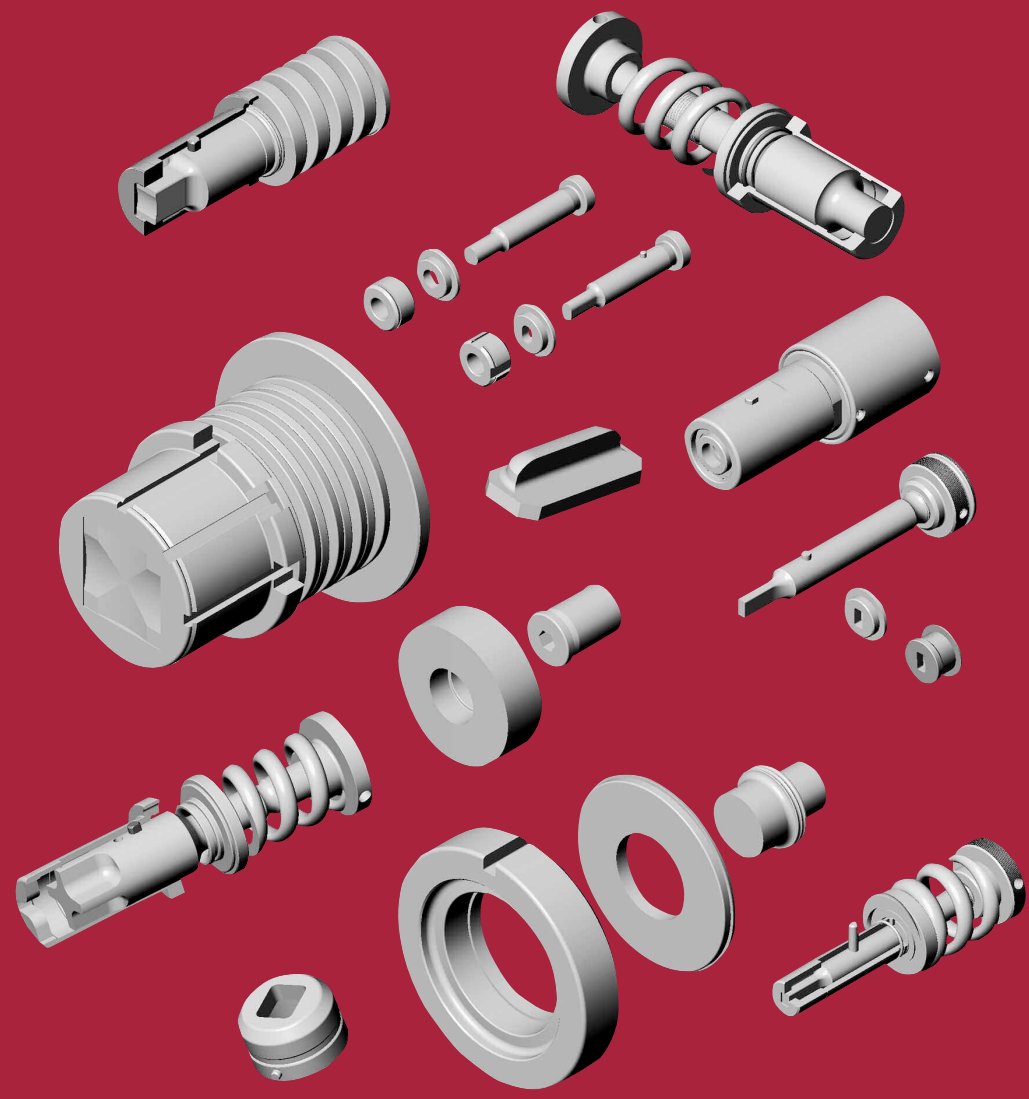
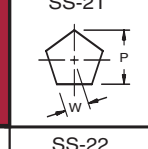
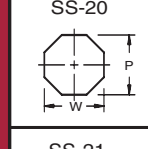
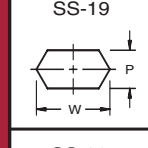
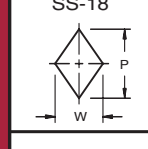
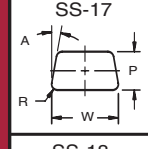
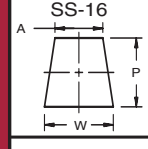
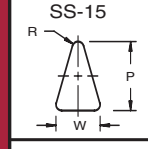
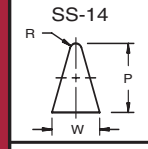
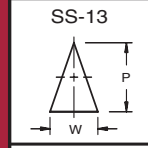
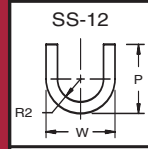
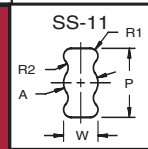
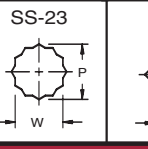
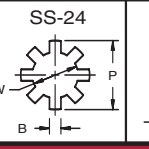
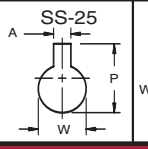
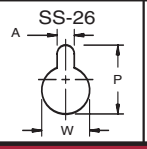
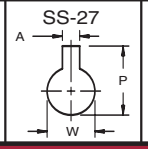
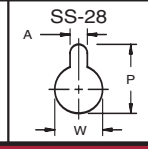
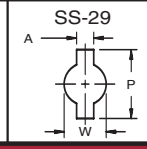
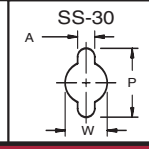
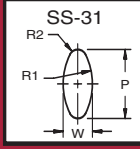


EXACTA



THIN TURRET TOOLING

CAT #THIN303





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*Series 80/90® are Trademarks of Wilson Tooling International
 Wilson® is a Trademark of Wilson Tool International
 Strippit® is a Trademark of L.V.D. Strippit*

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.

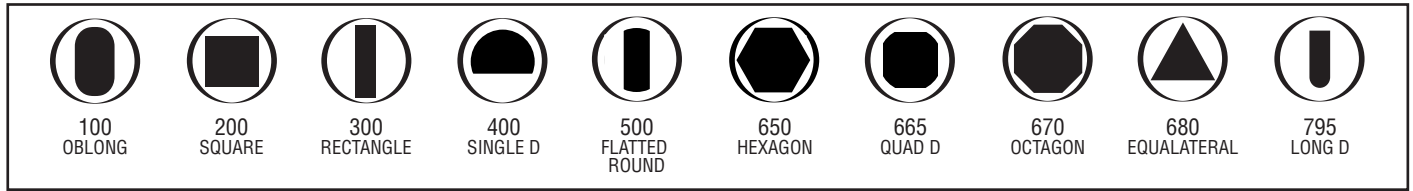
5965 Chemin St. François
 Ville St. Laurent, Québec, H4S 1B6

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 and Shape Codes



(SPECIFY KEYING REQUIRED ON 400, 680 AND 795)

Standard Keying

1-1/4" Stations - Front of Machine

Keying on Guides (Including Drop-In)

Standard 0°

Keying on Dies

Standard 0°

POSITIVE DIES SHIPPED UNLESS SPECIFIED



2" Station (Full Body) - Front of Machine

Keying on Punches

Standard 0°

Squares 0° & 135°

Keying on Dies

Standard 0° & 90°

Squares 0° & 135°

Keying on Guides

Standard 0° & 90°

POSITIVE DIES SHIPPED UNLESS SPECIFIED



3-1/2" Station (Full Body) - Front of Machine

Keying on Punches

Standard 0°

Keying on Guides

Standard 0° & 90°

Keying on Dies

Standard 0° & 90°

Squares 0° & 135°

POSITIVE DIES SHIPPED UNLESS SPECIFIED



3-1/2" Station (Fab Style) - Front of Machine

Keying on Punches

Standard 0°

Keying on Guides

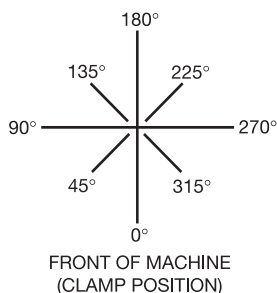
Standard 0°

Keying on Dies

Standard 0° & 90°

Squares 0° & 135°

POSITIVE DIES SHIPPED UNLESS SPECIFIED



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" STATION
- SPECIAL SHAPES - USE NUMBERS ON FRONT AND BACK COVERS



1/2" Drop-In Tooling

North American (Fab) Series

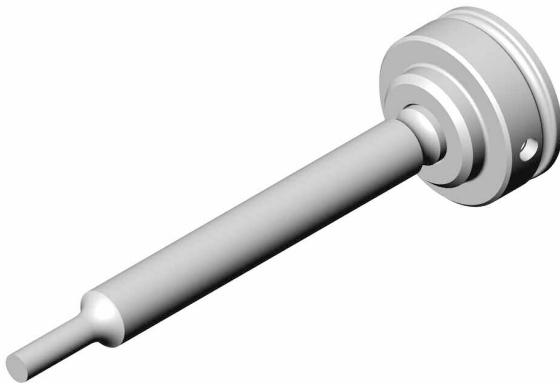
MAXIMUM PUNCH DIAMETER = .500" - 12.7mm
 MINIMUM PUNCH DIAMETER = .093" - 2.36mm
 MINIMUM PUNCH WIDTH = .093" - 2.36mm



F0668

F0668 Punch Holder Assembly (For Use with Round or Shaped Punches)

DESCRIPTION	PART NO.
COMPLETE HOLDER ASSEMBLY	F0668
STRIPPING UNIT	F0648
GUIDE	F0611
SET SCREW	F3081
NYLON BALL	F1143
STRIPPER RETAINER RING	F0064
RETAINER RING PLIERS	F0065

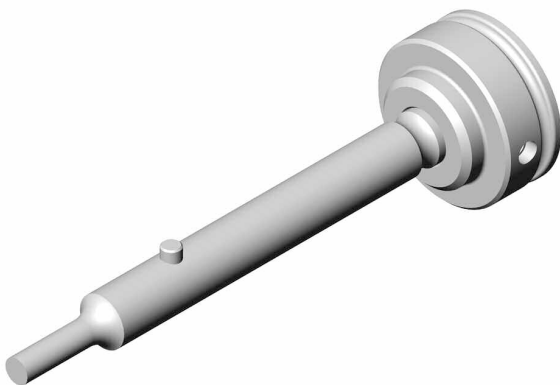


F0671

Round

PUNCHES PREMIUM HIGH SPEED STEEL

DESCRIPTION	PART NO.
PUNCH AND HEAD ASSEMBLY	F0671
PUNCH BODY	F0613
PUNCH HEAD	F0650
SET SCREW	F1627
NYLON BALL	F1143
ROUND STRIPPER	F1086



F0672

Shape

PUNCHES PREMIUM HIGH SPEED STEEL

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
PUNCH AND HEAD ASSEMBLY	F0672 _ _ _
PUNCH BODY	F0614 _ _ _
PUNCH HEAD	F0650
SET SCREW	F1627
NYLON BALL	F1143
SHAPE STRIPPER	F1089 _ _ _
SPECIFY SHAPE CODE IN PLACE OF _ _ _	



F8532

F8532 DIE - OPTIONS FOR ALL ASSEMBLIES

ROUND DIE	POSITIVE TAPER	F8532
ROUND DIE	NEGATIVE TAPER	F8532NT
ROUND DIE	SLUG CONTROL	F8532SC
ROUND DIE	SLUG STOP	F8532SS
ROUND DIE	TIGER CLAW (NOT SHOWN)	F8532TC
DIE SHIM	.032 THICK	F0487

