

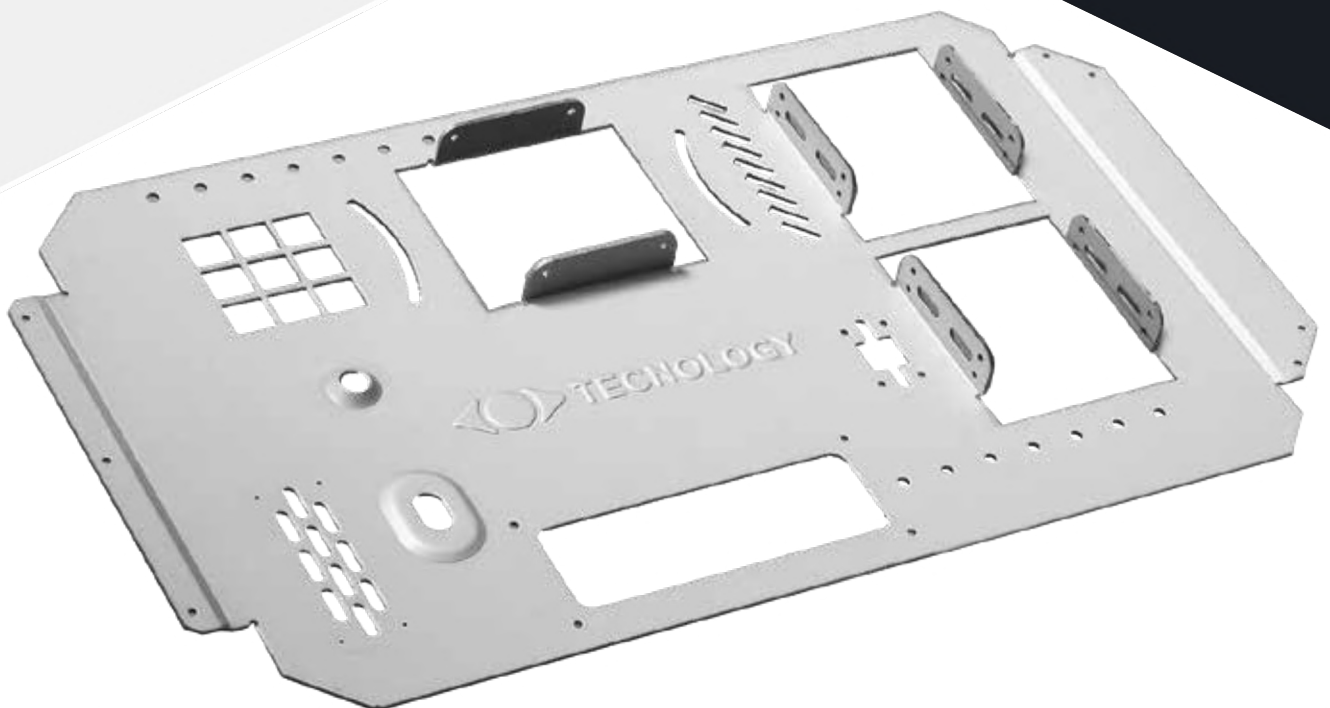


Created With Love

TOOLS

TECHNOLOGY Style

Punching tools



January 2019

EN

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OUR TECHNICAL OFFICE IS AVAILABLE FOR THE STUDY AND REALIZATION OF SPECIAL TOOLS (IE FORMING, MARKS, LOGOS, MULTIPLES, TRIANGLES) NOT INCLUDED IN THE CATALOG.

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1. NUMEROUS DISCOUNTS
2. FIND OUT IN FEW SECONDS SPARE PARTS AND TOOL
3. SAVE YOUR TIME AND YOU CAN PAY BY BANK TRANSFER, CREDIT CARD AND PAYPAL

MAINTENANCE OF TOOLS AND ACCESSORIES

With use, the punches and the dies wear out and must be periodically re-sharpened.
The life of the tools depends on different factors such as:

For a longer duration, it is therefore important to sharpen the tools at the right time, ie when the radius of the corner does not exceed 0.1 mm.

