MATE®
PRECISION TECHNOLOGIES
RESPECT • SUPPORT • INSPIRE

Thick Turret Style Tooling

ULTRA® AND THICK TURRET TOOLING

Headquartered in Anoka, Minnesota, in a 300,000 sq. ft. (28,000m^2) state-of-the-art facility.

SEVEN DECADES OF EXCELLENCE

Founded in 1962, Mate is a world-class manufacturer of superior solutions for the metal cutting and metal forming industries. We manufacture workholding systems, CNC punch press tooling, and offer a complete line of press brake tooling and laser consumables. Mate products and services are available worldwide, fully supported by more than 80 dealers in every industrialized country.

PERSONAL, RESPECTFUL RELATIONSHIPS

Mate does business with people, not companies. Our connection to you is personal. Mate's team of manufacturing and metalworking professionals knows what you go through. We know what it's like to compete for that next job, manage deadlines or even need a rescue. With Mate you have a partner that respects your knowledge and is dedicated to helping you succeed.

YOUR GO-TO SOURCE

Serving our customers is at the core of who we are. In your plant or on the phone, we're up for whatever metalworking challenges you face. Your Mate representatives are experts who know from experience what happens on the shop floor and provide our legendary in-field support. They speak your language, fully capable of helping you improve processes and solve problems. Mate customer service is ready to assist with fast quotes, guiding your order on to our top-notch machinists and shipping pros.

GET INSPIRED!

With our vast knowledge and broad product range we inspire innovative thinking. Our customer's projects can be seen around the world: from unique building façades thought to be impossible to make, to a new way to add strength to thin material. The possibilities are endless, so think big, bold and beyond.

WE'VE GOT YOU COVERED

Dedicated to quality in every aspect of our business, Mate offers an extensive standard product line that can be delivered with same day or next day service. All Mate products are backed with our industry leading 100% customer satisfaction guarantee.

MATE'S MISSION AND PROMISE TO YOU:

Mate's mission is to personally **Respect, Support** and **Inspire** metalworking professionals around the world with high-quality products and services for factory productivity.

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*All prices in this catalog are subject to change without notice.

THICK TURRET TOOLING SYSTEM

Mate offers the most comprehensive range of thick turret tooling systems designed to accommodate any punching application. Use this simple chart to determine which system is right for your typical thick turret applications.

LESS ● ●● ●●● ●●●● ●●●●● MORE	Ultra® QCT™	Ultra TEC®	Ultra XT™	ORIGINAL STYLE
Overall Value – The combination of features, purchase price, and operating costs.	●●●●●	●●●●	●●●	●●
Cost Savings – The ongoing cost savings of operating the tooling system over time.	●●●●●	●●●●	●●●	●
Ease of Use – Design features included in the tooling system that make it faster to install, simpler for the operator to set up, and more convenient to maintain.	●●●●●	●●●●	●●	●
Interchangeability – The ability of a tooling system to be compatible with other popular systems from other major suppliers.	●●●●●	●●●●	●●●	●●
Quick Set-up – Integral features which enable tools to be changed quickly and accurately, thus maximizing machine up time.	●●●●●	●●●●	●●●	●●
Grind Life – The sum of the number of holes punched between regrinds AND the total grindable length of the punch tip before it needs to be replaced.	●●●●●	●●●●	●●●	●●
Slug Free® Die – Advanced die geometry that prevents the slug from being pulled back to the top of the sheet.	●●●●●	●●●●●	●●●●●	●●●●●
Features – Elements of a tool system that affects its ease of use, performance and longevity.	●●●●●	●●●●	●●●	●●
Purchase Price – The initial purchase price of the system.	●●●●	●●●	●●	●

QUICK CHANGE

Mate Precision Technologies's ULTRA® QCT™ Thick Turret Tooling takes insert-style punching systems to a whole new level! With its durable patent-pending design, tool-less punch retention mechanism and M4PM™ steel inserts, you'll be on your way to faster, more cost effective punching in no time.

- Easy set-up & maintenance. No tools required!
- Longer lasting, superior insert performance
- Robust construction
- Simple

[Dimensions in Inches (mm)]

PERFORMANCE

Mate's Ultra TEC® precision tooling system is a thick turret punching system which increases tool performance and flexibility, offers extended tool life and allows interchangability with existing systems. Some features of the Ultra® system include:

- Premium high speed tool steel punches
- Quick tool change strippers – no tools required
- Relieved strippers for extended grind life
  - 0.118(3.00) for 1/2" A and 1-1/4" B station
  - 0.078(2.00) for 2" C, 3-1/2" D and 4-1/2" E stations
- Easy click length adjustment - no shims or tooling required
- Internal and external tool lubrication
- Hardened guides
- Slug Free® die design

Option: *M4PM™ steel available in A and B station punches for superior perfomance and longevity. (See page 93 for details and additional information.)*

CONVENIENCE

Mate's Ultra XT™ precision tooling system is a thick turret punching system which increases tool performance and flexibility, offers extended tool life and allows interchangeability with existing systems. Features of the Mate Ultra XT™ system include:

- Premium high speed tool steel punches.
- Quick tool change strippers.
- Relieved strippers for extended grind life.
  - 0.118(3.00) for 1/2" A and 1-1/4" B station
- OEM compatible strippers 2" C, 3-1/2" D, 4-1/2" E and 6" F stations.
- Easy click length adjustment - no shims or tooling required.
- Internal and external lubrication.
- Slug Free® die design.

ECONOMY

Original style thick turret tooling from Mate is OEM compatible, with several design enhancements, including:

- Premium high speed steel punches.
- Hexagon shaped punch heads in 1/2" A and 1-1/4" B stations for easier adjustment.
- Reversible spring retainers in 1/2" A and 1-1/4" B stations for additional tool life.
- Hardened guides for reduced friction and longer service life.
- Mate Slug Free® dies as standard.

FORMING

Mate's Ultraform® tooling system features adjustable length holders for 1-1/4" B, 2" C, 3-1/2" D and 4-1/2" E stations. Each Ultraform® holder can be used with a variety of special forming inserts.

Each Mate Ultraform® holder includes a precise and convenient length adjustment mechanism to allow the fine adjustment of any forming tool to achieve high quality piece parts.

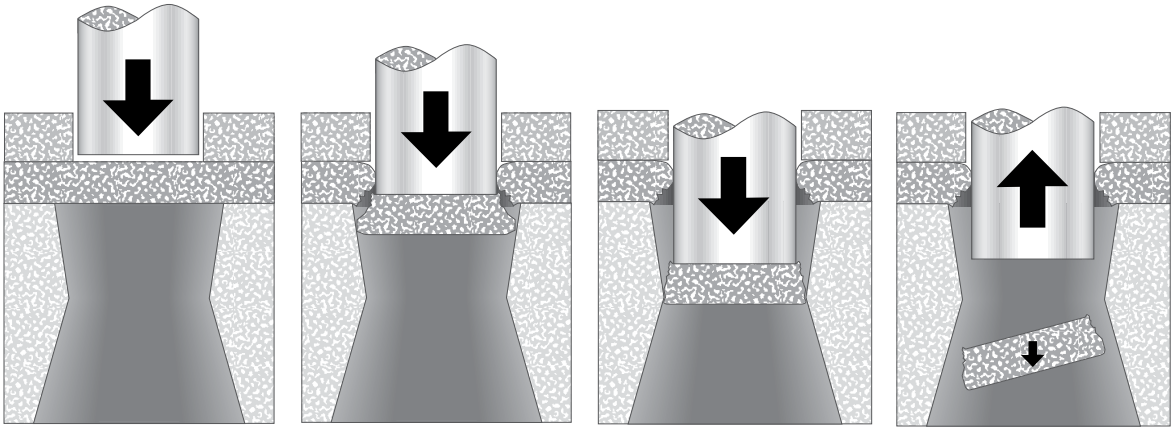
The benefits of the Ultraform® tooling system include reduced tooling cost, increased flexibility and ease of length adjustment for accurate forms.

[Dimensions in Inches (mm)]

MATE SLUG FREE® DIES

Mate Slug Free® dies eliminate slug pulling. Slug pulling is a condition where the slug returns to the top of the sheet during the stripping portion of the punching cycle. The slug comes between the punch and the top of the sheet on the next cycle. This causes damage to the piece part and the tooling. Slug Free® dies eliminate this problem.

The Slug Free® die has been designed with an opening that has a constriction point below the surface so the slug cannot return once it passes this point. Once the slug is separated from the punch, it is free to fall away from the punching area. Slug pulling is eliminated.



Material held securely by stripper before punch makes contact.

Punch penetrates the material. Slug fractures away from sheet.

Pressure point constricts slug. Punch stroke bottoms out as slug squeezes past pressure point.

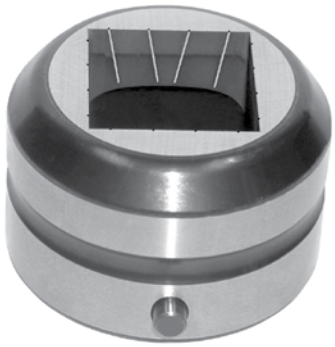
Punch retracts and slug is free to fall down and away through exit taper of the Slug Free® die.

MATE SLUG FREE LIGHT™ DIES FOR THIN SHEET METAL

Mate Slug Free Light™ thick turret dies are designed to eliminate slug pulling when punching thin sheet metal material, where the recommended die clearance is less than 0.008(0.20).

The Mate Slug Free Light™ die works by introducing a series of small protrusions around the edge of the slug. Each protrusion is created by a small angled notch cut into the die opening (See photo 1). As the slug passes through the die, the position of the protrusion relative to the notch changes slightly. This change creates slight pressure between the slug and the die land, which traps the slug into the die and eliminates the possibility of the slug being pulled back through the die. By eliminating slug pulling with every punch cycle, the piece part quality is improved and tool life is increased.

Mate Slug Free Light™ dies are available for thick turret tooling and are particularly effective when the die clearance is less than 0.008(0.20).



Mate Slug Free Light™ notches are cut at an angle to create a series of protrusions on the slug. As the slug moves through the die, the protrusions become trapped against the die land to prevent the slug pulling back on to the sheet. (Image enhanced for additional clarity)

- **Eliminate slug pulling**
- **Reduce tool breakage**
- **Improve tool life**
- **Increase quality**

[Dimensions in Inches (mm)]

ULTRA® PRECISION TOOLING SYSTEM – DESIGNED TO DRAMATICALLY IMPROVE ANY PUNCHING OPERATION

- 0.237(6.04) more grind life than original style tooling.
- No tools needed for quick disassembly and assembly of guide, punch and stripper.
- Quick length adjustment significantly reduces change over and set-up times.
- Fully compatible with alternative systems.
- Superior internal and external spiral grooved lubrication system ensures uniform distribution of oil for smooth friction free operation of punch to guide and guide to turret bore.
- Hardened and ground guides stay round and true to size which greatly reduces turret bore wear.
- Slug Free® dies eliminate slug pulling.

PUNCHES:

- Premium high speed tool steel for extended life between regrinds and maximum productivity.
- 1/4 degree back taper and near polished flanks to reduce friction, eliminate galling and extend punch life.
- External lubrication grooves to allow fluid flow.
- Available in multiple styles:
    - Ultra TEC® with lubrication grooves.
    - Ultra® QCT™ with lubrication grooves.
    - Ultra® Metric (original) style punches.
    - Inch style (1-1/4" B station only).

Option: *M4PM™ steel available in A and B station punches for superior perfomance and longevity. (See page 89 for details and additional information.)*

STRIPPERS:

- Relieved to allow 0.118(3.00) extra grind life.
- Quick-change mechanism to allow rapid tool change.
- Rounded edges to minimize sheet marking.

SLUG FREE® DIES:

- Slug Free die geometry eliminates slug pulling.
- Highly wear resistant, chrome air hardened tool steel
- Uniform clearance radii in die corners improve edge quality.
- Superior roundness and flatness with exceptional die strength.
- Up to 0.125(3.20) grind life.

CANISTER ASSEMBLIES:

- Quick length adjustment with positive engagement with the guide.
- Uniform spring pressure for reliable stripping.
- Available in multiple styles:
    - Ultra TEC® for use with Ultra TEC® and Ultra® QCT™ punches.
    - Ultra® Metric (Original) style punches.
    - Inch style (1-1/4" B station only) for Inch style punches.

UNIVERSAL GUIDES:

- Quick-change mechanism - no tools required.
- Tool remains assembled during tool length adjustment.
- Internal and external lubrication to reduce friction.
- Hardened and ground to reduce wear.
- Available in two styles:
    - Shaped – multiple precision internal keyways for shaped punches.
    - Round – internal keyway for round punches.

- **Long Lasting**
- **Freedom**
- **Flexibility**
- **Convenience**
- **Economy**
- **Quick adjustments**
- **Lowest cost per hole**

[Dimensions in Inches (mm)]

ULTRA® PRECISION TOOLING SYSTEM – DESIGNED TO DRAMATICALLY IMPROVE ANY PUNCHING OPERATION

- 0.212(5.38) more punch grind life than original style tooling.
- Quick change strippers.
- Quick length adjustment.
- Internal lubrication within punch guide.
- External lubrication between guide and turret bore ensures uniform distribution of oil within the turret bore.
- Hardened guides to reduce turret bore wear.
- Slug Free® dies eliminate slug pulling.

PUNCHES:

- Premium high speed tool steel for extended life between regrinds and maximum productivity.
- 1/4 degree back taper and near polished flanks to reduce friction and eliminate galling.
- Superior angularity, concentricity, and dimensional accuracy.
- Robust full-body design.
- Fully compatible with original style thick turret tooling.

STRIPPERS:

- Relieved to allow 0.078(2.00) extra grind life.
- Recessed to allow collection of lubrication fluid at punch tip.
- Quick-change mechanism to allow rapid tool change.
- Rounded edges to minimize sheet marking.
- Optional urethane stripper pads to eliminate sheet marking.

SLUG FREE® DIES:

- Highly wear resistant, chrome air hardened tool steel to balance hardness and toughness.
- Slug Free® die geometry eliminates slug pulling.
- Uniform clearance radii in die corners to improve edge quality.
- Precision orientation keyway.
- Up to 0.125(3.20) grind life.
- Superior roundness and flatness with exceptional die strength.

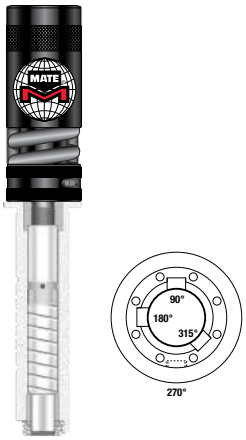
PUNCH GUIDE ASSEMBLY:

- Quick-change stripper release mechanism allows stripper to be removed easily, without tools.
- Quick length adjustment mechanism on the side of the guide allows the punch length to be adjusted without disassembly.
- Hardened and ground to stay round and true to size to greatly reduce turret bore wear.
- Internal and external lubrication grooves to reduce friction.
- High performance disc springs to optimize stripping force throughout the service life of the machine.

