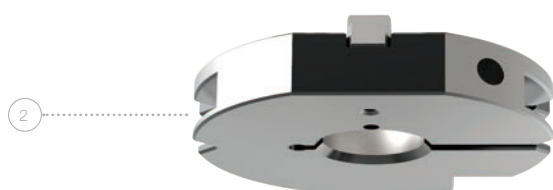
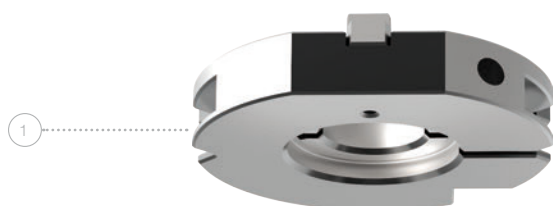


# PASS ADJUSTING RINGS

(FOR MACHINE GROUPS E / F / H / I)



SIZE	POSITION	PART-NO.
<b>AUTOMATIC ADJUSTING RINGS INCL. KEY</b>		
Size 1 with cut-out	1	118101
Size 2 without cut-out	2	118201
<b>ADJUSTING RING INCL. KEY FOR REINFORCED VERSION PUNCHES FORM</b>		
Reinforced	3	118V01

## Spare parts:

### SPARE PARTS FOR ADJUSTING RINGS

Key for automatic adjusting rings - part-no. 118902 - pos. 4

Key for reinforced adjusting rings - part-no. 118903 - pos. 5

## Cross references:

### ACCESSORIES

Punch size 1 and 2

ps:®passfit - explanation and additional costs

Spare parts

see page

6 - 13

40

52

# PASS PUNCH CHUCKS, ADAPTER RINGS

(FOR MACHINE GROUPS E / F / H / I)

SIZE	POSITION	PART-NO.
<b>PUNCH CHUCK</b>		
0 (up to 6,00 mm)	1	119A01
0 (up to 10,50 mm)	1	119B01
<b>ADAPTER RING FOR DIE</b>		
2 / 1	2	120210
<b>ADAPTER RING WITH BRUSHES</b>		
2 / 1	3	1S1820



## Spare parts:

### SPARE PARTS FOR ADAPTER RING WITH BRUSHES

Spare brush for adapter ring - part-no. 1S1822 - pos. 4

Set of compensating rings / shims (6xt = 0,5 mm) - part-no. 1S1823 - pos. 5

## Cross references:

### ACCESSORIES

Punch size 0

Die size 1

Spare parts

see page

6 - 13

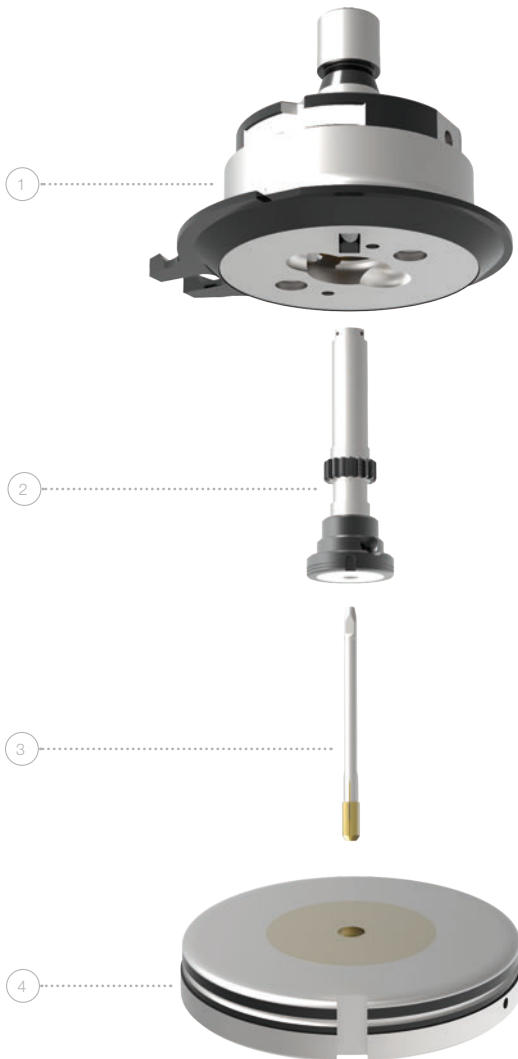
6 - 15

52

# PASS TAPPING TOOLS

FOR MACHINE GROUP I

(TRUPUNCH1000, 2000, 2020, 3000, 5000 TRUMATIC1000, 3000, 6000, 7000)



