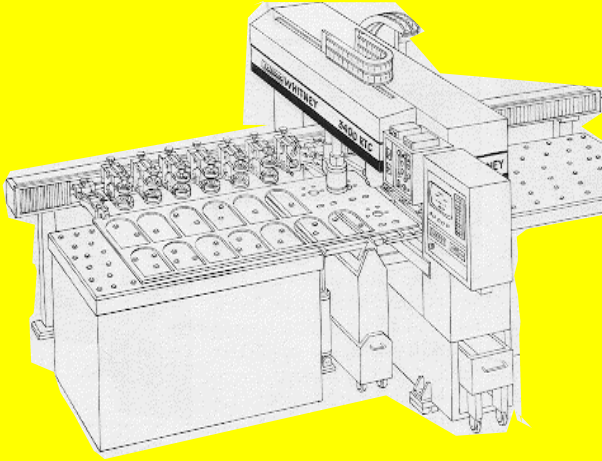


CE TOOLING

Section

5



Reference Section 1 For Technical Information



TOOLS FOR
.WHITNEY
EUROMACH • BOCHERT
• Roper Ironworkers
AND SIMILAR MACHINES



28XX • Roper (Non-Keyed)
36/37TC

Jun-13



ADDITIONAL COSTS FOR NON-STANDARD OPTIONS



RADIUS OR 45°CHAMFERS + \$.00 per corner

PUNCHES

Corners 1-3 X # 4(all)

With Length under 1.625 and any size Radius or Chamfer # X
 With Length over 1.625 & .032 maximum Radius or Chamfer # X
 With Length over 1.625 and Radius or Chamfer over .032(.8mm) # X

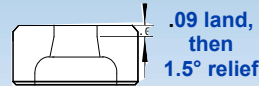
Add On To All DIES any size Radius or Chamfer # X

No Extra Charge for STRIPPERS or GUIDES When Ordered With Set

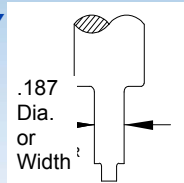
Add 25% to set price
 for Clearance
 of .003/.08mm & <

50% added to die
 price for **Solid Dies**.

Widths or Dia. Under .093(2,36mm) Add 30% to set price
 Widths or Dia. Under .062(1,57mm) Add 50% to set price
 Widths or Dia. Under .046(1,2mm) Add 100% to set price
Included in add-on cost; Dies are produced with .090 land then a 1.5° relief is given to prevent multiple slugs from stacking causing excessive pressure on punch. Further, punches can be produced with Stubby Punch Design at no additional charge.



STUBBY PUNCH

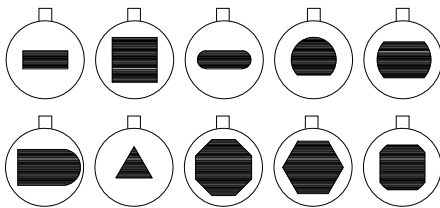


STANDARD KEYING

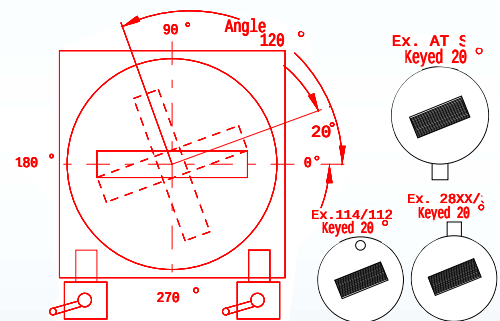
10 Standard Shapes plus Rounds. (RT Rectangles • SQ=Square • OB=Obround • SD=Single-D • DD=Double-D

LOOKING AT TOP OF DIE HOLDERS KEYED 0° & 90°

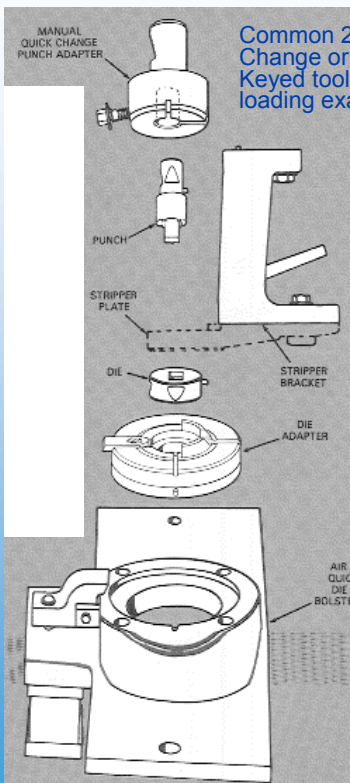
28XX
 &
 36/37TC



Shapes on Angles or Extra Key Locations. Die View



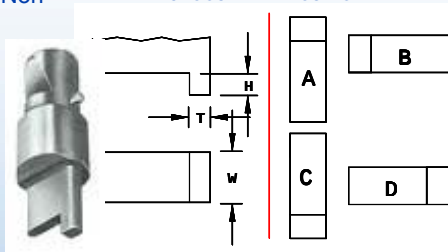
Visualize location key positioned as tool would load into turret. Start with length of shape horizontally. (Length points to 0°)
Next Rotate shape, not location key.
 A sketch accompanying your order ensures keying as required!



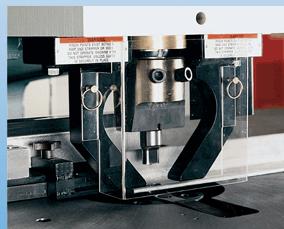
Common 28XX Quick-Change or Roper Non-Keyed tool loading example

HEEL PUNCH DIAGRAM

FACING MACHINE LOOKING DOWN AT DIE, CHOOSE HEEL POSITION



\$75.00 FOR HEEL FROM 1/4 TO 7/16"
 • STANDARD POSITION "A"



SPECIAL SHAPES



SHIPPED IN 1-8 days

Expediting: 3 days 20%, 2 days 35%, 1 day 50%

Guaranteed Expediting Services

FDS=Firm Delivery Service • Order by 2pm
 Same or Next day guarantee—1FDS
 Guaranteed to ship in 2 days – 2FDS

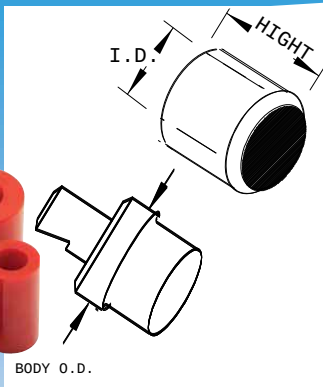
For Tool Styles: AT, AS, ST:

