ONTARIO

EXACTA PRECISION PRODUCTS LTD.

3115 Kennedy Road
 Scarborough, Ontario, Canada
 M1V 4Y1

Telephone: (416) 291-1942
 Toll Free: 1-800-268-5573
 Fax: (416) 291-8387
 Toll Free Fax: 1-800-668-9314

QUEBEC & MARITIMES

PRODUITS DE PRÉCISION EXACTA LTÉE.

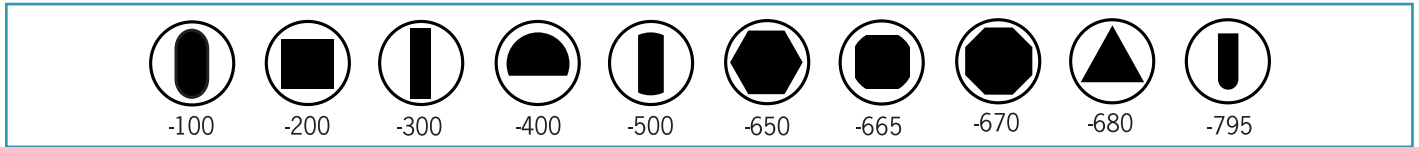
5965 Chemin St. François
 Ville St. Laurent, Québec, H4S 1B6

Téléphone: (514) 333-0146
 (Sans Frais) 1-800-361-6810
 Québec, N.B. - P.E.I. & N.S. (Toll Free)
 Télécopieur (514) 333-0147

Email: info@exactapunch.com • Website: www.exactapunch.com

General Information

Standard Shapes



Standard Keying

1/2" and 1-1/4" Stations - Front of Machine

Keying on Guides

Standard 0° & 90°
Squares 0° & 135°

Punches



Keying on Dies

Standard 0°
POSITIVE DIES SHIPPED UNLESS SPECIFIED

Dies



2" Station - Front of Machine

Keying on Punches

Standard 0°
Squares 0° & 135°

Keying on Guides

Standard 0°, 90° & 135°

Punches



Keying on Dies

Standard 0° & 90°
Squares 0° & 135°

Dies



3-1/2" Station - Front of Machine

Keying on Punches

Standard 0°
Squares 0° & 135°

Keying on Guides

Standard 0°, 90° & 135°

Punches



Keying on Dies

Standard 0° & 90°
Squares 0° & 135°

Dies



4-1/2" Station - Front of Machine

Keying on Punches

Standard 0°
Squares 0° & 135°

Keying on Guides

Standard 0° & 90°

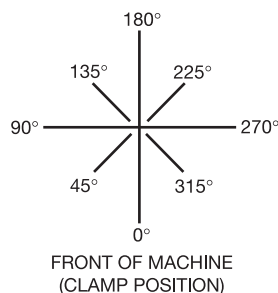
Punches



Keying on Dies

Standard 0° & 90°
Squares 0° & 135°

Dies



WHEN ORDERING TOOLING WITH KEYING OTHER THAN SHOWN ABOVE, SPECIFY SHAPE LOCATION BY DEGREE USING THIS DIAGRAM

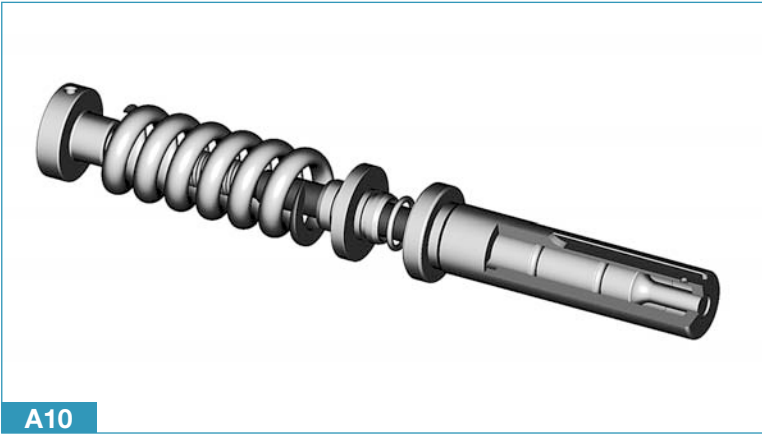
- IONITRIDING AVAILABLE
- EXSET COATING (GOLD) AVAILABLE
- URETHANE SHEDDERS SUPPLIED WHERE APPLICABLE
- HOUSE TOP SHEAR SUPPLIED ON WIDTHS FROM .250 AND UP ON 3-1/2" AND 4-1/2" STATIONS
- SPECIAL SHAPES - USE NUMBERS ON FRONT AND BACK COVERS



1/2" (A) Station Round Tooling

MAXIMUM PUNCH DIAMETER = .500" - 12.7mm
 MINIMUM PUNCH DIAMETER = .093" - 2.36mm

PUNCHES PREMIUM HIGH SPEED STEEL

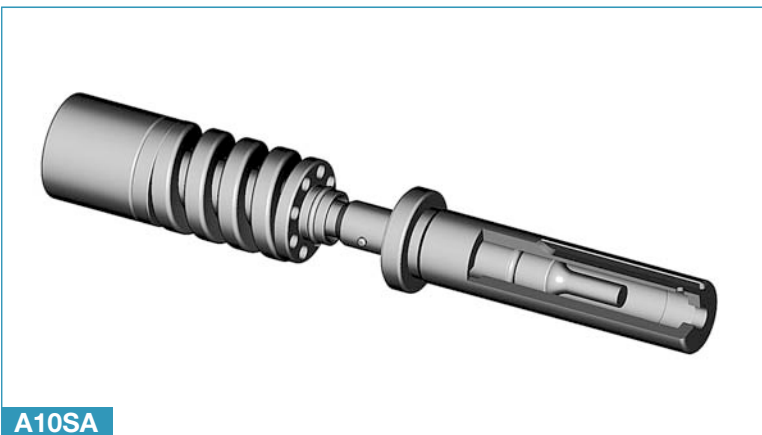


A10 Punch and Guide Assembly

Original Style
 (Does not include Die)

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A10
ROUND PUNCH	A30
ROUND GUIDE	A70
PUNCH HEAD	A100
STRIPPING SPRING	A130
*PUNCH COLLAR	A120
"O" RING	A110

*PUNCH COLLAR CAN BE REVERSED TO ACT AS A SHIM

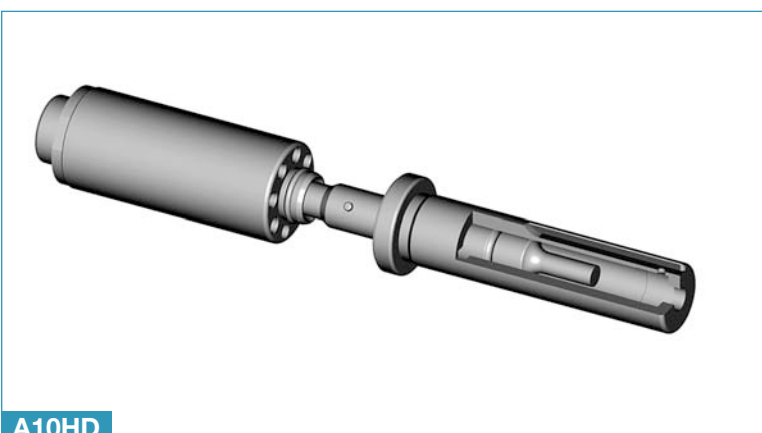


A10SA Punch and Guide Assembly

SA Style
 (Does not include Die)

"SA" is a self contained Spring Assembly with quick adjustment.
 To adjust, pull apart, turn spring unit and push together.

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A10SA
ROUND PUNCH	A30SA
ROUND GUIDE	A70SA
STRIPPING SPRING UNIT	A130SA
"O" RING	A110

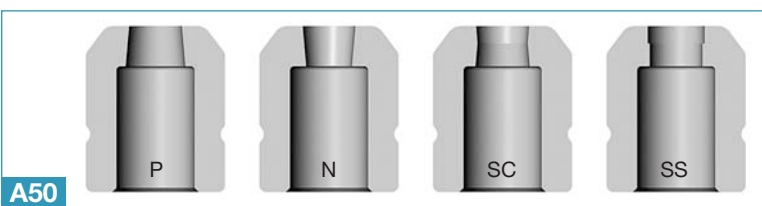


A10HD Punch and Guide Assembly

HD Style
 (Does not include Die)

"HD" is a self contained Disc Spring Assembly with quick adjustment.
 To adjust, pull apart, turn spring unit and push together.

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A10HD
ROUND PUNCH	A30SA
ROUND GUIDE	A70HD
STRIPPING DISC SPRING UNIT	A130HD
"O" RING	A110



A50 DIE - OPTIONS FOR ALL ASSEMBLIES

ROUND DIE	POSITIVE TAPER	A50
ROUND DIE	NEGATIVE TAPER	A50NT
ROUND DIE	SLUG CONTROL	A50SC
ROUND DIE	SLUG STOP	A50SS
ROUND DIE	TIGER CLAW	A50TC

M2 DIES AVAILABLE ON REQUEST

1/2" (A) Station **Shape** Tooling

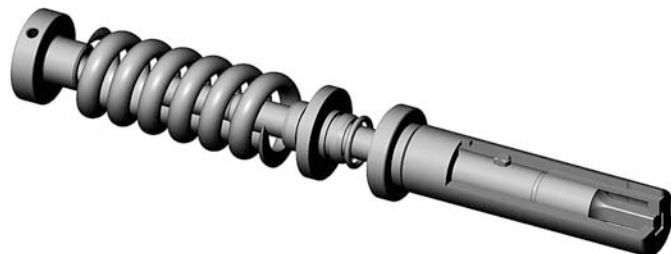
MAXIMUM ACROSS CORNERS = .500" - 12.7mm
 MINIMUM WIDTH = .093" - 2.36mm

PUNCHES PREMIUM HIGH SPEED STEEL

A20 Punch and Guide Assembly

Original Style
 (Does not include Die)

Refer to page 1 for standard shape codes



A20

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A20 ___
SHAPE PUNCH	A40 ___
SHAPE GUIDE	A80 ___
PUNCH HEAD	A100
STRIPPING SPRING	A130
*PUNCH COLLAR	A120
"O" RING	A110

*PUNCH COLLAR CAN BE REVERSED TO ACT AS A SHIM

SPECIFY SHAPE CODE IN PLACE OF ___

A20SA Punch and Guide Assemblies

SA Style
 (Does not include Die)

Refer to page 1 for standard shape codes

"SA" is a self contained Spring Assembly with quick adjustment.
To adjust, pull apart, turn spring unit and push together.



A20SA

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A20SA ___
SHAPE PUNCH	A40 ___
SHAPE GUIDE	A80SA ___
STRIPPING SPRING UNIT	A130SA
"O" RING	A110

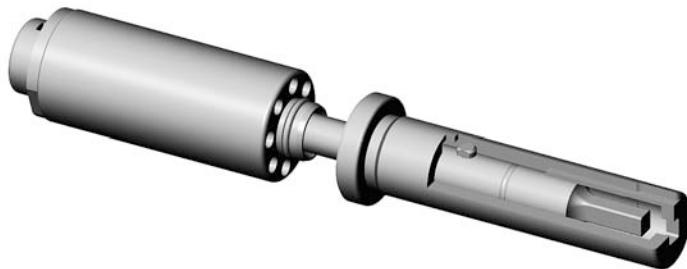
SPECIFY SHAPE CODE IN PLACE OF ___

A20HD Punch and Guide Assembly

HD Style
 (Does not include Die)

Refer to page 1 for standard shape codes

"HD" is a self contained Disc Spring Assembly with quick adjustment.
To adjust, pull apart, turn spring unit and push together.



A20HD

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A20HD ___
SHAPE PUNCH	A40 ___
SHAPE GUIDE	A80HD ___
STRIPPING DISC SPRING UNIT	A130HD
"O" RING	A110

SPECIFY SHAPE CODE IN PLACE OF ___



A60

A60 DIE - OPTIONS FOR ALL ASSEMBLIES

SHAPE DIE	POSITIVE TAPER	A60 ___
SHAPE DIE	NEGATIVE TAPER	A60NT ___
SHAPE DIE	SLUG CONTROL	A60SC ___
SHAPE DIE	SLUG STOP	A60SS ___
SHAPE DIE	TIGER CLAW (NOT SHOWN)	A60TC ___

M2 DIES AVAILABLE UPON REQUEST

SPECIFY SHAPE CODE IN PLACE OF ___

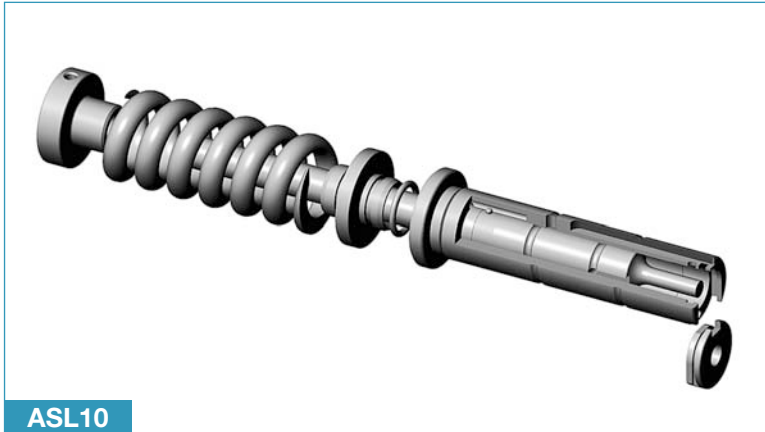


1/2" (A) Station Self Lube Round Tooling

SELF LUBE TOOLING IS FOR USE IN MACHINES THAT HAVE TOOLING LUBRICATION SYSTEM

MAXIMUM PUNCH DIAMETER = .500" - 12.7mm
 MINIMUM PUNCH DIAMETER = .093" - 2.36mm

PUNCHES PREMIUM HIGH SPEED STEEL

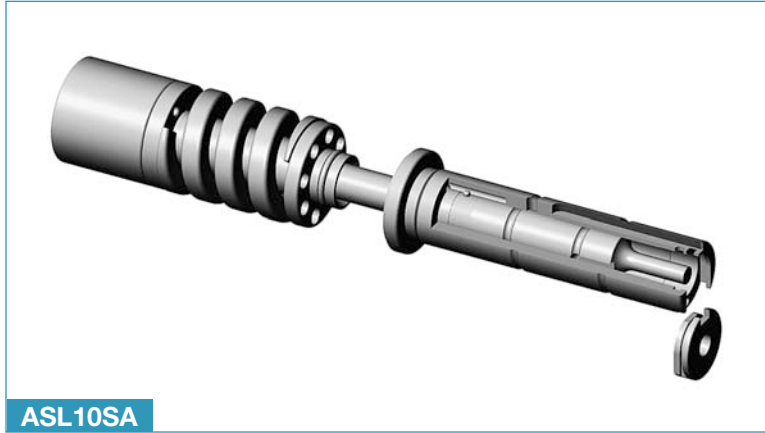


ASL10 Self Lube Punch and Guide Assembly Original Style

(Does not include Die)

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	ASL10
ROUND PUNCH	ASL30
ROUND GUIDE	ASL70
ROUND STRIPPER	ASL70SB
PUNCH HEAD	A100
STRIPPING SPRING	A130
*PUNCH COLLAR	A120
"O" RING	A110

*PUNCH COLLAR CAN BE REVERSED TO ACT AS A SHIM

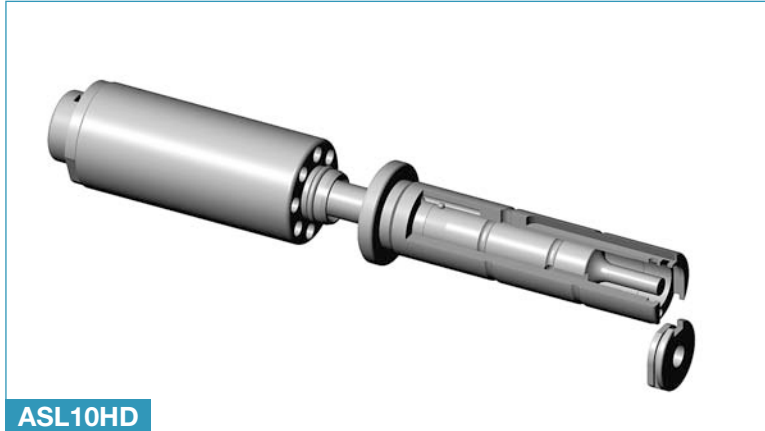


ASL10SA Self Lube Punch and Guide Assembly SA Style

(Does not include Die)

"SA" is a self contained Spring Assembly with quick adjustment.
 To adjust, pull apart, turn spring unit and push together.