[Dimensions in Inches (mm)]

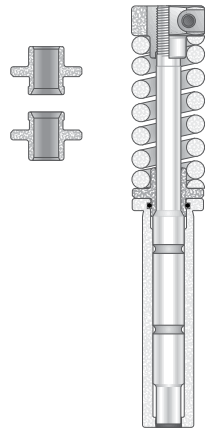
SIDE BY SIDE COMPARISON

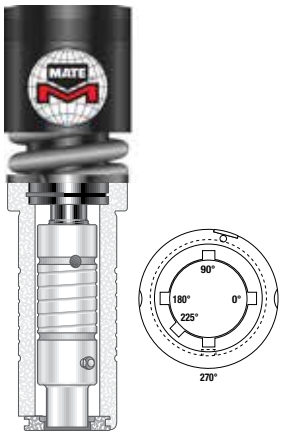
Ultra TEC®



1/2" A STATION

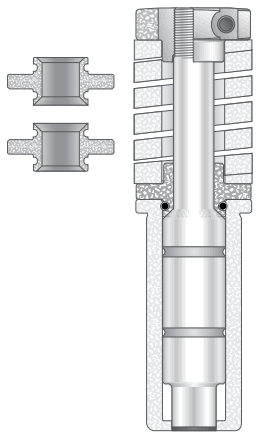
Ultra TEC®		MATE ORIGINAL STYLE
No tools required. Each 'click' is 0.006(0.15)	**LENGTH ADJUSTMENT**	Tools needed for adjustment
Self contained in canister	**SPRING ASSEMBLY**	Spring retainer with reversible design
Uses Ultra®, Ultra® QCT™ or Original style	**PUNCH**	Original style
Snap in, self locking design. 0.118(3.00) additional grind life	**STRIPPER**	One piece punch guide
3 internal slots: 90°, 180° and 315°. 1 external slot at 270°	**ANGLE ADJUSTMENT**	External slots: 1 for rounds 2 for shapes
Quick release locking mechanism	**ASSEMBLY**	O-ring snap fit

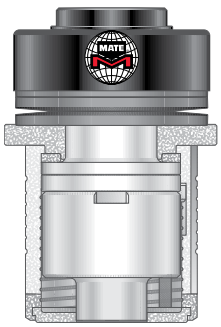




1-1/4" B STATION

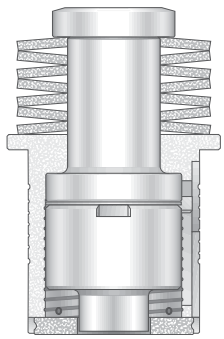
No tools required. Each 'click' is 0.008(0.20)	**LENGTH ADJUSTMENT**	Tools needed for adjustment
Self contained in canister	**SPRING ASSEMBLY**	Spring retainer with reversible design
Uses Ultra®, Ultra® QCT™, Metric (Original) Style, Inch Style or HP (Series 90)	**PUNCH**	Original style
Snap in, self locking design. 0.118(3.00) additional grind life	**STRIPPER**	One piece punch guide
5 internal slots: 0°, 90°, 180°, 225° and 270° 1 external slot at 270°	**ANGLE ADJUSTMENT**	External slots: 1 for rounds, 2 for shapes and 4 for special shapes
Quick release locking mechanism	**ASSEMBLY**	O-ring snap fit





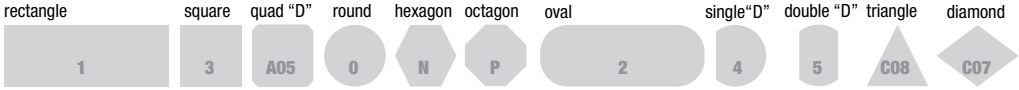
2" C, 3-1/2" D, 4-1/2" E STATION

No tools or shims required. Each 'click' is 0.008(0.20)*	**LENGTH ADJUSTMENT**	Tools and shims needed for adjustment
Uses Ultra®, original style or HP (Series 90)**	**PUNCH**	Original style
Snap in, self locking design. 0.079(2.00) additional grind life	**STRIPPER**	Stripper held in place with external clips
0° and 90° Two External Slots	**ANGLE ADJUSTMENT**	0° and 90° Two External Slots
Ease out design helps punch removal	**ASSEMBLY**	Tools required to make adjustments



* Holders made prior to June 1999 have length adjustment settings of 0.016(0.40) per 'click'
** Requires punch adapter and/or drawbolt change

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



[Dimensions in Inches (mm)]

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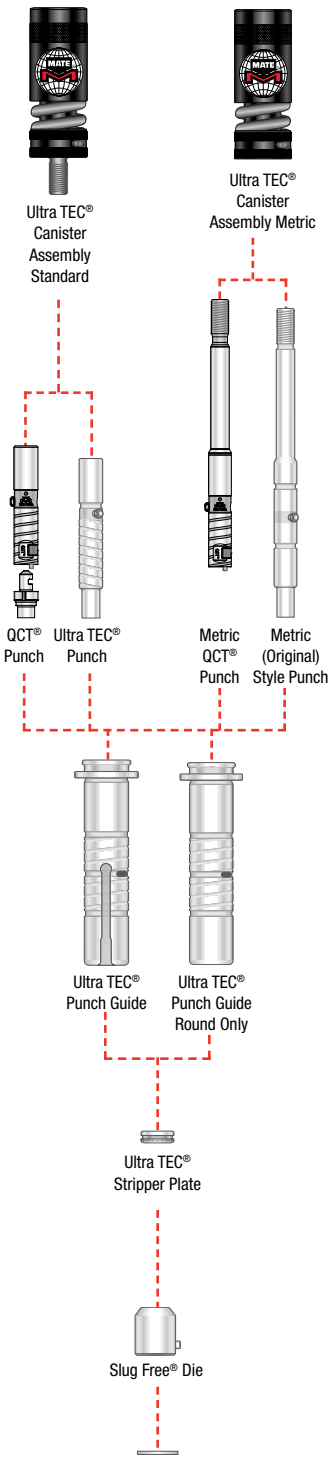
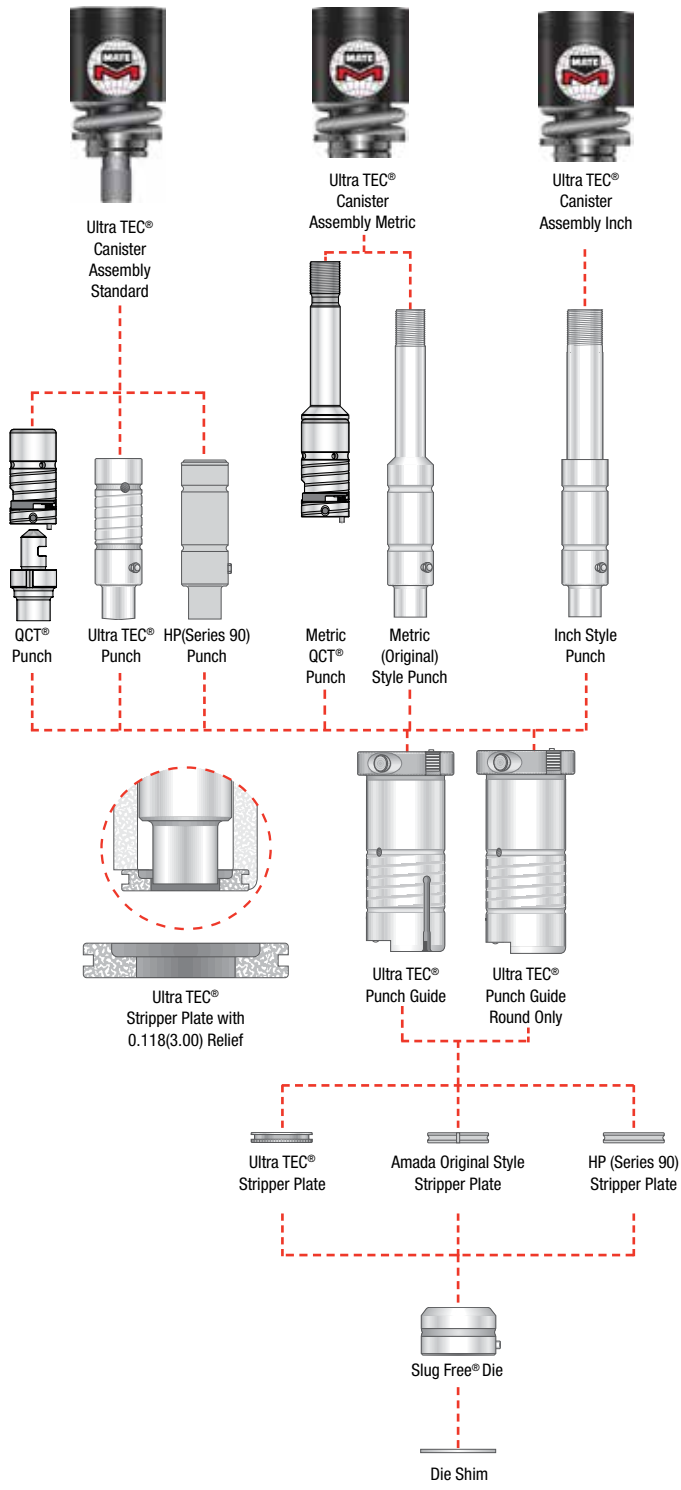
orders@mate.com

ULTRA TEC® SYSTEM OVERVIEW

1/2" A STATION



1-1/4" B STATION

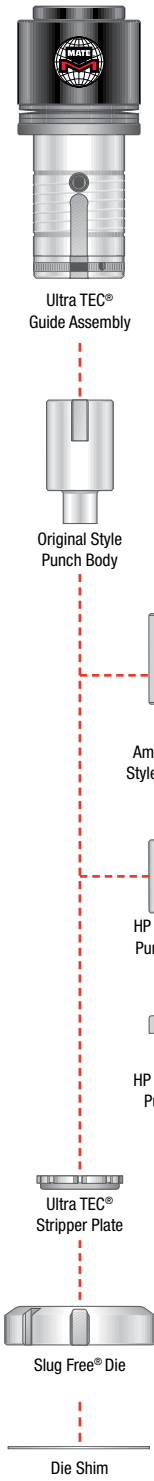


FEATURES INCLUDE:

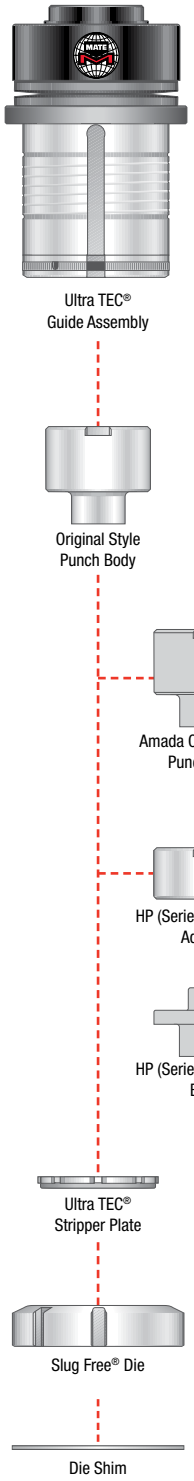
- Extended grind life
- Interchangeable components
- Multiple angle settings
- Quick length adjustment
- Quick tool change
- Premium high speed tool steel punches
- Slug Free® die

[Dimensions in Inches (mm)]

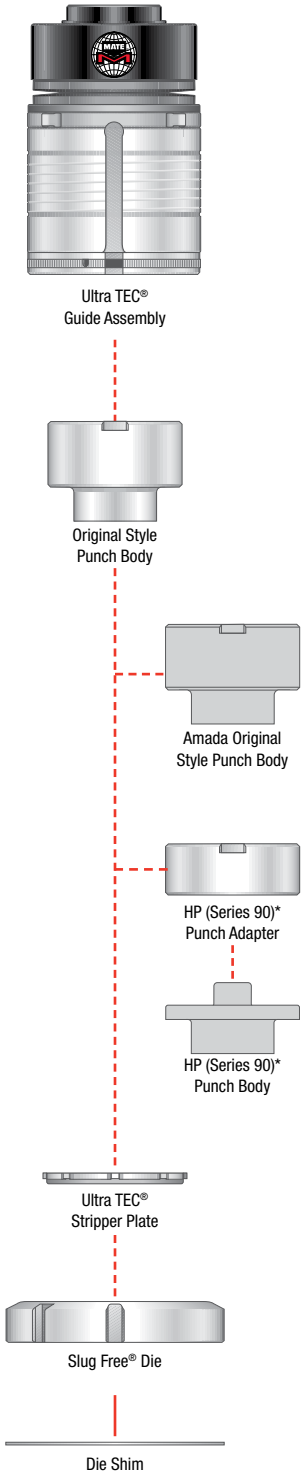
2" C STATION



3-1/2" D STATION



4-1/2" E STATION



FEATURES INCLUDE:

- Extended grind life
- Interchangeable components
- Multiple angle settings
- Quick length adjustment
- Quick tool change
- Premium high speed tool steel punches
- Slug Free® die

[Dimensions in Inches (mm)]

QUICK CHANGE TOOLING

Mate Precision Technologies's QCT™ thick turret tooling takes insert-style punching systems to a whole new level! With its durable patent-pending design, tool-less punch retention mechanism and M4PM™ steel inserts, you'll be on your way to faster, more cost effective punching in no time.

EASY SET-UP & MAINTENANCE. NO TOOLS REQUIRED!

QCT™ is designed to minimize effort and maximize uptime. There are no tools to use, break or lose to change the punch insert. Simply flip the durable latch to remove and snap the new insert into place. It's really that easy!

Maintenance is a breeze. Use compressed air to clean away debris without damage.

LONGER LASTING, SUPERIOR INSERT PERFORMANCE

QCT™ punch inserts are made from Mate's proprietary M4PM™ steel, the longest lasting tool steel in the industry. At .770(19,56), the SBR is longer than our standard length punches, for more grind life. The punch is keyed at the perimeter providing better angularity control. Since the punch insert OD interfaces with the guide ID, punch guiding is superior, too.

ROBUST CONSTRUCTION

The punch driver is made from high speed steel and comes standard with Mate's proprietary next generation SuperMax™ coating for extended life*. To ensure durability, Mate's complete line of QCT™ Quick Change Tooling has undergone extensive product testing in customer locations.