1 day FDS=25% 2 day FDS=10%

For Tool Styles 36tc, 28st, Lila, 92/93

1 day FDS=50% 2 day FDS=25%





28XX & ROPER URETHANE

Punch Flange	Stripper I.D.	Stripper O.D.	Stripper HEIGHT	Stripper CAT.CODE	Stripper PRICE
none	.495	1"	1.25	*AKSS-012114	
none	.99"	2"	1.9"	*AUSO2-281	
1.245"	1.24"	2.5"	2.15"	*AUSO2-282	
1.495"	1.49"	2.5"	2.15"	*AUSO3-283	
1.745"	1.75"	2.5"	2.15"	*AUS23-284	
1.995"	2"	2.75"	2.12"	*AUS24-285	
2.995"	3"	3.75"	2.12"	*ASU29-286	

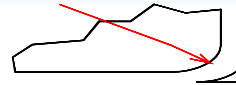
Specials: *AUS__ 3.5"ID X 2-1/8 Height • *AUS__ 4"ID X 2-1/8 Height

Corner ROUNDING TOOLS

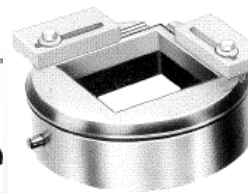
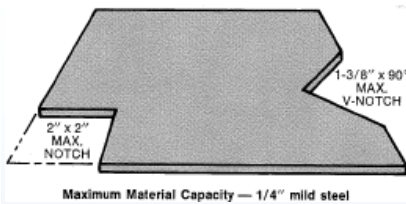
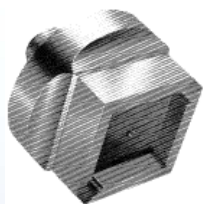
For Single station machine — Stocked dies for use with 22-7 gauge

(add "G" for die gauge, "H" for punch heel or "GH" for gauge & heel to the end of the following part numbers)

RADIUS	DIE O.D.	Roper Part#	28XX Part#	No Die Gauge Punch has heel	Die with Gauge & Heel on Punch
1/8, 3/16, 1/4, 5/16, 3/8, 7/16, 1/2	2-1/8	*SRBPDCR_	*S28BPDCR_		
5/8 & 3/4"	2-3/4	*SRPCPDCR_	*S28CPDCR_		
1" & 1 1/2"	3-3/4	*SRDPDCR_	*S28DPDCR_		
1 1/2 & 2"	4-3/4	*SRPEPDCR_	*S28EPDCR_		



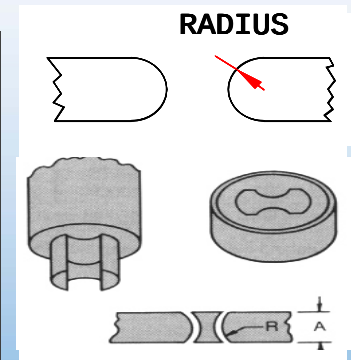
This special punch and die set is especially suitable for making small corner notches. The two adjustable gages permit fast, accurate notching up to 2" x 2" maximum. It can also be used for V-notching up thru 1-3/8" deep x 90°. This set fits into the quick change tooling setup but does require some modification to the die adapter to provide clearance for the adjustable gages.



Punch Part#	4 3/4" O.D. Die W/ Gauging	Die CL.
*A-8004-70630-31142	*A-8003-10630-01902	.006
*A-8001-90630-31144	*A-8002-14630-01904	.012
*A-8001-91630-31146	*A-8001-92630-01906	.021

TRIM & PART / LATTICE

RADIUS	DIE O.D.	Roper Part#	28XX Part#
TO 5/16" • NO GAUGING	2-1/8	*SRPBTP	*S28BTP
TO 5/16" • WITH GAUGING	2-1/8	*SRPBTPG	*S28BTPG
TO 3/8" • NO GAUGING	2-3/4	*SRPCTP	*S28CTP
TO 3/8" • WITH GAUGING	2-3/4	*SRPCTPG	*S28CTPG
TO 5/8" • NO GAUGING	3-3/4	*SRPDTP	*S28DTP
TO 5/8" • WITH GAUGING	3-3/4	*SRPDTPG	*S28DTPG
TO 3/4" • NO GAUGING	4-3/4	*SRPETP	*S28ETP
TO 3/4" • WITH GAUGING	4-3/4	*SRPETPG	*S28ETPG



Center & Alignment Tools

Use: Die holder is loosened to allow free movement. The alignment punch is slowly lowered into the die and from pressure onto die will align and center the die. The die holder is then secured.

Roper Style
B Station #RPB-Align
C Station #RPC-Align
D Station #RPD-Align
E Station #RPE-Align

28XX Style
B Station #28B-Align
C Station #28C-Align
D Station #28D-Align
E Station #28E-Align



Cost for Adding Dowel Pins In Die for
SHEET LOCATION, OR GAUGING +\$75



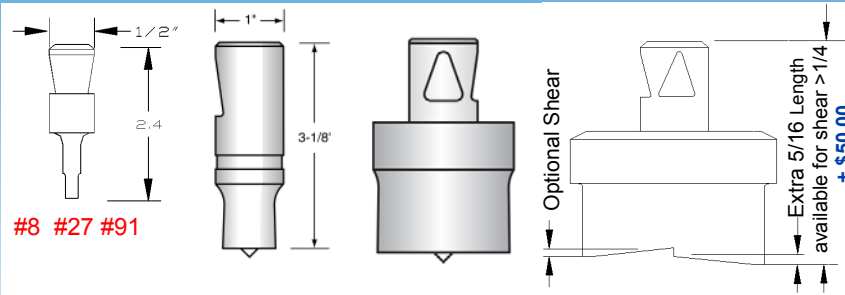


ROPER Style **NON KEYED** **RP**

The Following are similar machine models: *Roper*#127; 129; 130; 150; 230; 231; & 331 power presses
No. 15, 816, 118, 218, 32, 34, 29, 58, 68, 134, Kick & Lever Presses *PEXTO*# 218

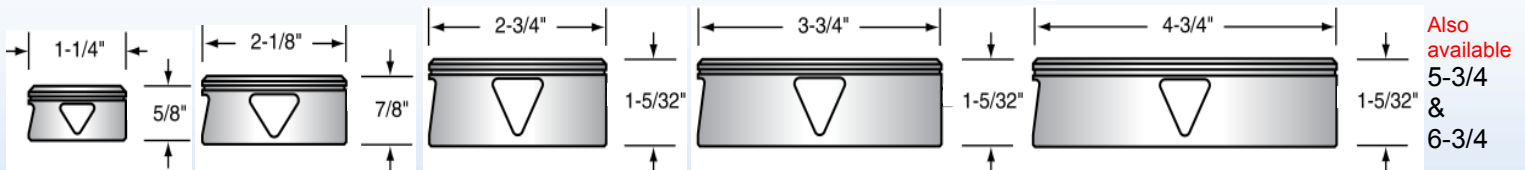
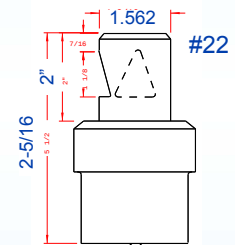
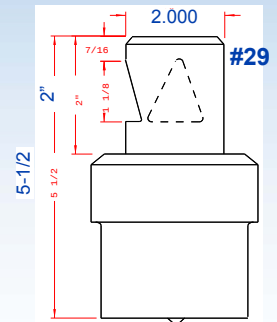
STANDARD PRICING IS FOR PUNCH TIP SIZES .093 (2.3MM) AND ABOVE

