



SUCE IS.....

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

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

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

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

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



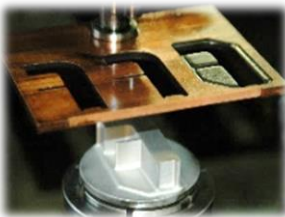
WHY SUCE?



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



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



No shape limitation thanks to EDM technology



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



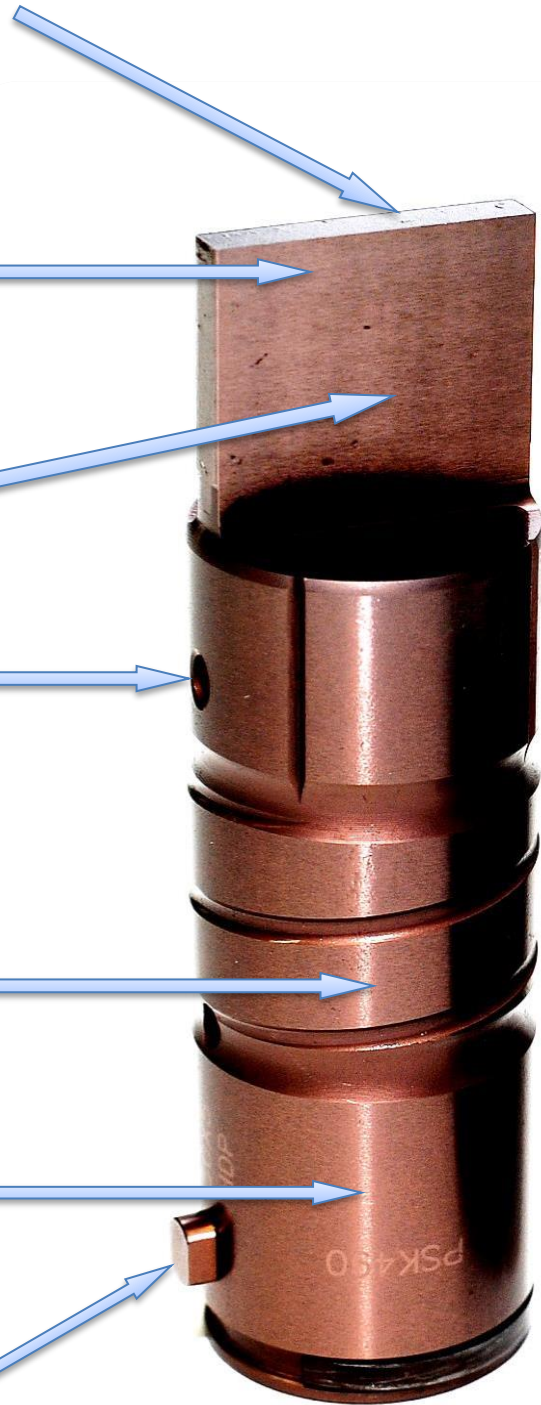
The use of the best steel available on the market by SUCE tools ensures a high standard quality and a long tool life.



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



Quality control

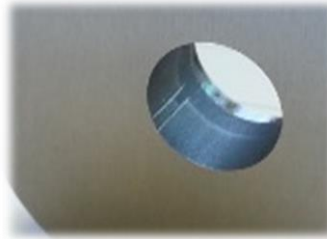




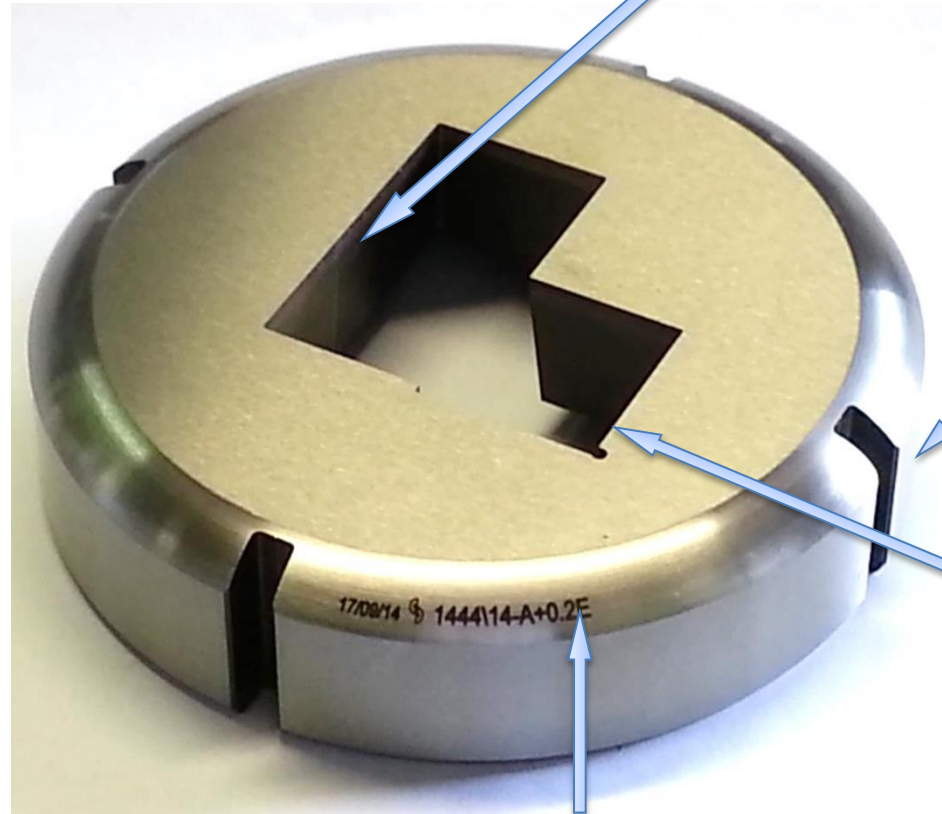
10,000 items available on stock divided into 20 different categories