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	ASL10SA
ROUND PUNCH	ASL30SA
ROUND GUIDE	ASL70SA
ROUND STRIPPER	ASL70SB
STRIPPING SPRING UNIT	A130SA
"O" RING	A110

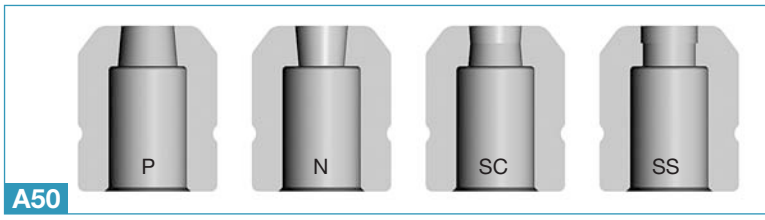


ASL10HD Self Lube Punch and Guide Assembly HD Style

(Does not include Die)

"HD" is a self contained Disc Spring Assembly with quick adjustment.
 To adjust, pull apart, turn spring unit and push together.

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	ASL10HD
ROUND PUNCH	ASL30SA
ROUND GUIDE	ASL70HD
ROUND STRIPPER	ASL70SB
STRIPPING DISC SPRING UNIT	A130HD
"O" RING	A110



A50 DIE - OPTIONS FOR ALL ASSEMBLIES

ROUND DIE	POSITIVE TAPER	A50
ROUND DIE	NEGATIVE TAPER	A50NT
ROUND DIE	SLUG CONTROL	A50SC
ROUND DIE	SLUG STOP	A50SS
ROUND DIE	TIGER CLAW	A50TC

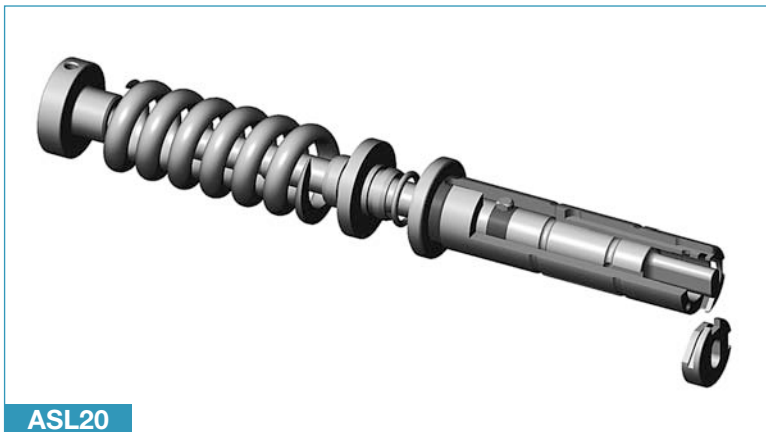
M2 DIES AVAILABLE ON REQUEST

1/2" (A) Station Self Lube Shape Tooling

SELF LUBE TOOLING IS FOR USE IN MACHINES THAT HAVE TOOLING LUBRICATION SYSTEM

MAXIMUM ACROSS CORNERS = .500" - 12.7mm
 MINIMUM WIDTH = .093" - 2.36mm

PUNCHES PREMIUM HIGH SPEED STEEL



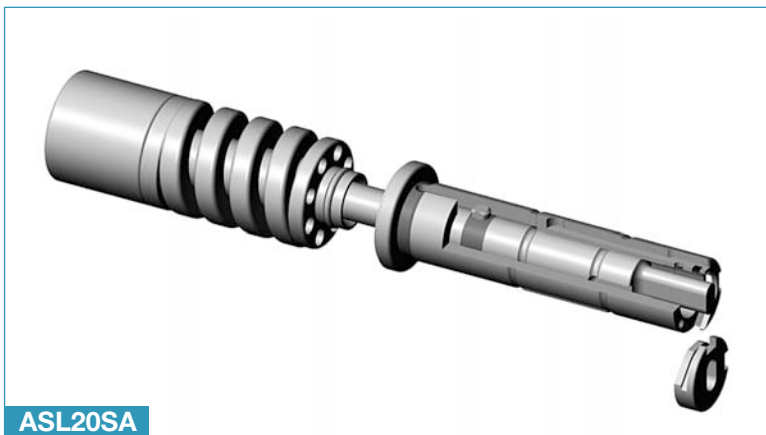
ASL20 Punch and Guide Assembly

Original Style
 (Does not include Die)

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	ASL20 ___
SHAPE PUNCH	ASL40 ___
SHAPE GUIDE	ASL80
SHAPE STRIPPER	ASL80SB ___
PUNCH HEAD	A100
STRIPPING SPRING	A130
*PUNCH COLLAR	A120
"O" RING	A110

*PUNCH COLLAR CAN BE REVERSED TO ACT AS A SHIM
 SPECIFY SHAPE CODE IN PLACE OF ___



ASL20SA Punch and Guide Assembly

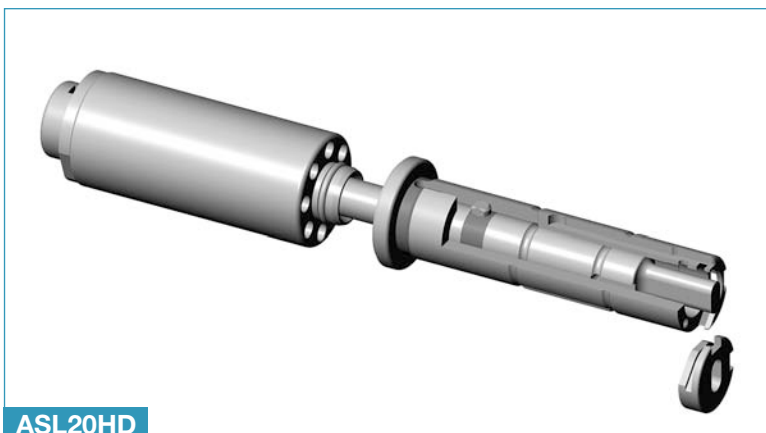
SA Style
 (Does not include Die)

Refer to page 1 for standard shape codes

"SA" is a self contained Spring Assembly with quick adjustment.
 To adjust, pull apart, turn spring unit and push together.

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	ASL20SA ___
SHAPE PUNCH	ASL40 ___
SHAPE GUIDE	ASL80SA
SHAPE STRIPPER	ASL80SB ___
STRIPPING SPRING UNIT	A130SA
"O" RING	A110

SPECIFY SHAPE CODE IN PLACE OF ___



ASL20HD Punch and Guide Assembly

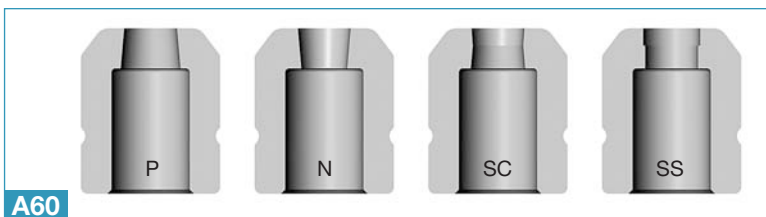
HD Style
 (Does not include Die)

Refer to page 1 for standard shape codes

"HD" is a self contained Disc Spring Assembly with quick adjustment.
 To adjust, pull apart, turn spring unit and push together.

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	ASL20HD ___
SHAPE PUNCH	ASL40 ___
SHAPE GUIDE	ASL80HD
SHAPE STRIPPER	ASL80SB ___
STRIPPING DISC SPRING UNIT	A130HD
"O" RING	A110

SPECIFY SHAPE CODE IN PLACE OF ___



A60 DIE - OPTIONS FOR ALL ASSEMBLIES

SHAPE DIE	POSITIVE TAPER	A60 ___
SHAPE DIE	NEGATIVE TAPER	A60NT ___
SHAPE DIE	SLUG CONTROL	A60SC ___
SHAPE DIE	SLUG STOP	A60SS ___
SHAPE DIE	TIGER CLAW (NOT SHOWN)	A60TC ___

M2 DIES AVAILABLE ON REQUEST
 SPECIFY SHAPE CODE IN PLACE OF ___



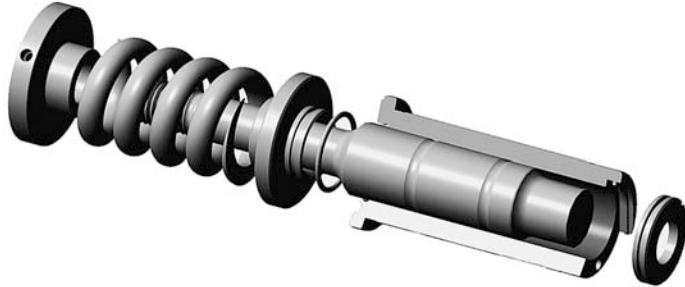
1-1/4" (B) Station Round Tooling

MAXIMUM PUNCH DIAMETER = 1.250" - 31.7mm
 MINIMUM PUNCH DIAMETER = .093" - 2.36mm

PUNCHES PREMIUM HIGH SPEED STEEL

A11 Punch and Guide Assembly

**Original Style
 (Does not include Die)**



A11

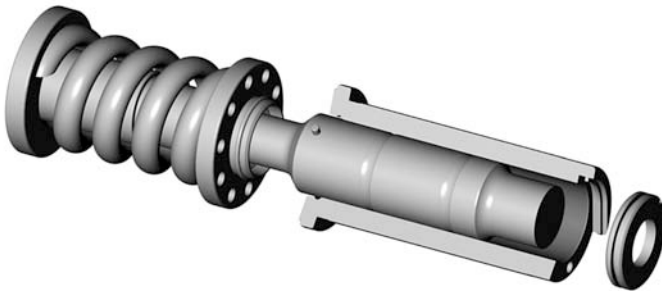
DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A11
ROUND PUNCH	A31
ROUND GUIDE	A71
ROUND STRIPPER	A71SB
PUNCH HEAD	A101
STRIPPING SPRING	A131
* PUNCH COLLAR	A121
"O" RING	A111

*PUNCH COLLAR CAN BE REVERSED TO ACT AS A SHIM

A11SA Punch and Guide Assembly

**SA Style
 (Does not include Die)**

"SA" is a self contained Spring Assembly with quick adjustment.
 To adjust, pull apart, turn spring unit and push together.



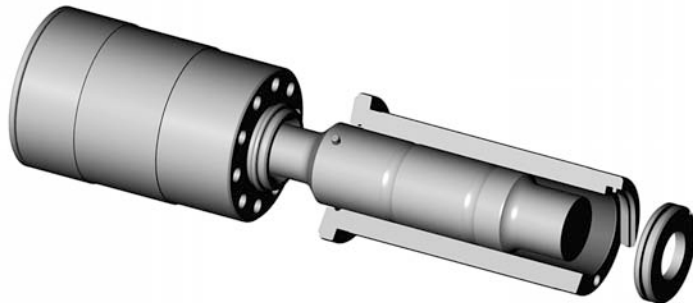
A11SA

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A11SA
ROUND PUNCH	A31SA
ROUND GUIDE	A71SA
ROUND STRIPPER	A71SB
STRIPPING SPRING UNIT	A131SA
"O" RING	A111SA

A11HD Punch and Guide Assembly

**HD Style
 (Does not include Die)**

"HD" is a self contained Disc Spring Assembly with quick adjustment.
 To adjust, pull apart, turn spring unit and push together.
 NOT FOR USE IN FINN POWER OR STRIPPIT MACHINES.