A2 TOOL STEEL



#8 #27 #91

STATION	RANGE -	ROUND	PRICE	SHAPE	PRICE
#8 or #27	.093 - 500	RP8PRD		RP8P-shape	
A #28-6301	.093 - 1.000	RPAPRD		RPAP-shape	
B #28-6301	1.001- 1.437	RPBPRD		RPBP-shape	
C #28-6301	1.438 - 2.000	RPCP-r		RPCP-shape	
D #28-6301	2.001 - 3.000	RPDP-r		RPDP-shape	
E #28-6301	3.001 - 4.000	RPEPRD		RPEP-shape	
F #28-6301	4.001 - 5.000	RPFPRD		RPFP-shape	
J #28-6301	5.001 - 6.000	RPFPRD		RPFP-shape	
G #29 2.000 Shank	.093 - 5.000 5.001-6.000	RPG1PRD RPG2PRD		RPG1P-shape RPG2P-shape	
H #22 1.562 Shank	.093 - 5.000 5.001-6.000	RPH1PRD RPH2PRD		RPH1P-shape RPH2P-shape	



Go To Page 2 for list of 10 Standard Shapes, Keying Charts

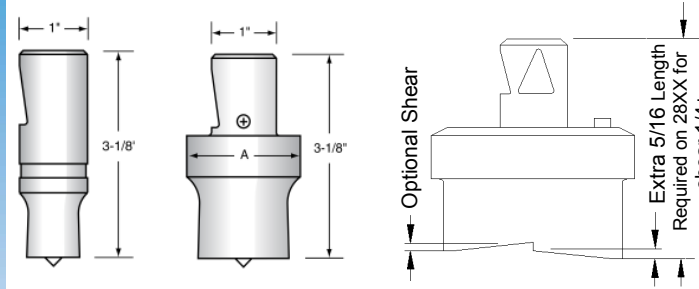
STA. O.D.	RANGE - DIAGONALLY	ROUND	PRICE	SHAPED	PRICE
A #20 1 1/4 x.62	.093 - .762 (.824 max.)	RPADRD		RPAD-shape	
B #40 2 1/8 x.87	.762 - 1.438 (1.465 max.)	RPBDRD		RPBD-shape	
C #28 2 3/4 x1.15	1.439 - 2.000 (2.012 max.)	RPCDRD		RPCD-shape	
D #28 3 3/4 x1.15	2.001 - 3.000 (3.012 max.)	RPDDRDRD		RPDD-shape	
E #28 4 3/4 x1.15	3.001 - 4.000 (4.012 max.)	RPEDRD		RPED-shape	
F #28 5 3/4 x1.15	4.001 - 5.000 (5.012 max.)	RPFDRD		RPFD-shape	
J 6 3/4 x1.15	5.001—6.000 (6.012 max.)	RPJDRD		RPJD-shape	



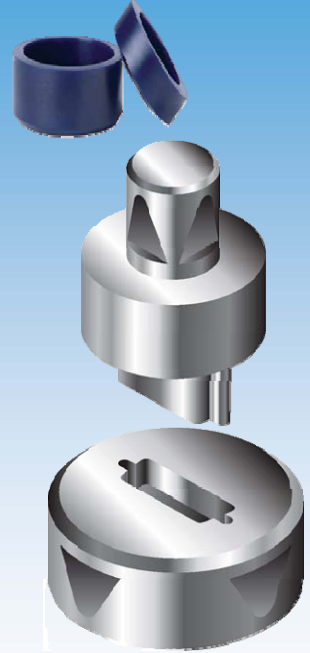
28XX QUICK CHANGE STYLE

STANDARD PRICING IS FOR PUNCH TIP SIZES .093(2.3MM) AND ABOVE

A2 TOOL STEEL

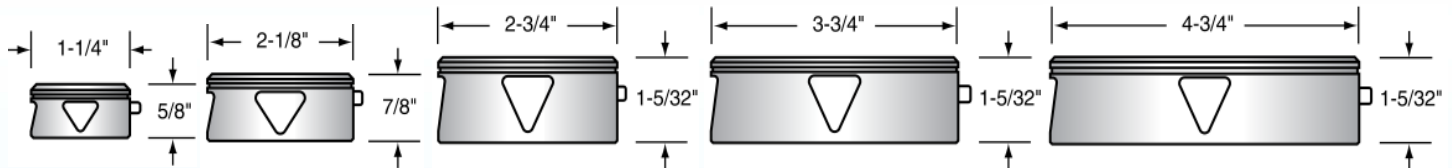


Tips -1" +\$25
1.001-2. \$50 2-3+\$75
3-4+\$100 4+ \$140



PUNCH

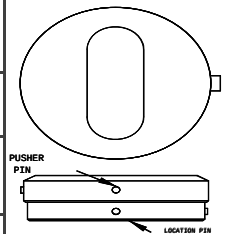
STA.	RANGE - DIAGONALLY	ROUND	PRICE	SHAPE	PRICE
A	.093—1.000	28APRD		28AP-shape	
B	1.001- 1.438	28BPRD		28BP-shape	
C	1.439 - 2.000	28CPRD		28CP-shape	
D	2.001 - 3.000	28DPRD		28DP-shape	
E	3.501 - 4.000	28EPRD		28EP-shape	
F	4.501 - 5.000	28FPRD		28FP-shape	



DIE

STA. O.D.	RANGE -DIAGONALLY	ROUND	PRICE	SHAPE	PRICE
A 1 1/4 x.62	.093 - .762 (.824 max.)	28ADRD		28A D-s	
B 2 1/8 x.87	.763 - 1.438 (1.465 max.)	28BDRD		28B2 D-s	
C 2 3/4 x1.15	1.439 - 2.000 (2.012 max.)	28CDRD		28C D-S	
D 3 3/4 x1.15	2.001 - 3.000 (3.012 max.)	28DDR		28D2 D-s	
E 4 3/4 x1.15	3.001 - 4.000 (4.012 max.)	28EDRD		28E2 D-s	
F 5 3/4 x1.85	4.501 - 5.000 (5.012 max.)	28FDRD		28F2 D-s	

F 5 3/4 x1.85

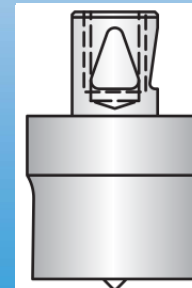


For extra pins
at 45° increments
add 50%

Sorry, we only add extra
pins at 45° increments.
For other angles, order a
separate tool Keyed at
angle desired.