No shape limitation thanks to Wire EDM technology



Different lock-slug systems available



In ware house: ready for delivery

SUCE special id.number

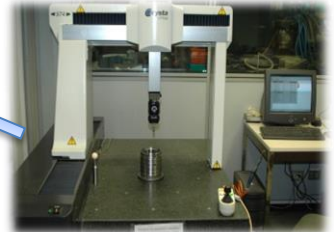
Manufacturing execution system



Wire EDM load-unload cell



Tool testing: fault free



Tool testing: fault free



In ware house: ready for delivery



SUCE special id.number



Manufacturing execution system



Die clearance

Die clearance is the total space between die and punch.

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

Material				
Thickness mm	Mild steel 16-20%	Stainless steel 18-24%	Aluminium 12-16%	Copper 10-14%
0,5 – 0,6	0,08-0,1	0,1- 0,12	0,06 – 0,08	0,05 – 0,06
0,8	0,14 – 0,16	0,15 – 0,2	0,1 – 0,14	0,08 – 0,1
1	0,16 – 0,2	0,18 – 0,24	0,12 – 0,16	0,1 – 0,14
1,2	0,2 – 0,24	0,24 – 0,3	0,15 – 0,2	0,12 – 0,15
1,5	0,25 – 0,3	0,27 – 0,35	0,18 – 0,24	0,15 – 0,2
2	0,34 – 0,4	0,36 – 0,45	0,24 – 0,3	0,2 – 0,25
2,5	0,45 – 0,5	0,45 – 0,55	0,32 – 0,35	0,25 – 0,3
3	0,5 – 0,6	0,6 – 0,7	0,35 -0,45	0,3 – 0,4
4	0,65 – 0,8	0,7 – 0,95	0,45 – 0,6	0,4 – 0,5
5	0,85 – 1	0,9 – 1,15	0,6 – 0,8	0,55 – 0,65
6	0,95 – 1,2	1,1 – 1,4	0,75 – 0,95	0,7 – 0,85

In case of blanking mild steel and stainless steel clearance is 15% of material thickness.

In case of blanking aluminium and copper clearance is 10% of material thickness.

Dies lock slug

SUCE lock slug dies eliminate slug pulling. This condition manifests where the slug returns to the top of the sheet during the stripping portion of the punching cycle. Because of this the slug comes between the punch and the top of the sheet on the next cycle, causing damage to the piece part and the tooling. How to avoid this problem?

The SUCE NO-SLUG has been designed with a reduction point of the shape below the surface so the slug cannot return once it passes through this point.

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



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

Once the slug is separated from the punch, it is free to fall through the die. Slug pulling is eliminated. This solution isn't suggested with slug exhaust system machines ; AS lock slug design with protrusions is best solution with thickness more than 3mm, minimum cl for AS system is 0.15mm. SUCE Lock slug E and A system is a standard for all Suce dies, AS is on request , reduced land is a standard for thick turret dies rt80x5 rt80x6 rt110x5 rt110x6.



lock slug AS
best opt. th>2.5mm



lock slug E
thick turret B,C,D,E



lock slug A
thick turret A



straight and conic
blank die



reduced land
slitting die



conic
trumpf style



Tools sharpening

Before starting, make sure that punch and die cutting edge are in perfect condition. Accurate maintenance of the tools guarantees a normal wearing and the result of punching will be without residual burr and defects. Regular sharpening of the 0,1 mm punch and 0,2mm die guarantees a constant life time of tooling.

It is preferable that grinding operation is made with tangential grinding machine with adequate cooling in order to avoid tool tempering; after grinding it is necessary to demagnetize the tools with an appropriate demagnetizer. If a urethane ejectors is applied, restore the initial hole depth in such a way that the ejector can be compressed.

Punching force

Before starting ensure that punching force doesn't exceed the capacity of punching machine.

In order to calculate the punching force in kg , use the following formula:

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

*mild steel 40-50 kg/mm² stainless steel 60-70 kg/mm² aluminium 20-25 kg/mm²

A sharpening other than the flat one reduces both punching stress and punching noise.