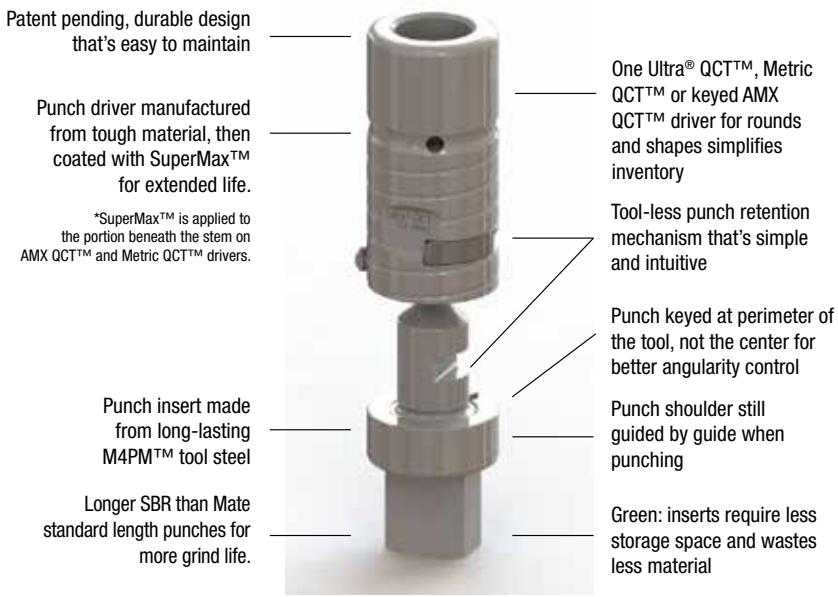
FULLY COMPATIBLE

There's no need to purchase a special or captive system. Mate's QCT™ works with all existing Ultra TEC®, Ultra XT™ and Ultra TEC® Fully Guided guides and canisters. Metric QCT™ is fully compatible with Mate Original Style and other long stem systems. AMX QCT™ is fully compatible with AMADA® Air Blow Systems (ABS) assemblies and holders. MXC QCT™ is fully compatible with Wilson Series 90™ and HP™ tooling systems.

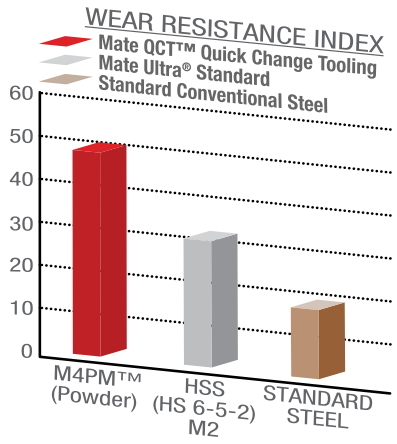
SIMPLE

Mate's QCT™ Quick Change Tooling simplifies your tooling storage needs. Only one punch driver is required for rounds or shapes with Ultra® QCT™, Metric QCT™ and AMX QCT™ drivers. Punch inserts take up less space than standard punches and waste less material.

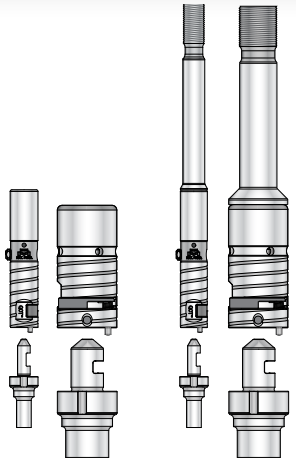
OVERVIEW



ULTRA® QCT™ SHOWN ABOVE



[Dimensions in Inches (mm)]



ULTRA® QCT™ METRIC QCT™

ULTRA® QCT™ SYSTEM

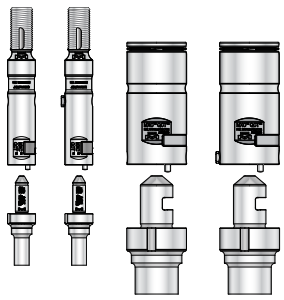
Mate's Ultra® QCT™ tooling is the flagship of our Quick Change Tooling (QCT™) product line. Available in both A and B station, Ultra QCT is fully compatible in all standard Ultra TEC® guides and canisters.

FULLY COMPATIBLE WITH:
Mate Ultra TEC guides and canisters
Mate Ultra XT guides and canisters
Mate Ultra Fully Guided guides and canisters

METRIC QCT™ SYSTEM

Mate's Metric QCT™ A and B Station punch drivers include all the benefits of our Ultra® tooling family with expanded compatibility to metric canisters that accept long stem punches also known as Mate Original Style and Amada Style.

FULLY COMPATIBLE WITH:
Mate's Ultra® family of guides and standard canisters
Mate's Original Style guides and Rapidset™ canisters
Mate's Original Style guides and spring packs
Amada NCT, NEX and Z-Tooling systems
Wilson thick turret metric punch systems



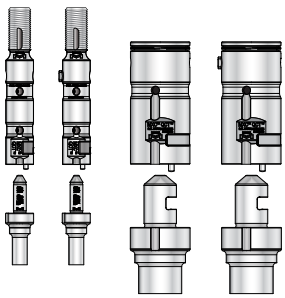
MXC QCT™

MXC QCT™ SYSTEM FOR WILSON HP/SERIES 90

Mate's MXC tooling system is replacement thick turret tooling for Wilson HP™ and Series 90™ tooling systems. These high-precision products increase tool performance and flexibility, offer extended tool life and are interchangeable with other systems. Features of the MXC system include:

100% COMPATIBLE WITH:
HP™
HP™ WLS®

COMPATIBILITY WITH:
UltraTEC®
Ultra XT™

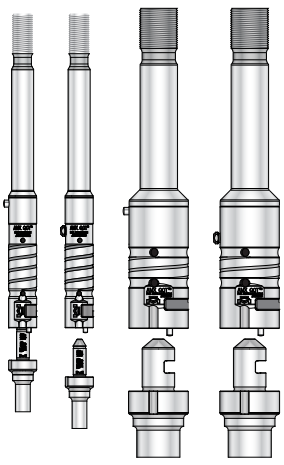


MXC QCT™ ABS

B Station Driver:
Uses standard QCT punch inserts (PAQB)

A Station Driver:
Wilson's HP/Series 90 A station product design uses a slightly narrower diameter than all other thick turret systems. As a result, the standard QCT A station punch insert cannot be used with the MXC QCT driver. This means that the MXC QCT A station driver requires a unique QCT punch insert (PXQA). To aid customers in identifying these inserts, we etch MXC QCT on the side of the insert.

The drivers are available in both Standard and (for HP WLS® style) ABS style.



AMX QCT™

AMX QCT™ SYSTEM FOR AMADA® ABS

Mate's AMX QCT™ tooling is a replacement tooling system for AMADA® Air Blow Systems (ABS) assemblies and holders. AMX QCT tooling provides all of the advantages of the QCT system for air blow systems. It delivers the flexibility of using the AMX QCT system with Mate's AMX guides, spring packs and Rapidset canisters, as well as Amada NCT, NEX and Z-Tooling air blow systems.

FULLY COMPATIBLE WITH:
Mate's Ultra® family of guides and standard canisters
Mate's Original Style guides and Rapidset™ canisters
Mate's Original Style guides and spring packs
Amada NCT, NEX and Z-Tooling systems
Wilson thick turret metric punch systems

[Dimensions in Inches (mm)]

QCT™ ORDER GUIDE

ULTRA® QCT™ ORDER GUIDE

PART NUMBER	DESCRIPTION
MATE02401	ULTRA QCT B Station Punch Driver
MATE02404	ULTRA QCT A Station Punch Driver
PUNCH INSERTS	
PAQB0A	ULTRA QCT B Station Round Punch Insert
PAQB_A	ULTRA QCT B Station Shaped Punch Insert
PAQA0A	ULTRA QCT A Station Round Punch Insert
PAQA_A	ULTRA QCT A Station Shaped Punch Insert

METRIC QCT™ ORDER GUIDE

PART NUMBER	DESCRIPTION
MATE02519	Metric QCT A Station Punch Driver for Shapes and Keyed Rounds
MATE02520	Metric QCT A Station Punch Driver for Keyless Rounds
MATE02521	Metric QCT B Station Punch Driver for Shapes and Keyed Rounds
MATE02522	Metric QCT B Station Punch Driver for Keyless Rounds
PUNCH INSERTS	
PAQB0A	QCT B Station Round Punch Insert
PAQB_A	QCT B Station Shaped Punch Insert
PAQA0A	QCT A Station Round Punch Insert
PAQA_A	QCT A Station Shaped Punch Insert

MXC QCT™ ORDER GUIDE

PART NUMBER	DESCRIPTION
MATE02546	MXC QCT A Station Punch Driver for Shapes and Keyed Rounds
MATE02545	MXC QCT A Station Punch Driver for Keyless Rounds
MATE02544	MXC QCT ABS Style A Station Punch Driver for Shapes and Keyed Rounds
MATE02543	MXC QCT ABS Style A Station Punch Driver for Keyless Rounds
MATE02525	MXC QCT B Station Punch Driver for Shapes and Keyed Rounds
MATE02524	MXC QCT B Station Punch Driver for Keyless Rounds
MATE02526	MXC QCT ABS Style B Station Punch Driver for Shapes and Keyed Rounds
MATE02568	MXC QCT ABS Style B Station Punch Driver for Keyless Rounds
QCT MXC A STATION INSERTS*	
PXQA0A	QCT MXC A Station Round Punch Insert
PXQA_A	QCT MXC A Station Shaped Punch Insert
QCT B STATION INSERTS	
PAQB0A	QCT B Station Round Punch Insert
PAQB_A	QCT B Station Shaped Punch Insert

AMX QCT™ ORDER GUIDE

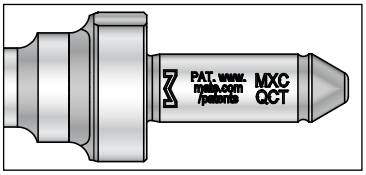
PART NUMBER	DESCRIPTION
MATE02551	AMX QCT A Station Punch Driver for Shapes and Keyed Rounds
MATE02553	AMX QCT A Station Punch Driver for Keyless Rounds
MATE02552	AMX QCT B Station Punch Driver for Shapes and Keyed Rounds
MATE02554	AMX QCT B Station Punch Driver for Keyless Rounds
PUNCH INSERTS	
PAQB0A	QCT B Station Round Punch Insert
PAQB_A	QCT B Station Shaped Punch Insert
PAQA0A	QCT A Station Round Punch Insert
PAQA_A	QCT A Station Shaped Punch Insert

[Dimensions in Inches (mm)]

AVAILABLE OPTIONS

GENERAL
Radius Corners
Non-Standard Straight before Radius (SBR) Dimension
Special Angle Settings
Optional Shear
SMALL DIAMETER ROUND TOOLS
Diameter 0.020(0,51) to 0.061(1,55)
Diameter 0.062(1,56) to 0.092(2,34)
NARROW WIDTH SHAPE TOOLS
Widths under 0.079(2,00)
SUPERMAX™ COATING
½" A Station
1-¼" B Station
MAXIMA™ COATING
½" A Station
1-¼" B Station

ULTRA TEC® STRIPPERS	
S6KA0A	Ultra TEC Stripper Plate, A Station, Round
S6KA_A	Ultra TEC Stripper Plate, A Station, Shape
S6KB0A	Ultra TEC Stripper Plate, B Station, Round
S6KB_A	Ultra TEC Stripper Plate, B Station, Shape
ORIGINAL STYLE STRIPPER GUIDES	
S6AA0A	Thick Turret A Station Stripper Guide for Shapes and Rounds
S6AA_A	Thick Turret A Station Stripper Guide for Shapes and Rounds
S6AB0A	Thick Turret B Station Stripper Guide for Rounds
S6AB_A	Thick Turret B Station Stripper Guide for Shapes
SLUG FREE® DIES	
D0AA00	Slug Free Die, A Station, Round
D0AA_0	Slug Free Die, A Station, Shape
D0AB00	Slug Free Die, B Station, Round
D0AB_0	Slug Free Die, B Station, Shape



***MXC QCT™ A STATION ETCH**

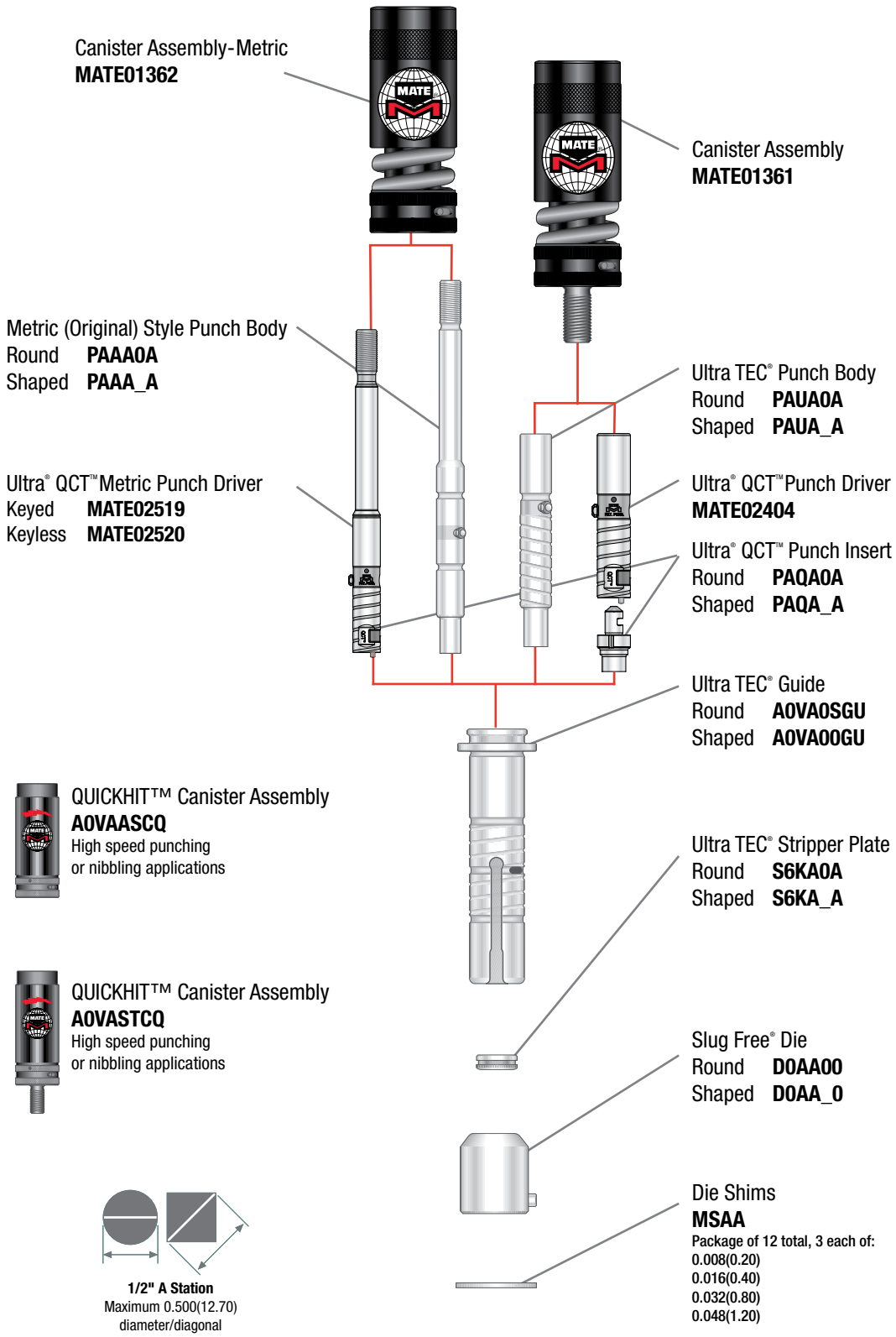
AVAILABLE SHAPES

STANDARD	SPECIAL
Round Rectangle Oval Square Single D Double D Hexagon Octagon	Arc Oval Arc U-Shape Band aid Break-Away Cable Opening Cable Opening with Tabs Bi-Diameter Tri-Diameter Quad-Diameter Diamond Ellipse Football Keyways Keyholes Parallelogram Pentagon Quad D 2-Way Radius 4-Way Radius 9-Way Radius Rect/Oval Double Rectangle Rectangle with Chamfered Corners Rectangle with Rounded Corners Rectangle with Tabs Rectangle with Notch Teardrop Trapezoid Triangle