SHAPES ON ANGLES

Tip Size	15° INCREMENTS		OTHER THAN 15°	
	PUNCH +	DIE +	PUNCH +	DIE +
Up to .750" A sta.				
.750-1.438 B sta.				
1.439-3.0" C & D sta.				
3.001-5.0" E & F sta.				



Heavy Duty
Punches
+ Thread
in Shank.
1/2-13
Standard
7/16-14
Optional
+

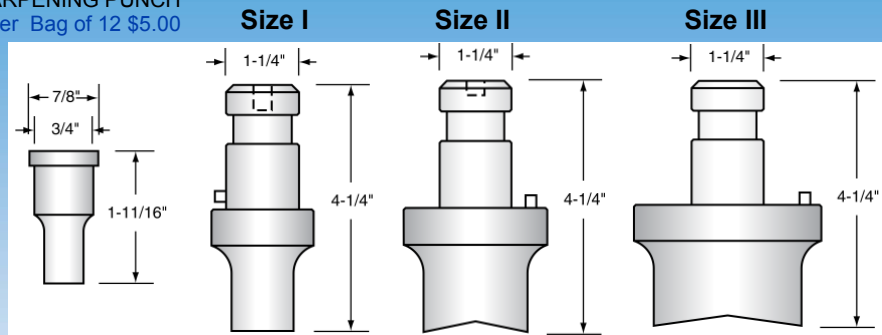


Whitney 36TC Style Tools (36)

For Models: 647PLUS, 647PLUS II, (Max. hole=3") • 661 -60, -84, -84ATC, -120 • 647ATC, 3500ATC-30, 3600ATC, 3700ATC

S7 TOOL STEEL
Superior Shock Proof

ADD SPACES AFTER SHARPENING PUNCH
*A36-Pspacer Bag of 12 \$5.00

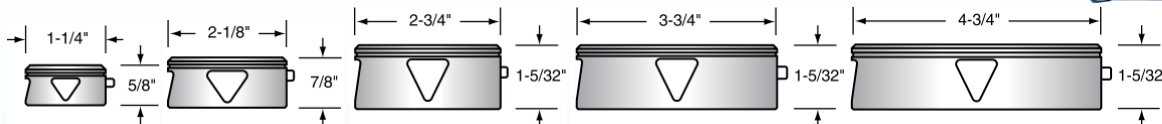


MAXIMUM CAPACITY	Part# Round	ROUND \$	Part# Shape	SHAPE \$
INSERT 3101 .093-.75"	36-0-PI -r			
INSERT 3103-HSS .093-.75	36-0-PIM-r			
Size I .093-1.250	36-1a-P-r		36-1a-P-s	
Size I 1.251-1.719	36-1b-P-r		36-1b-P-s	
Size II 1.720-2.469	36-2-P-r		36-2-P-s	
Size III 2.470-4.00	36-3a-P-r		36-3a-P-s	
Size III 4.001-5.00	36-3b-P-r		36-3b-P-s	

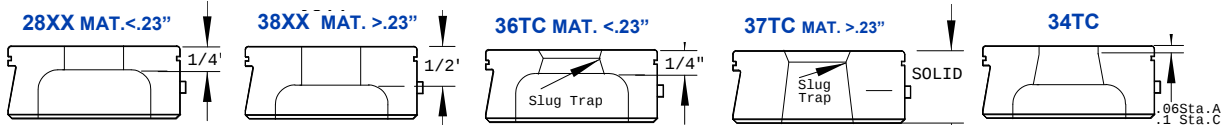
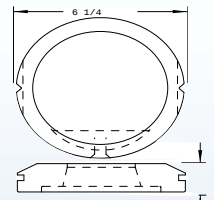
Standard N/C SHEAR
Size II = 1/4" III = 7/16"
Inverted/Concave or Roof Top



Punch Insert CHUCK
Part# 36-0Hr \$283.55
ref.# 8084-79360-15000



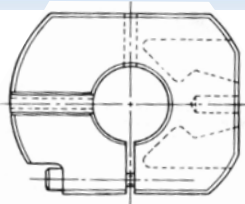
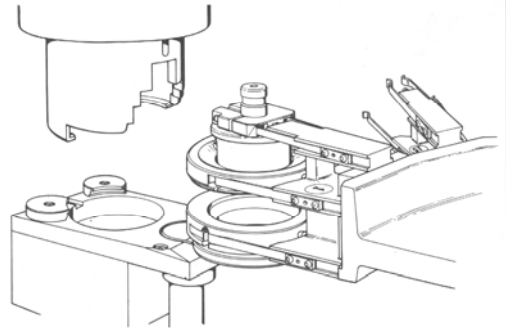
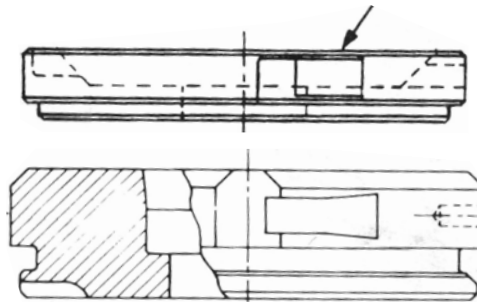
Go To Page 2 for list of 10 Standard Shapes, Keying Charts