DESCRIPTION	SIZE	POSITION	PART-NO.
<b>TOOL TYPE 1 <sup>(*)</sup></b>			
Upper part <sup>(*)</sup>	M2,5 - M5	1	924GF1101
Spare tapping module <sup>(*)</sup>	M2,5	2	924GF1301
Spare tapping module <sup>(*)</sup>	M3	2	924GF1302
Spare tapping module <sup>(*)</sup>	M3,5	2	924GF1303
Spare tapping module <sup>(*)</sup>	M4	2	924GF1304
Spare tapping module <sup>(*)</sup>	M5	2	924GF1305
Tap insert 6HX - TIN	M2,5	3	924GF1401
Tap insert 6HX - TIN	M3	3	924GF1402
Tap insert 6HX - TIN	M3,5	3	924GF1403
Tap insert 6HX - TIN	M4	3	924GF1404
Tap insert 6HX - TIN	M5	3	924GF1405
Die type A <sup>(*)</sup>	M2,5 - M8	4	924GF2201
Die type A <sup>(*)</sup>	M10	4	924GF2206
Die type B <sup>(*)</sup>	M2,5 - M8	4	924GF2211

DESCRIPTION	SIZE	POSITION	PART-NO.
<b>TOOL TYPE 2 <sup>(*)</sup></b>			
Upper part <sup>(*)</sup>	M6 - M10	1	924GF2101
Spare tapping module <sup>(*)</sup>	M6	2	924GF2301
Spare tapping module <sup>(*)</sup>	M8	2	924GF2302
Spare tapping module <sup>(*)</sup>	M10	2	924GF2303
Tap insert 6HX - TIN	M6	3	924GF2401
Tap insert 6HX - TIN	M8	3	924GF2402
Tap insert 6HX - TIN	M10	3	924GF2403
Die type A <sup>(*)</sup>	M2,5 - M8	4	924GF2201
Die type A <sup>(*)</sup>	M10	4	924GF2206
Die type B <sup>(*)</sup>	M2,5 - M8	4	924GF2211

Details:

Cross references:

see page

## INFORMATION

## ACCESSORIES

One complete tool always includes:  
„upper part; tapping module; tap insert and die“

RTC cartridge and die carrier

41

<sup>(\*)</sup> Without spare tapping module and tap insert

<sup>(\*)</sup> Without tap insert

<sup>(\*)</sup> Suitable for flat sheets and extrusions (form-up)

<sup>(\*)</sup> Suitable for flat sheets and extrusions (form-up and down)

<sup>(\*)</sup> Suitable for max. sheet thickness s = 1,50 mm to 5,00 mm

<sup>(\*)</sup> Suitable for max. sheet thickness s = 1,50 mm to 8,00 mm  
(for M10 s = 3,00 mm to 8,00 mm)