TONNAGE LIMITATIONS	
A STATION	5 U.S. TONS / 4.54 METRIC TONS
B STATION	14 U.S. TONS / 12.70 METRIC TONS

[Dimensions in Inches (mm)]

ULTRA TEC® ½" A STATION ASSEMBLY



Canister Assembly-Metric
MATE01362

Canister Assembly
MATE01361

Metric (Original) Style Punch Body
Round **PAAA0A**
Shaped **PAAA_A**

Ultra TEC® Punch Body
Round **PAUA0A**
Shaped **PAUA_A**

Ultra® QCT™ Metric Punch Driver
Keyed **MATE02519**
Keyless **MATE02520**

Ultra® QCT™ Punch Driver
MATE02404

Ultra® QCT™ Punch Insert
Round **PAQA0A**
Shaped **PAQA_A**

Ultra TEC® Guide
Round **A0VA0SGU**
Shaped **A0VA00GU**

QUICKHIT™ Canister Assembly
A0VAASCQ
High speed punching
or nibbling applications

Ultra TEC® Stripper Plate
Round **S6KA0A**
Shaped **S6KA_A**

QUICKHIT™ Canister Assembly
A0VASTCQ
High speed punching
or nibbling applications

Slug Free® Die
Round **D0AA00**
Shaped **D0AA_0**

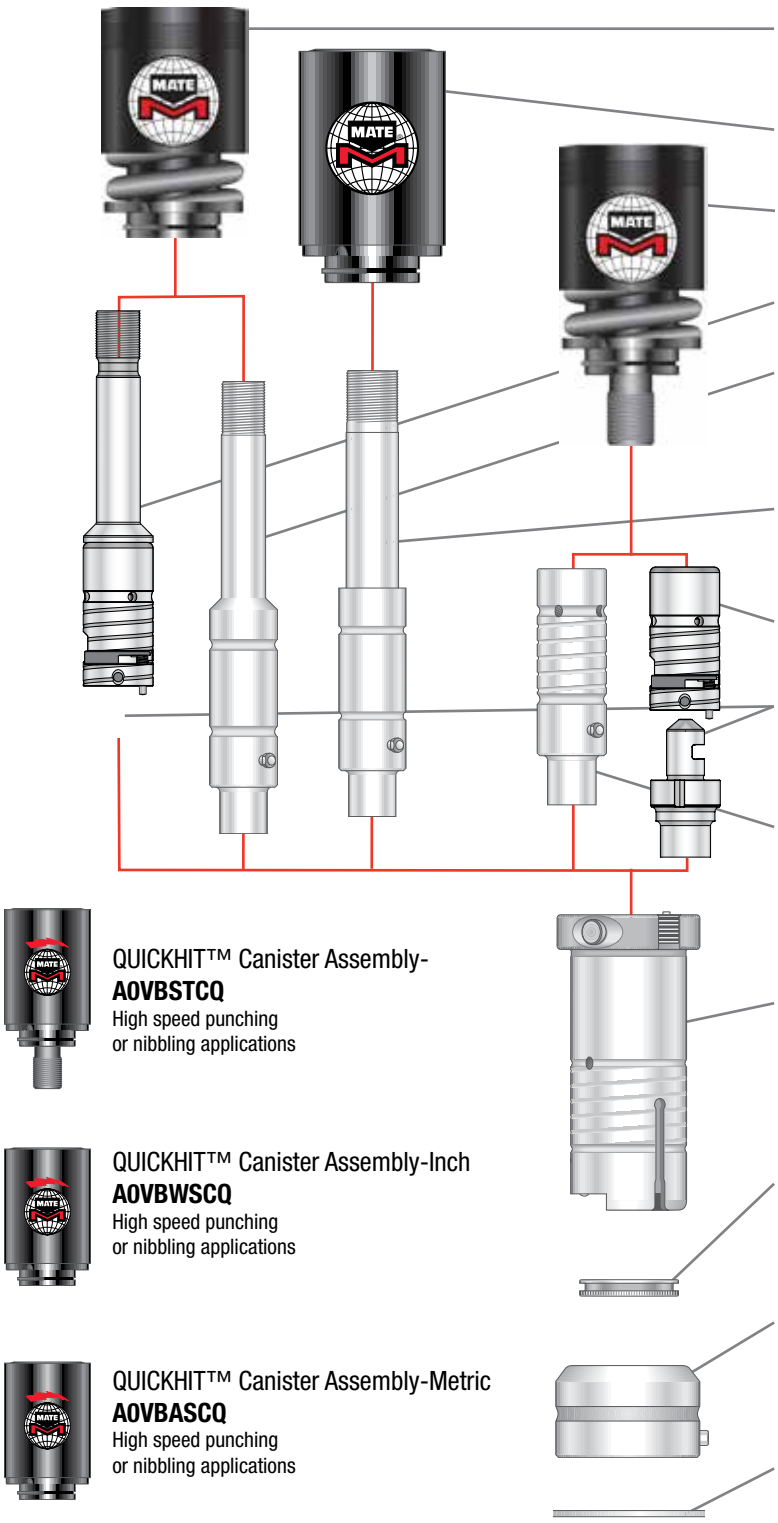
Die Shims
MSAA
Package of 12 total, 3 each of:
0.008(0.20)
0.016(0.40)
0.032(0.80)
0.048(1.20)

1/2" A Station
Maximum 0.500(12.70)
diameter/diagonal

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):

rectangle	square	quad "D"	round	hexagon	octagon	oval	single "D"	double "D"	triangle	diamond
1	3	A05	0	N	P	2	4	5	C08	C07

[Dimensions in Inches (mm)]



Canister Assembly-Metric
MATE01076

Canister Assembly-Inch
A0VBWSCA

Canister Assembly
MATE01078

Ultra® QCT™ Metric Punch Driver
Keyed **MATE02521**
Keyless **MATE02522**

Metric (Original) Style Punch Body
Round **PAAB0A**
Shaped **PAAB_A**

Inch Style Punch Body
Round **PAJB0A**
Shaped **PAJB_A**

Ultra® QCT™ Punch Driver
MATE02401

Ultra® QCT™ Punch Inserts
Round **PAQB0A**
Shaped **PAQB_A**

Ultra TEC® Punch Body
Round **PAUB0A**
Shaped **PAUB_A**

Ultra TEC® Punch Guide
Round **A0VB0SGU**
Shaped **A0VB00GU**

Ultra TEC® Stripper Plate
Round **S6KB0A**
Shaped **S6KB_A**

Slug Free® Die
Round **D0AB00**
Shaped **D0AB_0**

Die Shims
MSAB
Package of 12 total, 3 each of:
0.008(0.20)
0.016(0.40)
0.032(0.80)
0.048(1.20)

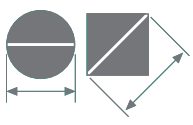
QUICKHIT™ Canister Assembly-
A0VBSTCQ
High speed punching
or nibbling applications

QUICKHIT™ Canister Assembly-Inch
A0VBWSCQ
High speed punching
or nibbling applications

QUICKHIT™ Canister Assembly-Metric
A0VBASCQ
High speed punching
or nibbling applications

See page 6 for Slug Free Light™ Dies

See page 92 for Add-Ons

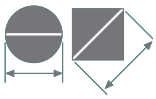


1-1/4" B Station
Maximum 1.250(31.75)
diameter/diagonal

[Dimensions in Inches (mm)]

ULTRA TEC® GUIDE ASSEMBLIES FOR THICK TURRET STYLE PUNCHES

2" C STATION



Maximum
2.000(50.80)
diameter/diagonal

Ultra TEC® Guide Assembly
AGVC1Y

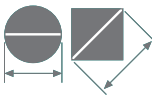
Original Style Punch Body
Round **PAAC0A**
Shaped **PAAC_A**

Ultra TEC® Stripper Plate
Round **S6KC0A**
Shaped **S6KC_A**

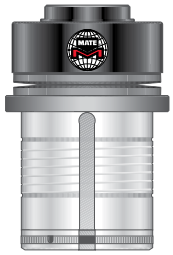
Slug Free® Die
Round **D0AC00**
Shaped **D0AC_0**

Die Shims
MSAC
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)

3-1/2" D STATION



Maximum
3.500(88.90)
diameter/diagonal



Ultra TEC® Guide Assembly
AGVD1Y

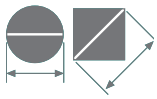
Original Style Punch Body
Round **PAAD0A**
Shaped **PAAD_A**

Ultra TEC® Stripper Plate
Round **S6KD0A**
Shaped **S6KD_A**

Slug Free® Die
Round **D0AD00**
Shaped **D0AD_0**

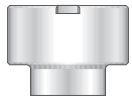
Die Shims
MSAD
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)

4-1/2" E STATION



Maximum
4.500(114.30)
diameter/diagonal

Ultra TEC® Guide Assembly
AGVERZ



Original Style Punch Body
Round **PAAE0A**
Shaped **PAAE_A**

Ultra TEC® Stripper Plate
Round **S6KE0A**
Shaped **S6KE_A**

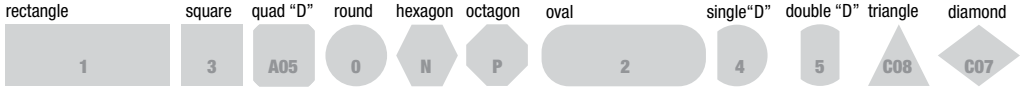
Slug Free® Die
Round **D0AE00**
Shaped **D0AE_0**

Die Shims
MSAE
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)

See page 6 for Slug Free Light™ Dies

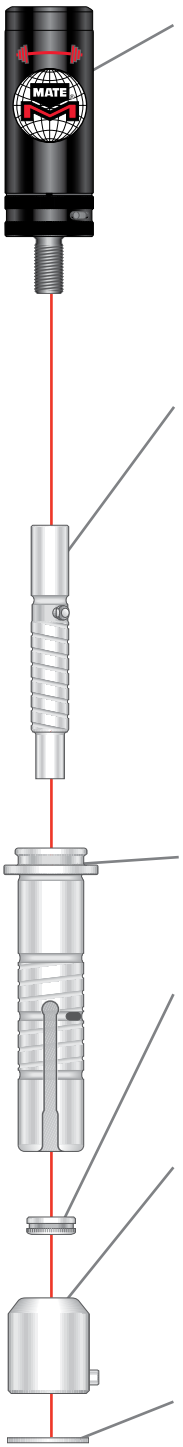
See page 92 for Add-Ons

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



[Dimensions in Inches (mm)]

1/2" A STATION



Canister Assembly

Standard:
MATE01866
Metric:
MATE01867

Ultra TEC® Heavy Duty
Punch Body
Round **PHUA0A**
Shaped **PHUA_A**

Maximum Heavy
Duty Punch Size
0.500(12.70)
diameter/diagonal

Ultra TEC® Guide
Round **A0VA0SGU**
Shaped **A0VA00GU**

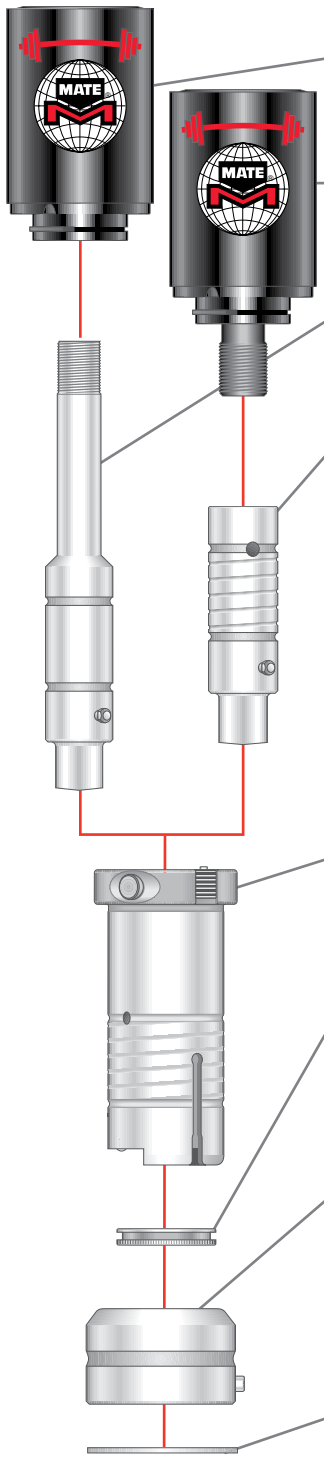
Ultra TEC® Heavy Duty
Stripper Plate
Round **SHKA0A**
Shaped **SHKA_A**

Heavy Duty Slug Free® Die
Round **DHAA00**
Shaped **DHAA_0**

Maximum Heavy
Duty Die Size
0.559(14.20)
diameter/diagonal
(includes clearance)

Die Shims
MSAA
Package of 12 total, 3 each of:
0.008(0.20)
0.016(0.40)
0.032(0.80)
0.048(1.20)