It is to underline the fact that the rounding of the edges is not proportional to the number of strokes carried out, but in the absence of sharpening the problem degenerates; the punch and the dies are consumed more quickly.

In the presence of non-sharp tools increase the power required for punching and burr on the machined parts.

Method of Sharpening Punches and Dies

The punches and the dies must be sharpened with suitable machines, in the presence of abundant coolant and with the use of abrasive grinding wheels suitable for tool steels.

For a correct sharpening it is correct to remove a quantity of material between 0.1 and 0.2 mm proceeding with a centesimal removal.

Periodic inspections

It is advisable to check the absence of clearance between the sliding members and, if necessary, to intervene by replacing the worn elements such as plugs or guide keys.

Check the good condition of the anti-friction rubbers on the punches.

Make the replacement of the extraction springs particularly stressed or used because fatigue failure is possible.

If the cup springs are compressed more than necessary they can break.

Lubrication and Cleaning

It is advisable to keep the punches, guides and relative housings well oiled in order to facilitate sliding during processing.

In particular, in the presence of plates encrusted with calamine or in the case of galvanized sheet, frequently perform the cleaning of the tools to prevent impurities from entering the sliding members creating a risk of seizures.

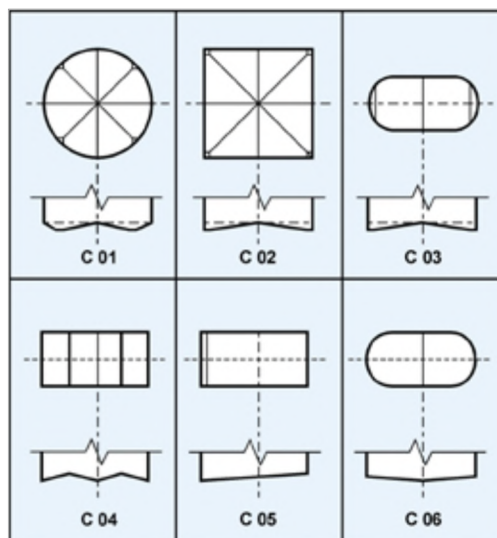
Recommended lubricants:

Oil ESSO TERESSO 32, SHELL TELLUS C32 o equivalenti.

The same care must be taken in the assembly / disassembly and tool storage operations in order to avoid damage such as scratches and dents.

For this purpose a series of drawers and a work table are available.

WHISPER



TONNAGE CALCULATION

The punching tonnage is calculated using the following formula:

$$\frac{\text{Cutting perimeter length (mm)} \times \text{Material thickness (mm)} \times \text{Resistance Cutting (kg/mm}^2\text{)}}{1000}$$

Example:

Rectangle 80 x 5 di Mild steel 1,5mm

$$\text{Necessary tonnage} = \frac{(80+80+5+5) \times (1,5) \times (40)}{1000}$$

Necessary tonnage = 10,2 tonnage

Resistenza al Taglio

MATERIAL TYPE	RESISTANCE TO CUTTING KG/mm ²
Mild Steel	40
Aluminum	30
Stainless Steel	60

Minimum hole diameter

As a general indication, the following on shows the minimum diameter of a punched hole in relation to the thickness of the material.

t = material thickness

MATERIAL TYPE	MINIMUM HOLE DIAMETER
Acciaio Dolce	1,0 x t
Alluminio	1,0 x t
Acciaio Inox	2,0 x t

It is possible to punch smaller strokes, for this reason contact our Technical Office.

DIE CLEARANCE CALCULATION

The table below shows the recommended die clearance for a range of materials and thicknesses.

