

PASS STANDARD I STATION B

DIAMETER UP TO 31,7 MM



HEAD UNIT

Hexagon head screw for simply assembling of punch assembly

Spring for sheet thickness up to 6 mm

2 mm length adjustment
by turning of the distance ring



PUNCH BODY

Metric-thread M20 x 1,5

Punch body made with premium H-PM®

Alignment pin with double D for exact adjustment



PUNCH GUIDE

Surface-hardened and polished punch
guide for sheet thickness up to 6 mm

Keyway:

Round: 0°

Square: 0-45°

Rect./Oblong: 0-90-225°

Asym. shapes: 0-90-180-270°

Tool shapes integrated in guide.

PASS STANDARD I STATION B

DIAMETER UP TO 31,7 MM

		PART NO.
COMPLETE PUNCH ASSEMBLY		
	Round	4012B01
	Square	4012B02
	Rectangle	4012B03
	Oblong	4012B04
	O.D. Ground Special Shape	4012B0G
	EDM Required Special Shape	4012B0E
HEAD UNIT (HEAD SCREW, SPRING, DISTANCE RING)		
	For all shapes	4092B01
PUNCH BODY (H-PM®)		
	Round	4022B01
	Square	4022B02
	Rectangle	4022B03
	Oblong	4022B04
	O.D. Ground Special Shape	4022B0G
	EDM Required Special Shape	4022B0E
PUNCH GUIDE		
	Round	4032B01
	Square	4032B02
	Rectangle	4032B03
	Oblong	4032B04
	O.D. Ground Special Shape	4032B0G
	EDM Required Special Shape	4032B0E
DIE (HWS)		
	Round	4052B01
	Square	4052B02
	Rectangle	4052B03
	Oblong	4052B04
	O.D. Ground Special Shape	4052B0G
	EDM Required Special Shape	4052B0E



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
Head screw	4092B31	TiCN coating
Spring	4092B11	T-MAX coating
Distance ring	4092B21	A-MAX coating
O-Ring (in punch guide)	4092B51	WT-shear
PU ejector Ø 3x6 (in punch)	4092P03	DOWT-shear
PU ejector Ø 6x10 (in punch)	4092P06	2 PT-shear
		4 PT-shear
		Cutting part under 1,00 mm
COMPENSATING SHIM FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE
Piece (2 mm)	499B4S2	Additional keyway
SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIES
1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1	Reinforced die
Shimkeeper (0,5 mm)	499B1M95	H-PM® Quality
		Additional pin hole

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DIAMETER UP TO 31,7 MM



HEAD UNIT

Canister for sheet thickness up to 4 mm

Continuously and easy length adjustment
in assembled status



PUNCH BODY

Metric-thread M20 x 1,5

Punch body made with premium H-PM®

Alignment pin with double D for exact adjustment



PUNCH GUIDE

Surface-hardened and polished punch
guide for sheet thickness up to 4 mm

Keyway:

All shapes: 0-45-90-180-270°

STRIPPER

Interchangeable stripper plate

ps:[®]alpha I STATION B

DIAMETER UP TO 31,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY

Round	4013B01
Square	4013B02
Rectangle	4013B03
Oblong	4013B04
O.D. Ground Special Shape	4013B0G
EDM Required Special Shape	4013B0E

HEAD UNIT

For all shapes	4093B01
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PUNCH BODY (H-PM[®])

Round	4023B01
Square	4023B02
Rectangle	4023B03
Oblong	4023B04
O.D. Ground Special Shape	4023B0G
EDM Required Special Shape	4023B0E

PUNCH GUIDE

For all shapes	4033B05
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STRIPPER

Round	4043B01
Square	4043B02
Rectangle	4043B03
Oblong	4043B04
O.D. Ground Special Shape	4043B0G
EDM Required Special Shape	4043B0E

DIE (HWS)

Round	4052B01
Square	4052B02
Rectangle	4052B03
Oblong	4052B04
O.D. Ground Special Shape	4052B0G
EDM Required Special Shape	4052B0E

SPARE PARTS

O-Ring (in punch guide)	4092B51
PU ejector Ø 3x6 (in punch)	4092P03
PU ejector Ø 6x10 (in punch)	4092P06

ADDITIONAL COSTS FOR PUNCH

TICN coating
T-MAX coating
A-MAX coating
WT-shear
DOWT-shear
2 PT-shear
4 PT-shear
Cutting part under 1,00 mm

COMPENSATING SHIM FOR PUNCH

Not necessary

ADDITIONAL COSTS FOR PUNCH GUIDE

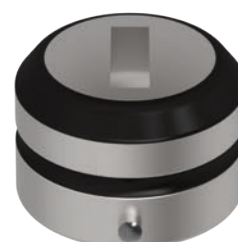
Additional keyway

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1
Shimkeeper (0,5 mm)	499B1M95