1-1/4" B STATION



Heavy Duty Canister
Assembly-Metric
A0VBHMCA

Heavy Duty Canister Assembly
A0VBHSCA

Heavy Duty Punch Body
Round **PHAB0A**
Shaped **PHAB_A**

Ultra TEC® Heavy Duty
Punch Body
Round **PHUB0A**
Shaped **PHUB_A**

Maximum Heavy
Duty Punch Size
1.250(31.75)
diameter/diagonal

Ultra TEC® Guide
Round **A0VB0SGU**
Shaped **A0VB00GU**

Ultra TEC® Heavy Duty
Stripper Plate
Round **SHKB0A**
Shaped **SHKB_A**

Heavy Duty Slug Free® Die
Round **DHAB00**
Shaped **DHAB_0**

Maximum Heavy
Duty Die Size
1.309(33.25)
diameter/diagonal
(includes clearance)

Die Shims
MSAB
Package of 12 total, 3 each of:
0.008(0.20)
0.016(0.40)
0.032(0.80)
0.048(1.20)

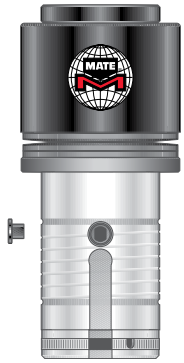
Minimum width/diameter in heavy duty is 0.250(6.35)

Features include:

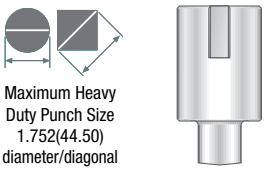
• 1 Degree back taper on punches (per side) • Quick tool change
• Heavy duty Slug Free® die design • Premium high speed tool steel punches
• Heavy duty springs (1-1/4" B Station)
• Rooftop shear • Quick length adjustment
• HD designation marked on heavy duty die

[Dimensions in Inches (mm)]

2" C STATION

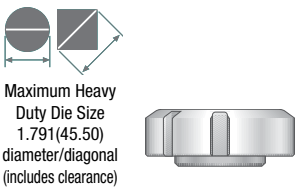


Ultra TEC® Guide Assembly
AGVC1Y



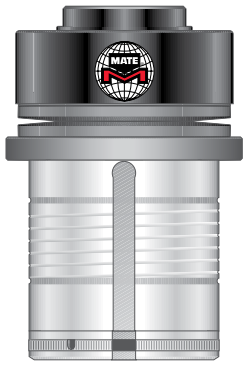
Heavy Duty Punch Body
Round **PHAC0A**
Shaped **PHAC_A**

Ultra TEC® Heavy Duty
Stripper Plate
Round **SHKC0A**
Shaped **SHKC_A**

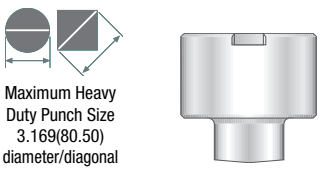


Heavy Duty Slug Free® Die
Round **DHAC00**
Shaped **DHAC_0**

3-1/2" D STATION

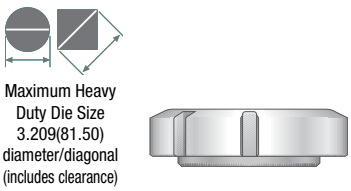


Ultra TEC® Guide Assembly
AGVD1Y



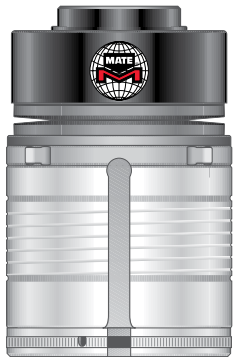
Heavy Duty Punch Body
Round **PHAD0A**
Shaped **PHAD_A**

Ultra TEC® Heavy Duty
Stripper Plate
Round **SHKD0A**
Shaped **SHKD_A**

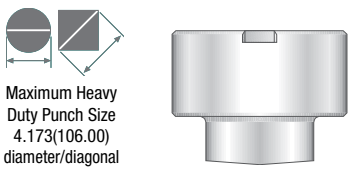


Heavy Duty Slug Free® Die
Round **DHAD00**
Shaped **DHAD_0**

4-1/2" E STATION

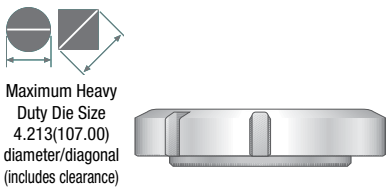


Ultra TEC® Guide Assembly
AGVERZ



Heavy Duty Punch Body
Round **PHAE0A**
Shaped **PHAE_A**

Ultra TEC® Heavy Duty
Stripper Plate
Round **SHKE0A**
Shaped **SHKE_A**



Heavy Duty Slug Free® Die
Round **DHAE00**
Shaped **DHAE_0**

Minimum width/diameter in heavy duty is 0.250(6.35)

See page 92 for Add-Ons

Lifter "T" Handle

A0LEH

[Dimensions in Inches (mm)]

1/2" A STATION

Ultra Light™ Spring Canister Ultra® Style
MATE00276

Ultra Light™ Spring Canister Metric Style
MATE00278

Ultra Light™ 1/2" A station canisters apply 70% of the stripping force of the standard Ultra TEC® 1/2" A station canisters.

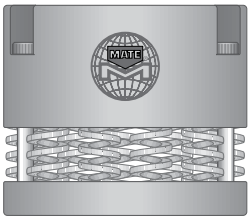
1-1/4" B STATION

Ultra Light™ Spring Canister Ultra® Style
MATE00277

Ultra Light™ Spring Canister Metric Style
MATE00279

Ultra Light™ 1-1/4" B station canisters apply 60% of the stripping force of the standard Ultra TEC® 1-1/4" B station canisters.

2" C STATION

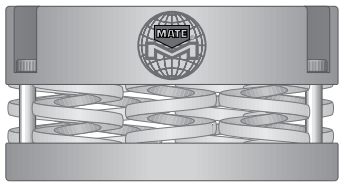


Ultra Light™ Spring Assembly
MATE00038

(Package of 9)
Heavy Pressure Gold Springs*
MATE00280

MATE00038 is assembled with 9 medium pressure blue springs.

3-1/2" D AND 4-1/2" E STATION



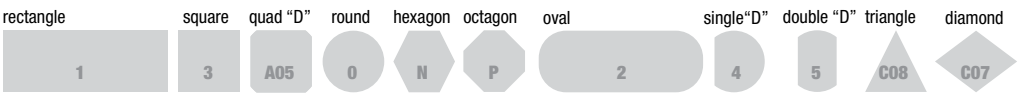
Ultra Light™ Spring Assembly
MATE00033

(Package of 9)
Medium Heavy Pressure Red Springs*
MATE00281

MATE00033 is assembled with 9 medium pressure blue springs.

***See page 46 for details on spring selection.**

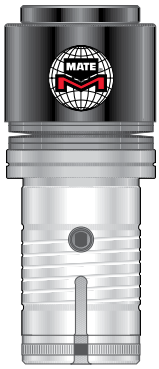
STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



[Dimensions in Inches (mm)]

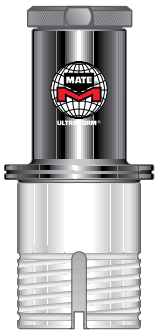
ULTRA TEC® LVD STYLE PUNCH GUIDE ASSEMBLIES

2" C STATION
0.250(6.35) wide keyway



Ultra® LVD Guide Assembly
LGVC1

Ultra® LVD Fully Guided Guide Assembly*
LGVS1

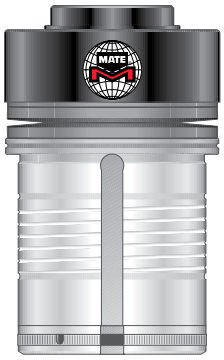


Ultraform® LVD Style Forming Unit Guide Assembly
LFKC2

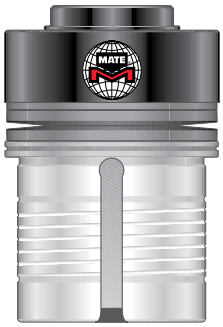
Lifter "T" Handle

AOLEH

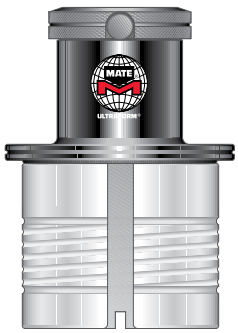
3-1/2" D STATION
0.512(13.00) wide keyway



Ultra® LVD Guide Assembly
LGVD1



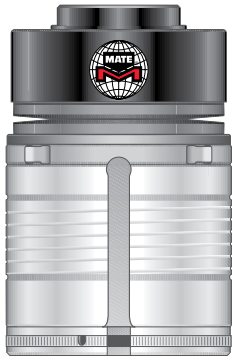
Ultra® LVD Fully Guided Guide Assembly**
LGVT1



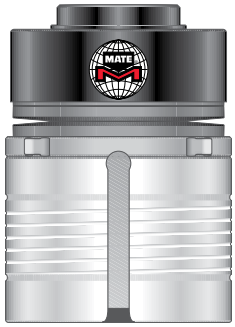
Ultraform® LVD Style Forming Unit Guide Assembly
LFKD2

*Also Available
(2" C Station Only)
LGVS3
External keyways at
0°, 45° and 90°

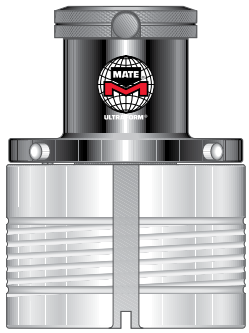
4-1/2" E STATION
0.512(13.00) wide keyway



Ultra® LVD Guide Assembly
LGVE1



Ultra® LVD Fully Guided Guide Assembly
LGVU1



Ultraform® LVD Style Forming Unit Guide Assembly
LFKE2

**Also Available
(3-1/2" D Station Only)
LGVT3
External keyways at
0°, 45° and 90°

[Dimensions in Inches (mm)]

1-1/4" B STATION

Ultra TEC® Canister Assembly Standard

Ultra TEC® Canister Assembly Metric

Ultra® QCT™ Punch

Ultra TEC® Punch

Metric QCT® Punch

Metric (Original) Style Punch

Ultra TEC® Fully Guided Punch Guide

Ultra TEC® Fully Guided Stripper Plate

Slug Free® Die

2" C STATION

Fully Guided Guide Assembly

Original Style Punch Body

Ultra TEC® Fully Guided Stripper Plate

Slug Free® Die

3-1/2" D STATION

Fully Guided Guide Assembly

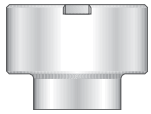
Original Style Punch Body

Ultra TEC® Fully Guided Stripper Plate

Slug Free® Die

4-1/2" E STATION

Fully Guided Guide Assembly



Original Style Punch Body

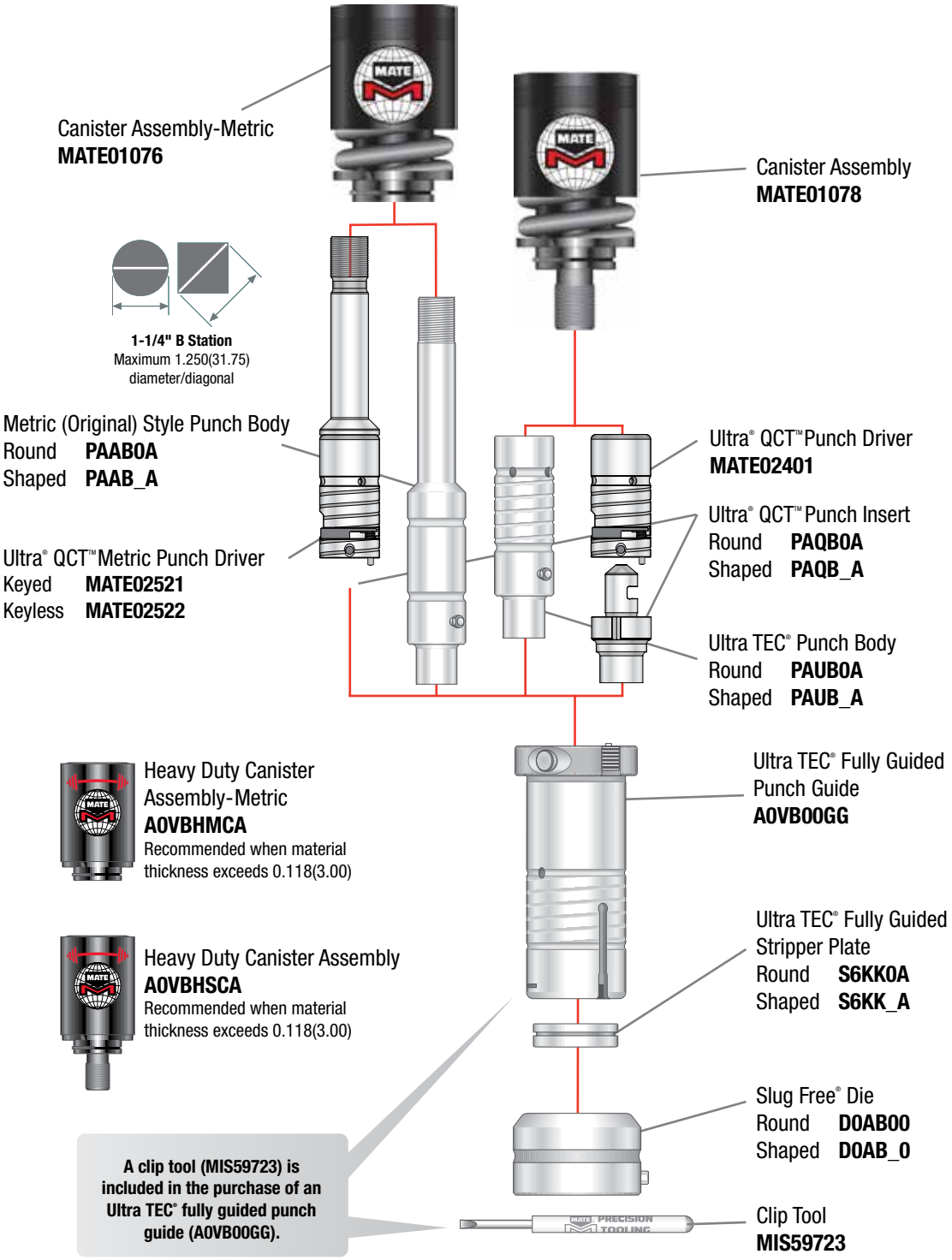
Ultra TEC® Fully Guided Stripper Plate

Slug Free® Die

- **Fully guided assembly**
  Accurate and close tolerances between guide and stripper hold punches rigid, control against hole distortion and saw toothing.
- **Premium high speed tool steel punches at 60-62 Rockwell C**
  Specially formulated high speed steel and specially developed heat treatment processes result in unusually high tool performance, superior dimensional accuracy and maximum tool life.
- **Stripper opening 0.0015(0.04) TC to point**
  Guiding at punch point supports punches, increases hole accuracy, improves stripping and prevents scrap from rising into the assembly.
- **Quick length adjustment**
  The external quick length adjustment button on the side of the guide allows the punch length to be adjusted without disassembly.
- **Hardened and ground guide**
  Reduces abrasive action of punching, diffuses heat effectively, resists galling, extends tool life, increases turret life and improves up time.
- **Interior and exterior spiral grease grooves**
  Even and consistent tool lubrication increases tool life.
- **Tool Lubrication**
  Interior vertical fluid grooves and fluid through holes provide even and efficient transfer of lubrication fluid to internal surfaces and to external guide surface area, increases lubrication and tool life.
- **Slug Free® die design**
  Clearing the slug every cycle eliminates slug pulling, extends tool life, improves piece part quality and reduces scrap.