Other thread sizes and versions (e. g. thread measured in inches) on request

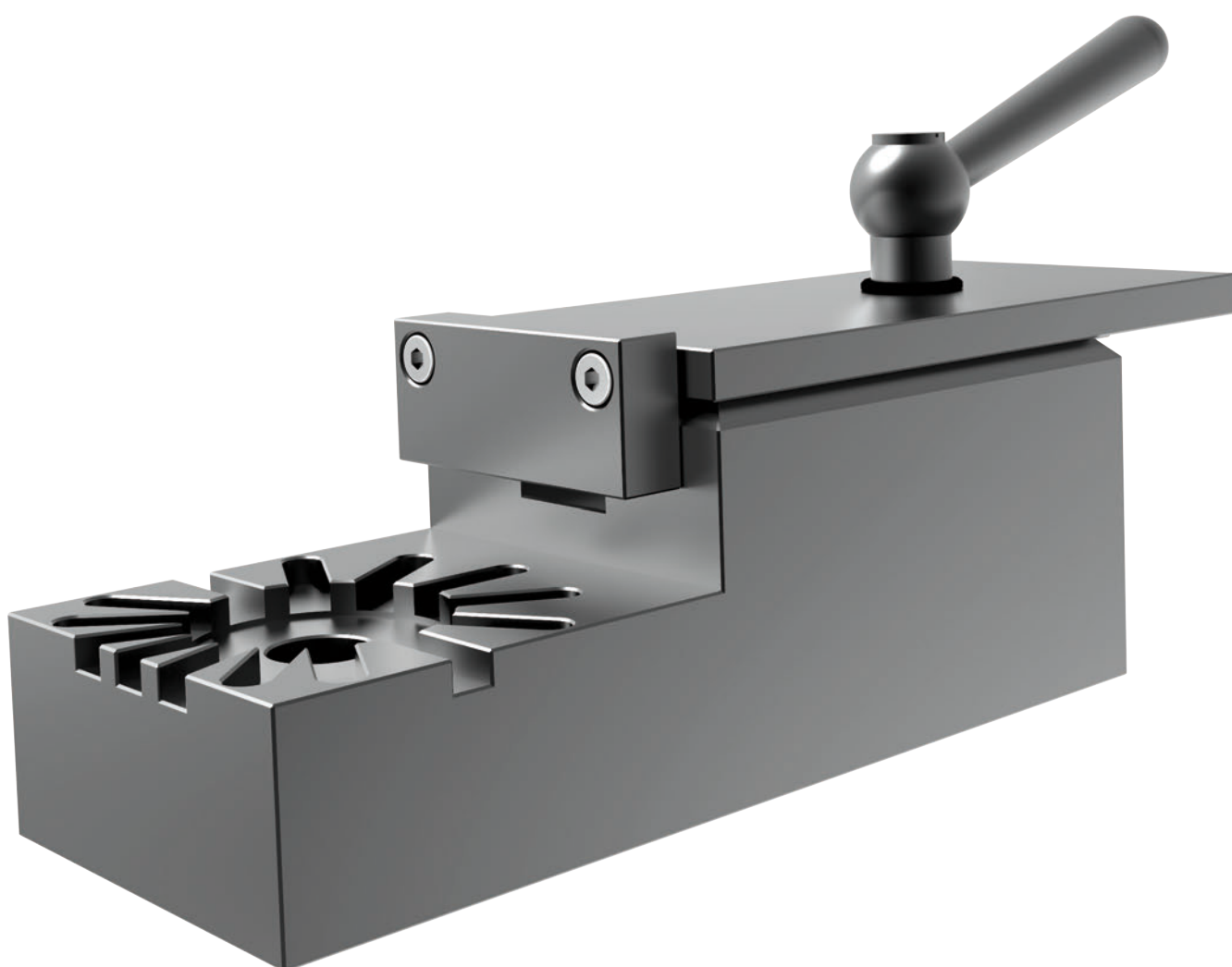
Please note that tapping tools are exclusively used in machines with programming option „Thread Forming“

# PASS ADJUSTMENT UNIT FOR PUNCH

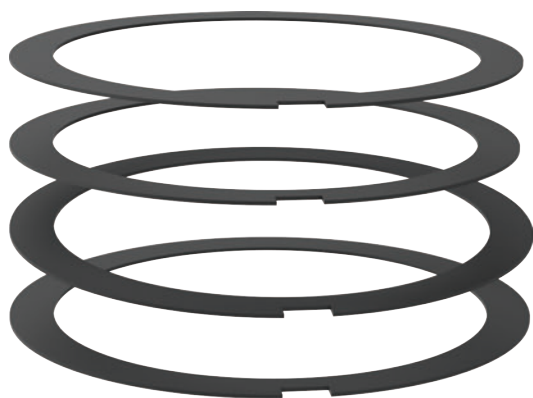
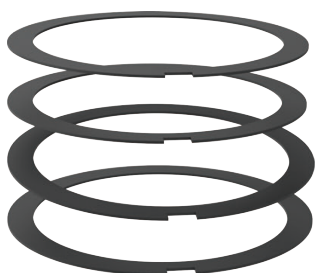
PART-NO.