MATERIAL THICKNESS	MILD STEEL	STAINLESS STEEL	ALUMINUM	COPPER	BRASS
0,8 mm	0,15 - 0,20	0,20 - 0,24	0,15 - 0,16	0,15 - 0,16	0,15 - 0,16
1,0 mm	0,20 - 0,25	0,25 - 0,30	0,15 - 0,20	0,15 - 0,20	0,15 - 0,20
1,5 mm	0,30 - 0,38	0,37 - 0,45	0,22 - 0,30	0,22 - 0,30	0,22 - 0,30
2,0 mm	0,40 - 0,50	0,50 - 0,60	0,30 - 0,40	0,30 - 0,40	0,30 - 0,40
2,5 mm	0,50 - 0,60	0,62 - 0,75	0,37 - 0,50	0,37 - 0,50	0,37 - 0,50
3,0 mm	0,60 - 0,75	0,75 - 0,90	0,45 - 0,60	0,45 - 0,60	0,45 - 0,60
4,0 mm	0,80 - 1,00	1,13 - 1,35	0,60 - 0,80	0,60 - 0,80	0,60 - 0,80
5,0 mm	1,00 - 1,25		0,75 - 1,00	0,75 - 1,00	0,75 - 1,00
6,0 mm	1,2 - 1,50		0,90 - 1,20	0,90 - 1,20	0,90 - 1,20

Note:

a) The values in the table above are given as the field of application for example 0.15 - 0.20 mm.

For mechanical machines, choose the smaller die clearance.

b) The values above are indicative. For more details, refer to the Punching Machine Operator's Manual.

15 SERIES TOOLS

15mm maximum punch size

Punch



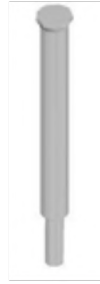
Punch Guide



Die



Punch



Reduction



Punch Guide



Die



For single station or Multi-tool

Round from 1,6mm to 15mm

DESCRIPTION	CODE
HSS Punch	914113
HSS Punch With Metallic Ejector*	914113EM
HSS Punch Guide	914311
HWS Die	914211

Square

DESCRIPTION	CODE
HSS Punch	914123
HSS Punch With Metallic Ejector*	914123EM
HSS Punch Guide	914321
HWS Die	914221

Rectangle

DESCRIPTION	CODE
HSS Punch	914143
HSS Punch With Metallic Ejector*	914143EM
HSS Punch Guide	914341
HWS Die	914241

Oblong

DESCRIPTION	CODE
HSS Punch	914133
HSS Punch With Metallic Ejector*	914133EM
HSS Punch Guide	914331
HWS Die	914231

Standard shape

DESCRIPTION	CODE
HSS Punch	914163
HSS Punch With Metallic Ejector*	914163EM
HSS Punch Guide	914361
HWS Die	914261

Only single station

Reduced Round Punch from 1mm to 7,5mm

DESCRIPTION	CODE
HSS Reduced Punch	911113
HSS Punch Holder (Reduced)	914511
HSS Punch Guide	914311
HWS Die	914211



*The metal ejector is present only from diameter or side from 6mm to 15mm

TICN Coating

To be requested when ordering, the TICN coating provides an higher price as in the table here below

DESCRIPTION
Punch from 1,6mm o 15mm
Reduced punch from 1mm to 7,5mm

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15 SERIES HOLDERS

SINGLE PUNCH- ALL MACHINES MODELS EXCEPT FOR TECNUMERIK



Holder

DESCRIPTION	CODE
Complete Holder	71.3.1.000.0000
Punch Holder	91.1.1.200.0000
Die Holder	71.1.1.500.0000

Spare parts

DESCRIPTION	CODE
Adapter Plate	71.0.1.100.0000
Stripper Unit	91.2.1.400.0000

MULTITOOL - ALL MACHINES MODELS EXCEPT FOR TECNUMERIK



Holder

DESCRIPTION	CODE
Complete Multi-tool	78.1.1.750.0000

Inside Multi-tool can not be used reduced round tools
but only tools with stew Ø15