[Dimensions in Inches (mm)]

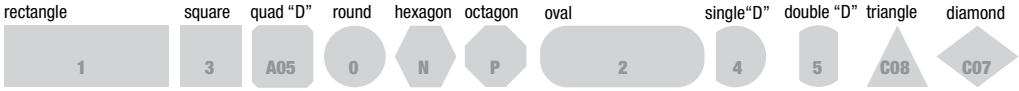
1-1/4" B STATION



See page 6 for Slug Free Light™ Dies

See page 92 for Add-Ons

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



[Dimensions in Inches (mm)]

2" C STATION

Ultra TEC® Fully Guided
Guide Assembly*
AGVS1Z

Original Style Punch Body
Round **PAAC0A**
Shaped **PAAC_A**

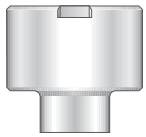
Fully Guided Stripper Plate
Round **S2KL0A**
Shaped **S2KL_A**

Slug Free® Die
Round **D0AC00**
Shaped **D0AC_0**

*Also Available
(2" C Station Only)
AGVS3Z
External keyways at
0°, 45° and 90°

3-1/2" D STATION

Ultra TEC® Fully Guided
Guide Assembly**
AGVT1Y



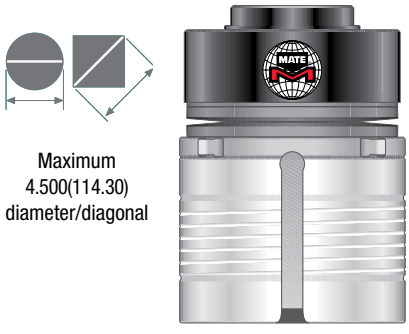
Original Style Punch Body
Round **PAAD0A**
Shaped **PAAD_A**

Fully Guided Stripper Plate
Round **S2KM0A**
Shaped **S2KM_A**

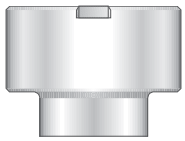
Slug Free® Die
Round **D0AD00**
Shaped **D0AD_0**

**Also Available
(3-1/2" D Station Only)
AGVT3Y
External keyways at
0°, 45° and 90°

4-1/2" E STATION

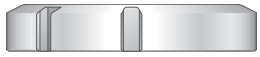


Ultra TEC® Fully Guided
Guide Assembly
AGVURZ



Original Style Punch Body
Round **PAAE0A**
Shaped **PAAE_A**

Fully Guided Stripper Plate
Round **S2KN0A**
Shaped **S2KN_A**



Slug Free® Die
Round **D0AE00**
Shaped **D0AE_0**

Lifter "T" Handle

A0LEH

[Dimensions in Inches (mm)]

ULTRA TEC® FULLY GUIDED CLAMP CLEARING FEATURES AND BENEFITS

3-1/2" D STATION

Ultra TEC® Fully Guided Clamp Clearing Guide Assmbly

Punch Retainer

Slitting Insert

"DD" Stripper Plate

"D" Stripper Plate

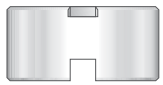
"DD" Clamp Clearing Slug Free® Die

"D" Clamp Clearing Slug Free® Die

- **Fully guided assembly**
  Accurate and close tolerances between guide and stripper hold punches rigid, control against hole distortion and saw toothing.
- **Premium high speed tool steel punches at 60-62 Rockwell C**
  Specially formulated M4PM™ high speed steel and specially developed heat treatment processes result in unusually high tool performance, superior dimensional accuracy and maximum tool life.
- **Stripper opening 0.0015(0.04) TC to point**
  Guiding at punch point supports punches, increases hole accuracy, improves stripping and prevents scrap from rising into the assembly.
- **Clamp clearing relief**
  Use this tool close to work holder clamps. The stripper and the die are relieved so the clamp can pass between the upper and the lower unit. No need to reposition the clamps, saves time, improves piece part quality.
- **Quick length adjustment**
  The external quick length adjustment button on the side of the guide allows the punch length to be adjusted without disassembly. Guide will adjust punch point length by 0.008(0.20) per click.
- **Hardened and ground guide**
  Reduces abrasive action of punching, diffuses heat effectively, resists galling, extends tool life, increases turret life and improves up time.
- **Interior and exterior spiral grease grooves**
  Even and consistent tool lubrication increases tool life.
- **Tool Lubrication**
  Interior vertical fluid grooves and fluid through holes provide even and efficient transfer of lubrication fluid to internal surfaces and to external guide surface area, increases lubrication and tool life.
- **Additional 0.079(2.00) punch grind life**
  Use insert style punches from Mate in combination with this specially designed stripper to gain additional grind life.
- **Slug Free® die design**
  Clearing the slug every cycle eliminates slug pulling, extends tool life, improves piece part quality and reduces scrap.

4-1/2" E STATION

Ultra TEC® Fully Guided Clamp Clearing Guide Assmbly



Punch Retainer

Slitting Insert

"DD" Stripper Plate

"D" Stripper Plate

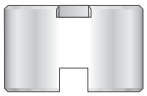
"DD" Clamp Clearing Slug Free® Die

"D" Clamp Clearing Slug Free® Die

[Dimensions in Inches (mm)]

3-1/2" D STATION

Ultra TEC® Fully Guided
Clamp Clearing
Guide Assembly



Punch Retainer

Slitting Insert

"DD" Stripper Plate

"D" Stripper Plate

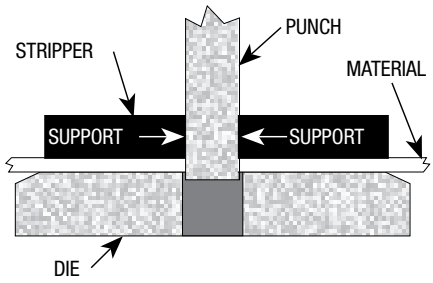
"DD" Clamp Clearing
Slug Free® Die

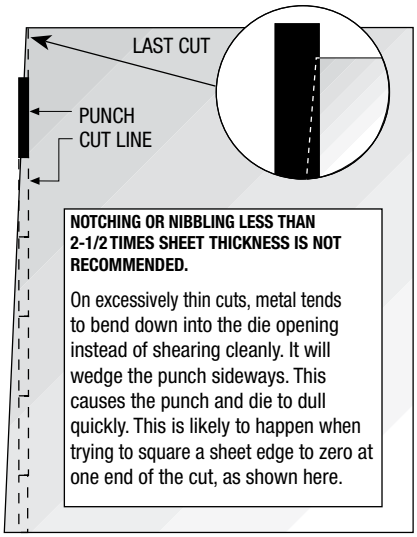
"D" Clamp Clearing
Slug Free® Die

ULTRA® CLAMP CLEARING SLITTING TOOL

This tool is specially designed for slitting and parting applications. Separating piece parts, trimming sheet edges, and reducing sheet sizes often requires the use of a tool with long narrow dimensions. Rectangles with radius corners or ovals are recommended.

Slitting and parting applications require the tool to pierce material cleanly and accurately while overcoming various side load and twisting pressures. For example, parting a sheet will include an amount of overlap in each step where sheet resistance is absent. This causes the force of resistance to build on one side which can cause the hole to distort or saw tooth. The same is true when trimming the edge of a sheet.





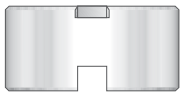
NOTCHING OR NIBBLING LESS THAN 2-1/2 TIMES SHEET THICKNESS IS NOT RECOMMENDED.

On excessively thin cuts, metal tends to bend down into the die opening instead of shearing cleanly. It will wedge the punch sideways. This causes the punch and die to dull quickly. This is likely to happen when trying to square a sheet edge to zero at one end of the cut, as shown here.

The Ultra clamp clearing slitting tool is designed to overcome these side load and twisting pressures. The advantage comes from punch point guiding. By squarely and tightly controlling the punch point where it contacts the sheet, the punch can accurately pierce a hole, even when punching partial hits.

4-1/2" E STATION

Ultra TEC® Fully Guided
Clamp Clearing
Guide Assembly

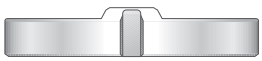


Punch Retainer

Slitting Insert

"DD" Stripper Plate

"D" Stripper Plate



"DD" Clamp Clearing
Slug Free® Die

"D" Clamp Clearing
Slug Free® Die

See page 6 for Slug Free Light™ Dies

See page 92 for Add-Ons

[Dimensions in Inches (mm)]

ULTRA TEC® FULLY GUIDED CLAMP CLEARING

3-1/2" D STATION

3.500(88.90) maximum punch diagonal/length

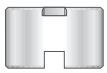
0.315(8.00) maximum punch width

3.560(90.40) maximum die diagonal/length

0.374(9.50) maximum die width

*Also Available
(3-1/2" D Station Only)
AGVT3Y
External keyways at 0°, 45° and 90°

Ultra TEC® Fully Guided Guide Assembly*
AGVT1Y



Punch Retainer
A0LD00PR

Slitting Insert
Shaped **P4AQ_A**

Clamp Clearing
"DD" Stripper Plate
Shaped **S6KW_A**

Clamp Clearing
"D" Stripper Plate
Shaped **S6KT_A**

Clamp Clearing
"DD" Slug Free® Die
Shaped **D0AW_0**

Clamp Clearing
"D" Slug Free® Die
Shaped **D0AT_0**

Lifter "T" Handle

A0LEH

4-1/2" E STATION

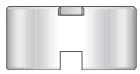
4.500(114.30) maximum punch diagonal/length

0.315(8.00) maximum punch width

4.560(115.80) maximum die diagonal/length

0.374(9.50) maximum die width

Ultra TEC® Fully Guided Guide Assembly*
AGVURZ



Punch Retainer
A0LE00PR

Slitting Insert
Shaped **P4AR_A**

Clamp Clearing
"DD" Stripper Plate
Shaped **S6KX_A**

Clamp Clearing
"D" Stripper Plate
Shaped **S6KU_A**

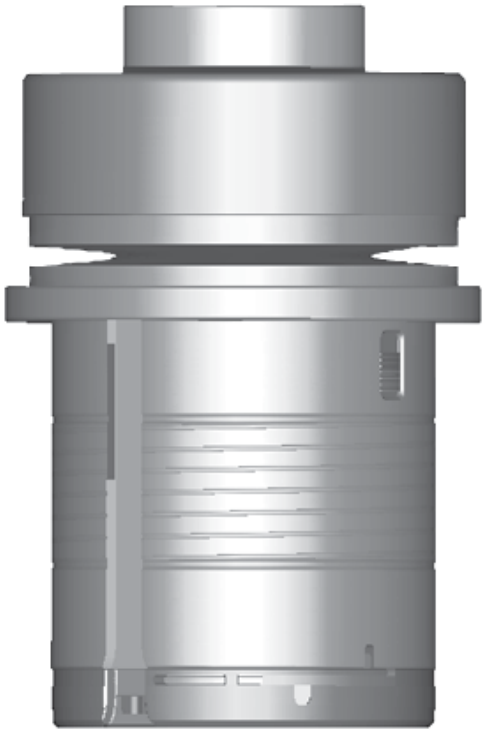
Clamp Clearing
"DD" Slug Free® Die
Shaped **D0AX_0**

Clamp Clearing
"D" Slug Free® Die
Shaped **D0AU_0**

[Dimensions in Inches (mm)]

ULTRA TEC® GUIDE ASSEMBLIES WITH M14 BOLTS

The Mate Ultra TEC® precision tooling system for thick turret punch presses increases tool performance and flexiblity, offers extended tool life, and allows interchangeability with existing tooling inventory.



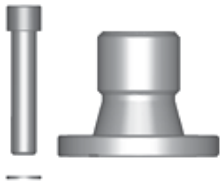
Mate Ultra TEC® punch guide assemblies with M14 bolts provide many important benefits:

- Quick length adjustment – no shims or tooling required.
- Internal and external grooves for superior lubrication.
- Hardened and ground surfaces for maximum turret bore life.
- High performance stripping springs for extended service life.
- Full compatibility with existing M14 threaded punches.
- Conversion kit for compatibility with M12 threaded punches.

Mate Ultra TEC® guides with M14 bolts are available in two versions:

ULTRA TEC®
- Quick-change stripper release mechanism allows stripper to be removed quickly and easily, without tools.
- Quick length adjustment mechanism on the side of the guide allows the punch length to be adjusted without disassembly.

ULTRA TEC® FULLY GUIDED
- Fully guided stripper to guide the punch tip for improved piece part quality and extended punch life. Ideal for slitting and nibbling applications.
- Quick length adjustment mechanism on the side of the guide allows the punch length to be adjusted without disassembly.



Also available is an M14 punch driver conversion kit to convert existing Mate Ultra TEC® guides with M12 bolts to suit punches with an M14 thread.

Tool Style / Station	2" C Station	3-1/2" D Station	4-1/2" E Station
Mate Ultra TEC® Guide with M14 bolt	**MATE02396**	**MATE00655**	**MATE01809**
Mate Ultra TEC® Fully Guided Guide with M14 bolt	**MATE00657**	**MATE00658**	**MATE01813**
Mate Ultra TEC®/Ultra XT® M14 Punch Driver Conversion Kit	**MATE00651**	**MATE00652**	**MATE00653**

[Dimensions in Inches (mm)]

½" A AND 1-¼" B STATION FEATURES AND BENEFITS

Mate's Ultra XT™ Precision Tooling System is a thick turret punching system which increases tool performance and flexibility, offers extended tool life and allows interchangeability with existing systems. Some features of the Ultra XT™ system include:

- Premium high speed tool steel punches
- Quick tool change
- Easy click length adjustment - no punch shims required
- Grooved guides for better lubrication
- Slug Free® die design
- 0.118(3.00) additional punch grind life.