A11HD

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A11HD
ROUND PUNCH	A31SA
ROUND GUIDE	A71HD
ROUND STRIPPER	A71SB
STRIPPING DISC SPRING UNIT	A131HD
"O" RING	A111SA

A51DIE - OPTIONS FOR ALL ASSEMBLIES

ROUND DIE	POSITIVE TAPER	A51
ROUND DIE	NEGATIVE TAPER	A51NT
ROUND DIE	SLUG CONTROL	A51SC
ROUND DIE	SLUG STOP	A51SS
ROUND DIE	TIGER CLAW	A51TC

M2 DIES AVAILABLE UPON REQUEST

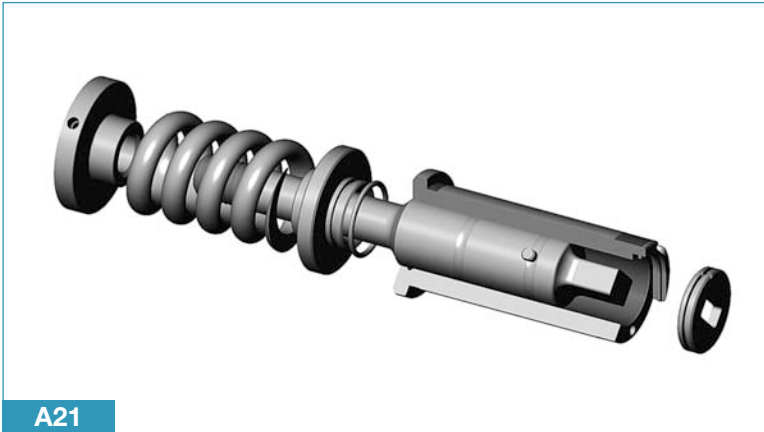


A51

1-1/4" (B) Station **Shape** Tooling

MAXIMUM ACROSS CORNERS = 1.250" - 31.7mm
 MINIMUM WIDTH = .093" - 2.36mm

PUNCHES PREMIUM HIGH SPEED STEEL



A21

A21 Punch and Guide Assembly

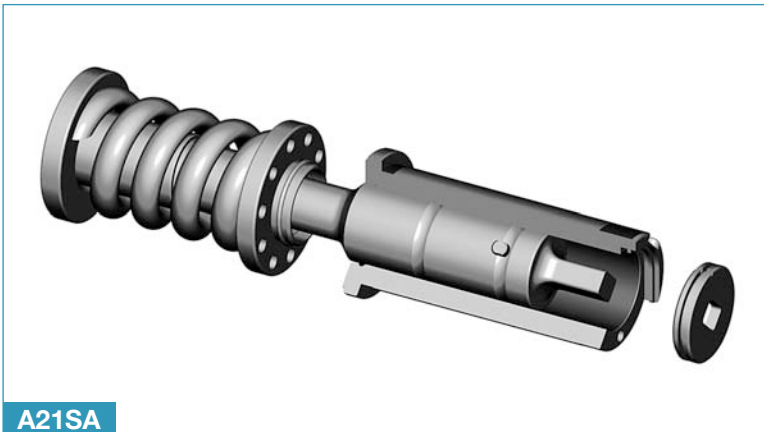
Original Style

(Does not include Die)

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A21 ___
SHAPE PUNCH	A41 ___
SHAPE GUIDE	A81
SHAPE STRIPPER	A81SB ___
PUNCH HEAD	A101
STRIPPING SPRING	A131
*PUNCH COLLAR	A121
"O" RING	A111

*PUNCH COLLAR CAN BE REVERSED TO ACT AS A SHIM
SPECIFY SHAPE CODE IN PLACE OF ___



A21SA

A21SA Punch and Guide Assembly

SA Style

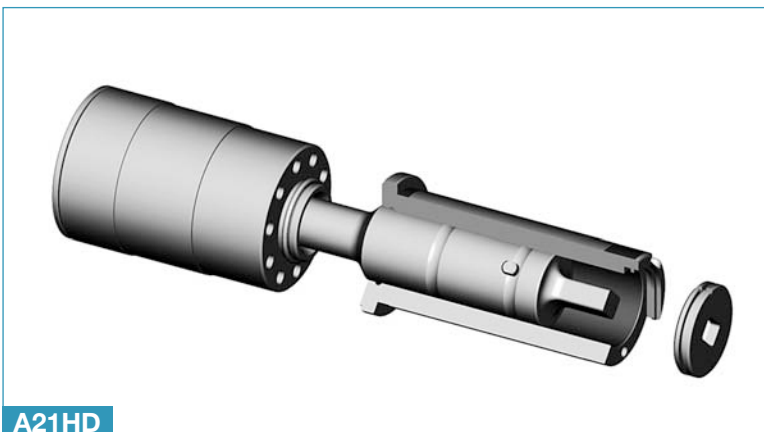
(Does not include Die)

Refer to page 1 for standard shape codes

SA" is a self contained Spring Assembly with quick adjustment. To adjust, pull apart, turn spring unit and push together.

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A21SA ___
SHAPE PUNCH	A41 ___
SHAPE GUIDE	A81SA
SHAPE STRIPPER	A81SB ___
STRIPPING SPRING UNIT	A131SA
"O" RING	A111SA

SPECIFY SHAPE CODE IN PLACE OF ___



A21HD

A21HD Punch and Guide Assembly

HD Style

(Does not include Die)

Refer to page 1 for standard shape codes

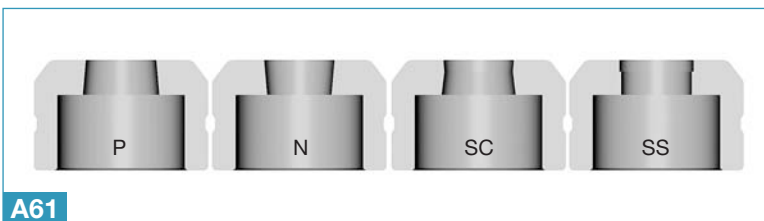
"HD" is a self contained Disc Spring Assembly with quick adjustment.

To adjust, pull apart, turn spring unit and push together.

NOT FOR USE IN FINN POWER OR STRIPPIT MACHINES.

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	A21HD ___
SHAPE PUNCH	A41 ___
SHAPE GUIDE	A81HD
SHAPE STRIPPER	A81SB ___
STRIPPING DISC SPRING UNIT	A131HD
"O" RING	A111SA

SPECIFY SHAPE CODE IN PLACE OF ___



A61

A61DIE - OPTIONS FOR ALL ASSEMBLIES

SHAPE DIE	POSITIVE TAPER	A61 ___
SHAPE DIE	NEGATIVE TAPER	A61NT ___
SHAPE DIE	SLUG CONTROL	A61SC ___
SHAPE DIE	SLUG STOP	A61SS ___
SHAPE DIE	TIGER CLAW (NOT SHOWN)	A61TC ___

M2 DIES AVAILABLE UPON REQUEST
SPECIFY SHAPE CODE IN PLACE OF ___



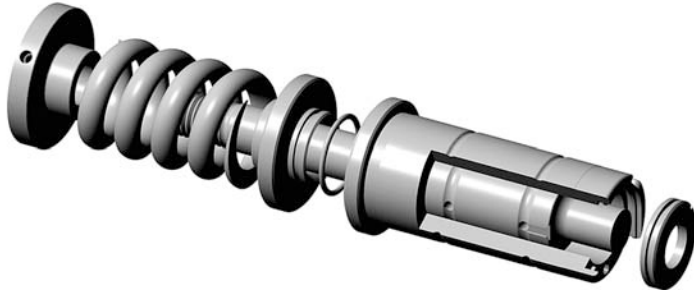
1-1/4" (B) Station Self Lube Round Tooling

MAXIMUM PUNCH DIAMETER = 1.250" - 31.7mm
 MINIMUM PUNCH DIAMETER = .093" - 2.36mm

PUNCHES PREMIUM HIGH SPEED STEEL

ASL11 Punch and Guide Assembly

**Original Style
 (Does not include Die)**



ASL11

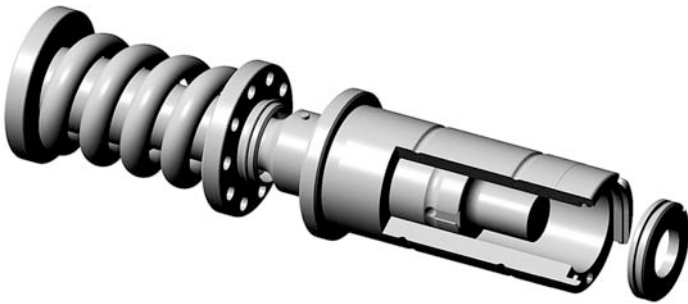
DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	ASL11
ROUND PUNCH	ASL31
ROUND GUIDE	ASL71
ROUND STRIPPER	ASL71SB
PUNCH HEAD	A101
STRIPPING SPRING	A131
*PUNCH COLLAR	A121
"O" RING	A111

*PUNCH COLLAR CAN BE REVERSED TO ACT AS A SHIM

ASL11SA Punch and Guide Assembly

**SA Style
 (Does not include Die)**

"SA" is a self contained Spring Assembly with quick adjustment.
To adjust, pull apart, turn spring unit and push together.



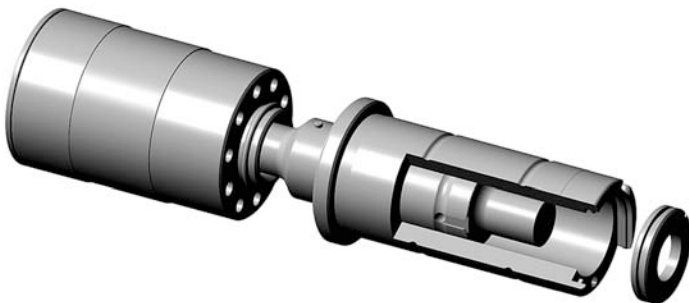
ASL11SA

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	ASL11SA
ROUND PUNCH	ASL31SA
ROUND GUIDE	ASL71SA
ROUND STRIPPER	ASL71SB
STRIPPING SPRING UNIT	A131SA
"O" RING	A111SA

ASL11HD Punch and Guide Assembly

**HD Style
 (Does not include Die)**

"HD" is a self contained Disc Spring Assembly with quick adjustment.
To adjust, pull apart, turn spring unit and push together.
NOT FOR USE IN FINN POWER OR STRIPPIT MACHINES.



ASL11HD

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	ASL11HD
ROUND PUNCH	ASL31SA
ROUND GUIDE	ASL71HD
ROUND STRIPPER	ASL71SB
STRIPPING DISC SPRING UNIT	A131HD
"O" RING	A111SA



A51

A51DIE - OPTIONS FOR ALL ASSEMBLIES

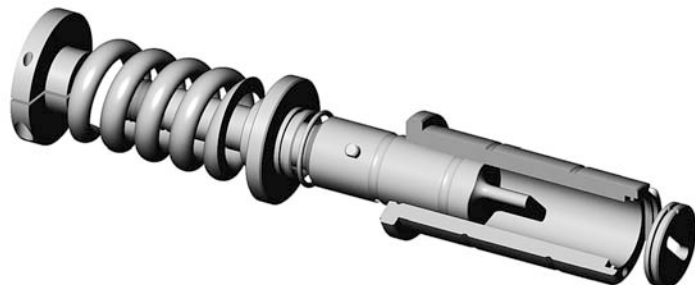
ROUND DIE	POSITIVE TAPER	A51
ROUND DIE	NEGATIVE TAPER	A51NT
ROUND DIE	SLUG CONTROL	A51SC
ROUND DIE	SLUG STOP	A51SS
ROUND DIE	TIGER CLAW	A51TC

M2 DIES AVAILABLE ON REQUEST

1-1/4" (B) Station Self Lube **Shape** Tooling

MAXIMUM ACROSS CORNERS = 1.250" - 31.7mm
 MINIMUM WIDTH = 0.93" - 2.36mm

PUNCHES PREMIUM HIGH SPEED STEEL



ASL21

ASL21 Punch and Guide Assembly

Original Style

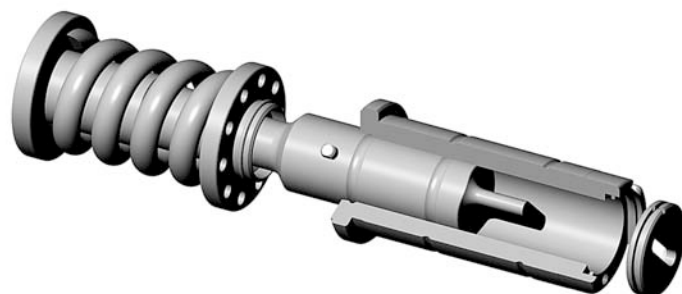
(Does not include Die)

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	ASL21 ___
SHAPE PUNCH	ASL41 ___
SHAPE GUIDE	ASL81
SHAPE STRIPPER	ASL81SB ___
PUNCH HEAD	A101
STRIPPING SPRING	A131
*PUNCH COLLAR	A121
"O" RING	A111

*PUNCH COLLAR CAN BE REVERSED TO ACT AS A SHIM

SPECIFY SHAPE CODE IN PLACE OF ___



ASL21SA

ASL21SA Punch and Guide Assembly

SA Style

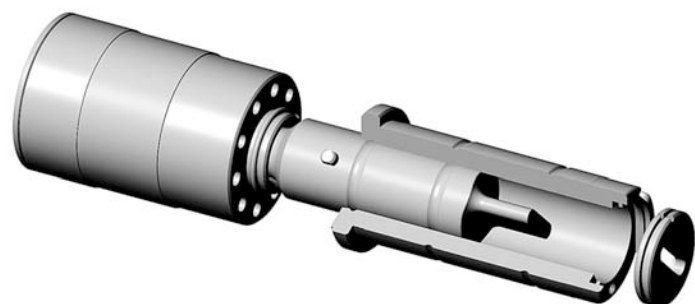
(Does not include Die)

Refer to page 1 for standard shape codes

"SA" is a self contained Spring Assembly with quick adjustment.
To adjust, pull apart, turn spring unit and push together.

DESCRIPTION	PART NO
PUNCH AND GUIDE ASSEMBLY	ASL21SA ___
SHAPE PUNCH	ASL41 ___
SHAPE GUIDE	ASL81SA
SHAPE STRIPPER	ASL81SB ___
STRIPPING SPRING UNIT	A131SA
"O" RING	A111SA

SPECIFY SHAPE CODE IN PLACE OF ___



ASL21HD

ASL21HD Punch and Guide Assembly

HD Style

(Does not include die)

Refer to page 1 for standard shape codes

"HD" is a self contained Disc Spring Assembly with quick adjustment.
To adjust, pull apart, turn spring unit and push together.

NOT FOR USE IN FINN POWER OR STRIPPIT MACHINES.

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	ASL21HD ___
SHAPE PUNCH	ASL41 ___
SHAPE GUIDE	ASL81HD
SHAPE STRIPPER	ASL81SB ___
STRIPPING DISC SPRING UNIT	A131HD
"O" RING	A111SA

SPECIFY SHAPE CODE IN PLACE OF ___



A61

A61DIE - OPTIONS FOR ALL ASSEMBLIES

SHAPE DIE	POSITIVE TAPER	A61 ___
SHAPE DIE	NEGATIVE TAPER	A61NT ___
SHAPE DIE	SLUG CONTROL	A61SC ___
SHAPE DIE	SLUG STOP	A61SS ___
SHAPE DIE	TIGER CLAW (NOT SHOWN)	A61TC ___

M2 DIES AVAILABLE ON REQUEST

SPECIFY SHAPE CODE IN PLACE OF ___



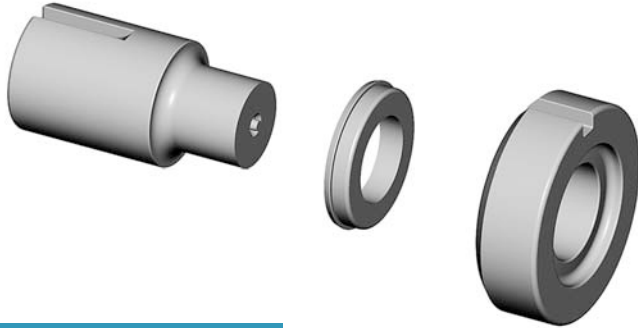
2" (C) Station Punches and Dies

MAXIMUM PUNCH DIAMETER = 2.000" - 50.80mm
 MINIMUM PUNCH DIAMETER = 1.251" - 31.77mm
 MINIMUM WIDTH = .093" - 2.36mm

PUNCHES PREMIUM HIGH SPEED STEEL

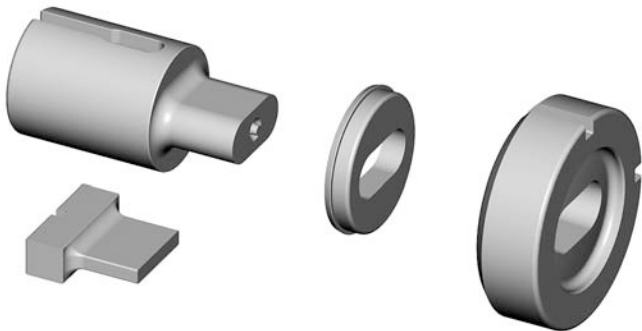
Refer to page 1 for standard shape codes