Therefore to ascertain the true punching force, multiply the pressure calculated using the above formula by the **sharpening factor**:

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

* standard shear height thick turret style

** standard shear height Trumpf style

The shear options

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

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



General rules

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

- a) the punching surface must not be lower than 60% of the used punch surface, isn't recommended to punch the edge of the sheet less than 2.5 times material thickness
- b) in case of nibbling, minimum feed must be 0,5 x thickness , smaller round punch with thickness 1mm is 4mm , smaller round punch with thickness 2mm is 6mm , smaller round punch with thickness 3mm is 8mm.
- c) before exceeding tons capability calculate punching force with formula on page 6.
- d) the tool dimension must not be lower than the material thickness and the shorter side must be at least 5% of the longest side.
- e) the advantage of the technical improvements of some models of dies punching penetration should be at least 2.5mm.
- f) slitting tools must be appropriately sharpened.
- g) the use of the steels commonly called High Speed Steel for our punches allows the punching of any steel. However, in order to considerably increase the punching effectiveness and reduce cold welds, apply some type of coating, such as TICN, HDP, FNC and use oil lubricant on sheet surface.
- h) ensure that tooling cutting edges are without seizing or cold welding material; if any , remove them with a diamond file.
- i) radius on punch corner is 0.25mm, constant radius on the corner of the dies ensures proper wear and a uniform burr.
- l) delivery time trumpf and thick turret tooling: 2/3 days standard, 5/7 coating tools, some items are available in stock.



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

Round : T

Standard shape:

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

Special 1:

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

Special 0:

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

Special 2:

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



Coating

HDP ACTION

high density plasma

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



Available with punches:

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

Test result



Coating is intact after 125.000 hits nibbling 1mm stainless steel

CHARACTERISTICS:

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

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



Coating

Double coating FNC

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



MOVIC is a self-lubricating and anti-adhesive coating based on MoS₂ (Molybdenum), which is produced by PVD sputtering Magnetron technology.

MOVIC has been developed in the aerospace to find alternatives to traditional oils (eg oil, grease) when their use is not permitted and it has shown excellent tribological features that made it very interesting for a variety of new applications.

Available with punches:

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

SPECIFICATIONS:

- Self-lubricating single-phase coating based on MoS₂.
- "Soft" coating with very low coefficient of friction (friction coefficient in dry air <0.05).
- Single-layer coating that can be combined with any hard coating.
- Functional Thickness of Coating <0.5 microns.
- Deposition temperature <150 ° C.
- Soft wear residues, lubricants (behavior Fail-safe: no abrasive particles from wear of the coating).
- Excellent running for rough surfaces. (Coating becomes smoother during the running in.)
- Positive transfer of lubricant film on the side in contact.
- can be easily re-covered without removal. If necessary the removal is easily achievable.

Structure	Micro-Hardness (HV 0.05)	Friction Coefficient (100 cr6)	Thickness (micron)	Deposition temperature (°C)	Max temperature (max°C)	Colour
Single layer	–	<0.1	1	<150	-	GREY



Tecnology



Models: T30 , Tecnotransfer , Tecnumerik , T30 , TP

- *P12 - S 15, nibbling - fitting S15*
- *P13 - S 40 - fitting S40*
- *P14 - S 70, fitting S 70 , S 100, fitting S 100*
- *P15 - Slitting tool 90x5, elliptical die, coating*



S 15



item	€	€	€	€					
PUNCH 7.5 Punzone D7.5 ridotto		PUNCH CHUCK D7.5 Portapunzone D7.5		PUNCH Punzone		GUIDE Guida		DIE Matrice	
ROUND Diametro	TEA575PST006T	D7.5 TEA175PPT0T		TEA1PUT006T		TEA1GUT0T		TEA1MAT001T	
SHAPE STD Sagoma std				TEA1PUT006S		TEA1GUT0S		TEA1MAT001S	
Special 0				TEA1PUT006C		TEA1GUT0D		TEA1MAT001D	
Special 1				TEA1PUT006D		TEA1GUT0D		TEA1MAT001D	
Special 2				TEA1PUT006F		TEA1GUT0D		TEA1MAT001D	

NIBBLING RD10 / Roditore D10



MODEL	ART.	€	
ALL / Tutti	NIBBLING PUNCH D10 / Punzone roditore DIAM.10	TEA10PTR06T	
ALL / Tutti	NIBBLING PUNCH D10 HDP / Punzone roditore DIAM 10 rivestito HDP	TEA10PTR06TH	
ALL / Tutti	NIBBLING PUNCH D10 FNC / Punzone roditore DIAM.10 rivestito FNC	TEA10PTR06TC	
TCNT-TECNOINDEX	DISC/Disco premi molla 75.1.1.720.1000	TEA10DPMX	
TECNUMERIK	DISC/Disco premi molla 95.1.1.720.1000	TEA10DPMK	
ALL / Tutti	SPRING / Molla a spirale G51X65 95.1.1.730.1000	TEA10MS	
ALL / Tutti	NIBBLING GUIDE RD10 / Guida punzone roditore GPR10	TEA10GU	
ALL / Tutti	DIE / Matrice per roditore	TEA1MAT001T	