Spare parts

DESCRIPTION	CODE
Spring	78.1.1.752.0000
Stripper Unit	78.2.1.400.0000

SINGLE PUNCH- ONLY FOR TECNUMERIK



Holder

DESCRIPTION	CODE
Complete Die	91.3.1.000.0000
Punch Holder	91.1.1.200.0000
Punch Die	91.1.1.500.0000

Spare parts

DESCRIPTION	CODE
Adapter Plate	91.0.1.100.0000
Stripper Unit	91.2.1.400.0000

MULTITOOL - ONLY FOR TECNUMERIK



Holder

DESCRIPTION	CODE
Complete Multitool	98.1.1.750.0000

Inside Multi-tool can not be used reduced round tools
but only tools with stew Ø15

Spare parts

DESCRIPTION	CODE
Spring	78.1.1.752.0000
Stripper unit	78.2.1.400.0000

35 SERIES TOOLS

35mm Maximum Punch Size

Punch



Punch Guide



Die



Only for Multi-tool



Round

DESCRIPTION	CODE
HSS Punch	974113
Punch Guide	974313
HWS Die	974213

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Square

DESCRIPTION	CODE
HSS Punch	974123
Punch Guide	974321
HWS Die	974223



Rectangle

DESCRIPTION	CODE
HSS Punch	974143
Punch Guide	974341
HWS Die	974243



Oblong

DESCRIPTION	CODE
HSS Punch	974133
Punch Guide	974331
HWS Die	974323



Standard shape



DESCRIPTION	CODE
HSS Punch	974163
Guida punzone	974361
Matrice HWS	974263



35 SERIES TOOLS - ALL MACHINES MODELS EXCEPT FOR TECNUMERIK



Holder

DESCRIPTION	CODE
Complete Multitool	78.1.1.350.0000

Spare parts

DESCRIPTION	CODE
Stripper unit	78.2.1.350.0000

26-40 SERIES TOOLS

40mm Maximum Punch Size

Punch
with stem Diam. 40



Punch
with stem Diam. 26



Punch Guide



Die



Round

	SERIES 26	SERIES 40
DESCRIPTION	CODE	CODE
HSS Punch	922113	924113
HSS Punch with metallic ejector*	922113EM	924113EM
HSS Punch guide	922311	924311
HSS Punch whisper	922315	924315
HSS Whisper punch guide	922312	924312
HWS Die	922211	924211

Square

	SERIES 26	SERIES 40
DESCRIPTION	CODE	CODE
HSS Punch	922123	924123
HSS Punch with metallic ejector*	922123EM	924123EM
HSS Punch guide	922321	924321
HSS Punch whisper	922325	924325
HSS Whisper punch guide	922322	924322
HWS Die	922221	924221

Rectangle

	SERIES 26	SERIES 40
DESCRIPTION	CODE	CODE
HSS Punch	922143	924143
HSS Punch with metallic ejector*	922143EM	924143EM
HSS Punch guide	922341	924341
HSS Punch whisper	922345	924345
HSS Whisper punch guide	922342	924342
HWS Die	922241	924241

Oblong

	SERIES 26	SERIES 40
DESCRIPTION	CODE	CODE
HSS Punch	922133	924133
HSS Punch with metallic ejector*	922133EM	924133EM
HSS Punch guide	922331	924331
HSS Punch whisper	922335	924335
HSS Whisper punch guide	922332	924332
HWS Die	922231	924231

Standard Shape

	SERIES 26	SERIES 40
DESCRIPTION	CODE	CODE
HSS Punch	922163	924163
HSS Punch with metallic ejector*	922163EM	924163EM
HSS Punch guide	922361	924361
HSS Punch whisper	922365	924365
HSS Whisper punch guide	922362	924362
HWS Die	922261	924261

TICN Coating

To be requested when ordering, the TICN coating provides an higher price as in the table here below