PUNCHES:

- Premium high speed tool steel for extended life between regrinds and maximum productivity.
- 1/4 degree back taper and near polished flanks to reduce friction, eliminate galling and extend punch life.
- External lubrication grooves to allow fluid flow.
- Available in multiple styles:
    - Ultra TEC® with lubrication grooves.
    - Ultra® QCT™ with lubrication grooves.
    - Ultra® Metric compatible with original style punches.
    - Inch Style (1-1/4" B station only).

Option: *M4PM™ steel available in Ultra TEC® A and B station punches for superior perfomance and longevity.* *(See page 93 for details and additional information.)*

STRIPPERS:

- Fully compatible with Ultra TEC® tooling system.
- Relieved to allow 0.118(3.00) extra grind life.
- Quick-change mechanism to allow rapid tool change.

SLUG FREE® DIES:

- Slug Free® die geometry eliminates slug pulling. See page 9.
- Highly wear resistant, chrome air hardened tool steel.
- Uniform clearance radii in die corners improve edge quality.
- Up to 0.125(3.20) grind life.

CANISTER ASSEMBLIES:

- Quick length adjustment with positive engagement with the guide.
- Uniform spring pressure for reliable stripping.
- Available in multiple styles:
    - Ultra TEC® for use with Ultra TEC® and Ultra® QCT™ punches.
    - Ultra® Metric for original style punches.
    - Inch Style (1-1/4" B station only) for Inch style punches.

GUIDES WITH EXTERNAL ORIENTATION SLOTS:

- Quick-change mechanism with no tools require.
- Tool remains assembled during tool length adjustment.
- Internal and external lubrication to reduce friction.
- Hardened and ground to reduce wear.
- Available in three styles:
    - Round – internal keyway for round punches only.
    - Shaped – one precision internal keyway, 0° and 90° external keyways.
    - Shaped – one precision internal keyway, 0° and 45° external keyways.

[Dimensions in Inches (mm)]

 | 1295 Lund Boulevard, Anoka, Minnesota 55303 USA. Phone: 763.421.0230 | mate.com
orders@mate.com

Mate's Ultra XT™ Precision Tooling System is a thick turret punching system which increases tool performance and flexibility, offers extended tool life and allows interchangeability with existing systems. Some features of the Ultra XT™ system include:

- Premium high speed tool steel punches.
- Quick tool change.
- Easy click length adjustment - no punch shims required.
- Grooved guides for better lubrication.
- Slug Free® die design.
- Compatible with machine tool lubrication systems.
- OEM compatible strippers in the 2" C, 3-1/2" D, 4-1/2" E stations.

PUNCHES:

- Premium high speed tool steel for extended life between regrinds and maximum productivity.
- 1/4 degree back taper and near polished flanks to reduce friction and eliminate galling.
- Superior angularity, concentricity, and dimensional accuracy.
- Robust full-body design.
- Fully compatible with original style thick turret tooling.

STRIPPERS:

- Fully OEM compatible.
- Close tolerance opening for superior piece part quality.
- Radiused face to ease installation and reduce sheet marking.

SLUG FREE® DIES:

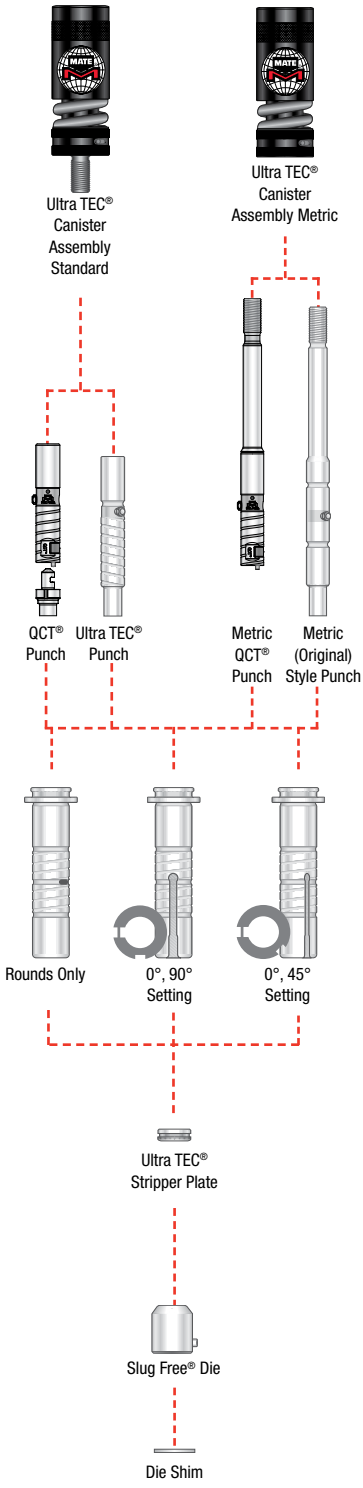
- Highly wear resistant, chrome air hardened tool steel to balance hardness and toughness.
- Slug Free® die geometry eliminates slug pulling. See page 14.
- Uniform clearance radii in die corners to improve edge quality.
- Precision orientation keyway.
- Up to 0.125(3.20) grind life.
- Superior roundness and flatness with exceptional die strength.

PUNCH GUIDE ASSEMBLY:

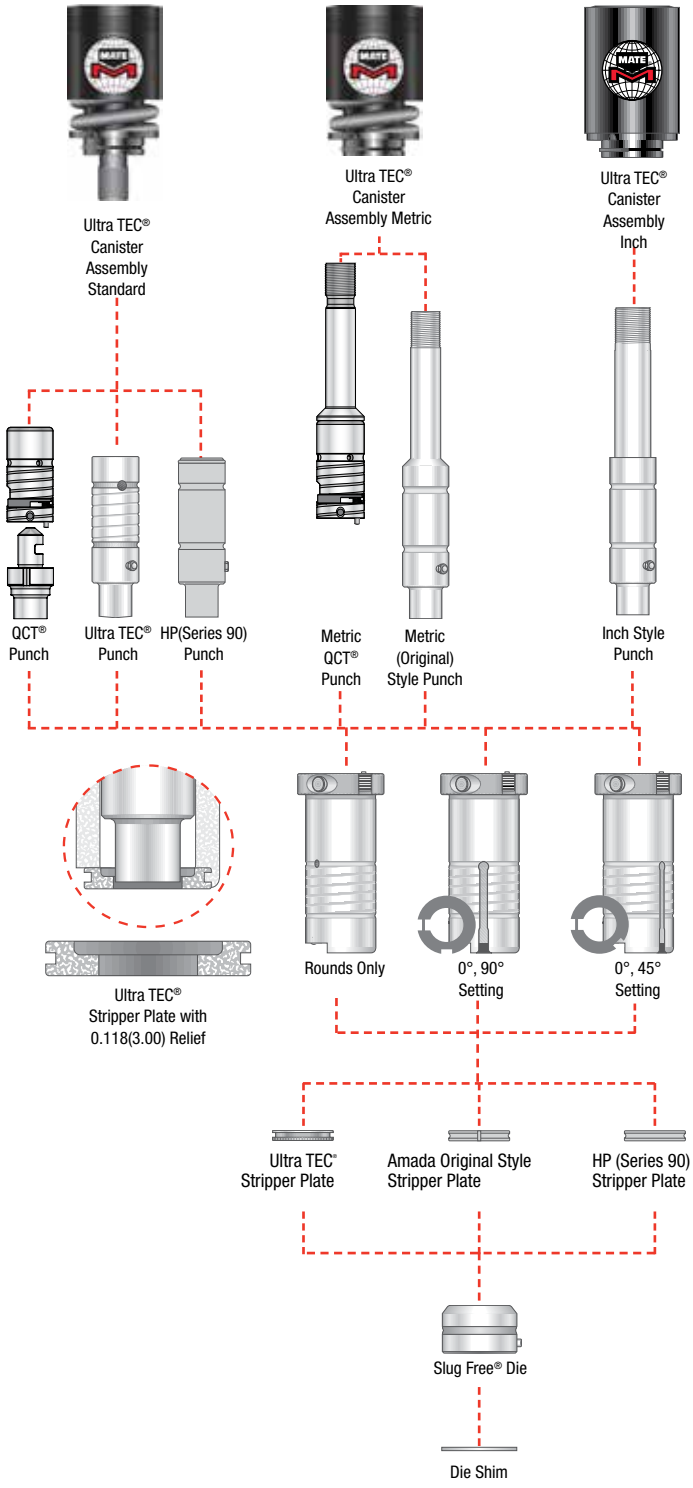
- Fully compatible with original style strippers.
- Quick length adjustment mechanism on the side of the guide allows the punch length to be adjusted without disassembly.
- Hardened and ground to stay round and true to size to greatly reduce turret bore wear.
- Internal and external lubrication grooves to reduce friction.
- High performance disc springs to optimize stripping force.

[Dimensions in Inches (mm)]

1/2" A STATION



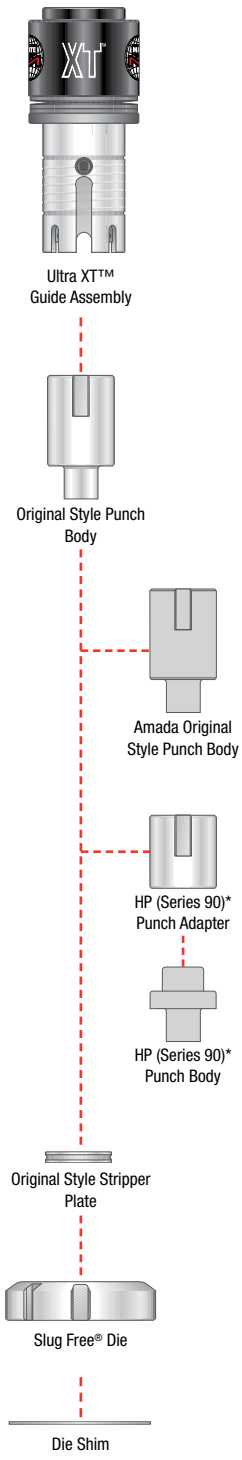
1-1/4" B STATION



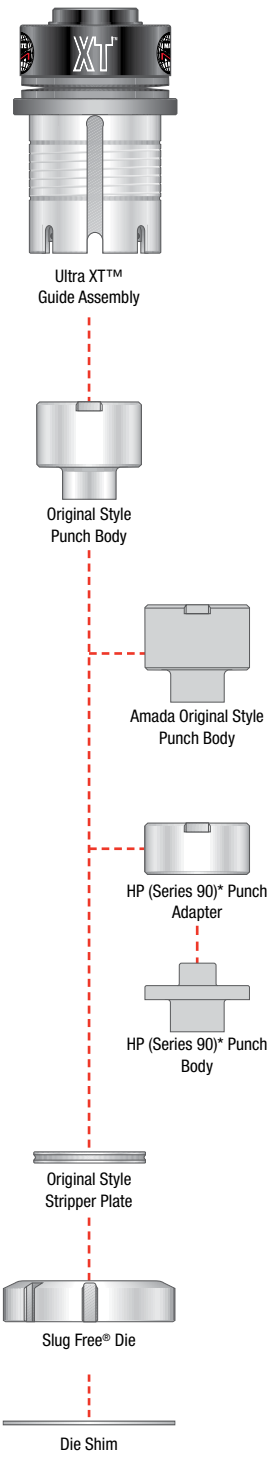
***HP WLS and HP ABS are not compatible with Ultra XT guides. Use Ultra TEC® guides.**

[Dimensions in Inches (mm)]

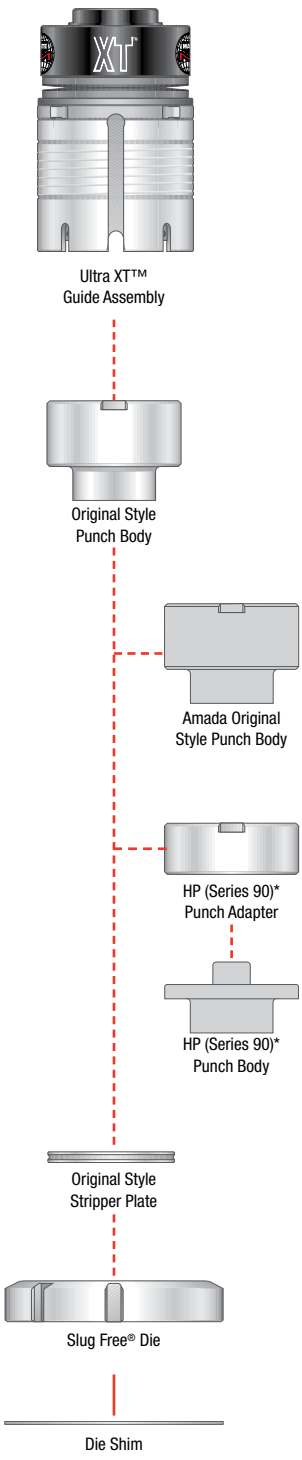
2" C STATION



3-1/2" D STATION

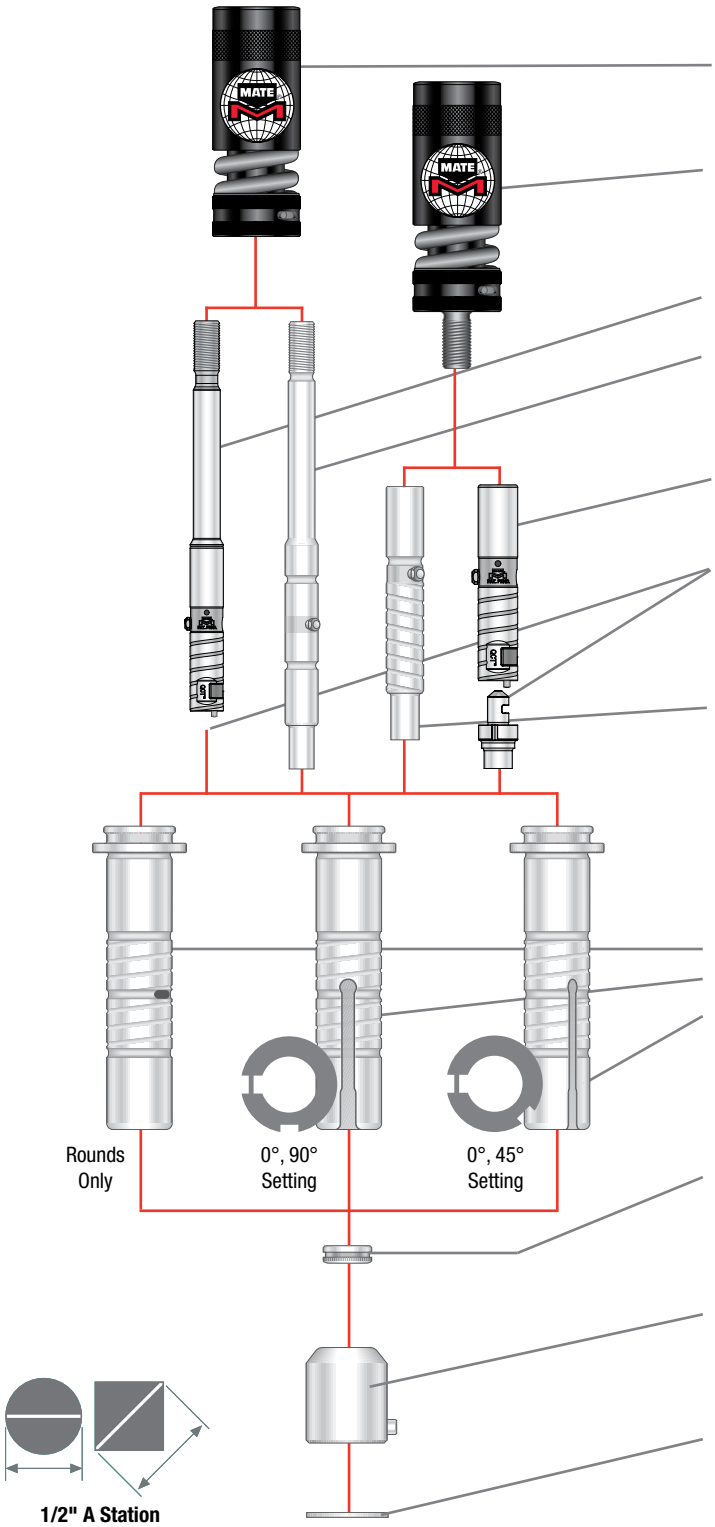


4-1/2" E STATION



[Dimensions in Inches (mm)]