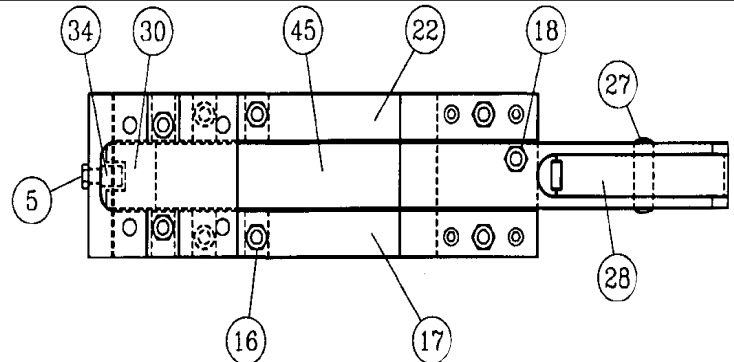
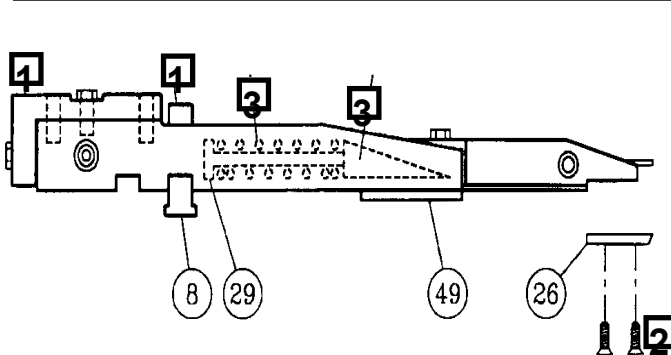
Sta. O.D.	CAPACITY	STYLE CODE.	ROUND MATT <.23	STYLE CODE	ROUND MATT >.23	STYLE CODE	SHAPED
A 1-1/4	.093 - .824	36TC 36AD-r		37TC 37AD-r	\$30.00	28XX 28AD-s	
		28XX 28AD-r		38XX 38AD-r	\$17.15	34TC 34AD-s	
		34TC 34AD-r				38XX 38AD-s	
B 2-1/8	.751 - 1.465	36TC 36BD-r		37TC 37BD-r	\$44.95	28XX 28B2D-s	
		28XX 28B2D-r		38XX 38BD-r	\$27.85	34TC 34BD-s	
		34TC 34BD-r				38XX 38BD-s	
C 2-3/4	1.439 - 2.012	28XX 28CD-r		38XX 38CD-r	\$51.40	28XX 28CD-s	
		36TC 36CD-r		34TC 34CD-r	\$67.45	34TC 34CD-s	
D 3-3/4	2.001 - 3.012	28XX 28D2D-r		38XX 38DD-r	\$69.55	28XX 28D2D-s	
		36TC 36DD-r		34TC 37DD-r	\$87.75	34TC 34DD-s	
E 4-3/4	3.001 - 4.012	28XX 28E2D-r		38XX 38ED-r	\$96.30	28XX 28E2D-s	
		36TC 36ED-r		37TC 37ED-r	\$112.35	34TC 34ED-s	
F 6-1/4	4.013-5.037	36TC 36FD-r		NOT RECOMMENDED		36TC 36FDs	

WHITNEY 36/37TC STRIPPERS & DIE ADAPTERS ↓

DESCRIPTION: LAST 6 DIGITS of C.E. Code = Whitney own Code	647 PLUS & 647+II PART # PRICE	661-60,-84,-84ATC,-120 PART NO. PRICE	647ATC•3500ATC-30• 3600ATC •3700ATC PART NO. PRICE
Punch Alignment Ring	36AL-641-110	36AL-641-339 3+<10% 6+<20%	36AL-661-339 3+<10% 6+<20%
STRIPPER 1.000 I.D.	36S-641-234 3+<10% 6+<20%	36S-661-934 3+<10% 6+<20%	36S-661-934 3+<10% 6+<20%
STRIPPER 1.875 I.D.	36S-641-235 3+<10% 6+<20%	36S-640-790 3+<10% 6+<20%	36S-661-790 3+<10% 6+<20%
STRIPPER 2.625 I.D.	36S-641-236 3+<10% 6+<20%	36S-640-791 3+<10% 6+<20%	36S-661-791 3+<10% 6+<20%
STRIPPER 3.125 I.D.	36S-641-535 3+<10% 6+<20%	NOT STANDARD	NOT STANDARD
STRIPPER 3.625 I.D.	36S-641-237 3+<10% 6+<20%	36S-640-792 3+<10% 6+<20%	36S-661-792 3+<10% 6+<20%
STRIPPER 4.125 I.D.		36S-640-792 3+<10% 6+<20%	36S-640-793 3+<10% 6+<20%
STRIPPER 5.125 I.D.		36S-662-906 3+<10% 6+<20%	36S-662-906 3+<10% 6+<20%
DIE Adapter 1.250 O.D.	36ADAD-641-226 3+<10% 6+<20%	36ADAD-661-334 3+<10% 6+<20%	36ADAD-661-334 3+<10% 6+<20%
DIE Adapter 2.125 O.D.	36BDAD-641-227 3+<10% 6+<20%	36BDAD-661-335 3+<10% 6+<20%	36BDAD-661-335 3+<10% 6+<20%
DIE Adapter 2.750 O.D.	36CDAD-641-228 3+<10% 6+<20%	36CDAD-661-336 3+<10% 6+<20%	36CDAD-661-336 3+<10% 6+<20%
DIE Adapter 3.750 O.D.	36DDAD-641-229 3+<10% 6+<20%	36DDAD-661-337 3+<10% 6+<20%	36DDAD-661-337 3+<10% 6+<20%
DIE Adapter 4.750 O.D.	No 4.750 STA. ON THESE MODELS	36EDAD-661-338 3+<10% 6+<20%	36EDAD-661-338 3+<10% 6+<20%

Punch Alignment Ring
661-339**CLAMPS: WHITNEY 647-927, 630-006**

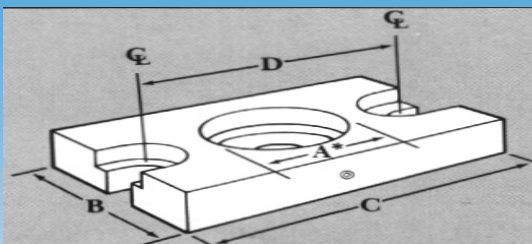
Dwg	Part	DESCRIPTION	Price	Dwg	Part	DESCRIPTION	Price
00	*AMH2WCO	Complete Assembly		26	*AMH2WLJ	Removable Lower Jaw/	
05	*AMH2WCP-05	Screw, BHCS		28	*AMH2WUJ	Clamp/ Top	
08	*AMH2WCP-08	Key/ T-Slot		29	*AMH2WCP-29S	Piston / Shaft	
17	*AMH2WCP-17	Guide /Right		30	*AMH2WCP-29EC	End Cap / Only DMC Unit	
18	*AMH2WCP-18	Spring /Nut Assembly		31	*AMH2WCP-RS	Spring/Piston/Only DMC	
19	*AMH2WCP-19	Clevis Mounting Plate		33	*AMH2WCP-33	Wedge	
22	*AMH2WCP-22	Guide /Left		44	*AMH2WCP-34	Clevis	
25	*AHSFS0516	Spring /Nut Assembly		45	*AMH2WPA	Clamp Bottom / Cyl. Assembly	
				49	*AMH2WCP-49	Plate / Tie	

**Other Whitney clamp parts**

CE Part#	Whitney#	Description	price
Below for models 3500, 3600 & 3700 machines			
*AMH645-606	645-606	Upper Grip Insert	

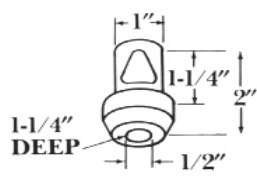


HOLDERS

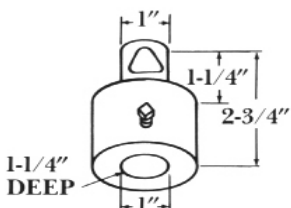


DIE SHOES				No Keyed	Keyed
"A"	B	C	D	Part#	Part#
2-1/8	3	7	5	RPBDHS	28BDHS
2 3/4	4	8	6	RPCDHS	28CDHS
3 3/4	5	9	7	RPDDHS	28DDHS
4 3/4	6	10	8	RPEDHS	28EDHS