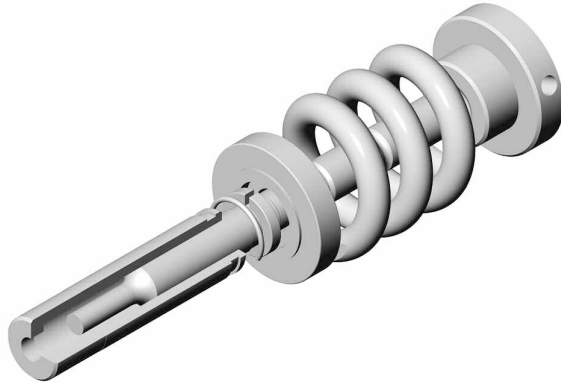
**M2 DIES AVAILABLE ON REQUEST
 FOR SHAPE DIES SEE PAGE 3**

1/2" Capacity Split Keeper Tooling

North American (Fab) Series

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

PUNCHES PREMIUM HIGH SPEED STEEL



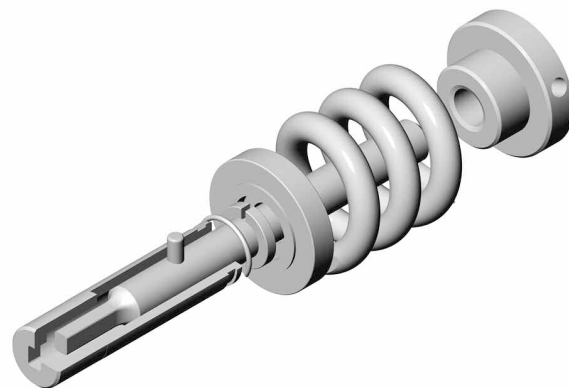
F0329

Round Punch and Guide Assembly

(Does not include Die)

For Adaptors see page 16

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	F0329
ROUND PUNCH	F0330
ROUND GUIDE	F0358
PUNCH HEAD	F8467
SET SCREW	F1627
NYLON BALL	F1143
STRIPPING SPRING	F8466
SPRING SUPPORT	F0331
KEEPER (SET OF 2)	F0321



F0340

Shape Punch and Guide Assembly - Short Pin Style

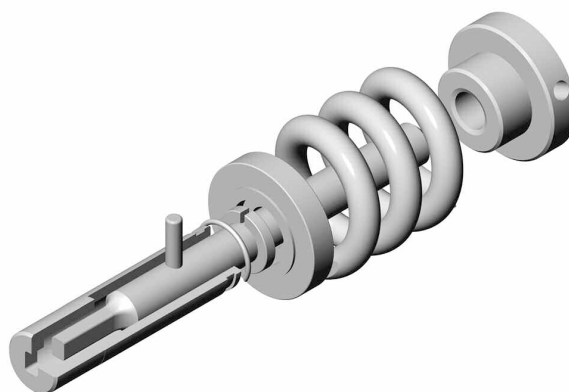
(Does not include Die)

Refer to page 1 for standard shape codes

For Adaptors see page 16

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	F0340 ___
SHAPE PUNCH	F0344 ___
SHAPE GUIDE	F0360 ___
PUNCH HEAD	F8467
SET SCREW	F1627
NYLON BALL	F1143
STRIPPING SPRING	F8466
SPRING SUPPORT	F0331
KEEPER (SET OF 2)	F0321

SPECIFY SHAPE CODE IN PLACE OF ___



F0335

Shape Punch and Guide Assembly - Long Pin Style

(Does not include Die)

Refer to page 1 for standard shape codes

For Adaptors see page 16

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	F0335 ___
SHAPE PUNCH	F0341 ___
SHAPE GUIDE	F0360 ___
PUNCH HEAD	F8467
SET SCREW	F1627
NYLON BALL	F1143
STRIPPING SPRING	F8466
SPRING SUPPORT	F0331
KEEPER (SET OF 2)	F0321

SPECIFY SHAPE CODE IN PLACE OF ___



F9400

F9400 DIE - OPTIONS FOR ALL ASSEMBLIES

SHAPE DIE	POSITIVE TAPER	F9400 ___
SHAPE DIE	NEGATIVE TAPER	F9400NT ___
SHAPE DIE	SLUG CONTROL	F9400SC ___
SHAPE DIE	SLUG STOP	F9400SS ___
SHAPE DIE	TIGER CLAW (NOT SHOWN)	F9400TC ___
DIE SHIM	.032 THICK	F0487

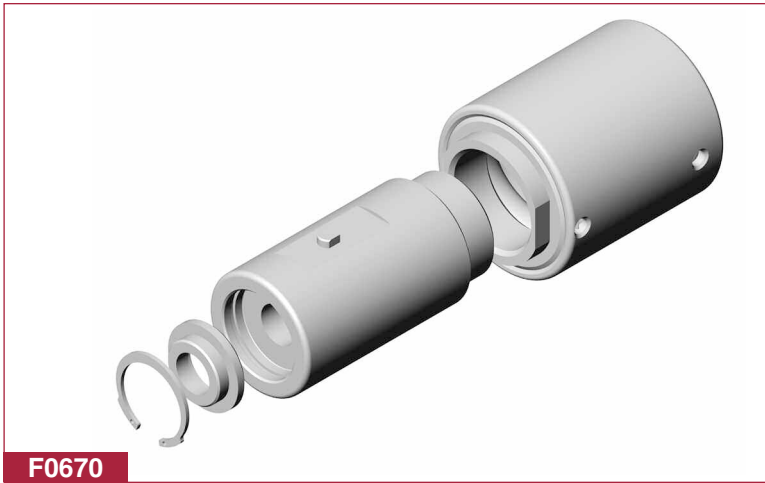
M2 DIES AVAILABLE ON REQUEST

SPECIFY SHAPE CODE IN PLACE OF ___

FOR ROUND DIES SEE PAGE 2



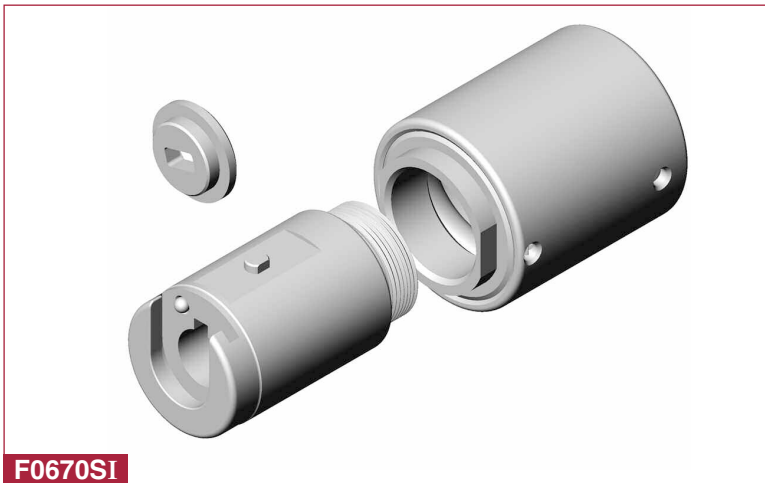
5/8" Drop-In Punch Holders



F0670 Punch Holder Assembly
 (For Use with Round or Shaped Punches)
 Retainer Ring Style Stripper

Use Strippers
 F1086 for Round } *See page 5*
 F1089 for Shape }

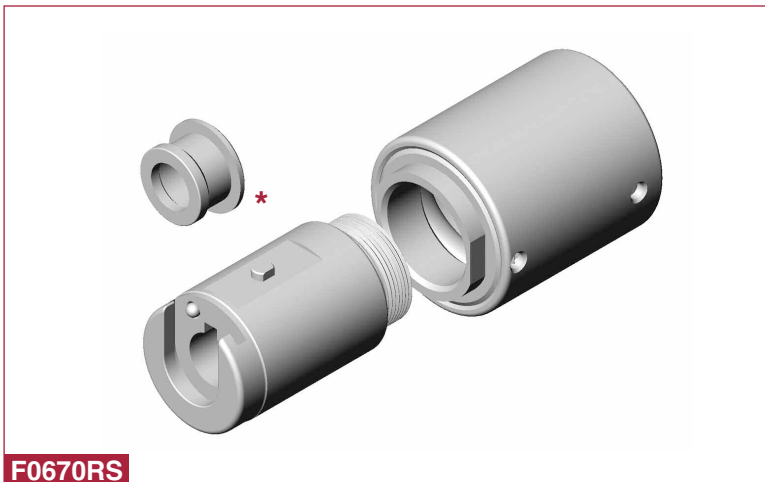
DESCRIPTION	PART NO.
COMPLETE HOLDER ASSEMBLY	F0670
STRIPPING UNIT	F0648
GUIDE	F0601
NYLON BALL	F1143
SET SCREW	F3081
STRIPPER RETAINER RING	F0064
RETAINER PLIERS	F0065



F0670SI Punch Holder Assembly
 (For Use with Round or Shaped Punches)
 Slip In Style Stripper

Use Strippers
 F1086 for Round } *See page 5*
 F1089 for Shape }

DESCRIPTION	PART NO.
COMPLETE HOLDER ASSEMBLY	F0670SI
STRIPPING UNIT	F0648
GUIDE	F1084
SPRING PLUNGER	F1767
SET SCREW	F3081
NYLON BALL	F1143



F0670RS Punch Holder Assembly
 (For Use with Round or Shaped Punches)
 Recess Style Slip In Stripper

Use Strippers
 F1053 for Round - Recess Style * } *See page 5*
 F1054 for Shape - Recess Style * }

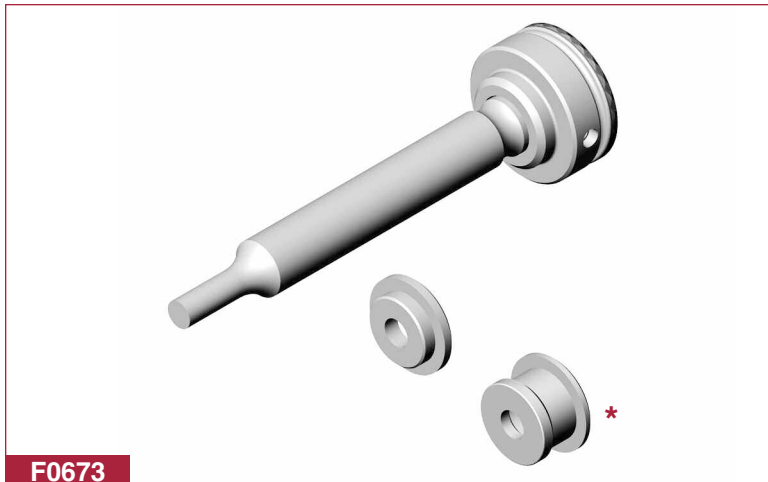
DESCRIPTION	PART NO.
COMPLETE HOLDER ASSEMBLY	F0670RS
STRIPPING UNIT	F0648
GUIDE	F1029
SPRING PLUNGER	F1767
SET SCREW	F3081
NYLON BALL	F1143