POSSIBLE ANGLES: 0° - 22,5° - 30° - 45° - 60° - 67,5° - 90°

Z497673



# PASS COMPENSATING RINGS FOR DIES



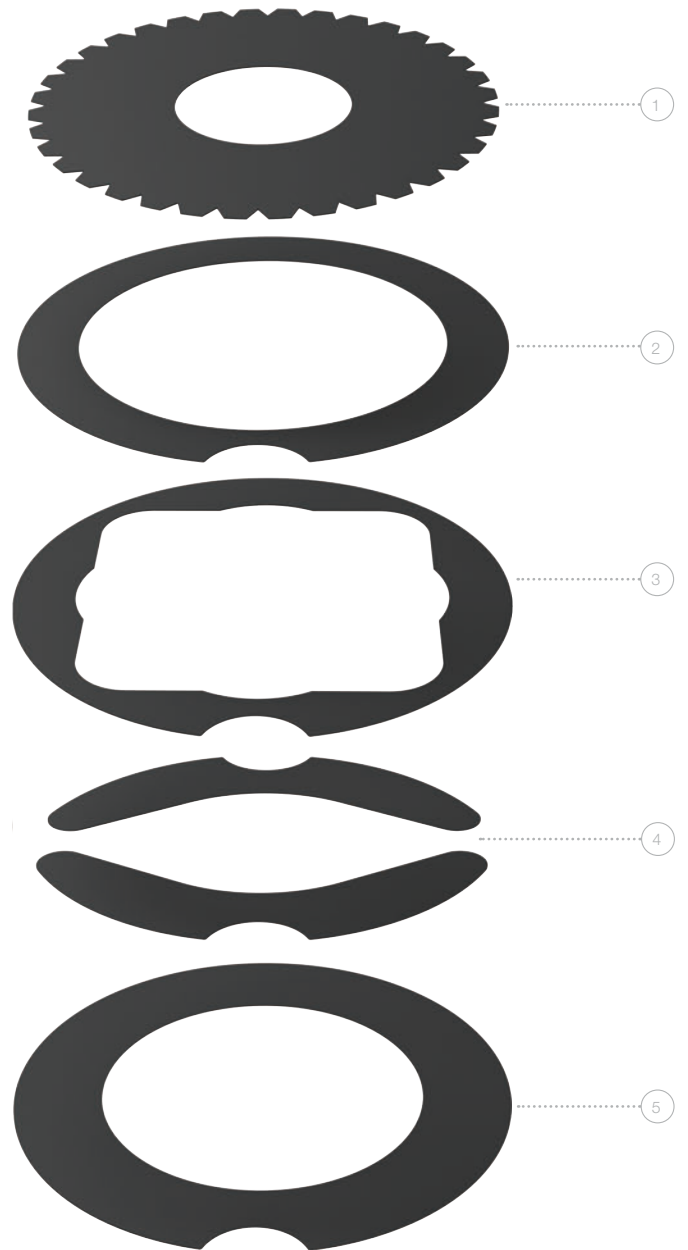
SIZE	RANGE	PART-NO.
<b>SET OF COMPENSATING RINGS FOR DIE SIZE 1</b>		
1	4 x t = 0,1 mm	11AS01
1	4 x t = 0,3 mm	11AS03
1	4 x t = 0,5 mm	11AS05
1	2x t = 0,1/1x t = 0,3/1x t = 0,5 mm	11AS0_
<b>SET OF COMPENSATING RINGS FOR DIE SIZE 2</b>		
2	4 x t = 0,1 mm	12AS01
2	4 x t = 0,3 mm	12AS03
2	4 x t = 0,5 mm	12AS05
2	2x t = 0,1/1x t = 0,3/1x t = 0,5 mm	12AS0_