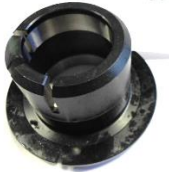


FITTING S15

Accessori

MODEL	ITEM	€	ITEM	€	ITEM	€	ITEM	€
TCNT-TECNOINDEX	ADAPTOR / Piastra di riduzione 71.0.1.100.0000 TEA1PRS15X		ALL MODELS SPRING PACK / Estrattore completo 91.2.1.400.0000 TEA1ESS15		PUNCH HOLDER Contenitore punzone predisposto 91.1.1.200.400		DIE HOLDER / Contenitore matrice 71.1.1.500.0000 TEA1PMATS15X	
TECNUMERIK	ADAPTOR / Piastra di riduzione 91.0.1.100.0000 TEA1PRS15K		SPRING /Molla a spirale G37X42 91.2.1.430.0000 TEA1MSS15		TEA1PPS15P		DIE HOLDER WITH LEVER /Contenitore matrice con leva 91.1.1.500.0000 TEA1PMATS15K	
			SPRING PLATE / Porta molla 91.2.1.410.0000 TEA1PMS15					
			SPRING DISK /Disco premi molla 91.2.1.420.0000 TEA1DPMS15					

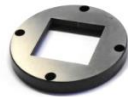
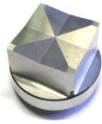


S 40												
	PUNCH/Punzone STEM/Corpo D26mm		PUNCH/Punzone STEM/Corpo D26mm SHARPENING/Tipo scaricato H96mm		PUNCH/Punzone STEM/Corpo D40mm		PUNCH/Punzone STEM/Corpo D40mm SHARPENING /Tipo scaricato H96mm		PUNCH GUIDE / Guida		DIE / Matrice	
												
item	PUNCH punzone	€	PUNCH WITH SHARPENING Punzone scaricato	€	PUNCH punzone	€	PUNCH WITH SHARPENING Punzone scaricato	€	GUIDE	€	DIE	€
ROUND Diametro	TEB1PUT006T		TEB1PUTL06T		TEB2PUT006T		TEB2PUTL06T		Ø26 TEB1GUT0T For sharp punch Ø26 TEB1GUTLT Ø40 TEB2GUT0T For sharp punch Ø40 TEB2GUTLT		TEB1MAT001T	
SHAPE STD Sagoma std	TEB1PUT006S		TEB1PUTL06S		TEB2PUT006S		TEB2PUTL06S		Ø26 TEB1GUT0S For sharp punch Ø26 TEB1GUTLS Ø40 TEB2GUT0S For sharp punch Ø40 TEB2GUTLS		TEB1MAT001S	
SPECIAL 0	TEB1PUT006C		TEB1PUTL06C		TEB2PUT006C		TEB2PUTL06C		Ø26 TEB1GUT0D For sharp punch Ø26 TEB1GUTLD Ø40 TEB2GUT0D For sharp punch Ø40 TEB2GUTLD		TEB1MAT001D	
SPECIAL 1	TEB1PUT006D		TEB1PUTL06D		TEB2PUT006D		TEB2PUTL06D		"		TEB1MAT001D	
SPECIAL 2	TEB1PUT006F		TEB1PUTL06F		TEB2PUT006F		TEB2PUTL06F		"		TEB1MAT001D	

FITTING S 40 Accessori						
MODEL	ART.	€	ART.	€	ALL MODELS	€
TCNT-TECNOINDEX	PUNCH HOLDER/Contenitore punzone 72.1.1.200.0000 TEB2PPUS40X		DIE HOLDER/Contenitore matrice 72.1.1.500.0000 TEB2PMATS40X		STRIPPER UNIT D26/Gruppo estrattore completo D26 92.2.1.400.1625 TEB2ESS26	
TECNUMERIK	PUNCH HOLDER/Contenitore punzone 92.1.1.200.0000 TEB2PPUS40K		DIE HOLDER WITH LEVER/Contenitore matrice con leva 92.1.1.500.0000 TEB2PMATS40K		STRIPPER UNIT D40/Gruppo estrattore completo D40 92.2.1.400.2640 TEB2ESS40 KIT N.10 SPRING DISCK/KIT N.10 MOLLE A TAZZA S40 92.2.1.430.0000 TEB2KITMTS40	
						



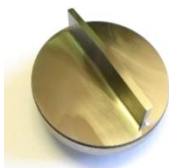
S 70



For flat punch h10
Per punzone piatto h10
For sharpened punch h13
Per punzone scaricato h13

item	PUNCH Punzone	€	STRIPPER Estrattore	€	DIE Matrice	€	€	€	
ROUND Diametro	TEC1PUT006T		TEC1PLTOBT h10 TEC1PLTOAT h13		TEC1MAT001T		TCNT TECNOINDEX PUNCH HOLDER Contentore punzone 73.1.1.200.0000 TEC1CONTPUS70X	O.D. TCNT TECNOINDEX DIE HOLDER Contentore matrice 73.1.1.500.0000 TEC1CONTMAS70X	O.D.
SHAPE STD Sagoma std	TEC1PUT006S		TEC1PLTOBS h10 TEC1PLTOAS h13		TEC1MAT001S		TECNUMERIK PUNCH HOLDER Contentore punzone 93.1.1.200.0000 TEC1CONTPUS70K	TECNUMERIK DIE HOLDER WITH LEVER/Contentore matrice con leva 93.1.1.500.0000 TEC1CONTMAS70K	
Special 0	TEC1PUT006C		TEC1PLTOBD h10 TEC1PLTOAD h13		TEC1MAT001D				
Special 1	TEC1PUT006D		TEC1PLTOBD h10 TEC1PLTOAD h13		TEC1MAT001D				
Special 2	TEC1PUT006F		TEC1PLTOBD h10 TEC1PLTOAD h13		TEC1MAT001D				