DESCRIPTION

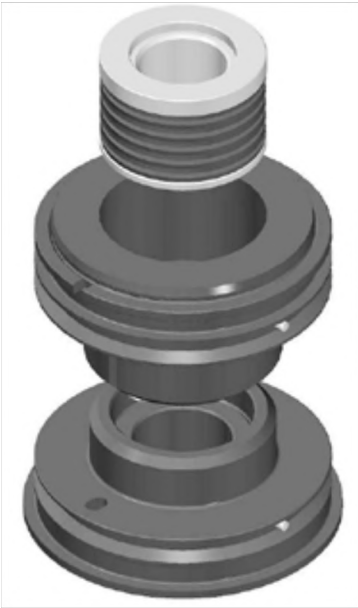
Punch from 15,1mm to 26mm

Punch from 26,1mm o 40mm

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26-40SERIES HOLDERS

SINGLE PUNCH - ALL MACHINES MODELS EXCEPT FOR TECNUMERIK



Holder

DESCRIPTION	CODE
Complete Holder	72.3.1.000.0000
Punch Holder	72.1.1.200.0000
Die Holder	72.1.1.500.0000

Spare parts

DESCRIPTION	CODE
Stripper Unit 40	92.2.1.400.2640
Stripper Unit 26	92.2.1.400.1625
Spring	92.2.1.430.0000

SINGLE PUNCH - ONLY FOR TECNUMERIK



Holder

DESCRIPTION	CODE
Complete Holder	92.3.1.001.0000
Punch Holder	92.1.1.200.0000
Die Holder	92.1.1.500.0000

Spare parts

DESCRIPTION	CODE
Stripper Unit 40	92.2.1.400.2640
Stripper Unit 26	92.2.1.400.1625
Spring	92.2.1.430.0000

70 SERIES TOOLS

70mm Maximum Punch Size

Punch



Stripper



Die



Round

DESCRIPTION	CODE
HSS flat Punch	934113
Stripper for flat punch	934411
HSS whisper punch	934115
Stripper for whisper punch	934312
HWS Die	934211

TICN Coating

To be requested when ordering, the TICN coating provides an higher price as in the table here below

DESCRIPTION

Punch from 40,1mm to 70mm



Square

DESCRIPTION	CODE
HSS flat Punch	934123
Stripper for flat punch	934421
HSS whisper punch	934125
Stripper for whisper punch	934322
HWS Die	934221

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Rectangle

DESCRIPTION	CODE
HSS flat Punch	934143
Stripper for flat punch	934441
HSS whisper punch	934145
Stripper for whisper punch	934342
HWS Die	934241



Oblong

DESCRIPTION	CODE
HSS flat Punch	934133
Stripper for flat punch	934431
HSS whisper punch	934135
Stripper for whisper punch	934332
HWS Die	934231



Standard Shape

DESCRIPTION	CODE
HSS flat Punch	934163
Stripper for flat punch	934461
HSS whisper punch	934165
Stripper for whisper punch	934362
HWS Die	934261



70 SERIES HOLDERS

SINGLE PUNCH -ALL MACHINES MODELS EXCEPT FOR TECNUMERIK



Holder

DESCRIPTION	CODE
Complete Holder	73.3.1.000.0000
Punch Holder	73.1.1.200.0000
Die Holder	73.1.1.500.0000

Spare parts

DESCRIPTION	CODE
Screw VTCE M10X60	14.01.0010.060
Screw VGR M8X40 (4pz)	14.21.8010.040
Spring G26x38 (8pcs)	93.1.1.230.0000

SINGLE PUNCH - ONLY FOR TECNUMERIK



Holder

DESCRIPTION	CODE
Complete Holder	93.3.1.001.0000
Punch Holder	93.1.1.200.0000
Die Holder	93.1.1.500.0000

Spare parts

DESCRIPTION	CODE
Screw VTCE M10X60	14.01.0010.060
Screw VGR M8X40 (4pz)	14.21.8010.040
Springs G26x38 (8pcs)	93.1.1.230.0000