Original Style - Round



A32 A92 A52

DESCRIPTION	PART NO.
ROUND PUNCH	A32
ROUND STRIPPER	A92
ROUND DIE - POSITIVE TAPER	A52
ROUND DIE - NEGATIVE TAPER	A52NT
ROUND DIE - SLUG CONTROL	A52SC
ROUND DIE - SLUG STOP	A52SS
ROUND DIE - TIGER CLAW	A52TC



A42 A96 A62 AL420I

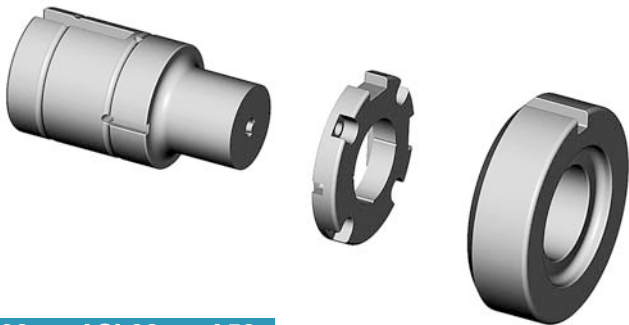
Original Style - Shape

DESCRIPTION	PART NO.
SHAPE PUNCH	A42 _ _ _
PUNCH INSERT AND HOLDER ASSEMBLY	AL42 _ _ _
INSERT HOLDER (NOT SHOWN)	AL42H
*PUNCH INSERT	AL420I _ _ _
BOLT (2 REQUIRED)	1/4"-20 x 1-3/4"
SHAPE STRIPPER	A96 _ _ _
SHAPE DIE - POSITIVE TAPER	A62 _ _ _
SHAPE DIE - NEGATIVE TAPER	A62NT _ _ _
SHAPE DIE - SLUG CONTROL	A62SC _ _ _
SHAPE DIE - SLUG STOP	A62SS _ _ _
SHAPE DIE - TIGER CLAW	A62TC _ _ _

*INSERTS ARE INTERCHANGEABLE - WIDTHS .093 TO .625

SPECIFY SHAPE CODE IN PLACE OF _ _ _

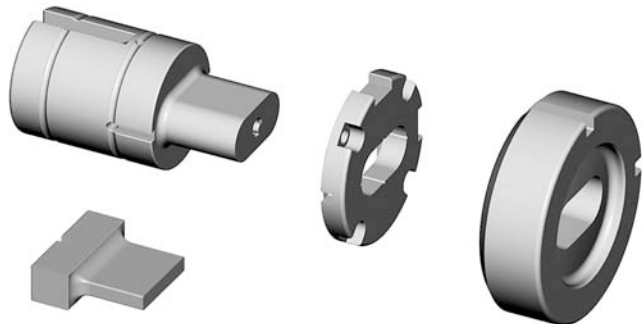
Self Lube - Round



ASL32 ASL92 A52

DESCRIPTION	PART NO.
ROUND PUNCH	ASL32
ROUND STRIPPER	ASL92
ROUND DIE - POSITIVE TAPER	A52
ROUND DIE - NEGATIVE TAPER	A52NT
ROUND DIE - SLUG CONTROL	A52SC
ROUND DIE - SLUG STOP	A52SS
ROUND DIE - TIGER CLAW	A52TC

Self Lube - Shape



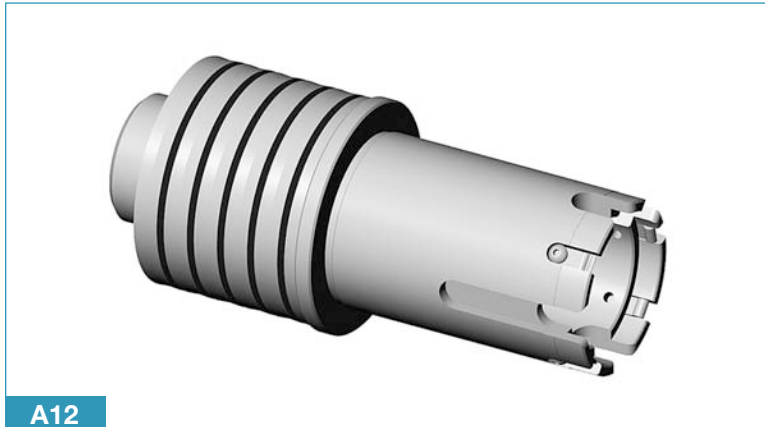
ASL42 ASL96 A62 AL420I

DESCRIPTION	PART NO.
SHAPE PUNCH	ASL42 _ _ _
PUNCH INSERT AND HOLDER ASSEMBLY	ALSL42 _ _ _
INSERT HOLDER (NOT SHOWN)	ALSL42H
*PUNCH INSERT	AL420I _ _ _
BOLT (2 REQUIRED)	1/4"-20 x 1-3/4"
SHAPE STRIPPER	ASL96 _ _ _
SHAPE DIE - POSITIVE TAPER	A62 _ _ _
SHAPE DIE - NEGATIVE TAPER	A62NT _ _ _
SHAPE DIE - SLUG CONTROL	A62SC _ _ _
SHAPE DIE - SLUG STOP	A62SS _ _ _
SHAPE DIE - TIGER CLAW	A62TC _ _ _

*INSERTS ARE INTERCHANGEABLE - WIDTHS .093 TO .625

SPECIFY SHAPE CODE IN PLACE OF _ _ _

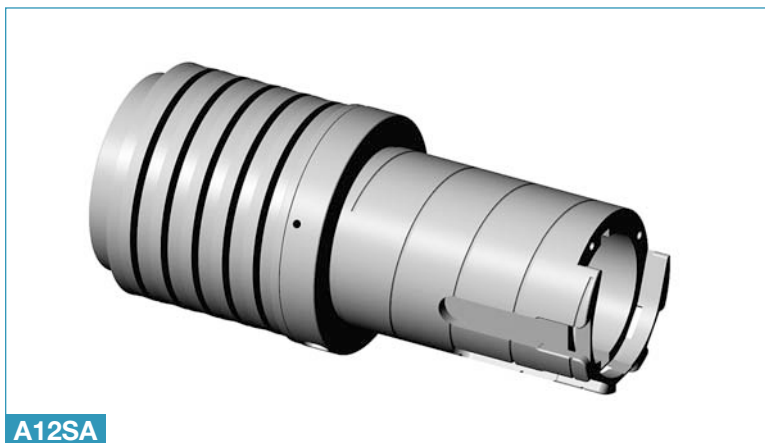
2" (C) Station Stripping Guide Assemblies



A12

Original - Guide Assembly

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	A12
PUNCH HEAD	A102
PUNCH DRIVER	A112
GUIDE ONLY	A72
PUNCH HEAD (VIPROS Z)	A102VZ
DISC SPRING (11 REQUIRED)	A132R
STRIPPER CLIP (4 REQUIRED)	A136
SCREW AND WASHER	A136AB
SCREW, CLIP AND WASHER	A137
DRAW BOLT	M12X55
HEAD SCREW (4 REQUIRED)	M8X25



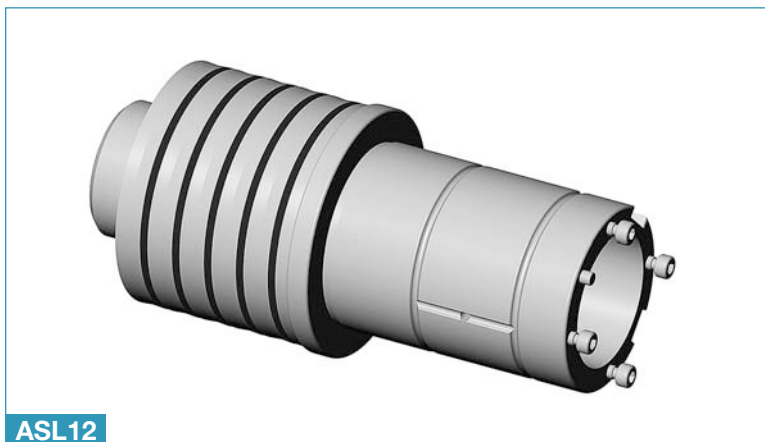
A12SA

Adjustable - Guide Assembly

Standard indexing: 0° - 45° - 90° - 135° - 180° - 225° - 270° - 315°

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	A12SA
PUNCH HEAD	A102SA
PUNCH DRIVER	A112SA
GUIDE ONLY*	A72SA
PUNCH HOLDER	APH112SA
DISC SPRING (11 REQUIRED)	A132R
SPRING SUPPORT	A132SS
LOCK PIN INCLUDED W/GUIDE	ALP72SA
SLIDE PIN INCLUDED W/GUIDE	ASP72SA
PUNCH KEY	A142SA
DRAW BOLT	M12X55
HEAD SCREW (4 REQUIRED)	M8X16

*INCLUDES LOCK PIN & SLIDE PIN



ASL12

Self Lube - Guide Assembly

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	ASL12
PUNCH HEAD	ASL102
PUNCH DRIVER	ASL112
GUIDE ONLY	ASL72
DISC SPRING (11 REQUIRED)	A132R
DRAW BOLT	ASLM14X70
HEAD SCREW (4 REQUIRED)	M8X25
STRIPPER SCREW (4 REQUIRED)	M5X20



3-1/2" (D) Station Punches and Dies

MAXIMUM PUNCH DIAMETER = 3.500" - 88.9mm
 MINIMUM PUNCH DIAMETER = 2.001" - 50.82mm
 MINIMUM WIDTH = .093" - 2.36mm

Refer to page 1 for standard shape codes

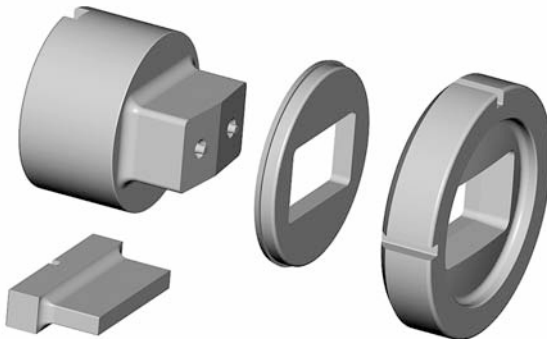
do changes still



A33 A93 A53

Original Style - Round

DESCRIPTION	PART NO.
ROUND PUNCH	A33
ROUND STRIPPER	A93
ROUND DIE - POSITIVE TAPER	A53
ROUND DIE - NEGATIVE TAPER	A53NT
ROUND DIE - SLUG CONTROL	A53SC
ROUND DIE - SLUG STOP	A53SS
ROUND DIE - TIGER CLAW	A53TC



A43 A97 A63 AL4301

Original Style - Shape

DESCRIPTION	PART NO.
SHAPE PUNCH	A43
PUNCH INSERT HOLDER ASSEMBLY	AL43
INSERT HOLDER (NOT SHOWN)	AL43H
*PUNCH INSERT HIGH SPEED STEEL	AL4301
BOLT (2 REQUIRED)	5/16"-18 x 1-1/4"
SHAPE STRIPPER	A97
SHAPE DIE - POSITIVE TAPER	A63
SHAPE DIE - NEGATIVE TAPER	A63NT
SHAPE DIE - SLUG CONTROL	A63SC
SHAPE DIE - SLUG STOP	A63SS
SHAPE DIE - TIGER CLAW	A63TC

*INSERTS ARE INTERCHANGEABLE - WIDTHS .093 TO .750

SPECIFY SHAPE CODE IN PLACE OF

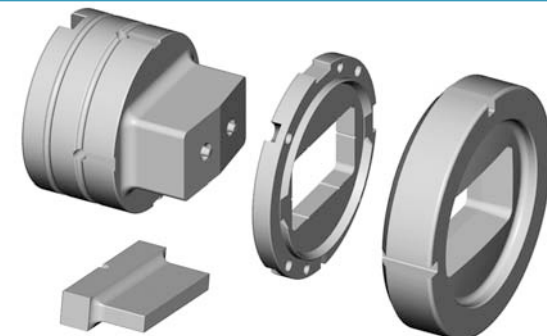


ASL33 ASL93 A53

Self Lube - Round

PUNCHES PREMIUM HIGH SPEED STEEL

DESCRIPTION	PART NO.
ROUND PUNCH	ASL33
ROUND STRIPPER	ASL93
ROUND DIE - POSITIVE TAPER	A53
ROUND DIE - NEGATIVE TAPER	A53NT
ROUND DIE - SLUG CONTROL	A53SC
ROUND DIE - SLUG STOP	A53SS
ROUND DIE - TIGER CLAW	A53TC



ASL43 ASL97 A63 AL4301

Self Lube - Shape

DESCRIPTION	PART NO.
SHAPE PUNCH	ASL43
PUNCH INSERT HOLDER ASSEMBLY	ALSL43
INSERT HOLDER (NOT SHOWN)	ALSL43H
*PUNCH INSERT	AL4301
BOLT (2 REQUIRED)	5/16"-18 x 1-1/4"
SHAPE STRIPPER	ASL97
SHAPE DIE - POSITIVE TAPER	A63
SHAPE DIE - NEGATIVE TAPER	A63NT
SHAPE DIE - SLUG CONTROL	A63SC
SHAPE DIE - SLUG STOP	A63SS
SHAPE DIE - TIGER CLAW	A63TC

*INSERTS ARE INTERCHANGEABLE - WIDTHS .093 TO .750

SPECIFY SHAPE CODE IN PLACE OF

3-1/2" (D) Station Stripping Guide Assemblies



A13

Original - Guide Assembly

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	A13
PUNCH HEAD	A103
PUNCH DRIVER	A113
GUIDE ONLY	A73
PUNCH HEAD (VIPROS Z)	A103VZ
DISC SPRING (7 REQUIRED)	A133
STRIPPER CLIP (4 REQUIRED)	A136
SCREW AND WASHER	A136AB
SCREW, CLIP AND WASHER	A137
PUNCH KEY	A143
DRAW BOLT	M12X75
HEAD SCREW (4 REQUIRED)	M8X25



A13SA

Adjustable - Guide Assembly

Standard indexing: 0° - 45° - 90° - 135° - 180° - 225° - 270° - 315°

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	A13SA
PUNCH HEAD	A103SA
PUNCH DRIVER	A113SA
GUIDE ONLY*	A73SA
PUNCH HOLDER	APH113SA
DISC SPRING (7 REQUIRED)	A133
SPRING SUPPORT	A133SS
LOCK PIN INCLUDED W/GUIDE	ALP72SA
SLIDE PIN INCLUDED W/GUIDE	ASP72SA
PUNCH KEY	A143
DRAW BOLT	M12X75
HEAD SCREW (4 REQUIRED)	M8X20