S 100





For flat punch h10
Per punzone piatto h10
For sharpened punch h13
Per punzone scaricato h13

item	PUNCH Punzone	€	STRIPPER Estrattore	€	DIE Matrice	€	€	€
ROUND Diametro	TED1PUT006T		TED1PLTOBT h10 TED1PLTOAT h13		TED1MAT001T		TCNT TECNOINDEX PUNCH HOLDER Contentore punzone 74.1.1.200.0000 TED1CONTPUS70X	TCNT TECNOINDEX DIE HOLDER Contentore matrice 74.1.1.500.0000 TED1CONTMAS70X
SHAPE STD Sagoma std	TED1PUT006S		TED1PLTOBS h10 TED1PLTOAS h13		TED1MAT001S		TECNUMERIK PUNCH HOLDER Contentore punzone 94.1.1.200.0000 TED1CONTPUS70K	TECNUMERIK DIE HOLDER WITH LEVER/Contentore matrice con leva 94.1.1.500.0000 TED1CONTMAS70K
Special 0	TED1PUT006C		TED1PLTOBD h10 TED1PLTOAD h13		TED1MAT001D			
Special 1	TED1PUT006D		TED1PLTOBD h10 TED1PLTOAD h13		TED1MAT001D			
Special 2	TED1PUT006F		TED1PLTOBD h10 TED1PLTOAD h13		TED1MAT001D			



SLITTING TOOL 90X5

Utensile da taglio 90x5

MODEL	DESCR		ART.	€
TCNT-TECNOINDEX	HOLDER PUNCH 90x5/ Gruppo porta punzone 90X5 PP 90X5 TCNT-TIX		TED1CONTPU90X5X	
TECNUMERIK	HOLDER PUNCH 90x5/ Gruppo porta punzone 90X5 PP90X5TK		TED1CONTPU90X5K	
ALL/Tutti	SLITTING PUNCH SHARP BLADE/ Lama punzone 90X5 scaricata		TED1PULT006S	
	SLITTING PUNCH SHARP BLADE COATING TICN/ Lama punzone 90X5 scaricata RIV TICN		TED1PULT006SRIV	
ALL/Tutti	STRIPPER 90x5 /Estrattore 90X5 ESE90X5		TED1ES90X5	
ALL/Tutti	KIT n.°4 SPRING DISK 32x38 / SET N.4 MOLLE SPIRALE 32X38 MG32X38		TED1KITMS90X5	
ALL/Tutti	DIE HOLDER 90x5 / Portamatrice 90X5 PMTCNT-TIX		TED1CONTMA90X5	
ALL/Tutti	SLITTING DIE 90x5 / Matrice ellittica 90X5		TED1MATE01S	

STATION	PUNCH D7.5	PUNCH S15	PUNCH S26/40	PUNCH S70	PUNCH S100
Coating HDP					
Coating FNC					



Rainer – metric style



Rainer – metric style

Models: 1000 , 2000 , 3000 , 4000 , OS2500 , OS1000 , OS4000 , ELETEK

- *P17 - Cat.g2a4, A – Station Eco-line, Smart2*
- *P18 - Cat.g2a4, A – Station Open guide*
- *P19 - Cat.g2a4, A – Station Smart2010 , Cat251 , Cat 252*
- *P20 - Cat253, Cat254 , adaptors*
- *P21 - Slitting tool , Special*
- *P22 - Urethan stripper: insert, dim 1,5÷30,5*
- *P23 - Urethan stripper: dim 30,6÷55, coating*



A STATION ECONO LINE , SOLID GUIDE

item	PUNCH Punzone	€	PUNCH ASSEMBLY Punzone assemblato	€	DIE HWS Matrice HWS	€	DIE HP Matrice HP	€
	ROUND Tondo	AMA1PUT006T		AMA1PARE06T		AMA1MAT001T		AMA1MAT006T
	SHAPE Sagoma	AMA1PUT006S		AMA1PARE06S		AMA1MAT001S		AMA1MAT006S

FITTING

item	HEAD Testa	€	SPRING Gruppo molle	€	OR COLLAR Ghiera inferiore	€	STANDARD GUIDE Guida standard	€
	RNAOCNTETO		AMA1MSRA		AMA1RIRA		ROUND Tondo	AMA1GUT0T
							SHAPE 0-90° Sagoma 0-90°	AMA1GUT0S
							SQUARE 0-135° Quadro 0-135°	AMA1GUT0Q