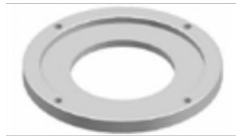
100 SERIES HOLDERS

100mm Maximum Punch Size

Punch



Stripper



Die



Round

DESCRIPTION	CODE
HSS flat punch	944113
Stripper for flat punch	944411
HSS whisper punch C03	944115
Stripper for whisper punch	944312
HWS Die	944211

TICN Coating

To be requested when ordering, the TICN coating provides an higher price as in the table here below

DESCRIPTION

Punch from 40,1mm to 70mm



Square

DESCRIPTION	CODE
HSS flat punch	944123
Stripper for flat punch	944421
HSS whisper punch C03	944125
Stripper for whisper punch	944322
HWS Die	944221

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Rectangle

DESCRIPTION	CODE
HSS flat punch	944143
Stripper for flat punch	944441
HSS whisper punch C03	944145
Stripper for whisper punch	944342
HWS Die	944241



Oblong

DESCRIPTION	CODE
HSS flat punch	944133
Stripper for flat punch	944431
HSS whisper punch C03	944135
Stripper for whisper punch	944332
HWS Die	944231



Standard Shape

DESCRIPTION	CODE
HSS flat punch	944163
Stripper for flat punch	944461
HSS whisper punch C03	944165
Stripper for whisper punch	944362
HWS Die	944261



100SERIES HOLDERS

SINGLE PUNCH - ALL MACHINES MODELS EXCEPT FOR TECNUMERIK



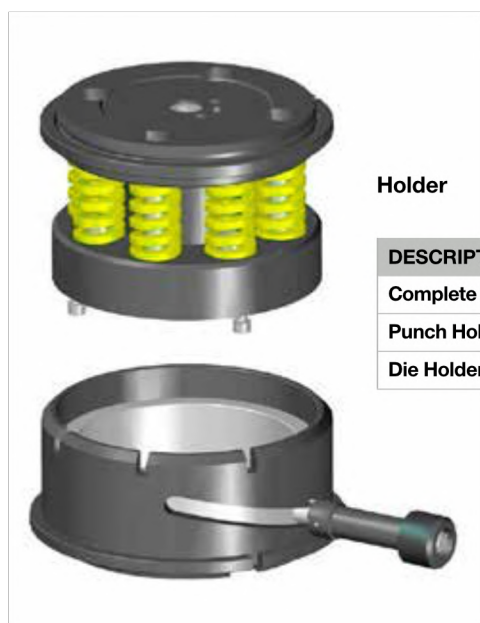
Holder

DESCRIPTION	CODE
Complete Holder	74.3.1.000.0000
Punch Holder	74.1.1.200.0000
Die Holder	74.1.1.500.0000

Spare parts

DESCRIPTION	CODE
Screw VTCE M10X60	14.01.0010.060
Screw VGR M8X40 (4pcs)	14.21.8010.040
Springs G26x38 (8pcs)	93.1.1.230.0000

SINGLE PUNCH - ONLY FOR TECNUMERIK



Holder

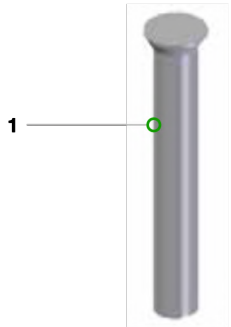
DESCRIPTION	CODE
Complete Holder	94.3.1.001.0000
Punch Holder	94.1.1.200.0000
Die Holder	94.1.1.500.0000

Spare parts

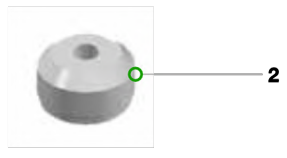
DESCRIPTION	CODE
Screw VTCE M10X60	14.01.0010.060
Screw VGR M8X40 (4pcs)	14.21.8010.040
Springs G26x38 (8pcs)	93.1.1.230.0000