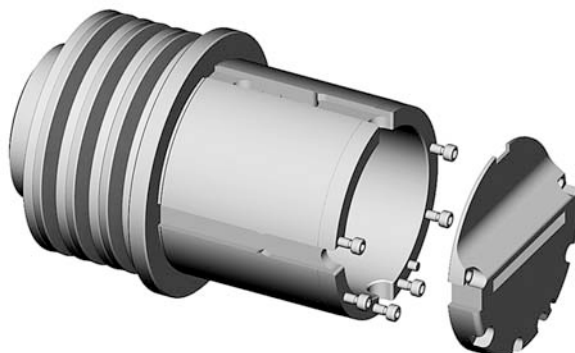
*INCLUDES LOCK PIN & SLIDE PIN



ASL13

Self Lube - Guide Assembly

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	ASL13
PUNCH HEAD	ASL103
PUNCH DRIVER	ASL113
GUIDE ONLY	ASL73
DISC SPRING (7 REQUIRED)	A133
PUNCH KEY	A143
DRAW BOLT	ASLM14X70
HEAD SCREW (4 REQUIRED)	M8X25
STRIPPER SCREW (4 REQUIRED)	M5X20



A13CR

Close to Clamp - Guide Assembly

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	A13CR
PUNCH HEAD	A103
PUNCH DRIVER	A113
GUIDE ONLY	A73CR
DISC SPRING (7 REQUIRED)	A133
STRIPPER	A97CR _ _ _
PUNCH KEY	A143
SINGLE RELIEF DIE	A63CR _ _ _
DOUBLE RELIEF DIE	A63DCR _ _ _
DRAW BOLT	M12X75
STRIPPER SCREW (6 REQUIRED)	M5X20
HEAD SCREW (4 REQUIRED)	M5X25

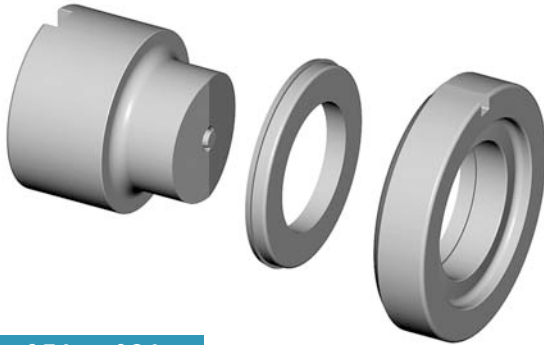
SPECIFY SHAPE CODE IN PLACE OF _ _ _



4-1/2" (E) Station Punches and Dies

MAXIMUM PUNCH DIAMETER = 4.500" - 114.3mm
 MINIMUM PUNCH DIAMETER = 3.001" - 76.22mm
 MINIMUM WIDTH = .093" - 2.36mm

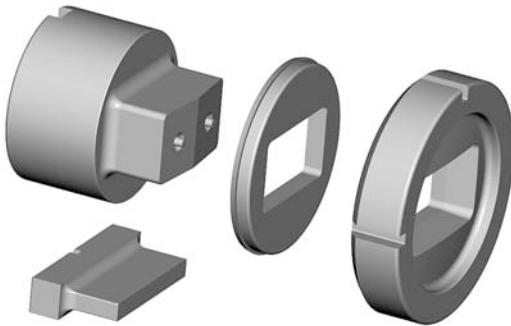
Refer to page 1 for standard shape codes



A34 A54 A94

Original Style - Round

DESCRIPTION	PART NO.
ROUND PUNCH	A34
ROUND STRIPPER	A94
ROUND DIE - POSITIVE TAPER	A54
ROUND DIE - NEGATIVE TAPER	A54NT
ROUND DIE - SLUG CONTROL	A54SC
ROUND DIE - SLUG STOP	A54SS
ROUND DIE - TIGER CLAW	A54TC



A44 A98 A64 AL440I

Original Style - Shape

DESCRIPTION	PART NO.
SHAPE PUNCH	A44 ___
PUNCH INSERT HOLDER ASSEMBLY	AL44 ___
INSERT HOLDER (NOT SHOWN)	AL44H
PUNCH INSERT HIGH SPEED STEEL	AL440I
BOLT (2 REQUIRED)	5/16"-18 x 1-1/4"
SHAPE STRIPPER	A98 ___
SHAPE DIE - POSITIVE TAPER	A64 ___
SHAPE DIE - NEGATIVE TAPER	A64NT ___
SHAPE DIE - SLUG CONTROL	A64SC ___
SHAPE DIE - SLUG STOP	A64SS ___
SHAPE DIE - TIGER CLAW	A64TC ___

*INSERTS ARE INTERCHANGEABLE - WIDTHS .093 TO .750

SPECIFY SHAPE CODE IN PLACE OF ___

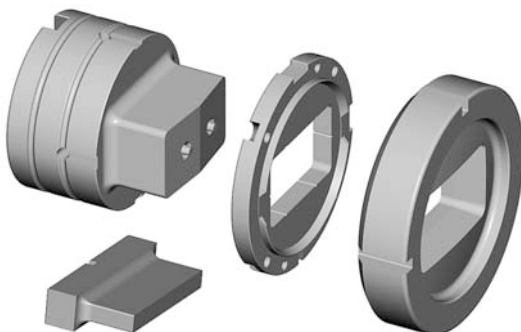


ASL34 ASL94 A54

Self Lube - Round

PUNCHES PREMIUM HIGH SPEED STEEL

DESCRIPTION	PART NO.
ROUND PUNCH	ASL34
ROUND STRIPPER	ASL94
ROUND DIE - POSITIVE TAPER	A54
ROUND DIE - NEGATIVE TAPER	A54NT
ROUND DIE - SLUG CONTROL	A54SC
ROUND DIE - SLUG STOP	A54SS
ROUND DIE - TIGER CLAW	A54TC



ASL44 ASL98 A64 AL440I

Self Lube - Shape

DESCRIPTION	PART NO.
SHAPE PUNCH	ASL44 ___
PUNCH INSERT HOLDER ASSEMBLY	ALSL44 ___
INSERT HOLDER (NOT SHOWN)	ALSL44H
PUNCH INSERT	AL440I
BOLT (2 REQUIRED)	5/16"-18 x 1-1/4"
SHAPE STRIPPER	ASL98 ___
SHAPE DIE - POSITIVE TAPER	A64 ___
SHAPE DIE - NEGATIVE TAPER	A64NT ___
SHAPE DIE - SLUG CONTROL	A64SC ___
SHAPE DIE - SLUG STOP	A64SS ___
SHAPE DIE - TIGER CLAW	A64TC ___

*INSERTS ARE INTERCHANGEABLE - WIDTHS .093 TO .750

SPECIFY SHAPE CODE IN PLACE OF ___

4-1/2" (E) Station Stripping Guide Assemblies



A14

Original - Guide Assembly

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	A14
PUNCH HEAD	A104
PUNCH DRIVER	A114
GUIDE ONLY	A74
PUNCH HEAD (VIPROS Z)	A104VZ
DISC SPRING (7 REQUIRED)	A133
STRIPPER CLIP (4 REQUIRED)	A136
SCREW AND WASHER	A136AB
SCREW, CLIP AND WASHER	A137
PUNCH KEY	A143
DRAW BOLT	M12X75
HEAD SCREW (4 REQUIRED)	M8X25



A14SA

Adjustable - Guide Assembly

Standard indexing: 0° - 90° - 180° - 270°

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	A14SA
PUNCH HEAD	A104SA
PUNCH DRIVER	A114SA
GUIDE ONLY*	A74SA
PUNCH HOLDER	APH114SA
DISC SPRING (7 REQUIRED)	A133
SPRING SUPPORT	A134SS
LOCK PIN INCLUDED W/GUIDE	ALP72SA
SLIDE PIN INCLUDED W/GUIDE	ASP72SA
PUNCH KEY	A143
DRAW BOLT	M12X75
HEAD SCREW (4 REQUIRED)	M8X20

*INCLUDES LOCK PIN & SLIDE PIN



ASL14

Self Lube - Guide Assembly

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	ASL14
PUNCH HEAD	ASL104
PUNCH DRIVER	ASL114
GUIDE ONLY	ASL74
DISC SPRING (7 REQUIRED)	A133
DRAW BOLT	ASLM14X70
HEAD SCREW (4 REQUIRED)	M8X25
STRIPPER SCREW (4 REQUIRED)	M5X20



A14CR

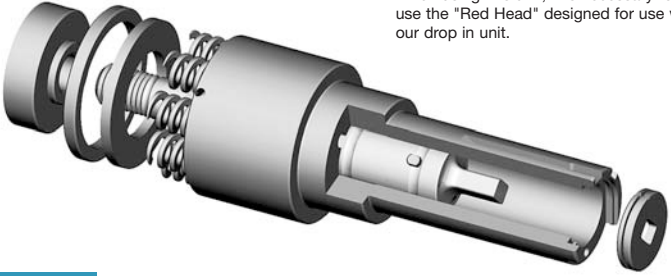
Close to Clamp - Guide Assembly

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	A14CR
PUNCH HEAD	A104
PUNCH DRIVER	A114
GUIDE ONLY	A74CR
DISC SPRING (7 REQUIRED)	A133
STRIPPER	A98CR _ _ _
PUNCH KEY	A143
SINGLE RELIEF DIE	A64CR _ _ _
DOUBLE RELIEF DIE	A64DCR _ _ _
DRAW BOLT	M12X75
HEAD SCREW (4 REQUIRED)	M8X25
STRIPPER SCREW (6 REQUIRED)	M5X20

SPECIFY SHAPE CODE IN PLACE OF _ _ _



Accessories for Thick Turret Punch Presses



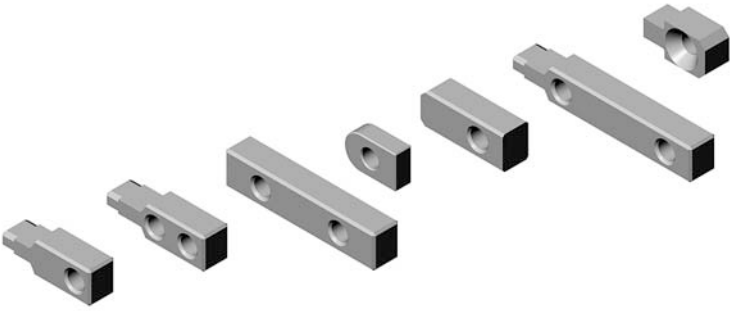
This unit uses all standard 1-1/4" punches, dies and stripper plates. When using this unit, it is necessary to also use the "Red Head" designed for use with our drop in unit.

A23DI

1-1/4" Station Drop In Tooling

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
1-1/4" PUNCH HOLDER - ROUND & SHAPE	A23DI
"RED HEAD" FOR DROP IN HOLDER	A101DI
PUNCH - ROUND	A31
PUNCH - SHAPE	A41
ROUND STRIPPER	A71SB
SHAPE STRIPPER	A81SB
STRIPPER CLIP	A71SC
NOT FOR USE IN FINN POWER MACHINES	
SPECIFY SHAPE CODE IN PLACE OF _ _ _	



17 18 19 20 21 16 12

Turret Keys

STATION	TURRET KEY NUMBER
1/2" and 1-1/4"	A74165117
1-1/4"	A74165118
2"	A74165119
3-1/2"	A74165120
4-1/2"	A74165121
1/2" and 1-1/4"	A74205116
1-1/4" Auto Index	A74058997
1/2" and 1-1/4"	A74348521
2" Amada Original Style Guide	A90142
2" Auto Index Aries® 245	A75424008
STATION	DIE KEY NUMBER
2" - 3-1/2" - 4-1/2"	A74165112
2" Aries® 245	A75413503
3-1/2" Aries® 245	A75413528



AUS12 **AUS25** **AUS39**

Urethane Slug Ejectors

DIA. or WIDTH of PUNCH	PART NO.
1/4" to 3/4"	AUS12
3/4" to 2"	AUS25
over 2"	AUS39



A100SL **A101SL** **A1000SA**

Split Lock Heads

DESCRIPTION	PART NO.
SPLIT LOCK HEAD 1/2" STATION	A100SL
SPLIT LOCK HEAD 1-1/4" STATION	A101SL
Eliminates Head Back Off on Tough Applications	

Adjustable Heads

DESCRIPTION	PART NO.
FOR 1-1/4" FORMING TOOLS ONLY	A-1000SA

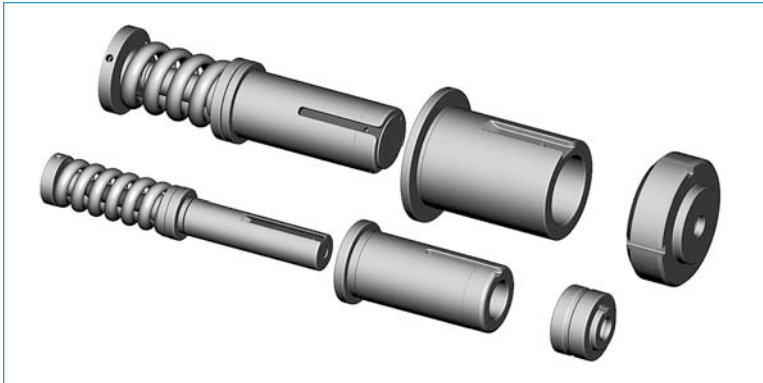
Work Holder Clamps for Turret Machines

Exacta Offers a Full Line of Work Holder Clamp Assemblies and Replacement Parts

Adaptors

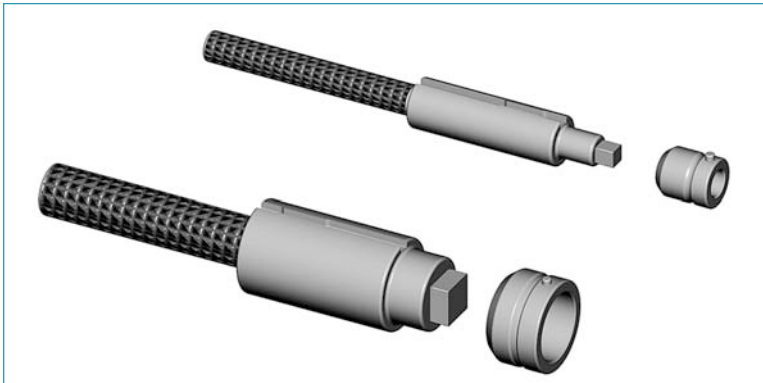
1/2" and 1-1/4" Adaptors

Allows 1/2" station and/or 1-1/4" station assemblies and dies to be used in larger stations

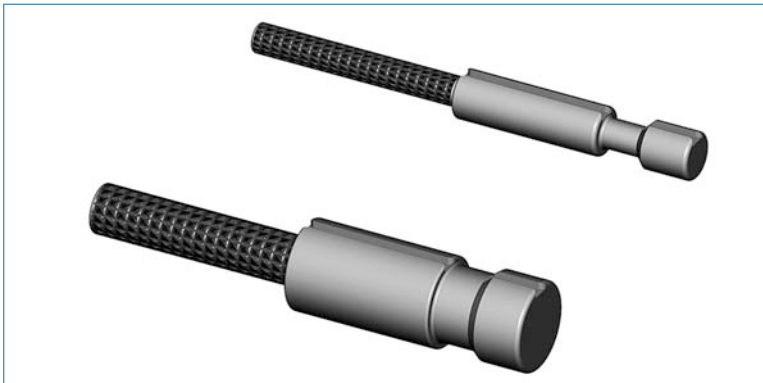


DESCRIPTION	STATION	PART NO.
PUNCH ADAPTOR	(1/2" - 1-1/4")	A20-21PA
DIE ADAPTOR	(1/2" - 1-1/4")	A60-61DA
PUNCH ADAPTOR	(1/2" - 2")	A20-72PA
DIE ADAPTOR	(1/2" - 2")	A60-62DA
PUNCH ADAPTOR	(1-1/4" - 2")	A21-72PA
DIE ADAPTOR	(1-1/4" - 2")	A61-62DA
PUNCH ADAPTOR	(1-1/4" - 3-1/2")	A21-73PA
DIE ADAPTOR	(1-1/4" - 3-1/2")	A61-63DA
PUNCH ADAPTOR	(1-1/4" - 4-1/2")	A21-74PA
DIE ADAPTOR	(1-1/4" - 4-1/2")	A61-64DA
PUNCH ADAPTOR	(2" - 3-1/2")	A72-73PA
DIE ADAPTOR	(2" - 3-1/2")	N/A
PUNCH ADAPTOR	(2" - 4-1/2")	A72-74PA
DIE ADAPTOR	(2" - 4-1/2")	A62-64DA