5/8" Drop-In Tooling

North American (Fab) Series

MAXIMUM PUNCH DIAMETER = .625" - 15.88mm
 MINIMUM PUNCH DIAMETER = .093" - 2.36mm
 MINIMUM PUNCH WIDTH = .093" - 2.36mm

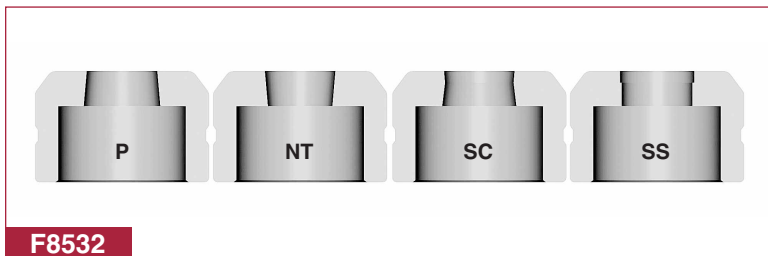
PUNCHES PREMIUM HIGH SPEED STEEL



Round

DESCRIPTION	PART NO.
PUNCH AND HEAD ASSEMBLY	F0673
ROUND PUNCH	F0551
PUNCH HEAD	F0649
SET SCREW	F1627
NYLON BALL	F1143
ROUND STRIPPER	F1086
ROUND STRIPPER - RECESS STYLE *	F1053

F0673

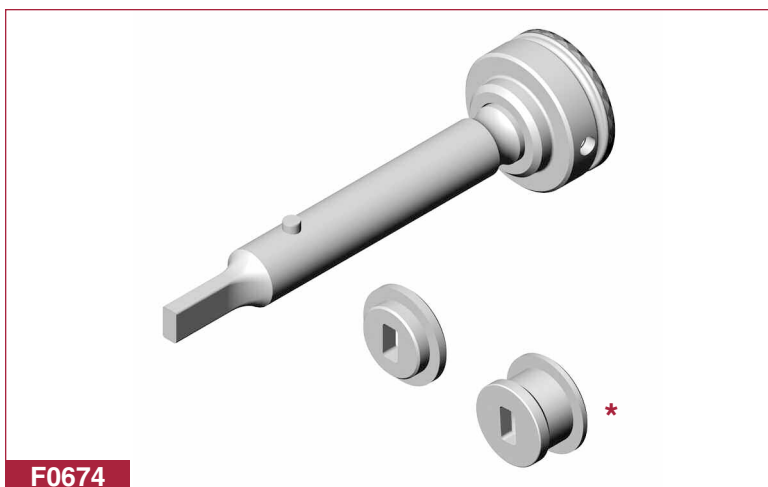


F8532 DIE - OPTIONS FOR ALL ASSEMBLIES

ROUND DIE	POSITIVE TAPER	F8532
ROUND DIE	NEGATIVE TAPER	F8532NT
ROUND DIE	SLUG CONTROL	F8532SC
ROUND DIE	SLUG STOP	F8532SS
ROUND DIE	TIGER CLAW (NOT SHOWN)	F8532TC
DIE SHIM	.032 THICK	F0487

M2 DIES AVAILABLE ON REQUEST

F8532



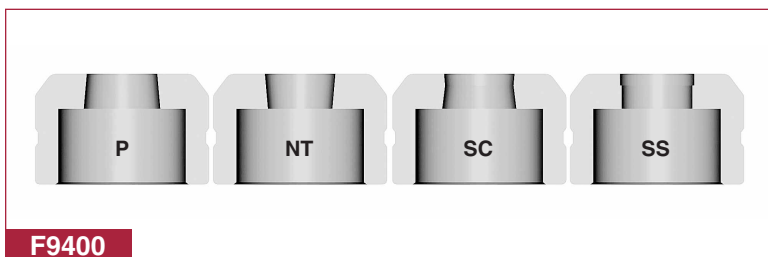
Shape

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
PUNCH AND HEAD ASSEMBLY	F0674 ___
SHAPE PUNCH	F0552 ___
PUNCH HEAD	F0649
SET SCREW	F1627
NYLON BALL	F1143
SHAPE STRIPPER	F1089 ___
SHAPE STRIPPER - RECESS STYLE *	F1054 ___

SPECIFY SHAPE CODE IN PLACE OF ___

F0674



F9400 DIE - OPTIONS FOR ALL ASSEMBLIES

SHAPE DIE	POSITIVE TAPER	F9400 ___
SHAPE DIE	NEGATIVE TAPER	F9400NT ___
SHAPE DIE	SLUG CONTROL	F9400SC ___
SHAPE DIE	SLUG STOP	F9400SS ___
SHAPE DIE	TIGER CLAW (NOT SHOWN)	F9400TC ___
DIE SHIM	.032 THICK	F0487

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

F9400

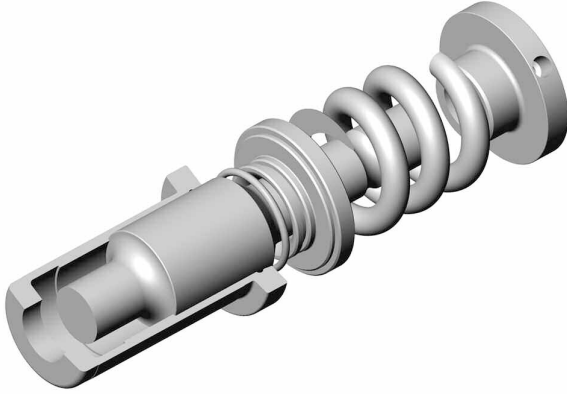


1-1/4" Station Round Tooling

North American (Fab) Series

MAXIMUM PUNCH DIAMETER = 1.250" - 31.75mm
 MINIMUM PUNCH DIAMETER = .250" - 6.35mm

PUNCHES PREMIUM HIGH SPEED STEEL

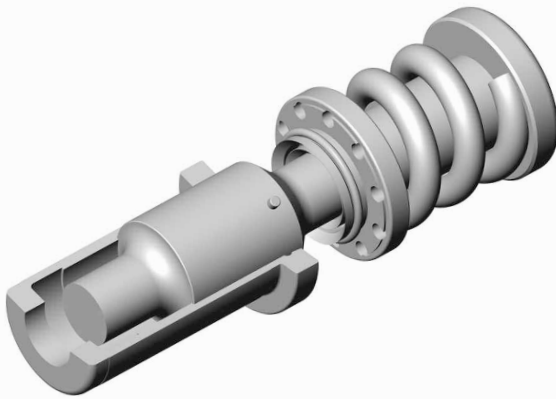


F9704

F9704 Punch and Guide Assembly

Original Style
 (Does not include Die)

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	F9704
ROUND PUNCH	F8531
ROUND GUIDE	F8529
PUNCH HEAD	F9671
SET SCREW	F1627
NYLON BALL	F1143
STRIPPING SPRING	F8466
PUNCH COLLAR	F9672
RUBBER RING	F0111
PUNCH SHIM	F7684



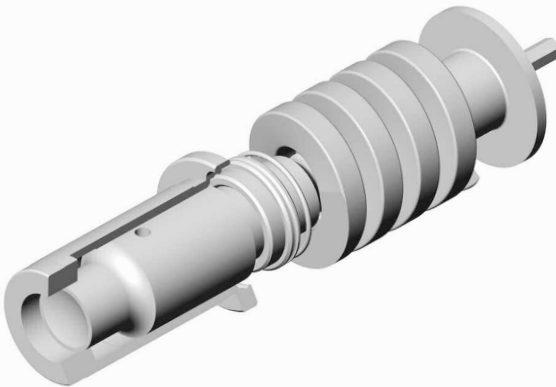
F9704SA

F9704SA 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	F9704SA
ROUND PUNCH	F8531SA
ROUND GUIDE	F8529SA
STRIPPING SPRING UNIT	F8466SA
RUBBER RING	F0111SA



F0439

F0439 Punch and Guide Assembly

Heavy Duty
 (Does not include Die)

NOT FOR USE IN PIERCE-ALL SHAPE MACHINES

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	F0439
ROUND PUNCH	F0233
ROUND GUIDE	F0438
PUNCH HEAD	F0237
STRIPPING SPRING	F1706
PUNCH LOCK	F0238
COLLAR	F0315
COLLAR (OLD OPEN GUIDE)	F0282
RUBBER RING	F0840



F8532

F8532 DIE - OPTIONS FOR ALL ASSEMBLIES

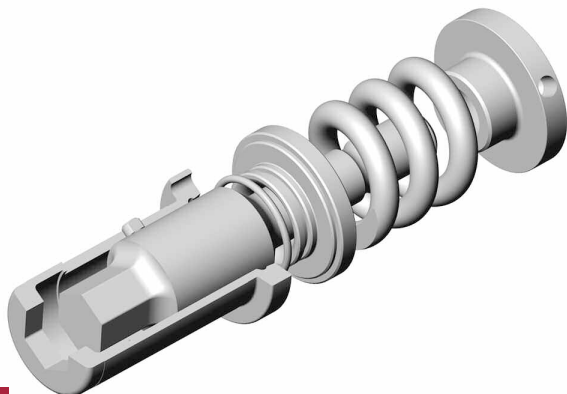
ROUND DIE	POSITIVE TAPER	F8532
ROUND DIE	NEGATIVE TAPER	F8532NT
ROUND DIE	SLUG CONTROL	F8532SC
ROUND DIE	SLUG STOP	F8532SS
ROUND DIE	TIGER CLAW (NOT SHOWN)	F8532TC
DIE SHIM	.032 THICK	F0487

1-1/4" Station **Shape** Tooling

North American (Fab) Series

MAXIMUM ACROSS CORNERS = 1.250" - 31.75mm
 MINIMUM WIDTH = .093" - 2.36mm

PUNCHES PREMIUM HIGH SPEED STEEL

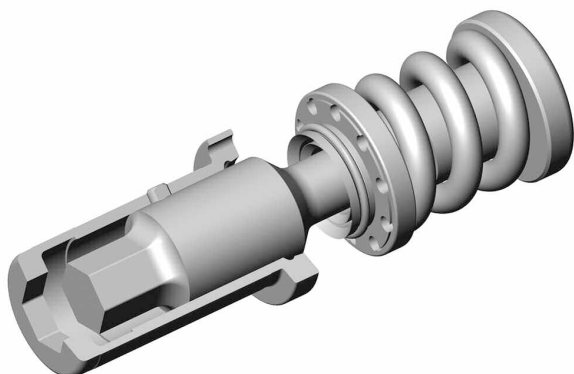


F9295

F9295 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	F9295 ---
SHAPE PUNCH	F8534 ---
SHAPE GUIDE	F9291 ---
PUNCH HEAD	F9671
SET SCREW	F1627
NYLON BALL	F1143
STRIPPING SPRING	F8466
PUNCH COLLAR	F9672
RUBBER RING	F0111
PUNCH SHIM	F7684
SPECIFY SHAPE CODE IN PLACE OF ---	



F9295SA

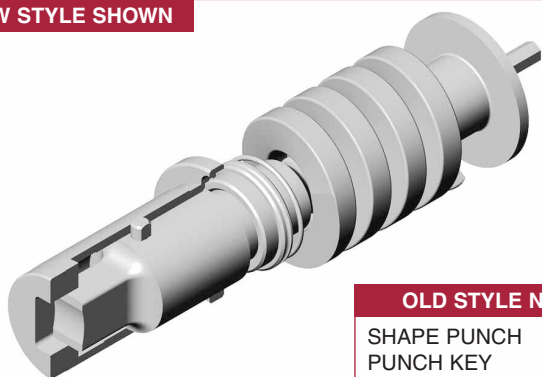
F9295SA Punch and Guide Assembly SA Style (Does not include Die)