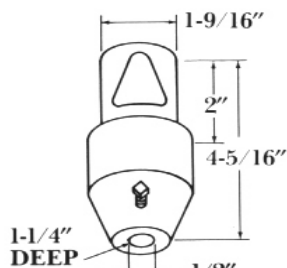
Call
For
Pricing



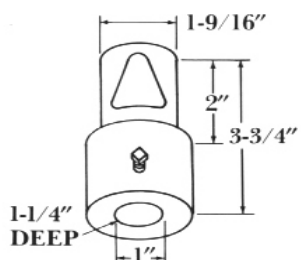
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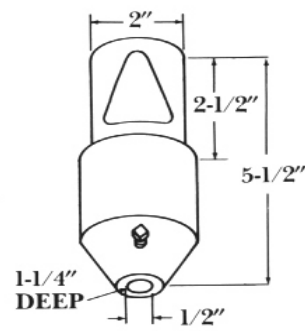
PH-11



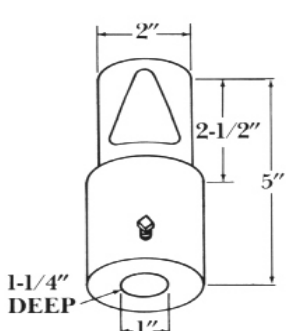
PH-95



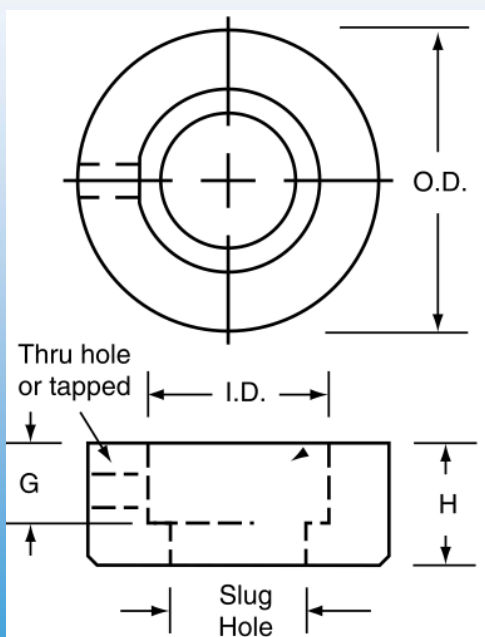
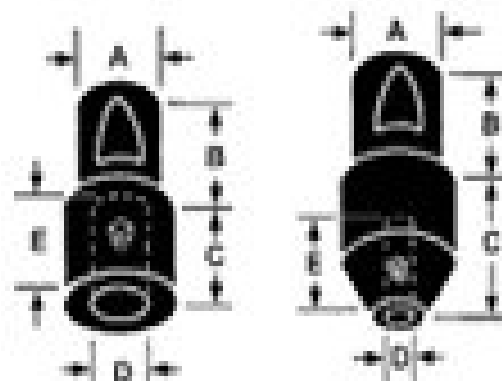
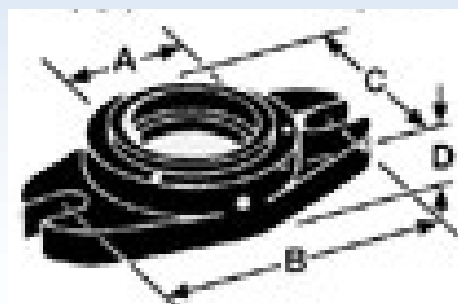
PH-91



PH-25



PH-21



Die Adapter		No Key		Keyed	
I.D.	O.D.	Part#	\$	Part#	\$
1-1/4	2-1/8	RPBADA		28BADA	
1-1/4	2-3/4	RPCADA		28CADA	
2-1/8	2-3/4	RPCBDA		28CBDA	
1-1/4	3-3/4	RPDADA		28DADA	
2 1/8	3-3/4	RPDBDA		28DBDA	
2 3/4	3-3/4	RPDCDA		28DCDA	
3 3/4	4-3/4	RPEDDA		28EDDA	



OPTIONAL PUNCH SHEARS

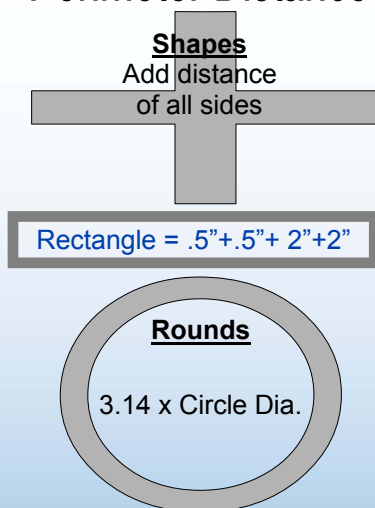
SHEARS Should be Considered for **All DIAGONAL DIMENSIONS** Over 2"/50.8mm
And a Minimum Width of .375(9.53MM)

Roof Top *ARTS Up to 1/8 1/4 7/16	Inverted *AIS	Concave *ACS Up to 1/8 1/4 7/16	Double Inverted *ADIS	Whisper (1-Way) *AWS	Spiracle *ASPS
Best all purpose shear for reducing tonnage requirement. Nibbling must be performed at 75% of punch size to avoid side loading.	An all purpose shear. Ideal for nibbling.	An all purpose shear. Ideal for nibbling. Used over Inverted Shear when punching heavy plate.	Best Shear for slotting tools, 3" or longer in length.	Reduces tonnage requirements while reducing slug deformation. Requires a very Ridged Press.	Ideal for rounds or squares < 1.18 30.m. Lessens tool side loading

Finding Tonnage Required

Does your press have the tonnage to pierce thick or tough material? Use this formula and below Shear Tonnage Reduction chart to find out.

Perimeter Distance



TONS PER SQUARE INCH

Use below chart, find the Tons per square inch for material you will punching.