ADDITIONAL COSTS FOR DIES

Reinforced die
H-PM[®] Quality
Additional pin hole



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DIAMETER UP TO 31,7 MM



HEAD UNIT

Canister for sheet thickness up to 4 mm

Continuously and easy length adjustment
in assembled status



PUNCH BODY

Metric-thread M20 x 1,5

Punch body made with premium H-PM®

Alignment pin with double D for exact adjustment



PUNCH GUIDE

Surface-hardened and polished punch
guide for sheet thickness up to 4 mm

Keyway:

Round: 0°

Square: 0-45°

Rect./Oblong: 0-45-90-135°

Asym. shapes: 0-90-180-270°

Tool shapes integrated in guide.

ps:® alpha-compact I STATION B

DIAMETER UP TO 31,7 MM

		PART NO.
COMPLETE PUNCH ASSEMBLY		
	Round	4017B01
	Square	4017B02
	Rectangle	4017B03
	Oblong	4017B04
	O.D. Ground Special Shape	4017B0G
	EDM Required Special Shape	4017B0E
HEAD UNIT		
	For all shapes	4093B01
PUNCH BODY (H-PM®)		
	Round	4023B01
	Square	4023B02
	Rectangle	4023B03
	Oblong	4023B04
	O.D. Ground Special Shape	4023B0G
	EDM Required Special Shape	4023B0E
PUNCH GUIDE		
	Round	4032B01
	Square	4032B02
	Rectangle	4032B03
	Oblong	4032B04
	O.D. Ground Special Shape	4032B0G
	EDM Required Special Shape	4032B0E
DIE (HWS)		
	Round	4052B01
	Square	4052B02
	Rectangle	4052B03
	Oblong	4052B04
	O.D. Ground Special Shape	4052B0G
	EDM Required Special Shape	4052B0E



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
O-Ring (in punch guide)	4092B51	TICN coating
PU ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU ejector Ø 6x10 (in punch)	4092P06	A-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Cutting part under 1,00 mm
COMPENSATING SHIM FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE
Not necessary		Additional keyway
SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIES
1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1	Reinforced die
Shimkeeper (0,5 mm)	499B1M95	H-PM® Quality
		Additional pin hole

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DIAMETER UP TO 31,7 MM



HEAD UNIT

Canister for sheet thickness up to 6 mm

Spring

10 mm length adjustment by thread

Oil channel for sheet lubrication

On request, suitable for PDC-system



PUNCH BODY

Oil channel for sheet lubrication

Alignment pin with double D for exact adjustment

Punch body made with premium H-PM®



PUNCH GUIDE

Simple length adjustment in assembled state by pressing the locking button

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Keyway:

All shapes: 0-90-225°

STRIPPER

Interchangeable stripper plate with oil channels

ps:®beta-V2® ABS I STATION B

DIAMETER UP TO 31,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY

Round	4019B01
Square	4019B02
Rectangle	4019B03
Oblong	4019B04
O.D. Ground Special Shape	4019B0G
EDM Required Special Shape	4019B0E

HEAD UNIT

For all shapes	4099B10
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PUNCH BODY (H-PM®)

Round	4029B01
Square	4029B02
Rectangle	4029B03
Oblong	4029B04
O.D. Ground Special Shape	4029B0G
EDM Required Special Shape	4029B0E

PUNCH GUIDE

For all shapes	4039B05
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STRIPPER

Round	4049B01
Square	4049B02
Rectangle	4049B03
Oblong	4049B04
O.D. Ground Special Shape	4049B0G
EDM Required Special Shape	4049B0E

DIE (HWS)

Round	4052B01
Square	4052B02
Rectangle	4052B03
Oblong	4052B04
O.D. Ground Special Shape	4052B0G
EDM Required Special Shape	4052B0E

SPARE PARTS

O-Ring (in punch guide)	4092B51
PU ejector Ø 3x6 (in punch)	4092P03
PU ejector Ø 6x10 (in punch)	4092P06

ADDITIONAL COSTS FOR PUNCH

TICN coating
T-MAX coating
A-MAX coating
WT-shear
DOWT-shear
2 PT-shear
4 PT-shear
Cutting part under 1,00 mm

COMPENSATING SHIM FOR PUNCH

Not necessary

ADDITIONAL COSTS FOR PUNCH GUIDE

Additional keyway

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1
Shimkeeper (0,5 mm)	499B1M95

ADDITIONAL COSTS FOR DIES

Reinforced die
H-PM® Quality
ps:®tornado-die (vacuum-style)
Additional pin hole



Head unit
for PDC-system
(without extra charge)