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

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	F9295SA ---
SHAPE PUNCH	F8534 ---
SHAPE GUIDE	F9291SA ---
STRIPPING SPRING UNIT	F8466SA
RUBBER RING	F0111SA
SPECIFY SHAPE CODE IN PLACE OF ---	

NEW STYLE SHOWN



F0440

OLD STYLE NOT SHOWN

SHAPE PUNCH	F0244 ---
PUNCH KEY	F0245
PUNCH SHIM	F0241
WASHER	F0282

F0440 Punch and Guide Assembly Heavy Duty (Does not include Die)

Refer to page 1 for standard shape codes

NOT FOR USE IN PIERCE-ALL SHAPE MACHINES

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	F0440 ---
SHAPE PUNCH	F0436 ---
SHAPE GUIDE	F0437 ---
PUNCH HEAD	F0237
STRIPPING SPRING	F1706
PUNCH LOCK	F0238
COLLAR	F0315
RUBBER RING	F0840
SPECIFY SHAPE CODE IN PLACE OF ---	



F9401

F9401 DIE - OPTIONS FOR ALL ASSEMBLIES

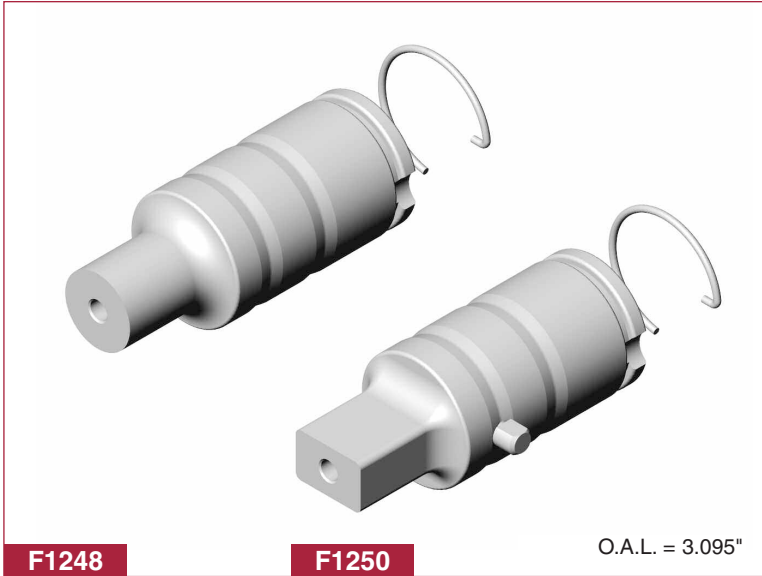
SHAPE DIE	POSITIVE TAPER	F9401 ---
SHAPE DIE	NEGATIVE TAPER	F9401NT ---
SHAPE DIE	SLUG CONTROL	F9401SC ---
SHAPE DIE	SLUG STOP	F9401SS ---
SHAPE DIE	TIGER CLAW (NOT SHOWN)	F9401TC ---
DIE SHIM	.032 THICK	F0487
SPECIFY SHAPE CODE IN PLACE OF ---		



Series 90[®] and Strippit Quick Tip[®] Style Punches

MAXIMUM DIAMETER = 1.250" - 31.75mm
 MINIMUM DIAMETER = .093" - 2.36mm
 MINIMUM WIDTH = .093" - 2.36mm

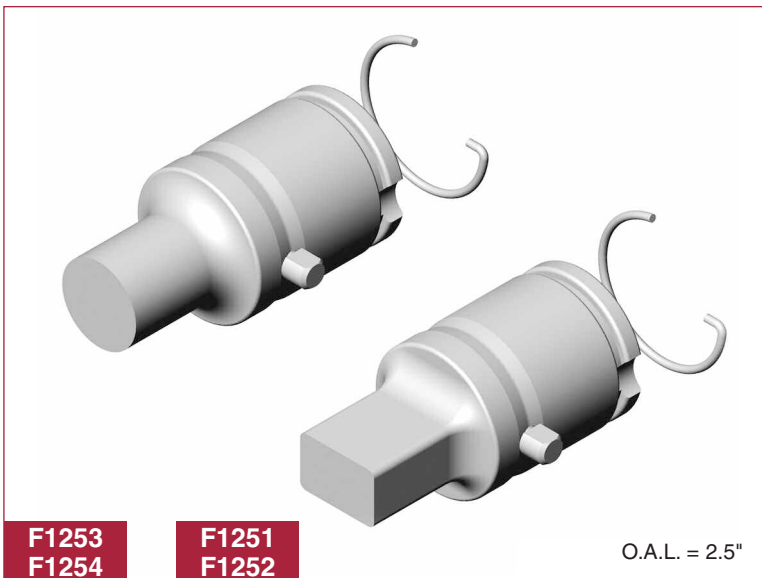
PUNCHES PREMIUM HIGH SPEED STEEL



Series 90[®] - 1-1/4 Station

Refer to page 1 for standard shape codes

DESCRIPTION	Wilson Ref. #	PART NO.
ROUND PUNCH WITH RING CLIP	10137	F1248
SHAPE PUNCH WITH RING CLIP	10136	F1250 _ _ _
RING CLIP	10044	WM065
SPECIFY SHAPE CODE IN PLACE OF _ _ _		
FOR DIES SEE PAGES 6 & 7		



Series 90[®] Heavy Duty - 1-1/4" Station

Refer to page 1 for standard shape codes

DESCRIPTION	Wilson Ref. #	PART NO.
ROUND PUNCH WITH RING CLIP	10046	F1253
SHAPE PUNCH WITH RING CLIP	10045	F1251 _ _ _
RING CLIP	10044	WM065
SPECIFY SHAPE CODE IN PLACE OF _ _ _		
FOR DIES SEE PAGES 6 & 7		

REPLACEMENT TIPS FOR ALL STRIPPIT QUICK TIP[®] ASSEMBLIES

DESCRIPTION	Strippit Ref. #	PART NO.
ROUND PUNCH WITHOUT CLIP	20154 000	F1254
SHAPE PUNCH WITHOUT CLIP	20152 000	F1252 _ _ _
SPECIFY SHAPE CODE IN PLACE OF _ _ _		
FOR DIES SEE PAGES 6 & 7		

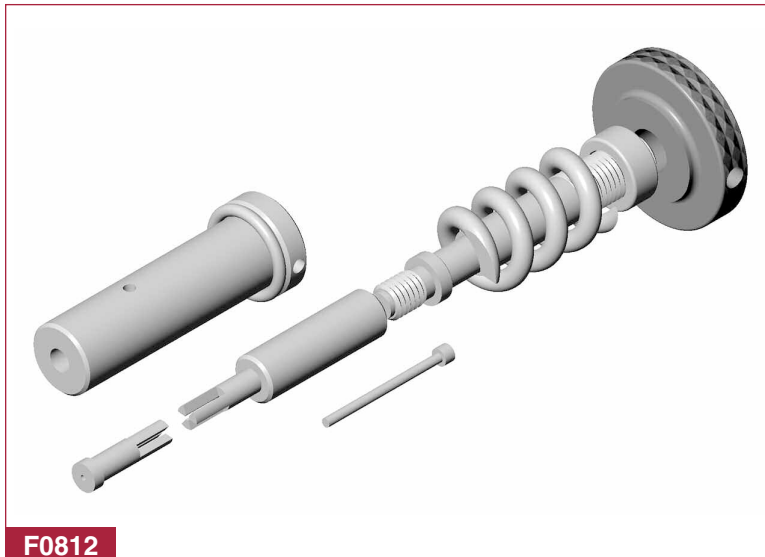
3-1/2" Station Punches and Dies

FOR SERIES 80 & 90 3-1/2" STATION WILSON STYLE TOOLING USE STANDARD PUNCHES, DIES AND STRIPPERS ON PAGE 10

Wilson Series 80/90[®] are Registered Trademarks of Wilson Tool International
 Strippit Quick Tip[®] is a Registered Trademark of L.V.D. Strippit

Perforator Tooling

MAXIMUM DIAMETER = .098" - 2.50mm
 MINIMUM DIAMETER = .031" - .78mm



F0812

For Holes Smaller Than Material Thickness

Maximum Material Thickness .134
 Maximum Tonnage 5 Tons

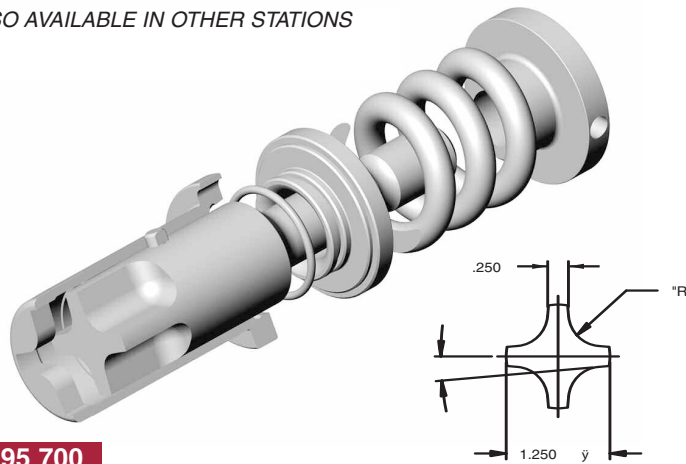
Round Punches Only

Not Recommended for Use on Stainless Steel

DESCRIPTION	PART NO.
COMPLETE PUNCH ASSEMBLY	F0812
PUNCH	F9682
SLEEVE SET	F9681
PUNCH HEAD	F8467
SET SCREW (2 REQUIRED)	F1627
NYLON BALL	F1143
SPACER	F0314
STRIPPING SPRING	F7177
PUNCH SHANK	F9678
SLEEVE COUPLING	F9679
GUIDE	F9680

4 Way Corner Rounding

ALSO AVAILABLE IN OTHER STATIONS



F9295 700

Stocked Sizes

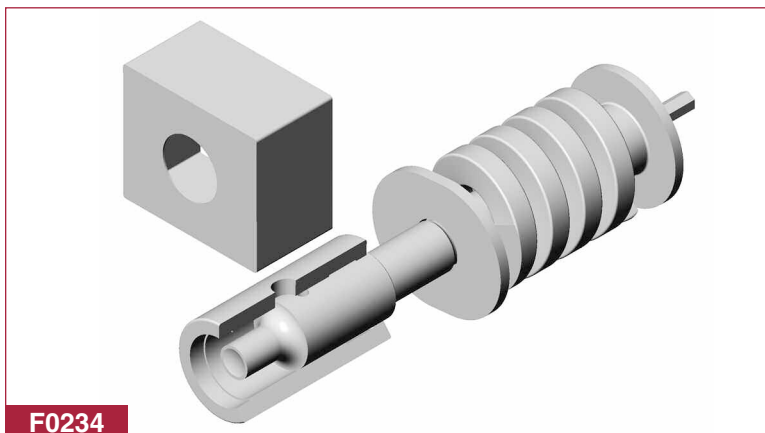
Also Available as SA Style Assemblies

RADIUS	PUNCH ASSEMBLY#	PUNCH ONLY #
.062 (1.58mm)	F9295700 .062	F8534700 .062
.094 (2.39mm)	F9295700 .094	F8534700 .094
.125 (3.18mm)	F9295700 .125	F8534700 .125
.156 (3.96mm)	F9295700 .156	F8534700 .156
.188 (4.78mm)	F9295700 .187	F8534700 .187
.250 (6.35mm)	F9295700 .250	F8534700 .250
.312 (7.93mm)	F9295700 .312	F8534700 .312
.375 (9.53mm)	F9295700 .375	F8534700 .375
.500 (12.7mm)	F9295700 .500	F8534700 .500