A STATION SMART2

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

item	PUNCH Punzone					PUNCH ASSEMBLY Punzone assemblato					STRIPPER Estrattore	€
	HP	€	PSM	€	HP	€	PSM	€			€	
	ROUND / Tondo	AMA1IPTM06T	AMA1IPTM04T		AMA1PATUR6T		AMA1PATUR4T			AMA1PLTUT		
	STANDARD	AMA1IPTM06S	AMA1IPTM04S		AMA1PATUR6S		AMA1PATUR4S			AMA1PLTUS		
SPECIAL 0	AMA1IPTM06C	AMA1IPTM04C		AMA1PATUR6C		AMA1PATUR4C			AMA1PLTUD			
SPECIAL 1	AMA1IPTM06D	AMA1IPTM04D		AMA1PATUR6D		AMA1PATUR4D			AMA1PLTUD			
SPECIAL 2	AMA1IPTM06F	AMA1IPTM04F		AMA1PATUR6F		AMA1PATUR4F			AMA1PLTUD			

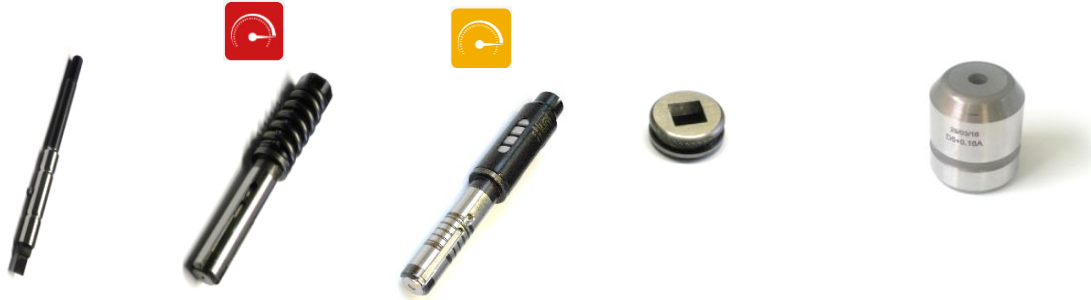
FITTING

item	SMART PRE-LOADED PACK SPRING Gruppo molle precaricato tipo SMART (max thickness 3mm)	€	SMART OPEN GUIDE Guida aperta tipo SMART	€
	AMA1LLTMRN		ONLY ROUND AMA1GUTUT	
			SHAPE 0-90-135° AMA1GUTUS	



A STATION STANDARD , OPEN GUIDE

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



item	PUNCH Punzone	€	PUNCH ASSEMBLY Punzone assiemato	€	PUNCH ASSEMBLY LONG LIFE Punzone assiemato recupero affilatura	€	STRIPPER Estrattore	€	HWS DIE Matrice HWS	€	HP DIE Matrice HP	€
ROUND Tondo	AMA1PUT006T		AMA1PATR306T		AMA1PALTR306T		AMA1PLTMT		AMA1MAT001T		AMA1MAT006T	
STANDARD Standard	AMA1PUT006S		AMA1PATR306S		AMA1PALTR306S		AMA1PLTMS		AMA1MAT001S		AMA1MAT006S	
SPECIAL 0	AMA1PUT006C		AMA1PATR306C		AMA1PALTR306C		AMA1PLTMD		AMA1MAT001D		AMA1MAT006D	
SPECIAL 1	AMA1PUT006D		AMA1PATR306D		AMA1PALTR306D		AMA1PLTMD		AMA1MAT001D		AMA1MAT006D	
SPECIAL 2	AMA1PUT006F		AMA1PATR306F		AMA1PALTR306F		AMA1PLTMD		AMA1MAT001D		AMA1MAT006D	

FITTING



Item	PRELOADED PACK SPRING	€	HEAD Testa	€	SPRING Molla	€	OR COLLAR Ghiera inferiore	€	STANDARD GUIDE Guida standard	€
	AMA1LGIOTR	80	RNA0CNTETO	30	AMA1MSRA	9	AMA1RIRA	5	ROUND AMA1GUA2T Tondo SHAPE 0-90° -135° AMA1GUL2S Sagoma 0-90°	

PUNCH INSERT

RD 6mm Max RD 5.9mm Max thickness: 3mm Grinding life: 1mm



item	PUNCH INSERT Insero punzone	€	PUNCH ASSEMBLY Punzone assiemato	€	DRIVER Codolo	€	PUNCH CHUCK Porta punzone	€
	AMA6PST006T		AMA6PPATRT		AMA6PPTOT1		AMA6PPTOT2	



A STATION SMART

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

item	PUNCH Punzone				PUNCH ASSEMBLY Punzone assieme				STRIPPER Estrattore	
	HP	€	PSM	€	HP	€	PSM	€		€
ROUND / Tondo	AMA1P16T06T		AMA1P16T04T		AMA1PANSTR06T		AMA1PANSTR04T		AMA1PLTMT	
STANDARD	AMA1P16T06S		AMA1P16T04S		AMA1PANSTR06S		AMA1PANSTR04S		AMA1PLTMS	
SPECIAL 0	AMA1P16T06C		AMA1P16T04C		AMA1PANSTR06C		AMA1PANSTR04C		AMA1PLTMD	
SPECIAL 1	AMA1P16T06D		AMA1P16T04D		AMA1PANSTR06D		AMA1PANSTR04D		AMA1PLTMD	
SPECIAL 2	AMA1P16T06F		AMA1P16T04F		AMA1PANSTR06F		AMA1PANSTR04F		AMA1PLTMD	