NIBBLING TOOLS

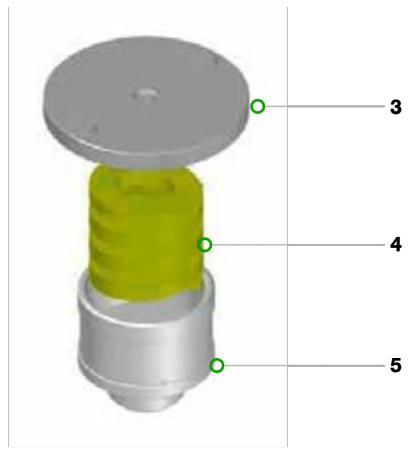
Nibbling Punch



Die



Stripper Unit



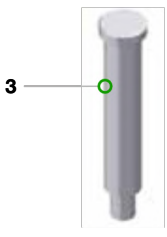
DIAMETER 10	
DESCRIPTION	CODE
1. Nibbling Punch D.10	954113
2. Die for Nibbling	954213
3. Spring Disk D.10	75.1.1.720.1000
4. Spring G51X65	95.1.1.730.0000
5. Nibbling punch guide	954311

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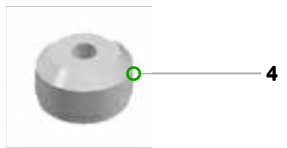
Nibbling Insert Punch



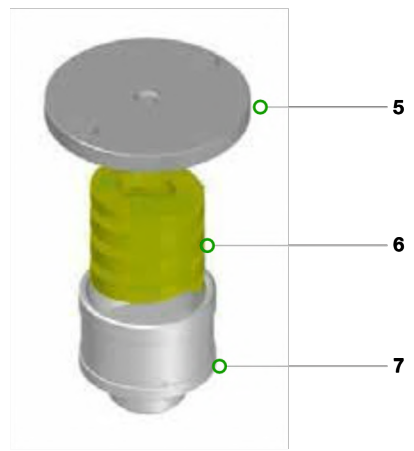
Nibbling Integral Punch



Die



Stripper Unit



DESCRIPTION	CODE
1. Reduced nibbling punch diam. 3-4-5-6-6,5-7-8	951113
2. Holder for reduced nibbling punch diam. 3-4-5-6-6,5-7-8	954515
3. Integral punch diam. from 8 to 15	952113
4. Die for nibbling	954213

DESCRIPTION	CODE
5. Spring Disk	75.1.1.720.1000
6. Spring G51X65	95.1.1.730.0000
7. Nibbling punch guide	954311