DIE #F9401700

STOCK CLEARANCES: .006" (.15mm) .012" (.3mm)

1-1/4" Station Nibble Tooling



F0234

F0234 Punch and Guide Assembly

.500 & 1.000 Diameter Stocked

DESCRIPTION	PART NO.
PUNCH AND GUIDE ASSEMBLY	F0234
ROUND PUNCH	F0236
ROUND GUIDE	F0235
PUNCH HEAD	F0237
PUNCH LOCK	F0238
SPRING	F1706
SPACER (COLLAR)	F0647
OIL RESERVOIR	F0463
ROUND DIE POSITIVE TAPER	F8532
ROUND DIE NEGATIVE TAPER	F8532NT
ROUND DIE SLUG CONTROL	F8532SC
ROUND DIE SLUG STOP	F8532SS
ROUND DIE TIGER CLAW	F8532TC
DIE SHIM .032 THICK	F0487



3-1/2" Station Punches and Dies

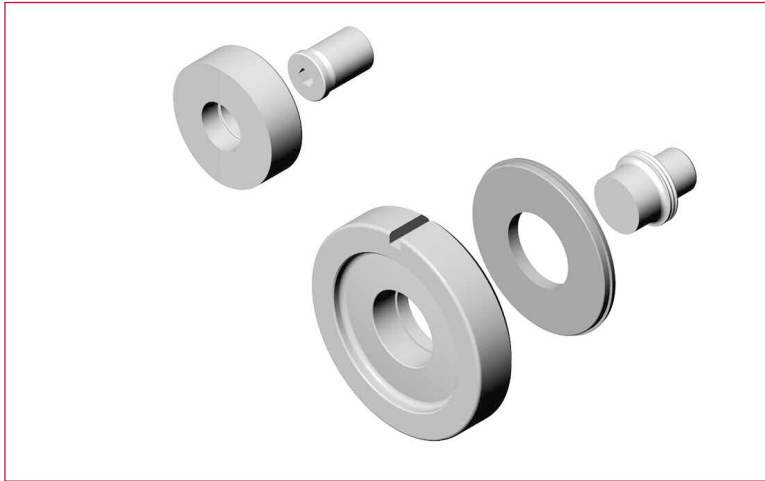
North American (Fab) Series

MAXIMUM PUNCH DIAMETER = 3.500" - 88.9mm
 MINIMUM PUNCH DIAMETER = 1.251" - 31.77mm
 MINIMUM WIDTH = .093" - 2.36mm

Note: F6717 Round Punches are Flat Faced.

All other 3.5 Stn Round or Shaped Punches are Standard with Roof Top Shear.

If Flat Face is required add B after Part #
 i.e.F8684-1 B or FQ076B100



Round

DESCRIPTION	PART NO.
ROUND PUNCH - 1.251 - 1.563	F6717
ROUND PUNCH - 1.564 - 2.250	F86841
ROUND PUNCH - 2.251 - 2.875	F86842
ROUND PUNCH - 2.876 - 3.500	F86843
ROUND STRIPPER (EXTRA GRIND LIFE)	F0912
ROUND STRIPPER (SOLID)	F0899
ROUND DIE POSITIVE TAPER	F1712
ROUND DIE NEGATIVE TAPER	F1712NT
ROUND DIE SLUG CONTROL	F1712SC
ROUND DIE SLUG STOP	F1712SS
ROUND DIE TIGER CLAW	F1712TC
PUNCH ADAPTOR	F6723
DIE SHIM .032 THICK	F0488

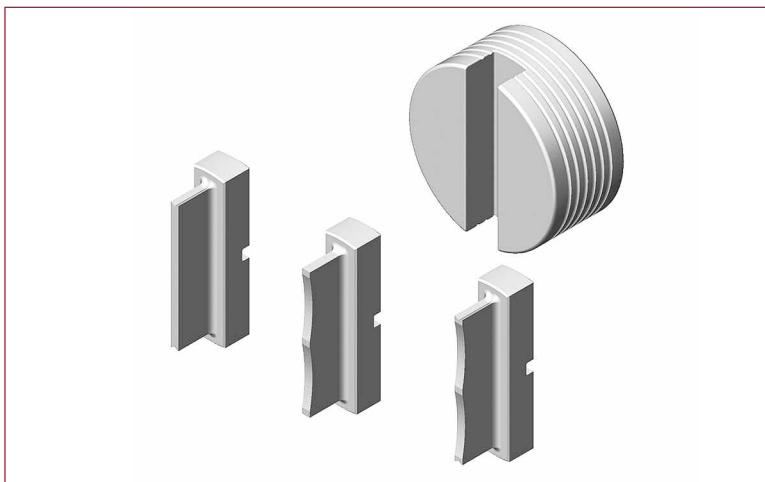


Shape

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
SHAPE PUNCH - UP TO 2.016 A/C	F6718 ---
SHAPE PUNCH - UP TO 2.512 A/C	F9076 ---
SHAPE PUNCH - UP TO 3.010 A/C	F9077 ---
SHAPE PUNCH - UP TO 3.500 A/C	F9078 ---
SHAPE STRIPPER (EXTRA GRIND LIFE)	F0913 ---
SHAPE STRIPPER (SOLID)	F0899 ---
SHAPE DIE POSITIVE TAPER	F1713 ---
SHAPE DIE NEGATIVE TAPER	F1713NT ---
SHAPE DIE SLUG CONTROL	F1713SC ---
SHAPE DIE SLUG STOP	F1713SS ---
SHAPE DIE TIGER CLAW	F1713TC ---
DIE SHIM .032 THICK	F0488

SPECIFY SHAPE CODE IN PLACE OF ---



F0915A Punch Insert Holder Assembly

DESCRIPTION	PART NO.
PUNCH INSERT HOLDER ASSEMBLY	F0915A ---
PUNCH HOLDER	F0915
PUNCH INSERT	F0940 ---
PUNCH INSERT (BOW TIE)	F0940796

*INSERTS ARE INTERCHANGEABLE

*DIES AND STRIPPERS ARE STANDARD SHAPE DIES

SPECIFY SHAPE CODE IN PLACE OF ---

3-1/2" Stripping Guide Assemblies



Original - Guide Assembly

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

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	F0810
PUNCH CAP	F0907
DRAW BOLT	F0291
LOCK WASHER	F0912LW
DISC SPRING (5 REQUIRED)	F3215
GUIDE FLANGE	F0910
SCREW (PUNCH CAP - 4 REQUIRED)	F2088
GUIDE BODY	F0768
SCREW (GUIDE FLANGE - 6 REQUIRED)	F9264
PUNCH BODY	F0449
PUNCH BODY KEY	F0575
SCREW (PUNCH BODY KEY - 1 REQUIRED)	F0771
PUNCH DRIVER	F0913PD
KEY KIT	F0793
LOCK ASSEMBLY	F0796
STRIPPER RING	F0753
PUNCH ADAPTOR (NOT SHOWN)	F6723

F0810



Adjustable - Guide Assembly

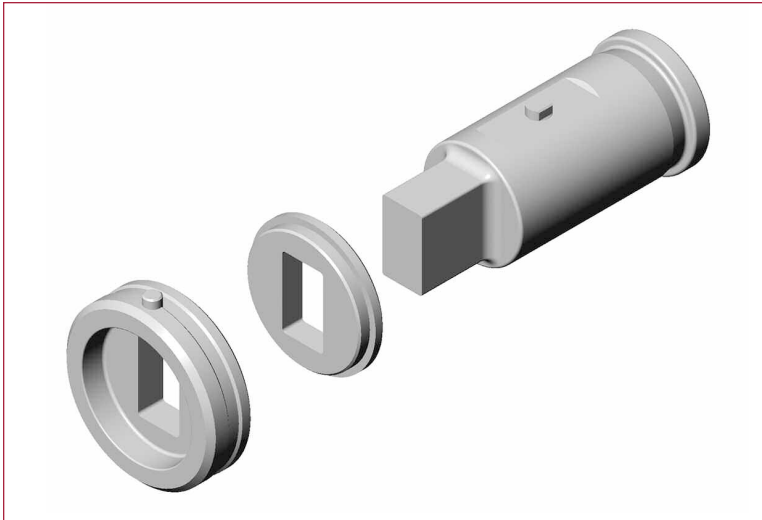
Standard indexing: 0° - 45° - 90° - 135° - 180° - 225° - 270° - 315°

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	F1400
PLUNGER	F1401
NUT	F1402
PUNCH CAP	F1403
TUBE	F1404
PUNCH BODY	F1405
WIRE RING	F0676
STEEL BALL	F1759
DISC SPRING (5 REQUIRED)	F3215
PUNCH BODY KEY	F1332
STRIPPER RING	F0753
KEY KIT	F0793
LOCK ASSEMBLY	F0796QA
DRAW BOLT	F1120
LOCK WASHER	F1120LW
PLUNGER SPRING	F1760
TUBE RING	F1761
PIN	F1762
GUIDE	F1419
PUNCH ADAPTOR (NOT SHOWN)	F6723

F1400



Strippit® Multi Tool Punches, Dies and Strippers

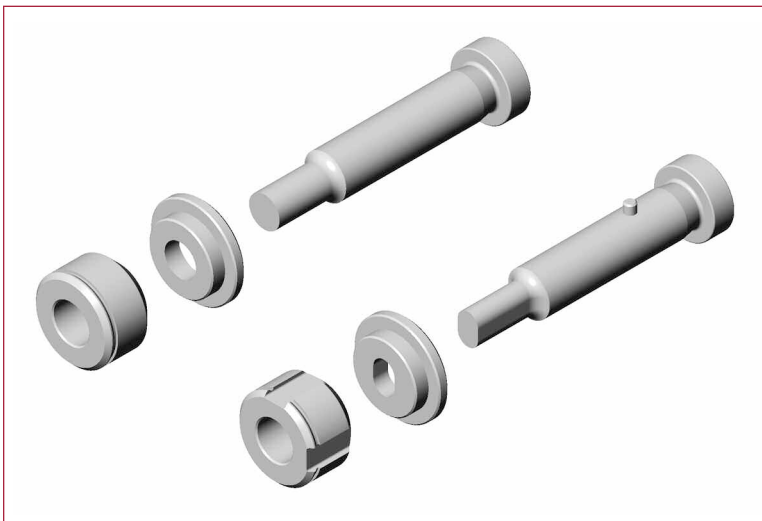


3 Station

Refer to page 1 for standard shape codes

RANGE .093 - 1.250

DESCRIPTION		PART NO.
SHAPE	PUNCH	F0966 _ _ _
	DIE POSITIVE TAPER	F2305 _ _ _
	DIE SLUG CONTROL	F2305SC _ _ _
	STRIPPER	F2302 _ _ _
SPECIFY SHAPE CODE IN PLACE OF _ _ _		