FITTING

item	SMART PRE-LOADED PACK SPRING Gruppo molle precaricato tipo SMART (max thickness 3mm)	€	SMART OPEN GUIDE Guida aperta tipo SMART	€
	RNA1LLNS		ONLY ROUND AMA1GUT2T SHAPE 0-90-135° AMA1GUT2S	

CAT 251

max 22mm

DIE Ø34

item	PUNCH HSS Punzone HSS	€	STRIPPER Estrattore	€	GUIDE COMPLETE Guida completa	€	DIE HWS Matrice HWS	€
ROUND / Tondo	RNB1PUCN06T		RNB1PLCNT		RNB1GACNT		RNB1MACN01T	
STANDARD	RNB1PUCN06S		RNB1PLCNS		RNB1GACNS		RNB1MACN01S	
SPECIAL 0	RNB1PUCN06C		RNB1PLCND		RNB1GACNS		RNB1MACN01D	
SPECIAL 1	RNB1PUCN06D		RNB1PLCND		RNB1GACNS		RNB1MACN01D	
SPECIAL 2	RNB1PUCN06F		RNB1PLCND		RNB1GACNS		RNB1MACN01D	

CAT 252

max 34mm

DIE Ø56

item	PUNCH HSS Punzone HSS	€	STRIPPER Estrattore	€	GUIDE COMPLETE Guida completa	€	DIE HWS Matrice HWS	€
ROUND / Tondo	RNC1PUCN06T		RNC1PLCNT		RNC1GACNT		RNC1MACN01T	
STANDARD	RNC1PUCN06S		RNC1PLCNS		RNC1GACNS		RNC1MACN01S	
SPECIAL 0	RNC1PUCN06C		RNC1PLCND		RNC1GACNS		RNC1MACN01D	
SPECIAL 1	RNC1PUCN06D		RNC1PLCND		RNC1GACNS		RNC1MACN01D	
SPECIAL 2	RNC1PUCN06F		RNC1PLCND		RNC1GACNS		RNC1MACN01D	



CAT 253

max 60mm



item	PUNCH HSS Punzone HSS	€	STRIPPER Estrattore	€	GUIDE COMPLETE STANDARD Guida complete std	€	GUIDE COMPLETE LONG LIFE Guida complete rec affilatura	€	DIE HWS Matrice HWS	€
ROUND / Tondo	RND1PUCN06T		RND1PLCNT		RND1GACNS		RND1GACNLL		RND1MACN01T	
STANDARD	RND1PUCN06S		RND1PLCNS		RND1GACNS		RND1GACNLL		RND1MACN01S	
SPECIAL 0	RND1PUCN06C		RND1PLCND		RND1GACNS		RND1GACNLL		RND1MACN01D	
SPECIAL 1	RND1PUCN06D		RND1PLCND		RND1GACNS		RND1GACNLL		RND1MACN01D	
SPECIAL 2	RND1PUCN06F		RND1PLCND		RND1GACNS		RND1GACNLL		RND1MACN01D	

CAT 254

max 100mm



item	PUNCH HSS Punzone HSS	€	STRIPPER Estrattore	€	GUIDE COMPLETE INDEX Guida complete rotante	€	DIE HWS Matrice HWS	€
ROUND / Tondo	RNE1PUCN06T		RNE1PLCNT		RNE1GACNR		RNE1MACN01T	
STANDARD	RNE1PUCN06S		RNE1PLCNS		RNE1GACNR		RNE1MACN01S	
SPECIAL 0	RNE1PUCN06C		RNE1PLCND		RNE1GACNR		RNE1MACN01D	
SPECIAL 1	RNE1PUCN06D		RNE1PLCND		RNE1GACNR		RNE1MACN01D	
SPECIAL 2	RNE1PUCN06F		RNE1PLCND		RNE1GACNR		RNE1MACN01D	

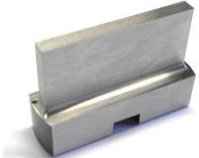
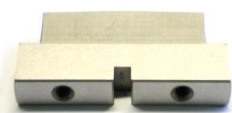