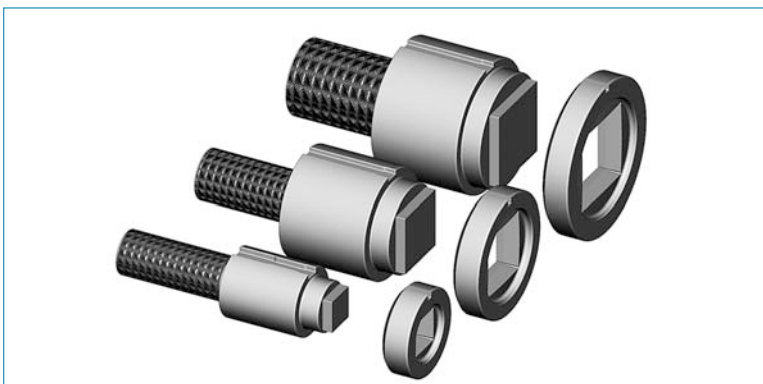
Alignment Tools



DESCRIPTION	STATION	PART NO.
TOOL SET (SINGLE TRACK)	1/2" (A)	A2000A
TOOL SET (SINGLE TRACK)	1-1/4" (B)	A2000B



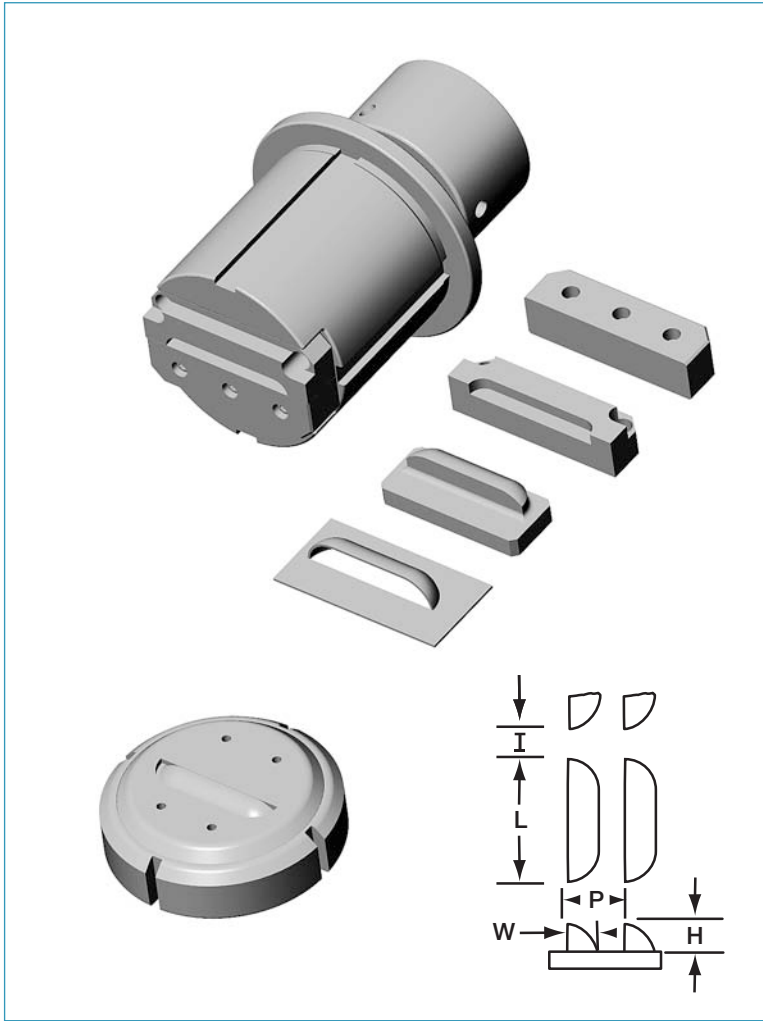
DESCRIPTION	STATION	PART NO.
COMBINATION (1 PIECE) (MULTIPLE TRACK)	1/2" (A)	A2000AM
NOTE: 2 SETS REQUIRED		
COMBINATION (1 PIECE) (MULTIPLE TRACK)	1-1/4" (B)	A2000BM
NOTE: 2 SETS REQUIRED		



DESCRIPTION	STATION	PART NO.
TOOL SET	2" (C)	A2000C
TOOL SET	3-1/2" (D)	A2000D
TOOL SET	4-1/2" (E)	A2000E



Louvre Tooling



3-1/2" (D) Station

DESCRIPTION	PART NO.
COMPLETE TOOL SET	A5080-450
FORMING INSERT*	A1074
REVERSIBLE CUTTING INSERT*	A1072
POCKET INSERT*	A1071
STRIPPER*	A1075

4-1/2" (E) Station

DESCRIPTION	PART NO.
COMPLETE TOOL SET	A5090-450
FORMING INSERT*	A1067
REVERSIBLE CUTTING INSERT*	A1065
POCKET INSERT*	A1064
STRIPPER*	A1068

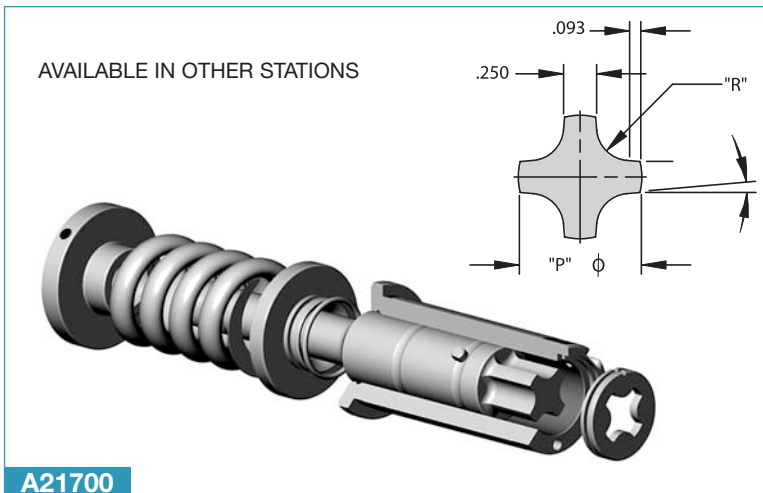
Standard Sizes				
L	W	H	P	PART NO.
2.00	.50	.19	.75	A5080-450
2.50	.50	.19	.75	A5080-450
3.00	.63	.25	.94	A5080-450
3.50	.63	.25	.94	A5080-450
4.00	.75	.25	1.12	A5090-450
4.50	.75	.25	1.12	A5090-450

*Inserts and strippers are interchangeable to accommodate different size louvres and/or material thickness.

When ordering: specify all lettered dimensions and material type and thickness.

Standard indexing: 0° - 90° - 180° - 270°

Louvre Tooling also available in other stations.



4 Way Corner Rounding

Stocked Sizes

Also available as SA, HD and Self Lube

RADIUS	"P" DIM ϕ	PUNCH ASSEMBLY#	PUNCH ONLY #
.062 (1.58mm)	.560 (14.22)	A21700 .062	A41700 .062
.094 (2.39mm)	.625 (15.87)	A21700 .094	A41700 .094
.125 (3.18mm)	.687 (17.45)	A21700 .125	A41700 .125
.156 (3.96mm)	.750 (19.05)	A21700 .156	A41700 .156
.188 (4.78mm)	.812 (20.62)	A21700 .188	A41700 .188
.250 (6.35mm)	.937 (23.80)	A21700 .250	A41700 .250
.312 (7.93mm)	1.062 (26.97)	A21700 .312	A41700 .312
.375 (9.53mm)	1.186 (30.42)	A21700 .375	A41700 .375
.500 (12.7mm)	1.250 (31.75)	A21700 .500	A41700 .500

STRIPPER A81SB700
DIE A61700 ---

STOCK CLEARANCES: .006 (.15mm) .012 (.3mm)
OTHER THAN STD USE GROUP B "SS92" ADDER.

Knockout Tooling

1 1/4" Station Form Up



SINGLE ROUND TOOL SET	PART NO.
.250 - .812	A5000-545
.813 - 1.000	A5010-545
1.001 - 1.125	A5020-545
DOUBLE ROUND TOOL SET	PART NO.
.250 - 1.000	A5020-766
1.001 - 1.125	A5020-766
SINGLE SQUARE OBLONG-RECT TOOL SET	PART NO.
WITHIN .250 - .812	A5000 ___
WITHIN .813 - 1.000	A5010 ___
WITHIN 1.001 - 1.125	A5020 ___
SPECIFY SHAPE CODE IN PLACE OF ___	

Stacked Tooling

SINGLE 16 GA CLEARANCE		
ACTUAL SIZE	CONDUIT SIZE	PART NO.
.250		A5000-545-16
.500		A5000-545-16
.750		A5000-545-16
.875	1/2	A5010-545-16
1.125	3/4	A5020-545-16
DOUBLE 16GA CLEARANCE		
.875 x 1.125	1/2 x 3/4	A5020-766-16

WHEN ORDERING:
 - SPECIFY IF SIZES ARE ACTUAL OR CONDUIT
 - SPECIFY MATERIAL TYPE AND THICKNESS

2", 3-1/2" & 4-1/2" Station Form Up



STATION	RANGE	TYPE	PART NO.
2"	1.125 - 1.750	SINGLE ROUND	A5030-545
		DOUBLE ROUND	A5030-766
		SINGLE SHAPE	A5030 ___
3-1/2"	1.751 - 3.000	SINGLE ROUND	A5040-545
		DOUBLE ROUND	A5040-766
		SINGLE SHAPE	A5040 ___
4-1/2"	3.001 - 4.125	SINGLE ROUND	A5050-545
		DOUBLE ROUND	A5050-766
		SINGLE SHAPE	A5050 ___
SPECIFY SHAPE CODE IN PLACE OF ___			

Stacked Tooling

SINGLE 16 GA CLEARANCE		
ACTUAL SIZE	CONDUIT SIZE	PART NO.
1.375	1	A5030-545-16
1.750	1-1/4	A5030-545-16
DOUBLE 16GA CLEARANCE		
1.125 x 1.375	3/4 x 1	A5030-766-16
1.375 x 1.750	1 x 1-1/4	A5030-766-16

Special Tools

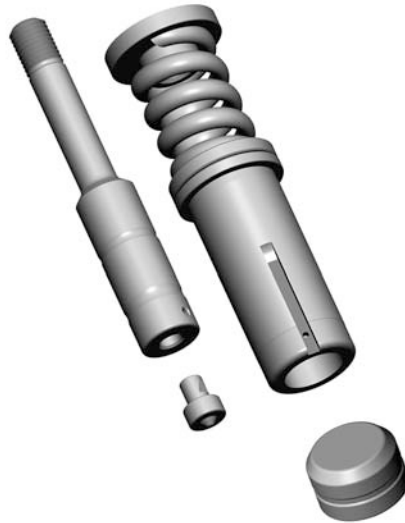
Cluster Tool

Enables multi-hole punching in one hit. Three types available depending upon structure. Solid type, replaceable tip and combination of the two.



Coin Countersinking Tools

Coin Down Design Shown
Coin Up Design Available
Interchangeable Tips



A5060-654

Small Diameter Punch and Guide

Assembly .030 diameter to .093 diameter

This tool recommended where material thickness exceeds punch diameter.



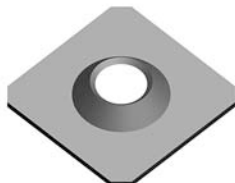
SLEEVE ASSEMBLY (w/Punch Inserted)

A10IM

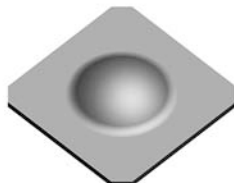
Forming Tools - Available for all Stations



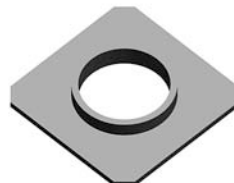
BRIDGE LANCE
-855



*COUNTERSINK
-655



DIMPLE
-625



*EXTRUSION
-675



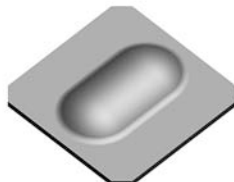
EYEBROW
-460



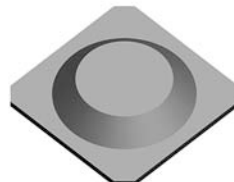
LANCE AND FORM
(ONE BEND)
-440



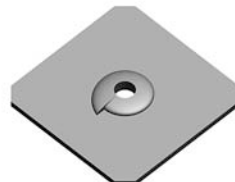
LANCE AND FORM
(THREE BENDS)
-445



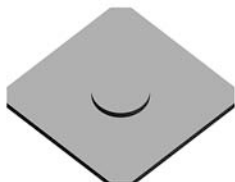
RIB
-370



EMBOSS
-755



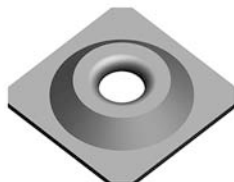
*THREAD FORM
-380



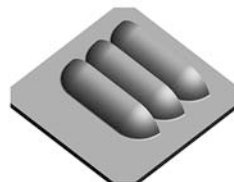
SHEAR TAB
-548



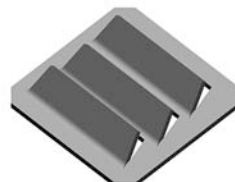
CHARACTER STAMP
-725



*EMBOSS UP
EXTRUDE DOWN
-775



CLOSED END
LOUVRE
-450



OPEN END
LOUVRE (LANCE)
-440

*Must have pre-pierced hole

Replacement Mate® Style Tooling

Refer to page 1 for standard shape codes

SPECIFY SHAPE CODE IN PLACE OF _ _ _



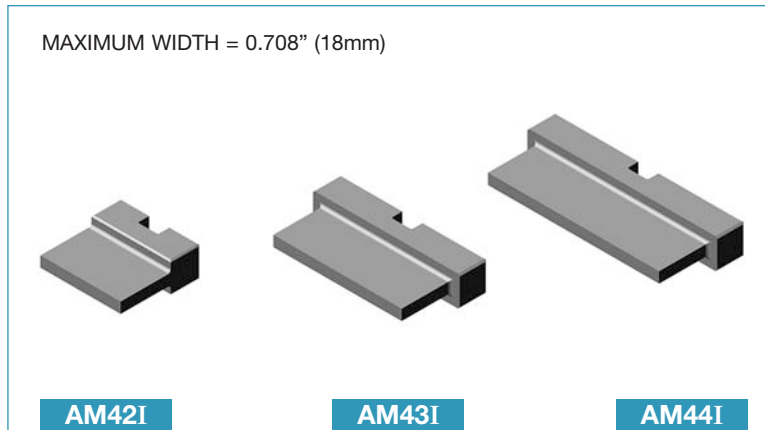
1/2" (A) Station - Ultra® Style

DESCRIPTION	Mate Ref. #	PART NO.
ROUND PUNCH TIP	PAUA0A	AMU30
SHAPE PUNCH TIP	PAUA_A	AMU40 _ _ _
ROUND STRIPPER	S6KA0A	AMU70SB
SHAPE STRIPPER	S6KA_A	AMU80SB _ _ _