Part.-no. „see left“-PDC
e.g.: 4019B01-PDC

ps:®beta-compact ABS I STATION B

DIAMETER UP TO 31,7 MM



HEAD UNIT

Canister for sheet thickness up to 6 mm

Spring

10 mm length adjustment by thread

Oil channel for sheet lubrication

On request, suitable for PDC-system



PUNCH BODY

Oil channel for sheet lubrication

Alignment pin with double D for exact adjustment

Punch body made with premium H-PM®



PUNCH GUIDE

Simple length adjustment in assembled state by pressing the locking button

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Keyway:

Round: 0°

Square: 0-45°

Rect./Oblong: 0-45-90-135°

Asym. shapes: 0-90-180-270°

Tool shapes integrated in guide.

ps:®beta-compact ABS I STATION B

DIAMETER UP TO 31,7 MM

		PART NO.
COMPLETE PUNCH ASSEMBLY		
	Round	4018B01
	Square	4018B02
	Rectangle	4018B03
	Oblong	4018B04
	O.D. Ground Special Shape	4018B0G
	EDM Required Special Shape	4018B0E
HEAD UNIT		
	For all shapes	4095B10
PUNCH BODY (H-PM®)		
	Round	4025B01
	Square	4025B02
	Rectangle	4025B03
	Oblong	4025B04
	O.D. Ground Special Shape	4025B0G
	EDM Required Special Shape	4025B0E
PUNCH GUIDE		
	Round	4038B01
	Square	4038B02
	Rectangle	4038B03
	Oblong	4038B04
	O.D. Ground Special Shape	4038B0G
	EDM Required Special Shape	4038B0E
DIE (HWS)		
	Round	4052B01
	Square	4052B02
	Rectangle	4052B03
	Oblong	4052B04
	O.D. Ground Special Shape	4052B0G
	EDM Required Special Shape	4052B0E



Head unit
for PDC-system
(without extra charge)

Part.-no. „see left“-PDC
e.g.: 4018B01-PDC



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
O-Ring (in punch guide)	4092B51	TICN coating
PU ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU ejector Ø 6x10 (in punch)	4092P06	A-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Cutting part under 1,00 mm
COMPENSATING SHIM FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE
Not necessary		Additional keyway
SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIES
1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1	Reinforced die
Shimkeeper (0,5 mm)	499B1M95	H-PM® Quality
		ps:®tornado-die (vacuum-style)
		Additional pin hole

ps:® alpha ABS I STATION B

DIAMETER UP TO 31,7 MM



HEAD UNIT

Canister for sheet thickness up to 4 mm

Continuously and easy length adjustment
in assembled status

Oil channel for sheet lubrication



PUNCH BODY

Metric-thread M20 x 1,25

Oil channel for sheet lubrication

Punch body made with premium H-PM®

Alignment pin with double D for exact adjustment



PUNCH GUIDE

Surface-hardened and polished punch
guide for sheet thickness up to 4 mm

Keyway:
All shapes: 0-90-225°

STRIPPER

Interchangeable stripper plate with oil channels

ps:® alpha ABS I STATION B

DIAMETER UP TO 31,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY

Round	40110B01
Square	40110B02
Rectangle	40110B03
Oblong	40110B04
O.D. Ground Special Shape	40110B0G
EDM Required Special Shape	40110B0E

HEAD UNIT

For all shapes	40910B10
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PUNCH BODY (H-PM®)

Round	40210B01
Square	40210B02
Rectangle	40210B03
Oblong	40210B04
O.D. Ground Special Shape	40210B0G
EDM Required Special Shape	40210B0E

PUNCH GUIDE

For all shapes	40310B05
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STRIPPER

Round	40410B01
Square	40410B02
Rectangle	40410B03
Oblong	40410B04
O.D. Ground Special Shape	40410B0G
EDM Required Special Shape	40410B0E

DIE (HWS)

Round	4052B01
Square	4052B02
Rectangle	4052B03
Oblong	4052B04
O.D. Ground Special Shape	4052B0G
EDM Required Special Shape	4052B0E

SPARE PARTS

O-Ring (in punch guide)	4092B51
PU ejector Ø 3x6 (in punch)	4092P03
PU ejector Ø 6x10 (in punch)	4092P06

ADDITIONAL COSTS FOR PUNCH

TICN coating
T-MAX coating
A-MAX coating
WT-shear
DOWT-shear
2 PT-shear
4 PT-shear
Cutting part under 1,00 mm

COMPENSATING SHIM FOR PUNCH

Not necessary	
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ADDITIONAL COSTS FOR PUNCH GUIDE

Additional keyway

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1
Shimkeeper (0,5 mm)	499B1M95

ADDITIONAL COSTS FOR DIES

Reinforced die
H-PM® Quality
ps:®tornado-die (vacuum-style)
Additional pin hole