INDEX STATION ADAPTOR

Adattatore per stazione index

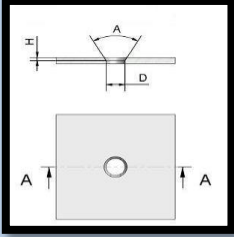
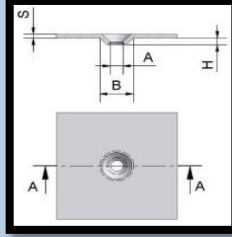
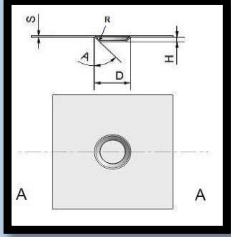
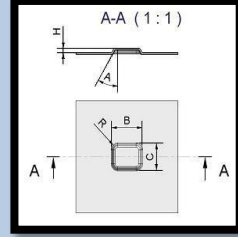
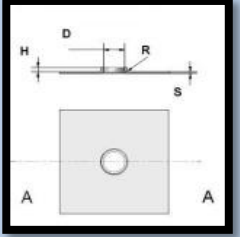
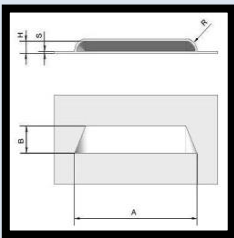
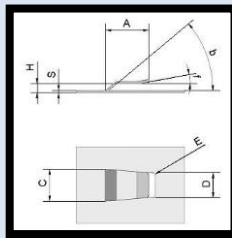
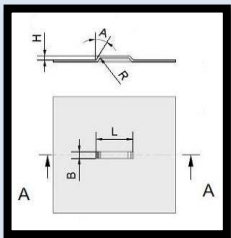
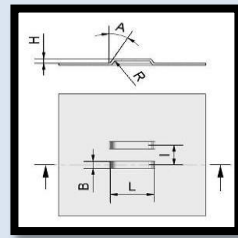
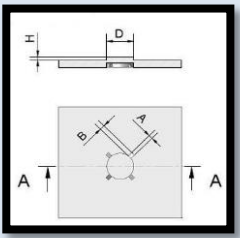


ITEM	PUNCH ADAPTOR Adattatore per punzoni	Cod	€	DIE ADAPTOR Adattatore per matrici	Cod	€
	254 index - 251	RNEBRIPU		252 – STAZ.A 2 A4	RNACRIMA	
	254 index - 252	RNCEBRIPU		252 – 251	RNBCRIMA	
	254 index - 253	RNEDBRIPU		254 index - 252	RNECRIMA	
				254 index - 253	RNDERIMA	



SLITTING TOOL Utensili da taglio CAT253		CAT254	
	SUCE TYPE H 35,0mm Tipo SUCE		SUCE TYPE H 46,5mm Tipo SUCE
	RAINER TYPE H 47,5mm Tipo Rainer		RAINER TYPE H 45,5mm Tipo Rainer
SLITTING TOOL BLADE Lama da taglio For holder RAINER type Per porta lama Rainer HSS AMC1PULTG06S PSM AMC1PULTG02S	€	BLADE HOLDER Porta lama For RAINER blade Per lama Rainer RND1PPLACNS	€
For holder SUCE type Per porta lama SUCE HSS RAB1PULT006S Add on Microjoint PSM= powder steel		For holder SUCE type Per porta lama SUCE HSS RNE1PULCN06S Add on Microjoint	
SLITTING TOOL BLADE Lama da taglio For holder RAINER type Per porta lama Rainer HSS AMD1PULTG06S PSM AMD1PULTG02S	€	BLADE HOLDER Porta lama For RAINER blade Per lama Rainer RNE1PPLACNS	€

SPECIAL TOOLS

Special				
Countersink after pre-pierce 	Countersink down forming 	Round Emboss 	Shape Emboss 	Round extrusion 
Louwer 	Lance up 	Bridge 	Double bridge 	Round Knock-out 



PUNCH DIMENSION BETWEEN 30.6 TO 55.0

item	PUNCH HP	€	O-RING	€	OR COLLAR FOR STRIPPER	€	STRIPPER	€	DIE	€
	Punzone HP				OR per estrattore		Estrattore		Matrice	
ROUND Tondo	RNB1PUT306T		NOR000002187		MRNB1RST2		RNB1PLT2T		RNC1MAT001T	
STANDARD Standard	RNB1PUT306S		NOR000002187		MRNB1RST2		RNB1PLT2S		RNC1MAT001S	
SPECIAL 0	RNB1PUT306C		NOR000002187		MRNB1RST2		RNB1PLT2D		RNC1MAT001D	
SPECIAL 1	RNB1PUT306D		NOR000002187		MRNB1RST2		RNB1PLT2D		RNC1MAT001D	
SPECIAL 2	RNB1PUT306F		NOR000002187		MRNB1RST2		RNB1PLT2D		RNC1MAT001D	

Punch assembly: punch + o-ring + OR collar stripper + stripper

PUNCH DIMENSION BETWEEN 55.1 A 80.0

item	PUNCH HP	€	O-RING	€	OR COLLAR FOR STRIPPER	€	STRIPPER	€	DIE	€
	Punzone HP				OR per estrattore		Estrattore		Matrice	
ROUND Tondo	RNC1PUT306T		NOR000002287		MRNC1RST2		RNC1PLT2T		RNE1MAT001T	
STANDARD Standard	RNC1PUT306S		NOR000002287		MRNC1RST2		RNC1PLT2S		RNE1MAT001S	
SPECIAL 0	RNC1PUT306C		NOR000002287		MRNC1RST2		RNC1PLT2D		RNE1MAT001D	
SPECIAL 1	RNC1PUT306D		NOR000002287		MRNC1RST2		RNC1PLT2D		RNE1MAT001D	
SPECIAL 2	RNC1PUT306		NOR000002287		MRNC1RST2		RNC1PLT2D		RNE1MAT001D	

Punch assembly: punch + O-ring + OR collar stripper + stripper

COATING

	A STATION	251	252	253	254
Coating HDP					
Coating FNC					





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