1-1/4" (B) Station - Ultra® Style

DESCRIPTION	Mate Ref. #	PART NO.
ROUND PUNCH TIP	PAUB0A	AMU31
SHAPE PUNCH TIP	PAUB_A	AMU41 _ _ _
ROUND STRIPPER	S6KB0A	AMU71SB
SHAPE STRIPPER	S6KAB_A	AMU81SB _ _ _

Slitting Punch and Die Inserts - Ultra® Style Strippers



DESCRIPTION	Mate Ref. #	PART NO.
2" (C) STATION		
PUNCH	PAAP_A	AM42I _ _ _
DIE PLATE	D0KP_0	AM62I _ _ _
SHAPE STRIPPER	S6UC-P	AMU96 _ _ _
ROUND STRIPPER	S6UCOP	AMU92
3-1/2" (D) STATION		
PUNCH	PAAQ_A	AM43I _ _ _
DIE PLATE	D0KQ_0	AM63I _ _ _
SHAPE STRIPPER	S6UD-P	AMU97 _ _ _
ROUND STRIPPER	S6UDOP	AMU93
4-1/2" (E) STATION		
PUNCH	PAAR_A	AM44I _ _ _
DIE PLATE	D0KR_0	AM64I _ _ _
SHAPE STRIPPER	S6UE-P	AMU98 _ _ _
ROUND STRIPPER	S6UEOP	AMU94

Replacement Strippit® Style Tooling

1/2" (1) Station - Heavy Duty Round

DESCRIPTION	Strippit Ref. #	PART NO.
PUNCH AND GUIDE ASMBLY.	202050-000	AF2050
ROUND PUNCH	202052-000	AF2052
ROUND GUIDE	202054-000	AF2054
PUNCH HEAD	202051-000	AF2051
STRIPPING UNIT	N/A	AF2050SU

1/2" (A) Station - Heavy Duty Shape

DESCRIPTION	Strippit Ref. #	PART NO.
PUNCH AND GUIDE ASMBLY.	202060-XXX	AF2060 _ _ _
SHAPE PUNCH	202062-XXX	AF2062 _ _ _
SHAPE GUIDE	202064-XXX	AF2064 _ _ _
PUNCH HEAD	202051-000	AF2051
STRIPPING UNIT	N/A	AF2050SU
SPECIFY SHAPE CODE IN PLACE OF _ _ _		

STRIPPIT 3.5 STATION		
REPLACEMENT PUNCH INSERTS		AF2272 _ _ _
BOW TIE SHAPE		AF2272796
STRIPPIT 4.5 STATION		
REPLACEMENT PUNCH INSERTS		AF2275 _ _ _
BOW TIE SHAPE		AF2275796
SPECIFY SHAPE CODE IN PLACE OF _ _ _		

1-1/4" (B) Station - Heavy Duty Round

DESCRIPTION	Strippit Ref. #	PART NO.
PUNCH AND GUIDE ASMBLY.	202125-000	AF2125
ROUND PUNCH	202127-000	AF2127
ROUND GUIDE (SOLID END)	202129-000	AF2921
PUNCH HEAD	202126-000	AF2126
DISC SPRING (20 REQUIRED)	N/A	AF131
PUNCH COLLAR	N/A	AF121
"O" RING	N/A	AF1115

1-1/4" (B) Station - Heavy Duty Shape

DESCRIPTION	Strippit Ref. #	PART NO.
PUNCH AND GUIDE ASMBLY.	202135-XXX	AF2135 _ _ _
SHAPE PUNCH	202137-XXX	AF2137 _ _ _
SHAPE GUIDE (SOLID END)	202139-XXX	AF2139
PUNCH HEAD	202126-000	AF2126
DISC SPRING (20 REQUIRED)	N/A	AF131
PUNCH COLLAR	N/A	AF121
"O" RING	N/A	AF111

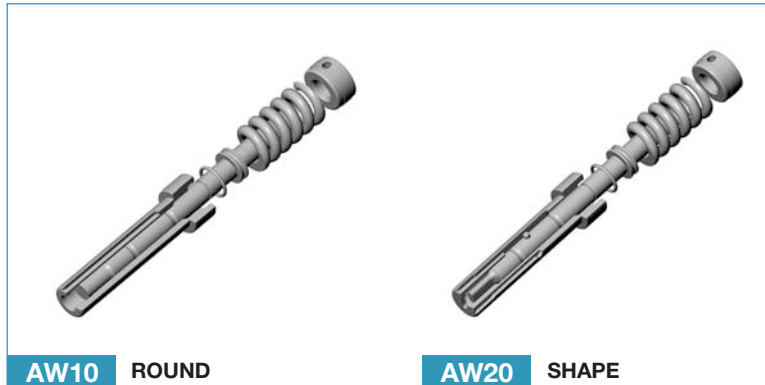
NOTE: DIES FOR THE ABOVE SEE PAGES 2 - 14

®Trademark of Mate ®Ultra Trademark of Mate ®Trademark of Strippit



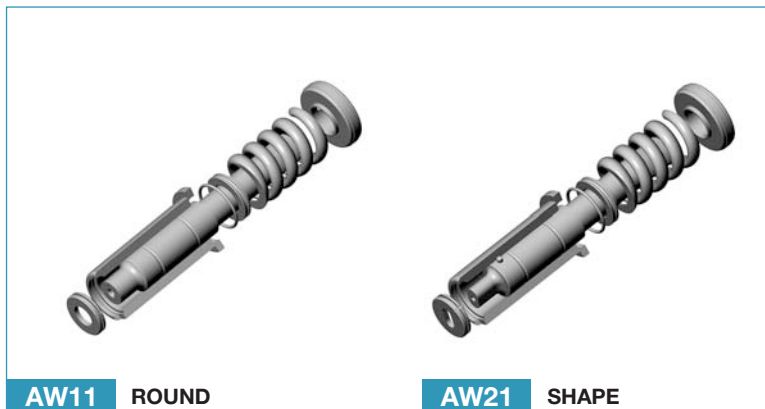
Replacement Wilson® Style Tooling

Refer to page 1 for standard shape codes



1/2" (A) Station - Econo-Line® Style

DESCRIPTION	Wilson Ref. #	PART NO.
ROUND ASSEMBLY	01801	AW10
ROUND PUNCH c/w CLIPS	01807	AW30
ROUND GUIDE	01806	AW70
PUNCH CLIP SET	01805	5107-59
SHAPE ASSEMBLY	01811	AW20 ___
SHAPE PUNCH	01816	AW40 ___
SHAPE GUIDE	01814	AW80 ___
HEAD	01802	AW100
SPRING	01803	AW130
SPRING RETAINER & "O" RING	01804	AW120
"O" RING	02282	AW110
SPECIFY SHAPE CODE IN PLACE OF ___		



1-1/4" (B) Station - Econo-Line® Style

DESCRIPTION	Wilson Ref. #	PART NO.
ROUND ASSEMBLY	01819	AW11
ROUND PUNCH	01827	AW31
ROUND GUIDE	02222	AW71
ROUND STRIPPER	01890	A71SB
STRIPPER CLIP	02224	A71SC
SHAPE ASSEMBLY	01831	AW21 ___
SHAPE PUNCH	01839	AW41 ___
SHAPE GUIDE	02223	AW81
SHAPE STRIPPER	01917	A81SB ___
HEAD	01821	AW101
SPRING	01953	AW131
SPRING RETAINER & "O" RING	01824	AW121
"O" RING	02283	AW111
SPECIFY SHAPE CODE IN PLACE OF ___		



1/2" (A) Station - Series 90®

DESCRIPTION	Wilson Ref. #	PART NO.
ROUND PUNCH TIP	02405	AW30-90
SHAPE PUNCH TIP	02406	AW40-90 ___
SPECIFY SHAPE CODE IN PLACE OF ___		

1-1/4" (B) Station - Series 90®

DESCRIPTION	Wilson Ref. #	PART NO.
ROUND PUNCH TIP	02407	AW31-90
SHAPE PUNCH TIP	02408	AW41-90 ___
ROUND STRIPPER	01890	A71SB
SHAPE STRIPPER	01917	A81SB ___
SPECIFY SHAPE CODE IN PLACE OF ___		



1/2" (A) Station - Series 90® ABS

DESCRIPTION	Wilson Ref. #	PART NO.
ROUND PUNCH TIP	02385	AWSL30-90
SHAPE PUNCH TIP	02389	AWSL40-90 ___
SPECIFY SHAPE CODE IN PLACE OF ___		

1-1/4" (B) Station - Series 90® ABS

DESCRIPTION	Wilson Ref. #	PART NO.
ROUND PUNCH TIP	02398	AWSL31-90
SHAPE PUNCH TIP	02399	AWSL41-90 ___
ROUND STRIPPER	02433	ASL71SB
SHAPE STRIPPER	02432	ASL781SB ___
SPECIFY SHAPE CODE IN PLACE OF ___		

NOTE: DIES FOR THE ABOVE SEE PAGES 2 - 9

"Series 80/90" and "Series 90 ABS" are Registered Trademarks of Wilson Tool International

Replacement Wilson® Style Tooling

NOTE: WILSON'S ABS (SELF LUBE) USES STANDARD SERIES 80/90 STYLE PUNCHES AS LISTED ON 2 3.5 & 4.5 STATIONS

Refer to page 1 for standard shape codes



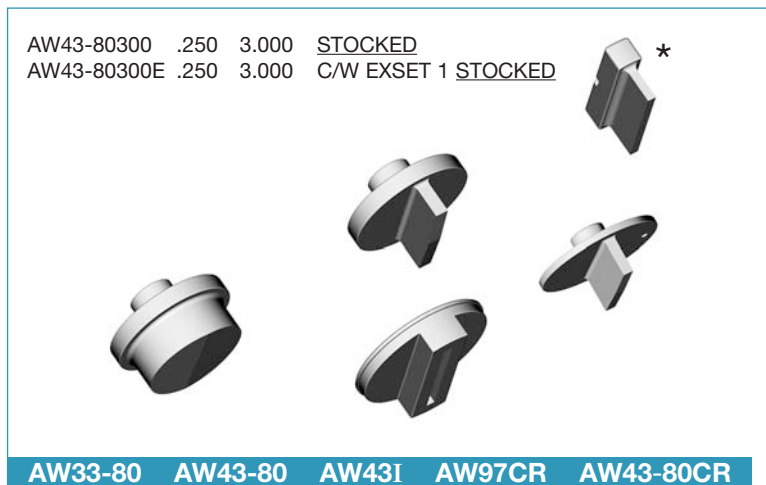
2" (C) Station

Series 80/90®

Replaceable Insert

DESCRIPTION	Wilson Ref. #	PART NO.
ROUND PUNCH	05026	AW32-80
ROUND STRIPPER	01848	A92
SHAPE PUNCH	05025	AW42-80 ___
SHAPE STRIPPER	01854	A96 ___
SHAPE PUNCH INSERT	02590	AW42I ___
<u>SELF LUBE (ABS)</u>		
ROUND STRIPPER	05150	AWSL92
SHAPE STRIPPER	05151	AWSL96 ___
SPECIFY SHAPE CODE IN PLACE OF ___		

AW3280 AW4280 AW42I



AW43-80300 .250 3.000 STOCKED
 AW43-80300E .250 3.000 C/W EXSET 1 STOCKED

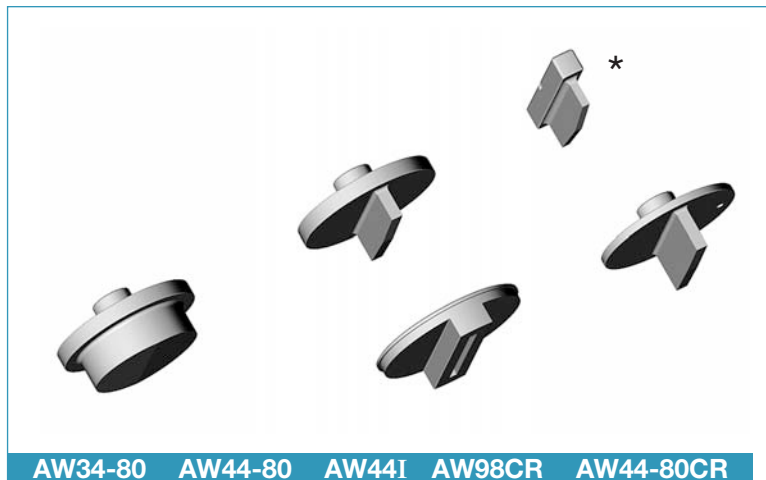
3-1/2" (D) Station

Series 80/90®

Round, Shape & Close To Clamp
 Replacement Punches and Strippers

DESCRIPTION	Wilson Ref. #	PART NO.
ROUND PUNCH	05028	AW33-80
ROUND STRIPPER	01864	A93
SHAPE PUNCH	05027	AW43-80 ___
SHAPE STRIPPER	01869	A97 ___
SHAPE PUNCH INSERT	01967	AW43I ___
* SHAPE PUNCH - CLOSE TO CLAMP	05114	AW43-80CR ___
SHAPE STRIPPER - CLOSE TO CLAMP	05399	AW97CR ___
<u>SELF LUBE (ABS)</u>		
ROUND STRIPPER	05152	AWSL93
SHAPE STRIPPER	05153	AWSL97 ___
CLOSE TO CLAMP STRIPPER (ABS)	05360	AWSL98CR
*AW43I ALSO FITS AMADA HOLDERS		
SPECIFY SHAPE CODE IN PLACE OF ___		

AW33-80 AW43-80 AW43I AW97CR AW43-80CR



4-1/2" (E) Station

Series 80/90®

Round, Shape & Close To Clamp
 Replacement Punches and Strippers

DESCRIPTION	Wilson Ref. #	PART NO.
ROUND PUNCH	05030	AW34-80
ROUND STRIPPER	01877	A94
SHAPE PUNCH	05029	AW44-80 ___
SHAPE STRIPPER	01882	A98 ___
SHAPE PUNCH INSERT	01970	AW44I ___
SHAPE PUNCH - CLOSE TO CLAMP	05109	AW44-80CR ___
SHAPE STRIPPER - CLOSE TO CLAMP	05400	AW98CR ___
<u>SELF LUBE (ABS)</u>		
ROUND STRIPPER	05154	AWSL94
SHAPE STRIPPER	05155	AWSL98 ___
CLOSE TO CLAMP STRIPPER (ABS)	05385	AWSL98CR
*AW44I ALSO FITS AMADA HOLDERS		
SPECIFY SHAPE CODE IN PLACE OF ___		