NIBBLING HOLDER

SINGLE PUNCH - ALL MACHINES MODELS EXCEPT FOR TECNUMERIK



Holder

DESCRIPTION	CODE
Complete Holder	75.3.1.003.0070



Spare parts

DESCRIPTION	CODE
Punch Holder*	75.1.1.700.0000
Die Holder*	71.1.1.500.0000

*Only external part of the holder without internal components

SINGLE PUNCH - ONLY FOR TECNUMERIK



Holder

DESCRIPTION	CODE
Complete Holder	95.3.1.001.0000



Spare parts

DESCRIPTION	CODE
Punch Holder*	95.1.1.700.0000
Die Holder*	91.1.1.500.0000

*Only external part of the holder without internal components

LOUVRES TOOL -ALL MACHINES MODELS EXCEPT FOR TECNUMERIK



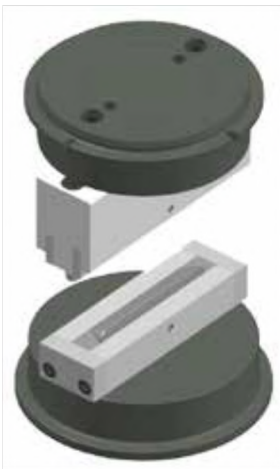
Holder

DESCRIPTION	CODE
Complete Louvres tool	764661

Spare parts

DESCRIPTION	CODE
Cutting insert	764161
Die Insert	764261

LOUVRES TOOL -ONLY FOR TECNUMERIK



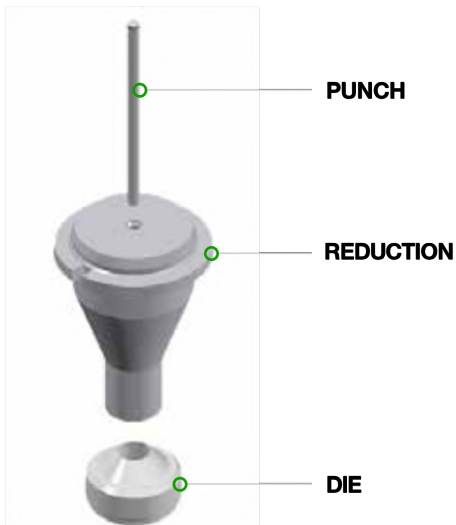
Holder

DESCRIPTION	CODE
Complete Louvres tool	964661

Spare parts

DESCRIPTION	CODE
Cutting insert	964161
Die Insert	964261

TPS TOOL



"M" Screw	PUNCH DIAMETER	REDUCTION DIAMETER	DIE DIAMETER
M4	3,7	3,7	4
M5	4,7	4,7	5
M6	5,7	5,7	6
M8	7,7	7,7	8
M10	9,7	9,7	10

DESCRIPTION	CODE	PRICE
Punch	911117	10,00 €
Reduction	911514	319,00 €
Die	911216	96,00 €

SHEAR TOOL

Cut without scrap



Holder

DESCRIPTION	CODE
Complete shear tool	761662

Spare parts

DESCRIPTION	CODE
Punch blade	761261*
	761262**
	761263***
Die blade	762263

Thickness
 * from 2mm to 3 mm of Iron
 ** from 1,5mm to 2 mm of Inox
 ***from 0,6mm to 1mm

RECTANGULAR BLOCK TOOLS

It is ideal to cut with minimum scrap



Holder

DESCRIPTION	CODE
Complete block tool	764643
Punch Holder	761643
Die Holder	762643

Spare parts

DESCRIPTION	CODE
Slitting punch blade	764143
Slitting die	764243
Spring	
Screw VGR M8X50 (5pz)	14.21.8010.050

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ACCESSORIES

GRINDER MACHINE



Standard equipment

- Cooling equipment with electropump.
- Wheel holder and cup wheel.
- Wheel protection carter.
- Table protection carter.
- Key for wheel tightening.
- Wheel C.B.N. Ø 175x78x45
- Demagnetizer
- Permanent magnetic chuck 260x140 mm
- Enclinable vice for punch sharpening (specify the brand)
- Instruction manual/test certificate.
- Conformity declaration 2006/42/CE

Technical features

Description	U.M	Data
Max. grinding surface	mm	140x330
Fast feed per revolution	mm	2
Micrometric down feed by pawl	mm	0,01
Size of the cup wheel	mm	Ø 78x78x78
Wheel motor revolutions	giri/min	2840
Machine weight	kG	450

Price: € 9.860,00

KIT FOR "C" AXIS ALIGNMENT



Case equipment

- Complete alignment tool (C1 - C2)
- Caliber
- Comparator
- Manual for "C" axis zeroing

NOTES

A large rectangular area containing horizontal lines for writing notes, enclosed by a dotted border.

A large rectangular area with a dashed border, containing 25 horizontal lines for writing.

OUR PRODUCTS

ADVANCED LINE

Punching Machine



TP ZETA

SMART LINE

Punching Machine



TP OMEGA

Punching Machine



TP ALPHA

**FULL
WARRANTY
24 MONTHS**



Created With Love

EAST GATE PROJECT MAKİNE SANAYİ TİCARET LİMİTED ŞİRKETİ

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January 2019