Type of Material	Tons per Sq.	Shear Strength
Aluminum (1/2 hard	9.5	19,000 PSI
Brass (1/2 hard sheet)	17.5	35,000 PSI
Copper (rolled)	14.0	20,000 PSI
Steel, mild	25.0	50,000 PSI
Steel, ASTM-A#6	30.0	60,000 PSI
Steel, 50 carbon	35.0	70,000 PSI
Steel, cold drawn	30.0	60,000 PSI
Steel, stainless (18-8)	35.0	70,000 PSI

FORMULA

Multiply
Perimeter x Tons
x Material Thickness

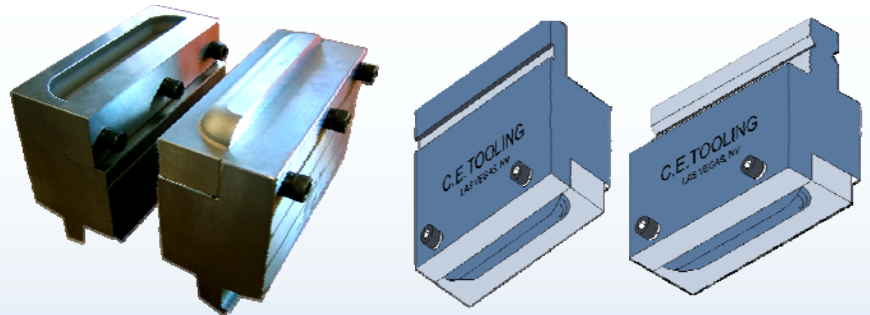
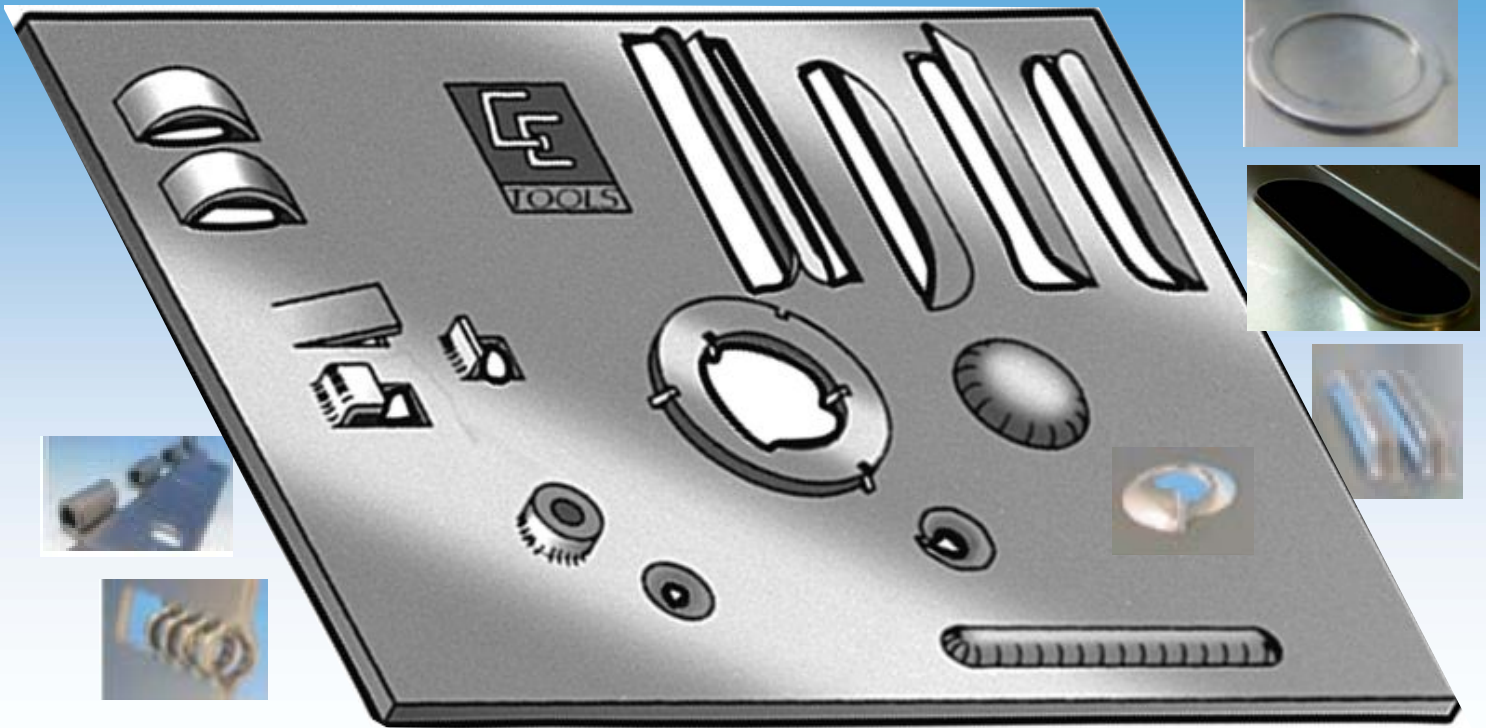
The answer to this formula is the required Tonnage

Tonnage Reduction Chart When Shear is Used. Use the Formula above to find the tonnage required with no shear. Next, multiply that by the value found in this chart.

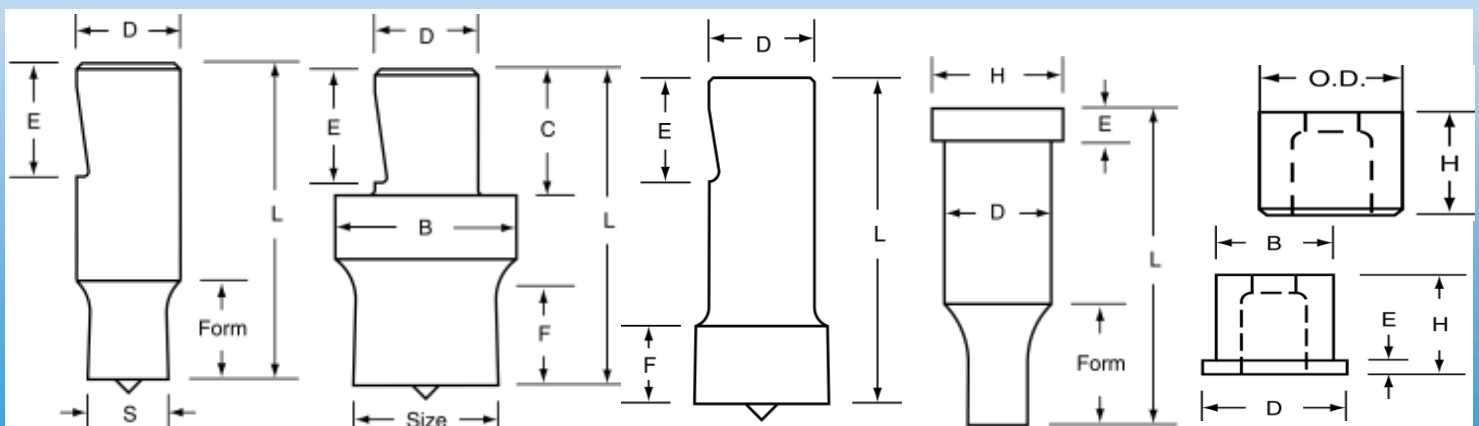
Shear Depth	16 Gage .060" 1,5mm	14 Gage .075" 1,9mm	12 Gage .105" 2,7mm	10 Gage .135" 3,4mm	8 Gage .165" 4,2mm	3/16 Gage .187" 4,8mm	1/4 Gage .250" 6,4mm	5/16 Gage .312" 7,9mm	3/8 Gage .375" 9,5mm
1/16	.5	.58	.72	.78	.83	.86	.90		
3/32		.50	.56	.67	.73	.78	.83	.87	.90
1/8		.46	.51	.56	.62	.63	.74	.85	.95
1/4				.40	.46	.49	.54	.62	.70
7/16				.25	.28	.31	.36	.41	.48



CE TOOLING SPECIAL APPLICATION FORMING TOOLS
HIGHER PRODUCTIVITY THROUGH SUPERIOR ENGINEERING



Custom Punches & Die Diagrams





Replaceable Insert CHARACTER

DEDICATED MARKING UNITS Produced to stamp Logo's, Names, Part No., etc.. Contact our tooling engineers to discuss your particular application. Cad-.DXF/.IGES files are ideal for Logo's.