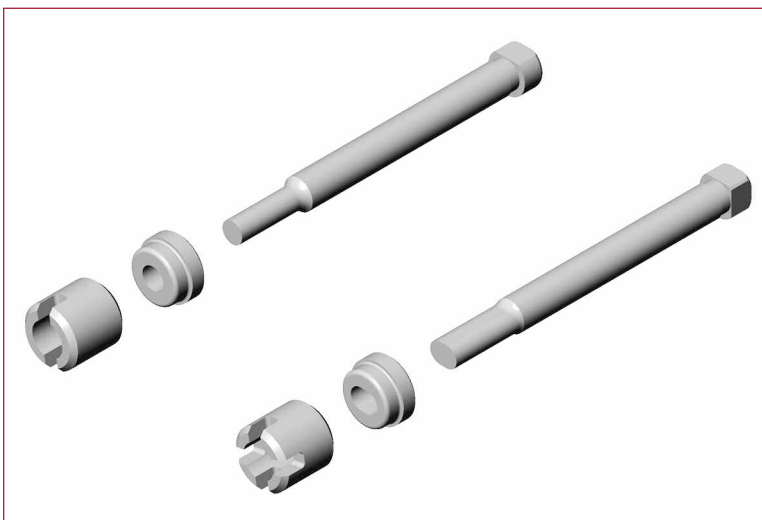


8 Station

Refer to page 1 for standard shape codes

RANGE .093 - .500

DESCRIPTION		PART NO.
ROUND	PUNCH	F0714
	DIE SLUG CONTROL	F0720
	STRIPPER	F0732
SHAPE	PUNCH	F0715 _ _ _
	DIE SLUG CONTROL	F0721 _ _ _
	STRIPPER	F0743 _ _ _
SPECIFY SHAPE CODE IN PLACE OF _ _ _		



30 Station

Refer to page 1 for standard shape codes

RANGE .075 - .250

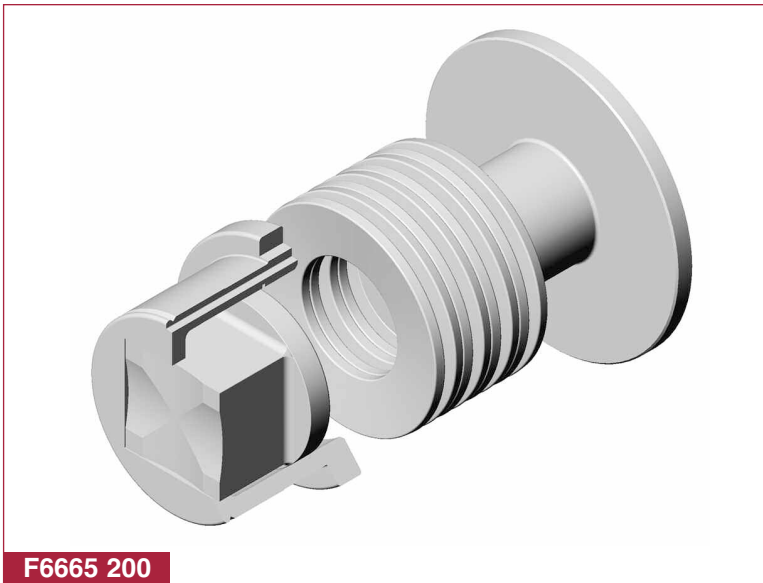
DESCRIPTION		PART NO.
ROUND	PUNCH	F0734
	DIE SLUG CONTROL	F0739
	STRIPPER	F0737
SHAPE	PUNCH	F0735 _ _ _
	DIE SLUG CONTROL	F0740 _ _ _
	STRIPPER	F0738 _ _ _
SPECIFY SHAPE CODE IN PLACE OF _ _ _		

Strippit® is a Trademark of L.V.D. Strippit

Universal Notch Tooling

MAXIMUM MATERIAL = .250" - 6.35mm

PUNCHES PREMIUM HIGH SPEED STEEL



F6665 200

F6665 Punch and Guide Assembly (Does not include Die)

DESCRIPTION	PART NO.
SQUARE PUNCH AND GUIDE ASSEMBLY	F6665200
SQUARE PUNCH	F6670200
SQUARE GUIDE	F6667200
ROUND PUNCH AND GUIDE ASSEMBLY	F6665
ROUND PUNCH	F6670
ROUND GUIDE	F6667
PUNCH CAP	F6668
DISC SPRING (8 REQUIRED)	F7057
RETAINER RING (GUIDE)	F7138
RETAINER RING (CAP)	F7058
DRAW BOLT	F0828
LOCKWASHER	F1756



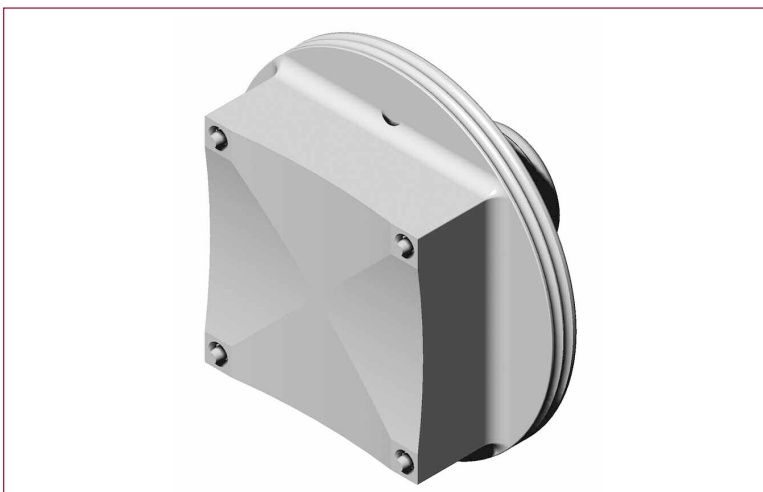
F1712

F1713

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
SQUARE DIE POSITIVE TAPER	F1713200
ROUND DIE POSITIVE TAPER	F1712
DIE SHIM .032 THICK	F0488

Light Duty Notching



Square Punch Notch Tooling

For Use in F0810 and F1400 3-1/2 Guide Assemblies
- See page 11

For Dies and Stripper - See page 10

Recommended for notching of materials .134" (3.43mm) and lighter. Punch has double concave shear with ejectors.

DESCRIPTION	MAX. P	METRIC	PART NO.
SQUARE PUNCH	1.414"	35.91mm	F6718200DCS
SQUARE PUNCH	1.767"	44.88mm	F9076200DCS
SQUARE PUNCH	2.121"	53.87mm	F9077200DCS
SQUARE PUNCH	2.474"	62.84mm	F9078200DCS



Knockout Tooling

1 1/4" Station Form Up



SINGLE ROUND TOOL SET .250 - .812 .813 - 1.125	PART NO. F5000-545 F5010-545
DOUBLE ROUND TOOL SET .250 - .812 .813 - 1.125	PART NO. F5020-766 F5020-766
SINGLE SQUARE OBLONG-RECT TOOL SET WITHIN .250 - .812 WITHIN .813 - 1.125	PART NO. F5000 ___ F5010 ___
SPECIFY SHAPE CODE IN PLACE OF ___	

F5010-545

3-1/2" Station Form Up



SINGLE ROUND TOOL SET 1.126 - 2.500	PART NO. F5080-545
DOUBLE ROUND TOOL SET 1.126 - 2.500	PART NO. F5080-766
SINGLE SQUARE OBLONG-RECT TOOL SET 1.126 - 2.500	PART NO. F5080 ___
SPECIFY SHAPE CODE IN PLACE OF ___	

F5040-766

Louvre Tooling

3-1/2" Station



DESCRIPTION	PART NO.
COMPLETE TOOL SET	F5080-450
FORMING INSERT*	FF1038
REVERSIBLE CUTTING INSERT*	FF1039
POCKET INSERT*	FF1040
STRIPPER*	FF1041

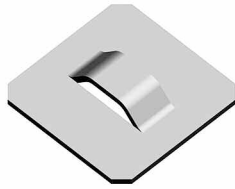
Standard Size Stock List					
L	W	H	P	PART NO.	SIZE
2.00	.50	.19	.75	F5080-450	2.000
2.50	.50	.19	.75	F5080-450	2.500
3.00	.63	.25	.94	F5080-450	3.000
3.50	.63	.25	.94	F5080-450	3.500

*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

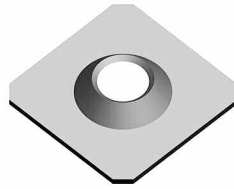
F5050

Forming Tools

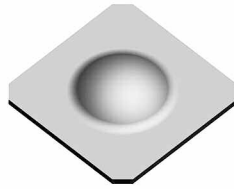
EXAMPLES AND SHAPE CODES FOR AVAILABLE STATIONS



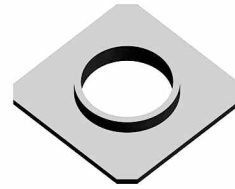
BRIDGE LANCE
-855



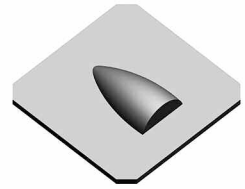
* COUNTERSINK
-654



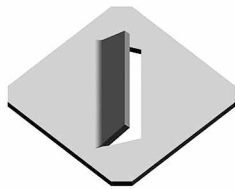
DIMPLE
-625



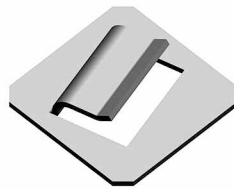
* EXTRUSION
-675



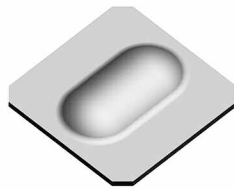
EYEBROW
-460



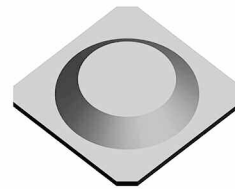
LANCE AND FORM
(ONE BEND)
-440



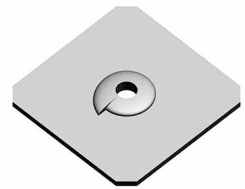
LANCE AND FORM
(THREE BENDS)
-445



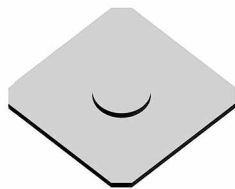
RIB
-370



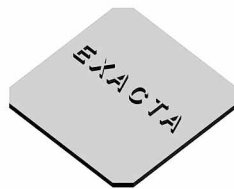
EMBOSS
-755



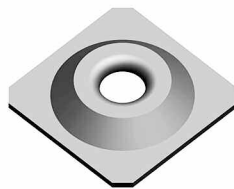
* THREAD FORM
-380



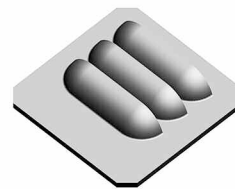
SHEAR TAB
-548



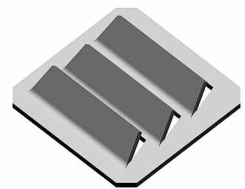
CHARACTER STAMP
-725



* EMBOSS UP
EXTRUDE DOWN
-775



CLOSED END
LOUVRE
-450



OPEN END
LOUVRE (LANCE)
-455

*MUST HAVE PRE PIERCED HOLE

Ordering Information

1. Applicable **SHAPE CODE** _ _ _ _
2. Machine Model
3. Material Type
4. Material Thickness
5. Form Up or Form Down
6. Hole Pattern (if applicable)
7. Dimensioned Drawing or Sketch
8. Specify Keying



Strippit® Tooling Accessories



1-1/4" Station Adaptors

For 1/2" Capacity Tooling

DESCRIPTION	PART NO.	REF. #
1/2" SHORT PIN TOOLING	F3047	201120
1/2" LONG PIN TOOLING	F9299	49299

Turret Bushings

Replaceable Hardened Wear Bushings

STATION	KEYWAY LOCATIONS	PART NO.
1-1/4"	0-270	F0230
1-1/4"	0-90-180-270	F02301
1-1/4"	0-45-270-315	F02302
1-1/4"	0-135-225-270	F02303
3-1/2"	STANDARD -0-	F0734TB