Details: see page

ACCESSORIES	
Adapter rings for die	35
RTC cartridge and die carrier	41

# PASS SOFT PADS

SIZE	RANGE	POSITION	PART-NO.
<b>SOFT PADS FOR STRIPPER</b>			
2	Inside-Ø 16	1	PAD2A16
2	Inside-Ø 25	1	PAD2A25
2	Inside-Ø 50	1	PAD2A50
2	Inside-Ø 76	1	PAD2A76
<b>SOFT PADS FOR DIE</b>			
2	General	2	PAD2MAN
2	Square	3	PAD2MQN
2	Rectangle / oblong	4	PAD2MFN
<b>SOFT PADS FOR ADAPTER RING</b>			
2 to 1		5	PAD2ZAN





DESCRIPTION	MACHINE GROUP	PART-NO.
ps:®passfit ADJUSTING RING INCL. KEY FOR PUNCH SIZE 1		
Size 1	E-I	1181P1

ps:®passfit ADJUSTING RING INCL. KEY FOR PUNCH SIZE 2		
Size 2	E-I	1182P1

ps:®passfit ADJUSTING RING INCL. KEY FOR PUNCH REINFORCED VERSION		
Reinforced	E-I	118VP1

DESCRIPTION	LOCATION	PART-NO.
ps:®passfit FOR PUNCH SIZE 1		
First keyway	0°	__P1
Each additional keyway		

ps:®passfit FOR PUNCH SIZE 2 AND SIZE 3		
First alignment hole & pin	0 - 90°	__P2
Each additional alignment hole		

ps:®passfit PUNCH REINFORCED FORM		
First keyway	0°	__P1
Each additional keyway		

### Details:

#### INFORMATION ABOUT ps:®passfit

- Form-fitting anti-rotation-lock
- High operational security of the machine
- Solid tool, as the approved standard punches serve as basic tool
- Profile debilitation develops at the tension shaft
- High precision mating with punch; does not add to tool length
- Keyways on customer request
- Also reasonable for special tools
- All PASS cluster tools are generally equipped with ps:®passfit

### Additional costs:

#### SPARE PARTS

- Adjusting key for ps:®passfit - adjusting ring size 1 and size 2 - part-no. 118902
- Adjusting key for ps:®passfit - adjusting ring reinforced form - part-no. 118903

# RTC CARTRIDGE

FOR MACHINE GROUP H & I

(TC 200, TC500, TC600, TRUPUNCH1000, 2000, 2020, 3000, 5000  
TRUMATIC1000, 3000, 6000, 7000)

DESCRIPTION	POSITION	PART-NO.
RTC CARTRIDGE AND DIE CARRIER	1 - 2	on request
RTC CARTRIDGE	1	960100010
DIE CARRIER FOR RTC CARTRIDGE	2	960100020





# SPARE PARTS

DESCRIPTION	PART-NO.
<b>SCREWS</b>	
M5 x 10 for punch chuck Ø 6,00 mm	905006
M6 x 6 for punch chuck Ø 10,50 mm	905019
M8 x 16 for adapter rings size 2/1	905009
M8 x 12 with pins for adapter rings 3/1 - 3/2	905008
M14 x 1,5 x 12 for punch chuck	119991
<b>CYLINDER PIN</b>	
Ø 8 x 16 for adapter ring size 2/1	1-901013
Ø 8 x 16 for adapter ring size 3/1 - 3/2	2-901013
<b>ps:®passfit</b>	
Cylinder pin Ø 3 x 10 for adjusting ring size 1	901003
Adjusting key for punch size 2 + 3	11890006
<b>SLITTING PUNCH BLADE INSERT AND DIE PLATE INSERT</b>	
Center pin Ø 6 x 20 for slitting punch blade adapter	901018
Set of spare screws for die plate adapter M4 x 12 - 6 pieces	1-907005
Set of spare screws for die plate adapter M4 x 12 - 4 pieces	2-907005
<b>MISCELLANEOUS</b>	
Die clip for die	106991
Stripper pin	110991
Clamping screw M6 x 25 for adjusting ring size 1 + 2	907013
Fixing screw M3 x 8 for adjusting key	907062
Handle for stripper adapter ring „manual“ size 3/2	120326-2