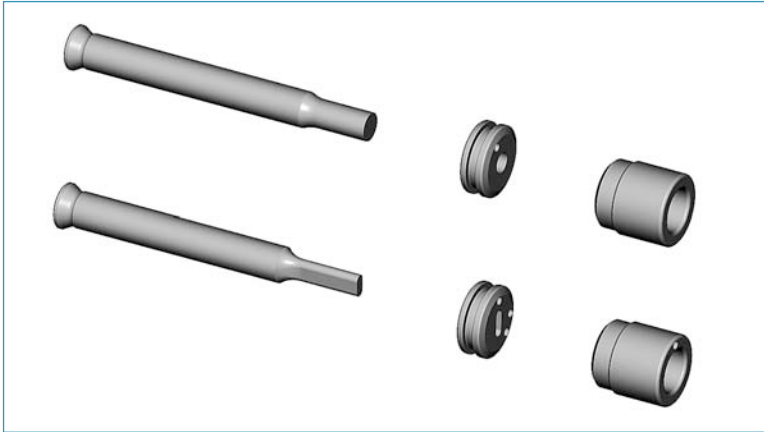
AW34-80 AW44-80 AW44I AW98CR AW44-80CR

NOTE: DIES FOR THE ABOVE SEE PAGES 10 - 14

"Series 80" and "Series 90" are Registered Trademarks of Wilson Tool International



Finn Power Multi-Tool® Punches, Dies and Strippers



12, 20 & 24 Station - 8mm Punch Body

Refer to page 1 for standard shape codes

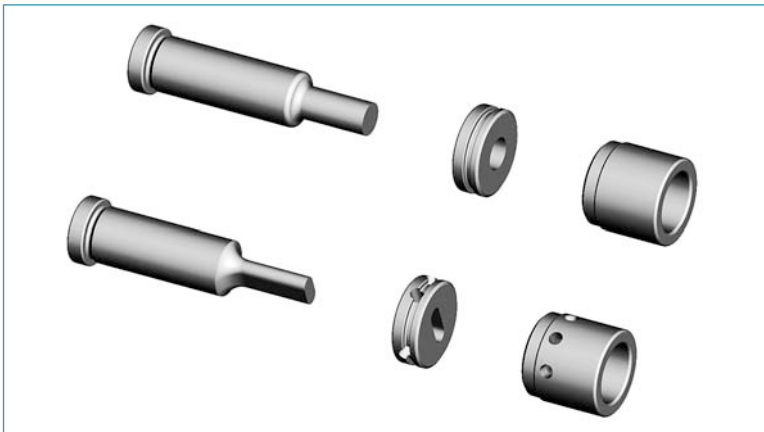
8mm BODY

RANGE .093 - .315

MT 12-8 MT 20-8 MT 24-8

DESCRIPTION		Wilson Ref. #	PART NO.
PUNCH	ROUND	06080	NTP31
	SHAPE	06147	NTPZ31 ___
STRIPPER	ROUND	06079	NTS63
	SHAPE	06148	NTSZ63 ___
DIE	ROUND	06081	NTD63
	SHAPE	06149	NTDZ63 ___

SPECIFY SHAPE CODE IN PLACE OF ___



6 & 10 Station - 16mm Punch Body

Refer to page 1 for standard shape codes

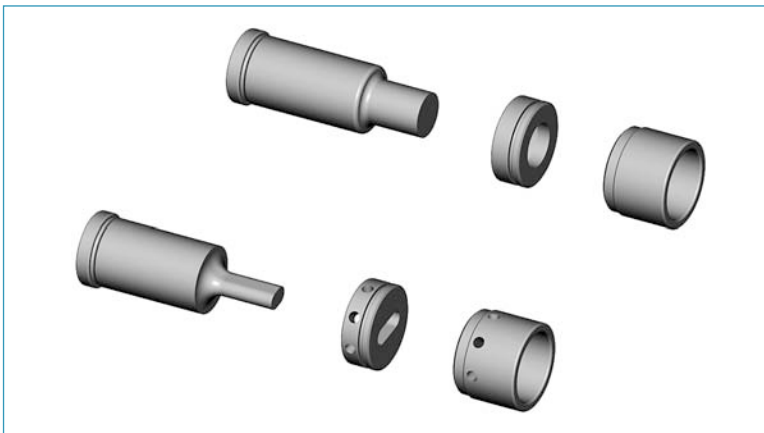
16mm BODY

RANGE .093 - .630

MT 6-16 MT 10-16

DESCRIPTION		Wilson Ref. #	PART NO.
PUNCH	ROUND	06075	NTP63
	SHAPE	06076	NTPZ63 ___
STRIPPER	ROUND	06073	NTS98
	SHAPE	06074	NTSZ98 ___
DIE	ROUND	06077	NTD98
	SHAPE	06078	NTDZ98 ___

SPECIFY SHAPE CODE IN PLACE OF ___



6 & 8 Station - 24mm Punch Body

Refer to page 1 for standard shape codes

24mm BODY

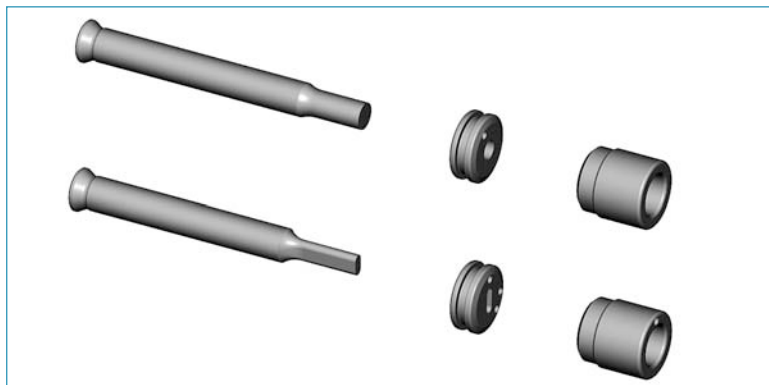
RANGE .093 - .944

MT 6-24 MT 8-24

DESCRIPTION		Wilson Ref. #	PART NO.
PUNCH	ROUND	06150	NTP94
	SHAPE	06153	NTPZ94 ___
STRIPPER	ROUND	06151	NTS118
	SHAPE	06154	NTSZ118 ___
DIE	ROUND	06152	NTD122
	SHAPE	06155	NTDZ122 ___

SPECIFY SHAPE CODE IN PLACE OF ___

Euromac® Multi-Tool Punches, Dies and Strippers

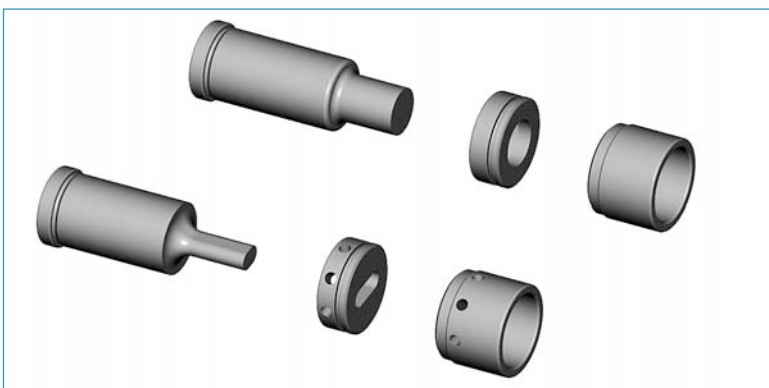


10 Station - 8mm Punch Body

Refer to page 1 for standard shape codes

RANGE .093 - .315

DESCRIPTION		PART NO.
PUNCH	ROUND	NTP31
	SHAPE	NTPZ31 ___
STRIPPER	ROUND	NTS63
	SHAPE	NTSZ63 ___
DIE	ROUND	NTD63
	SHAPE	NTDZ63 ___
SPECIFY SHAPE CODE IN PLACE OF ___		

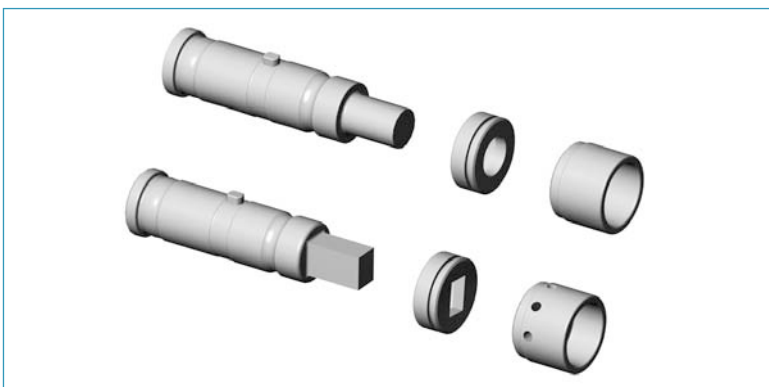


6 & 10 Station - 24mm Punch Body

Refer to page 1 for standard shape codes

RANGE .093 - .944

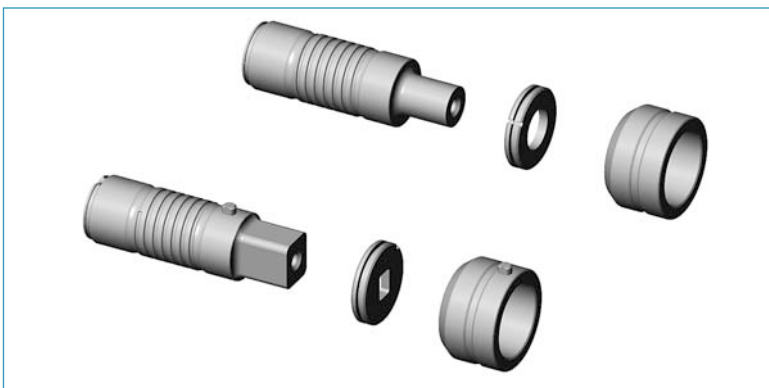
DESCRIPTION		PART NO.
PUNCH	ROUND	NTP94
	SHAPE	NTP94 ___
STRIPPER	ROUND	NTS118
	SHAPE	NTS118 ___
DIE	ROUND	NTD122
	SHAPE	NTD122 ___
SPECIFY SHAPE CODE IN PLACE OF ___		



Punches, Die, Stripper for XMTE6 Style Holder®

RANGE .093 - .944

DESCRIPTION		PART NO.
PUNCH	ROUND	XMTE6P
	SHAPE	XMTEZ6 ___
STRIPPER	ROUND	NTS118
	SHAPE	NTSZ118 ___
DIE	ROUND	NTD122
	SHAPE	NTDZ122 ___
SPECIFY SHAPE CODE IN PLACE OF ___		

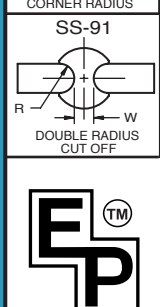
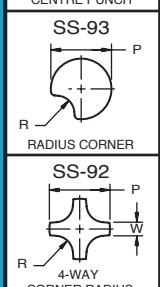
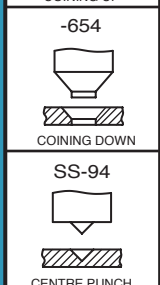
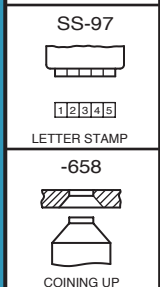
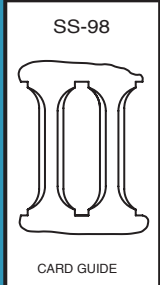
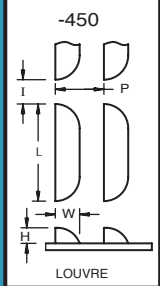
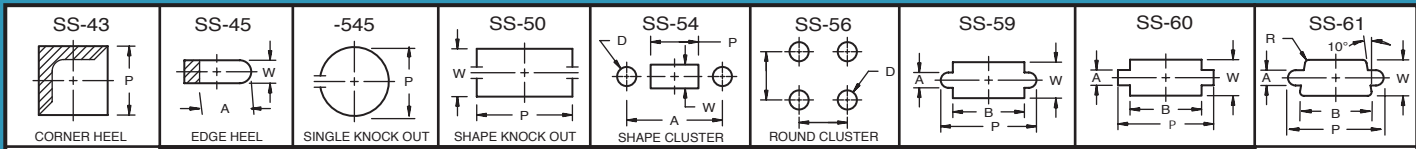


4 Station - 31.75mm Punch Body

Refer to page 1 for standard shape codes

RANGE .093 - 1.250

DESCRIPTION	Mate Ref.	PART NO.
PUNCH ROUND	PAUB0A	AMU31
PUNCH SHAPE	PAUB_A	AMU41 ___
STRIPPER ROUND	S6KB0A	AMU71SB
STRIPPER SHAPE	S6KAB_A	AMU81SB ___
DIE ROUND		A51
DIE SHAPE		A61 ___
SPECIFY SHAPE CODE IN PLACE OF ___		



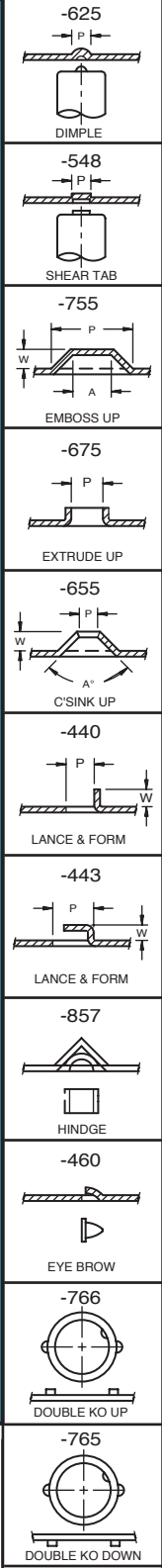
RECOMMENDED DIE CLEARANCE

MATERIAL THICKNESS (MILD STEEL)	DIE CLEARANCE (TO BE ADDED TO PUNCH SIZE)
1/32	(22 - 18 GA) .006
1/16	(17 - 13 GA) .012
1/8	(12 - 9 GA) .018
3/16	(8 - 6 GA) .024
1/4	(5 - 3 GA) .042
3/8	.075
1/2	.100
3/4	.150

SOFT ALUMINUM & COPPER REDUCE DIE CLEARANCE
STAINLESS STEEL INCREASES DIE CLEARANCE

REQUIRED TONNAGE

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	12 .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



Exacta Precision Products Ltd.
3115 Kennedy Road
Scarborough, Ontario, Canada
M1V 4Y1

Exacta Produits de Précision Ltée.
5965 Chemin St. François
Ville St. Laurent, Québec
H4S 1B6

Telephone (416) 291-1942
Toll Free 1-800-268-5573
Fax: (416) 291-8387
Toll Free Fax 1-800-668-9314

Téléphone (514) 333-0146
(Aucun Frais) 1-800-361-6810
Québec, N.B., .P.E.I. & N.S.
(Toll Free)Télécopieur (514) 333-0147