Manual Machine Guide Bushing

DESCRIPTION	PART NO.
1-1/4" HOLDER	F0230
3-1/2" HOLDER	F2508



Punch and Die Adaptors

For Use in Single Station and Turret Machines
Except "R" and "L.V.D." Series

DESCRIPTION	PART NO.
1-1/4" TO 3-1/2 PUNCH ADAPTORS	F0678
1-1/4" TO 3-1/2 DIE ADAPTORS	F2520

For Use in "R" Series Turret Machines

DESCRIPTION	PART NO.
1-1/4" TO 3-1/2 PUNCH ADAPTORS	F0678
1-1/4" TO 3-1/2 DIE ADAPTORS	F0777

For Use in "L.V.D."® Style Thin Turret Machines

DESCRIPTION	PART NO.
1-1/4" TO 3-1/2 PUNCH ADAPTORS	F4015
1-1/4" TO 3-1/2 DIE ADAPTORS	F2384



Alignment Tool Sets

DESCRIPTION	REF. #	PART NO.
TURRET MACHINES		
1-1/4" TOOL SET	200293	F2000B
3-1/2" TOOL SET		F2000D
MANUAL MACHINES		
1-1/4" TOOL SET	200292	F2000BM

F2000B

F2000D

Strippit® is a Trademark of L.V.D. Strippit
L.V.D.® is a Trademark of L.V.D. Strippit

5/8" Drop-In Tooling

Metric Series

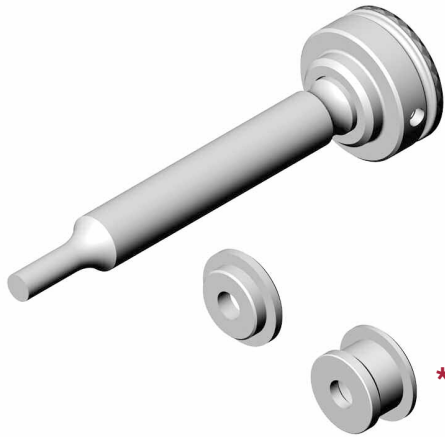
Punches and Heads are Supplied with Metric Threads

MAXIMUM DIAMETER = 15.88mm - .625
 MINIMUM DIAMETER = 2.36mm - .093
 MINIMUM WIDTH = 2.36mm - .093

PUNCHES PREMIUM HIGH SPEED STEEL

Round

For Punch Holders see page 4



FM0673

DESCRIPTION	PART NO.
PUNCH AND HEAD ASSEMBLY	FM0673
ROUND PUNCH	FM0551
PUNCH HEAD	FM0649
HEAD SCREW	FM1627
NYLON BALL	F1143
ROUND STRIPPER	F1086
ROUND STRIPPER - RECESS STYLE *	F1053



F8532

F8532 DIE - OPTIONS FOR ALL ASSEMBLIES

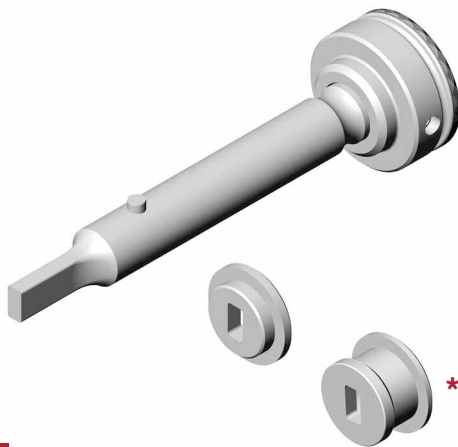
ROUND DIE	POSITIVE TAPER	F8532
ROUND DIE	NEGATIVE TAPER	F8532NT
ROUND DIE	SLUG CONTROL	F8532SC
ROUND DIE	SLUG STOP	F8532SS
ROUND DIE	TIGER CLAW (NOT SHOWN)	F8532TC
DIE SHIM	.032 THICK	F0487

M2 DIES AVAILABLE ON REQUEST

Shape

For Punch Holders see page 4

Refer to page 1 for standard shape codes



FM0674

DESCRIPTION	PART NO.
PUNCH AND HEAD ASSEMBLY	FM0674 ___
SHAPE PUNCH	FM0552 ___
PUNCH HEAD	FM0649
HEAD SCREW	FM1627
NYLON BALL	F1143
SHAPE STRIPPER	F1089 ___
SHAPE STRIPPER - RECESS STYLE *	F1054 ___
SPECIFY SHAPE CODE IN PLACE OF ___	



F9400

F9400 DIE - OPTIONS FOR ALL ASSEMBLIES

SHAPE DIE	POSITIVE TAPER	F9400 ___
SHAPE DIE	NEGATIVE TAPER	F9400NT ___
SHAPE DIE	SLUG CONTROL	F9400SC ___
SHAPE DIE	SLUG STOP	F9400SS ___
SHAPE DIE	TIGER CLAW (NOT SHOWN)	F9400TC ___
DIE SHIM	.032 THICK	F0487

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



1-1/4" Station Tooling

Metric Series

Punches and Heads are Supplied with Metric Threads

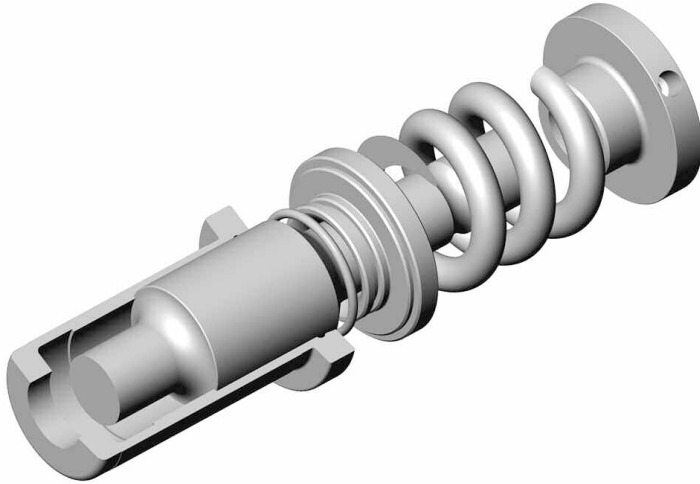
MAXIMUM PUNCH DIAMETER = 31.75mm - 1.250"
MINIMUM PUNCH DIAMETER = 6.35mm - .250"

PUNCHES PREMIUM HIGH SPEED STEEL

Round Punch and Guide Assembly

Original Style

(Does not include Die)



DESCRIPTION	PART NO.
ROUND PUNCH AND GUIDE ASSEMBLY	FM9704
ROUND PUNCH	FM8531
ROUND GUIDE	F8529
PUNCH HEAD	FM9671
SCREW	FM1627
STRIPPING SPRING	F8466
PUNCH COLLAR	F9672
RUBBER RING	F0111
PUNCH SHIM	F7684
FOR DIES SEE PAGE 6	

Shape Punch and Guide Assembly

DESCRIPTION	PART NO.
SHAPE PUNCH AND GUIDE ASSEMBLY	FM9295 ___
SHAPE PUNCH	FM8534 ___
SHAPE GUIDE	F9291 ___
ALL OTHER PARTS SAME AS ROUND (ABOVE)	
FOR DIES SEE PAGE 7	

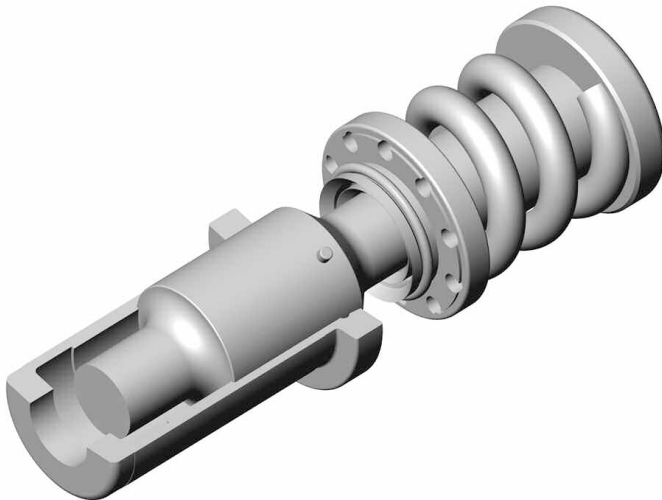
FM9704

Round 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	FM9704SA
ROUND PUNCH	FM8531SA
ROUND GUIDE	F8529SA
STRIPPING SPRING UNIT	FM8466SA
RUBBER RING	F0111SA
FOR DIES SEE PAGE 6	

Shape Punch and Guide Assembly

DESCRIPTION	PART NO.
SHAPE PUNCH AND GUIDE ASSEMBLY	FM9295SA ___
SHAPE PUNCH	FM8534 ___
SHAPE GUIDE	F9291 ___
STRIPPING SPRING UNIT	FM8466SA
RUBBER RING	F0111SA
FOR DIES SEE PAGE 7	

FM9704SA

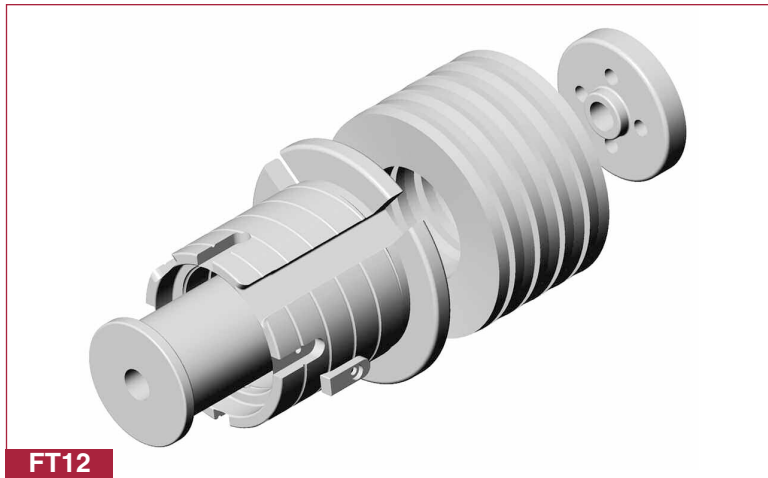
2" Station Stripping Guide Assemblies

Metric Series

(Only in Selected Thin Turret Machines)

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

PUNCHES PREMIUM HIGH SPEED STEEL

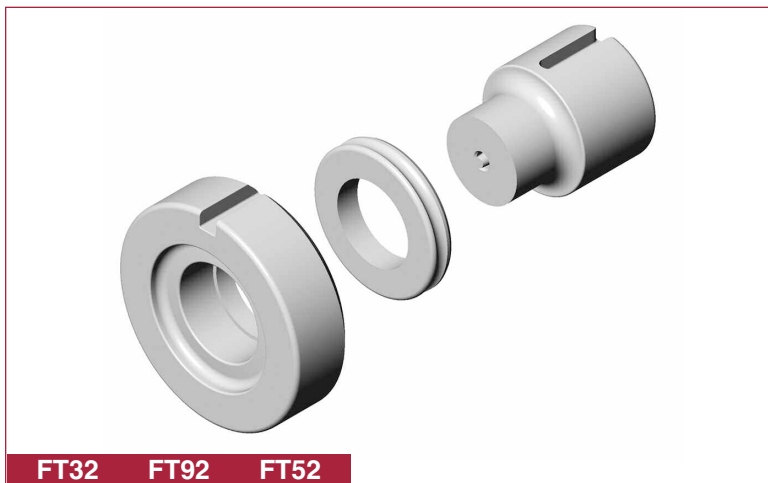


Original - Guide Assembly

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	FT12
PUNCH HEAD	FT102
PUNCH DRIVER	FT112
GUIDE ONLY	FT72
DISC SPRING (9 REQUIRED)	FT132
STRIPPER CLIP (4 REQUIRED)	F2546
SCREW AND WASHER	FT136AB2
SCREW, CLIP AND WASHER	FT1372
DRAW BOLT	M12X55
HEAD SCREW (4 REQUIRED)	M6X20