# PASS PUSH-OUT STRIPPER

(FOR MACHINE GROUPS H / I)

DESCRIPTION	POSITION	PART-NO.
<b>PUSH-OUT STRIPPER</b>		
Round	1 - 4	1S21201
Square	1 - 4	1S21202
Rectangle	1 - 4	1S21203
Oblong	1 - 4	1S21204
Special shape	1 - 4	1S21200
<b>SPARE PARTS</b>		
Spare screws (4 per set)	2	1S21291
Spare springs (4 per set)	3	1S21292

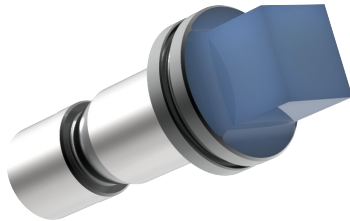


Additional costs:	Cross references:	see page
<b>STRIPPER</b>		
Polished version for low-scratch material handling	Standard tools	6 - 13
	Slitting tools	26 - 28
	Spare parts	52

# PUNCH COATINGS

ADVANTAGE: INCREASES TOOL LIFETIME, REDUCES MATERIAL BUILD UP

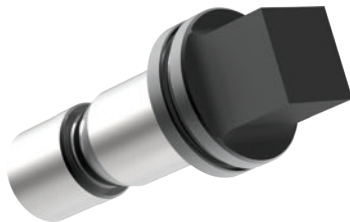
TICN



T-MAX



A-MAX



SIZE	RANGE
<b>TICN COATING (FOR WORKING WITH STAINLESS STEEL) <sup>(*)</sup></b>	
0	- 10,50 mm
1	- 30,50 mm
2	- 76,20 mm
3	- 105,00 mm
Multitool	- 16,00 mm
Slitting punch blade insert	- 60,00 mm
Slitting punch blade insert	- 80,00 mm

SIZE	RANGE
<b>T-MAX COATING (FOR WORKING WITH GALVANIZED SHEET / ZINCOR) <sup>(*)</sup></b>	
0	- 10,50 mm
1	- 30,50 mm
2	- 76,20 mm
3	- 105,00 mm
Multitool	- 16,00 mm
Slitting punch blade insert	- 60,00 mm
Slitting punch blade insert	- 80,00 mm

SIZE	RANGE
<b>A-MAX COATING (FOR DRY PROCESSING WITH ALUMINIUM SHEET) <sup>(*)</sup></b>	
0	- 10,50 mm
1	- 30,50 mm
2	- 76,20 mm
3	- 105,00 mm
Multitool	- 16,00 mm
Slitting punch blade insert	- 60,00 mm
Slitting punch blade insert	- 80,00 mm

Details:

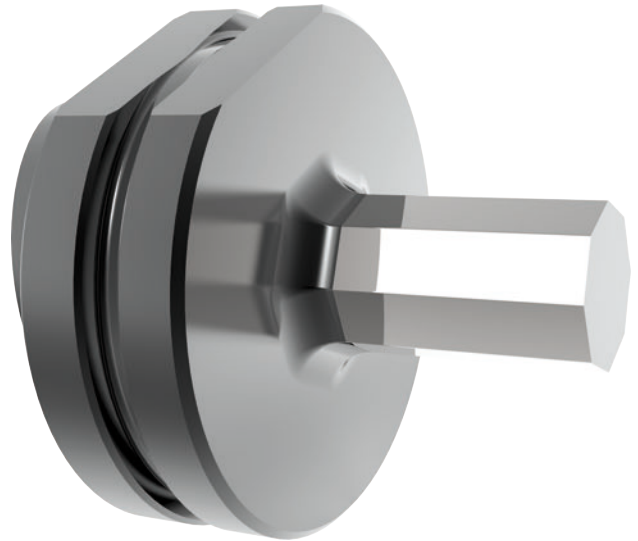
<sup>(\*)</sup> Suitable for cutting part sizes from Ø 4,00 mm or wide bases of 2,50 mm