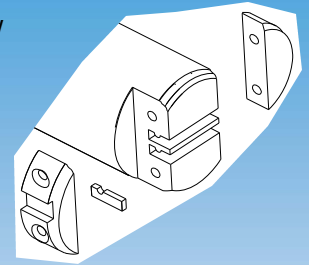
Available 1/16, 1/8, & 3/16 width X ¼ height. 1/8 is standard • Blanks/ Spacers cost = 50% of regular character price

1/8 *ACHAR 1/8 stamps .09X.15 1/16 *ACHAR 1/16 stamps .06X.12" • 5/32 *ACHAR 5/32 stamps .125"X.19, 3/16 *ACHAR 3/16 stamps .156X.23

Spacer Kit *ASPACER includes widths of: 6 each 1/16, 1/8 & 2 Pcs of 3/16

Lengths: CE & Amada Standard Character Length=.875" WT=.750"

(WT old styl length=.572" +\$3.50ea. Insert)



Shear Proof Punches

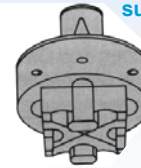
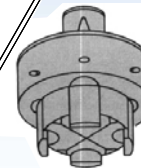
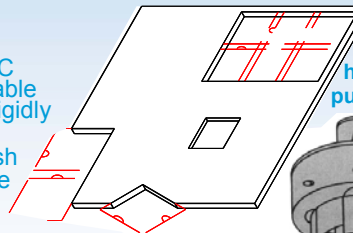
DESCRIPTION	CAT CODE	Round	Shape
1" OR 25MM	28CSP-*		
2" OR 50MM	28DSP-*		

Unique Design: The heel portion of our Shear Proofs are CNC Wire EDM'ed to produce 2 locating flat sides which the retractable heels are fitted to. With this design, the retractable heels are rigidly supported throughout the entire length of the punch tip.

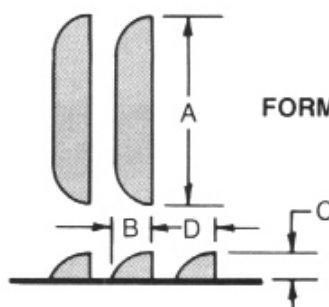
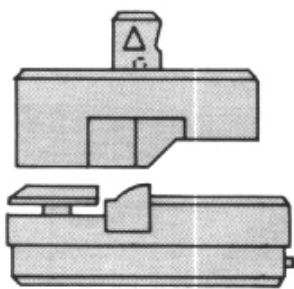
Maintenance: Depress the retractable heels until they are flush to the top of punch face. Lock the heels in this position with the set screws provided in the body of the punch. Know sharpen the punch just as you would a standard punch.

SHEAR PROOFS are designed for applications such as Notching or Nibbling where side loading of tools occurs.

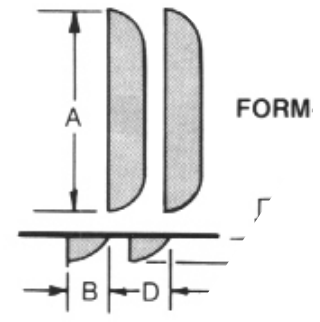
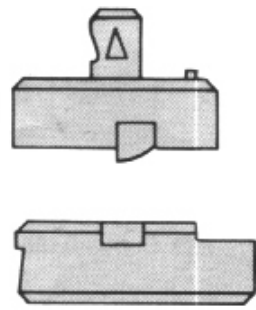
Square or Round Shear Proofs help prevent side loading through the use of Retractable Heels. One of more heels enter into the die before the actual punching occurs. This gives ridged support and helps the tool line up through out the stroke of the press.



LOUVER & CARD GUIDE TOOLS



FORM-UP



FORM

FORM UP

Sta.	Part No.	Max. A	"B"	"C"	"D"	SET Price	Form Insert Only	Cut Insert Only
C 2-3/4	Roper Style =*FRPCFUL2 28XX Style = *F28CFUL2	2"	1/2"	3/16"	5/8"		Roper Style =*FRPCFUL2 28XX Style = *F28CFUL2	Roper Style =*FRPCFUC2 28XX Style = *F28CFUC2
D 3-3/4	Roper Style =*FRPDFUL3 28XX Style = *F28DFUL3	3"	1/2"	1/4"	3/4"		Roper Style =*FRPDFUL3 28XX Style = *F28DFUL3	Roper Style =*FRPDFUC3 28XX Style = *F28DFUC3
E 4-3/4	Roper Style =*FRPEFUL4 28XX Style = *F28EFUL4	4"	3/4"	1/4"	15/16"		Roper Style =*FRPEFUL4 28XX Style = *F28EFUL4	Roper Style =*FRPEFUC4 28XX Style = *F28EFUC4
F 5-3/4	Roper Style =*FRPFFUL_ 28XX Style = *F28FFUL_	5" 6"	3/4"	5/16"	1-1/8"		Roper Style =*FRPFFUL_ 28XX Style = *F28FFUL_	Roper Style =*FRPFFUC_ 28XX Style = *F28FFUC_

FORM DOWN

Sta.	Part No.	Max. A Length	Common "B"	Common "C"	Common "D"	SET Price	Form Insert Only
C 2-3/4	Roper Style =*FRPCFDL2 28XX Style = *F28CFDL2	2"	1/2"	3/16"	5/8"		Roper Style =*FRPCFDLI2 28XX Style = *F28CFDLI2
D 3-3/4	Roper Style =*FRPDFDL3 28XX Style = *F28DFDL3	3"	1/2"	3/16"	3/4"		Roper Style =*FRPDFDLI3 28XX Style = *F28DFDLI3
E 4-3/4	Roper Style =*FRPEFDL4 28XX Style = *F28EFDL4	4"	5/8"	1/4"	15/16"		Roper Style =*FRPEFDLI4 28XX Style = *F28EFDLI4
F 5-3/4	Roper Style =*FRPFFDL_ 28XX Style = *F28FFDLI_	5" 6"	3/4"	1/4"	1-1/8"		Roper Style =*FRPFFDLI_ 28XX Style = *F28FFDLI_

FABRICATING TOOLS
and Accessories for most
Punching, Bending and
Shearing Equipment



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