2" Station Punches and Dies

Thin Turret



Round Full Body

DESCRIPTION	PART NO.
ROUND PUNCH	FT32
ROUND STRIPPER	FT92
ROUND DIE POSITIVE TAPER	FT52
ROUND DIE NEGATIVE TAPER	FT52NT
ROUND DIE SLUG CONTROL	FT52SC
ROUND DIE SLUG STOP	FT52SS
ROUND DIE TIGER CLAW	FT52TC



Shape Full Body

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
SHAPE STRIPPER	FT96 ___
SHAPE DIE POSITIVE TAPER	FT62 ___
SHAPE DIE NEGATIVE TAPER	FT62NT ___
SHAPE DIE SLUG CONTROL	FT62SC ___
SHAPE DIE SLUG STOP	FT62SS ___
SHAPE DIE TIGER CLAW	FT62TC ___

SPECIFY SHAPE CODE IN PLACE OF ___

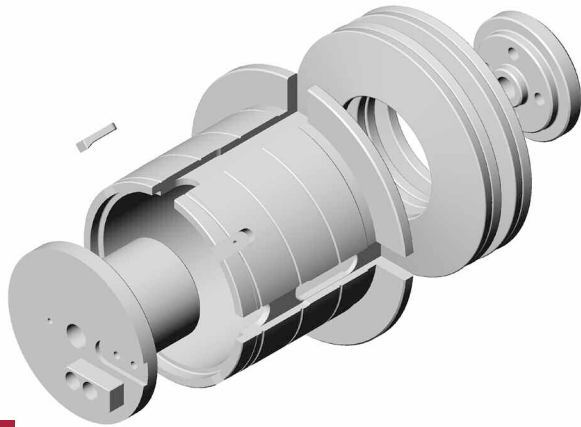


3-1/2" Station Stripping Guide Assemblies

Metric Series

Thin Turret

MAXIMUM PUNCH DIAMETER = 88.90mm - 3.500"
 MINIMUM PUNCH DIAMETER = 31.77mm - 1.251"
 MINIMUM WIDTH = 2.36mm - .093"



FT13

Original - Guide Assembly

DESCRIPTION	PART NO.
GUIDE ASSEMBLY	FT13
PUNCH HEAD	FT103
PUNCH DRIVER	FT113
GUIDE ONLY	FT73
DISC SPRING (SET OF 4)	FT133
STRIPPER CLIP (4 REQUIRED)	FT136
GUIDE KEY	FT143
SCREW	FT136AB
SCREW AND CLIP	FT137
DRAW BOLT	M12X55
HEAD SCREW (4 REQUIRED)	M6X25

3-1/2" Station Punches and Dies

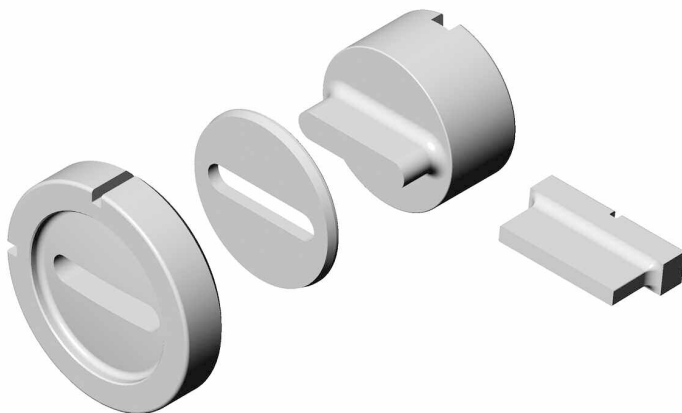
Thin Turret



FT33 FT93 FT53

Round Full Body

DESCRIPTION	PART NO.
ROUND PUNCH	FT33
ROUND STRIPPER	FT93
ROUND DIE POSITIVE TAPER	FT53
ROUND DIE NEGATIVE TAPER	FT53NT
ROUND DIE SLUG CONTROL	FT53SC
ROUND DIE SLUG STOP	FT53SS
ROUND DIE TIGER CLAW	FT53TC
DIE SHIM .032 THICK	F0488



Shape Full Body

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
SHAPE PUNCH	FT43 ___
PUNCH INSERT HOLDER ASSEMBLY	FTL43 ___
INSERT HOLDER (NOT SHOWN)	FTL43H
*PUNCH INSERT HIGH SPEED STEEL	FTL4301 ___
BOLT (2 REQUIRED)	5/16-18x7/8
SHAPE STRIPPER	FT97 ___
SHAPE DIE POSITIVE TAPER	FT63 ___
SHAPE DIE NEGATIVE TAPER	FT63NT ___
SHAPE DIE SLUG CONTROL	FT63SC ___
SHAPE DIE SLUG STOP	FT63SS ___
SHAPE DIE TIGER CLAW	FT63TC ___
DIE SHIM .032 THICK	F0488

**INSERTS ARE INTERCHANGEABLE - WIDTHS .093 TO .750*

SPECIFY SHAPE CODE IN PLACE OF ___

3-1/2" Station Punches and Dies

Metric Series

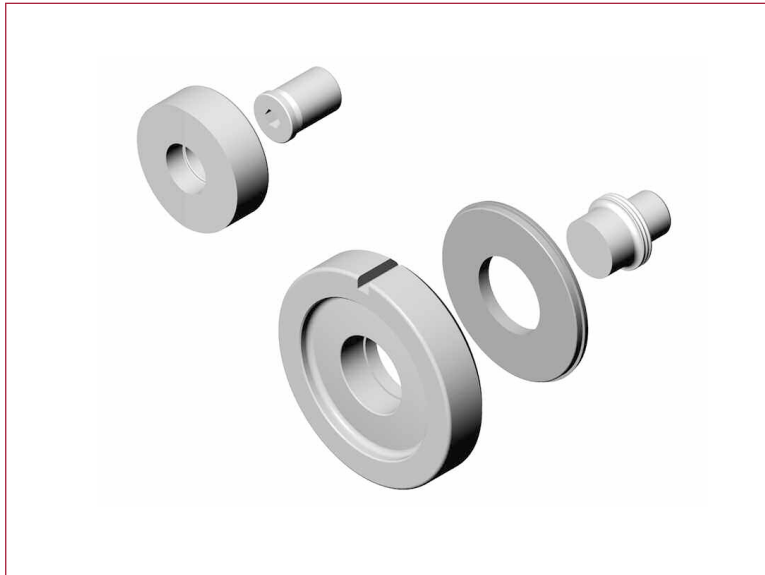
Thin Turret

Punches Supplied with Metric Threads

MAXIMUM PUNCH DIAMETER = 88.91mm - 3.500"
 MINIMUM PUNCH DIAMETER = 31.77mm - 1.251"
 MINIMUM WIDTH = 2.36mm - .093"

NOTE:

3-1/2" METRIC STRIPPING GUIDE ASSEMBLIES AVAILABLE SIMILIAR TO PAGE 11.



Round - Shank Style (Metric Thread)

DESCRIPTION	PART NO.
ROUND PUNCH - 31.77 - 39.71mm	FM6717
ROUND PUNCH - 39.72 - 57.16mm	F86841
ROUND PUNCH - 57.17 - 73.03mm	F86842
ROUND PUNCH - 73.04 - 88.90mm	F86843
ROUND STRIPPER (EXTRA GRIND LIFE)	F0912
ROUND STRIPPER (SOLID)	F0899
ROUND DIE POSITIVE TAPER	FT53
ROUND DIE NEGATIVE TAPER	FT53NT
ROUND DIE SLUG CONTROL	FT53SC
ROUND DIE SLUG STOP	FT53SS
ROUND DIE TIGER CLAW	FT53TC
PUNCH ADAPTOR	FM6723
DIE SHIM .032 THICK	F0488

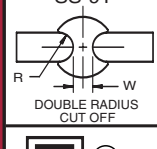
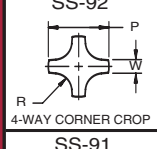
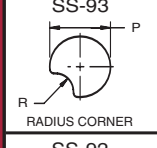
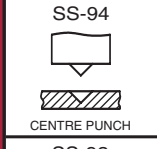
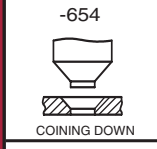
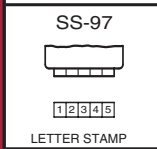
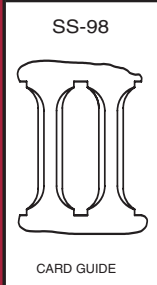
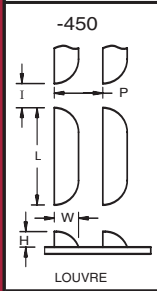
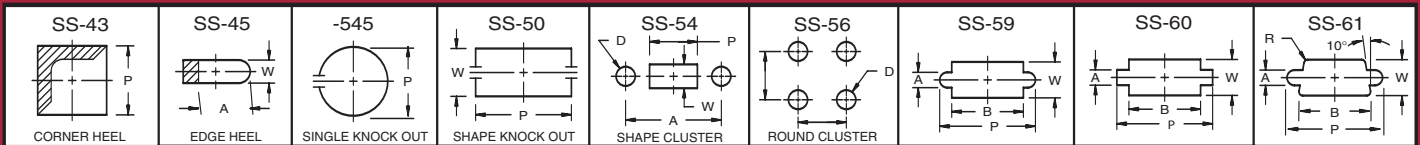


Shape - Shank Style (Metric Thread)

Refer to page 1 for standard shape codes

DESCRIPTION	PART NO.
SHAPE PUNCH - UP TO 51.20mm	FM6718
SHAPE PUNCH - UP TO 63.80mm	FM9076
SHAPE PUNCH - UP TO 76.45mm	FM9077
SHAPE PUNCH - UP TO 88.91mm	FM9078
SHAPE STRIPPER (EXTRA GRIND LIFE)	F0913
SHAPE STRIPPER (SOLID)	F0899
SHAPE DIE POSITIVE TAPER	FT63
SHAPE DIE NEGATIVE TAPER	FT63NT
SHAPE DIE SLUG CONTROL	FT63SC
SHAPE DIE SLUG STOP	FT63SS
SHAPE DIE TIGER CLAW	FT63TC
DIE SHIM .032 THICK	F0488

SPECIFY SHAPE CODE IN PLACE OF _ _ _



RECOMMENDED DIE CLEARANCE

MATERIAL THICKNESS (MILD STEEL)	DIE CLEARANCE (TO BE ADDED TO PUNCH SIZE)
20GA (.036)	.008
18GA (.048)	.010
16GA (.060)	.012
14GA (.075)	.015
12GA (.105)	.020
11GA (.120)	.030
10GA (.135)	.034
3/16 (.187)	.046
1/4 (.250)	.075

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

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