# DRAW-POLISHING

## PUNCH EDGES

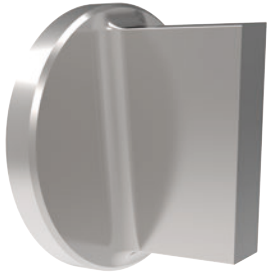
INCREASES TOOL LIFETIME, REDUCES MATERIAL BUILD UP

SIZE	RANGE
<b>ROUND</b>	
0	- 10,50 mm
1	- 30,50 mm
2	- 76,20 mm
3	- 105,00 mm
Multitool	- 16,00 mm
<b>SQUARE / RECTANGLE / OBLONG</b>	
0	- 10,50 mm
1	- 30,50 mm
2	- 76,20 mm
3	- 105,00 mm
Multitool	- 16,00 mm
<b>O.D. GROUND SPECIAL SHAPES (SPECIAL SHAPE GROUP 1 &amp; 2)</b>	
0	- 10,50 mm
1	- 30,50 mm
2	- 76,20 mm
3	- 105,00 mm
Multitool	- 16,00 mm
<b>EDM REQUIRED SPECIAL SHAPES (SPECIAL SHAPE GROUP 3 &amp; 4)</b>	
0	- 10,50 mm
1	- 30,50 mm
2	- 76,20 mm
3	- 105,00 mm
Multitool	- 16,00 mm

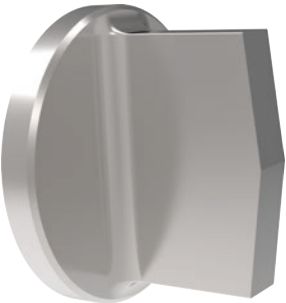


# PUNCHES WITH DIFFERENT SHEAR TYPES

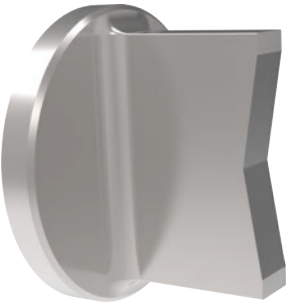
WT



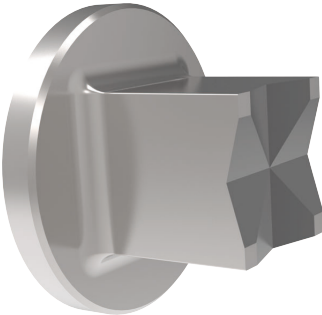
DOWT



2 PT



4 PT



DESCRIPTION

SHEAR TYPES	
WT	
DOWT	
2 PT	
4 PT	

# PASS SLUG-SNAP FOR DIES

SIZE	RANGE
<b>FOR DIES ROUND</b>	
1	- 32,00 mm
2	- 77,00 mm
1 reinforced form	- 32,00 mm
2 reinforced form	- 62,00 mm
Multitool	- 16,00 mm
<b>FOR DIE FORM</b>	
1	- 32,00 mm
2	- 77,00 mm
1 reinforced form	- 32,00 mm
2 reinforced form	- 62,00 mm
Multitool	- 16,00 mm



SLUG-SNAP

Details:

## SLUG-SNAP

Special holding bolts are included in the die, clamping the slug positively (better than the slug-stop version, negative cutting part)

The slug-snap version is also more convenient for shapes smaller than 4 mm and clearance smaller/equal 0,1 mm