ULTRA XT™ ½" A STATION ASSEMBLY FOR ULTRA TEC® AND THICK TURRET STYLE PUNCHES



Canister Assembly-Metric
MATE01362

Canister Assembly
MATE01361

Ultra® QCT™ Metric Punch Driver
Keyed **MATE02519**
Keyless **MATE02520**

Metric (Original) Style Punch Body
Round **PAAA0A**
Shaped **PAAA_A**

Ultra® QCT™ Driver
MATE02404

Ultra® QCT™ Punch Insert
Round **PAQA0A**
Shaped **PAQA_A**

Ultra TEC® Punch Body
Round **PAUA0A**
Shaped **PAUA_A**

Ultra XT™ Guide
Round **A0VA0SGU**
Shaped **MATE00204**
Shaped **MATE00205**

Ultra TEC® Stripper Plate
Round **S6KA0A**
Shaped **S6KA_A**

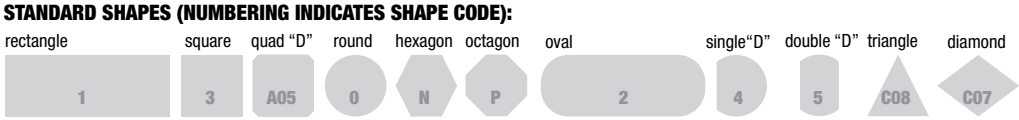
Slug Free® Die
Round **D0AA00**
Shaped **D0AA_0**

Die Shims
MSAA
Package of 12 total, 3 each of:
0.008(0.20)
0.016(0.40)
0.032(0.80)
0.048(1.20)

1/2" A Station
Maximum 0.500(12.70) diameter/diagonal

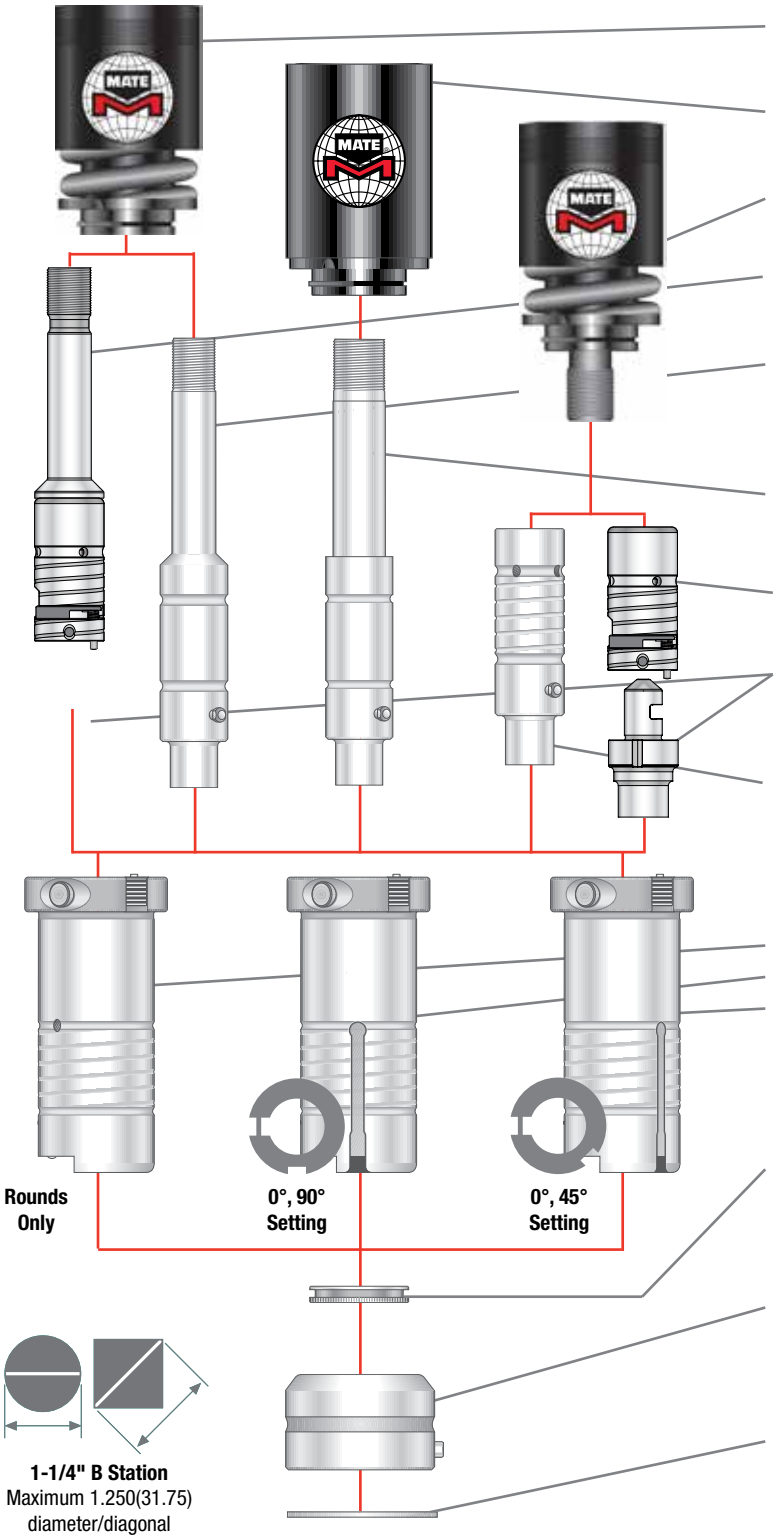
See page 6 for Slug Free Light™ Dies
See page 92 for Add-Ons

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



[Dimensions in Inches (mm)]

ULTRA XT™ 1-¼" B STATION ASSEMBLY FOR ULTRA TEC® AND THICK TURRET STYLE PUNCHES



Canister Assembly-Metric
MATE01076

Canister Assembly-Inch
A0VBWSCA

Canister Assembly
MATE01078

Ultra® QCT™ Metric Punch Driver
Keyed **MATE02521**
Keyless **MATE02522**

Metric (Original) Style Punch Body
Round **PAAB0A**
Shaped **PAAB_A**

Inch Style Punch Body
Round **PAJB0A**
Shaped **PAJB_A**

Ultra® QCT™
Driver **MATE02401**

Ultra® QCT™ Punch Insert
Round **PAQB0A**
Shaped **PAQB_A**

Ultra TEC® Punch Body
Round **PAUB0A**
Shaped **PAUB_A**

Ultra XT™ Guide
Round **A0VB0SGU**
Shaped **MATE00206**
Shaped **MATE00207**

Ultra TEC® Stripper Plate
Round **S6KB0A**
Shaped **S6KB_A**

Slug Free® Die
Round **D0AB00**
Shaped **D0AB_0**

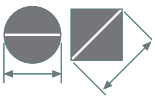
Die Shims
MSAB
Package of 12 total, 3 each of:
0.008(0.20)
0.016(0.40)
0.032(0.80)
0.048(1.20)

See page 6 for Slug Free Light™ Dies
See page 92 for Add-Ons

[Dimensions in Inches (mm)]

ULTRA XT™ GUIDE ASSEMBLIES FOR THICK TURRET STYLE TOOLING

2" C STATION



Maximum
2.000(50.80)
diameter/diagonal

Ultra XT™ Guide Assembly
MATE00209

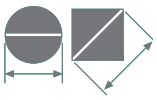
Original Style Punch Body
Round **PAAC0A**
Shaped **PAAC_A**

Original Style Stripper Plate
Round **S6AC0A**
Shaped **S6AC_A**

Slug Free® Die
Round **D0AC00**
Shaped **D0AC_0**

Die Shims
MSAC
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)

3-1/2" D STATION



Maximum
3.500(88.90)
diameter/diagonal

Ultra XT™ Guide Assembly
MATE00211

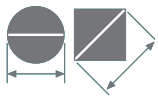
Original Style Punch Body
Round **PAAD0A**
Shaped **PAAD_A**

Original Style Stripper Plate
Round **S6AD0A**
Shaped **S6AD_A**

Slug Free® Die
Round **D0AD00**
Shaped **D0AD_0**

Die Shims
MSAD
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)

4-1/2" E STATION



Maximum
4.500(114.30)
diameter/diagonal

Ultra XT™ Guide Assembly
MATE01814

Original Style Punch Body
Round **PAAE0A**
Shaped **PAAE_A**

Original Style Stripper Plate
Round **S6AE0A**
Shaped **S6AE_A**

Slug Free® Die
Round **D0AE00**
Shaped **D0AE_0**

Die Shims
MSAE
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)

6" F STATION ULTRA XT ASSEMBLY

Ultra XT™ Guide Assembly
MATE02070

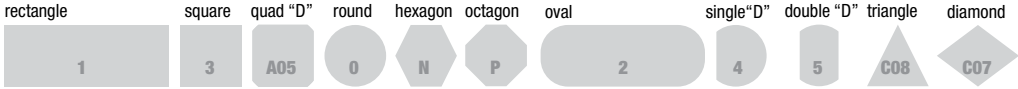
Original Style Punch Body
Round **PAAF0A**
Shaped **PAAF_A**

Original Style Stripper Plate
Round **S6AF0A**
Shaped **S6AF_A**

Slug Free® Die
Round **D0AF0A**
Shaped **D0AF_A**

Die Shims
MSAF
Package 3 each:
0.016(0.40),
0.032(0.80),
0.048(1.20)

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



See page 6 for Slug Free Light™ Dies

See page 92 for Add-Ons

[Dimensions in Inches (mm)]

Mate's Original Style Thick Turret Tooling is fully OEM compatible tooling with several design enhancements. Premium High Speed Tool Steel is a standard feature in all Mate Thick Turret punches.

PUNCHES:
- Premium high speed tool steel - optimum edge wear resistance.
- 1/4 degree back taper and near polished flanks to reduce friction and eliminate galling.
- Exceptional dimensional accuracy and tool life.
- Minute corner radii to reduce chipping.
- Superior angularity and concentricity.

STRIPPERS:
- Fully OEM compatible.
- Close tolerance opening - superior piece part quality.
- Precision alignment slots - superior piece part quality.
- Hardened and ground - to reduce friction.
- Radiused face - to reduce sheet marking.

SLUG FREE® DIES:
- Highly wear resistant, chrome air hardened tool steel.
- Slug Free® die geometry eliminate slug pulling.
- Uniform clearance radii in die corners for improved piece part quality.
- Precision orientation with hardened pin.
- Up to 0.125(3.20) grind life.
- Improved die strength.
- Superior roundness and flatness.

PUNCH HEAD:
- Hexagonal design and 12.9 grade socket head cap screw for easier installation and adjustment.

SPRING:
- High performance spring shot peened prior to painting for extended service life.

SPRING RETAINER:
- Reversible design returns the punch point to "new" position by turning over retainer after 0.078(2.00) has been removed during regrinding.

[Dimensions in Inches (mm)]

FEATURES AND BENEFITS 2" C, 3-½" D, 4-½" E AND 6" F STATION

Mate's Original Style Thick Turret Tooling is fully OEM compatible tooling with several design enhancements. Premium High Speed Tool Steel is a standard feature in all Mate Thick Turret punches.

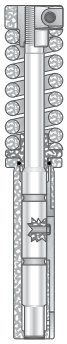
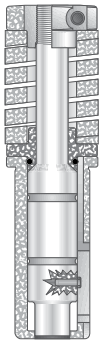
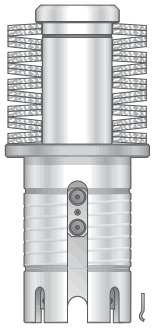
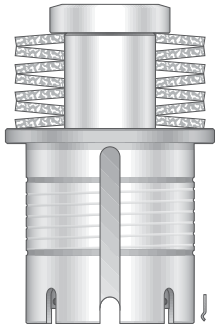
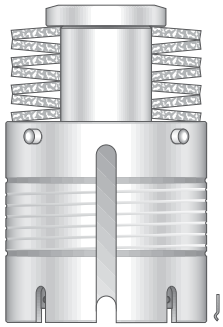
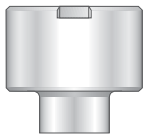
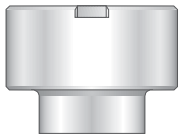
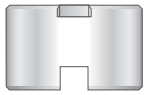
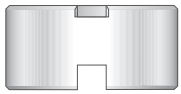
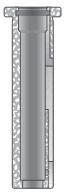
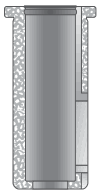
PUNCHES:
- Premium high speed tool steel - optimum edge wear resistance.
- 1/4 degree back taper and near polished flanks to reduce friction and eliminate galling.
- Exceptional dimensional accuracy and tool life.
- Minute corner radii to reduce chipping.
- Superior angularity and concentricity.

SLUG FREE® DIES:
- Highly wear resistant, chrome air hardened tool steel.
- Slug Free® die geometry eliminates slug pulling.
- Uniform clearance radii in die corners for improved piece part quality.
- Precision orientation with external keyway.
- Up to 0.125(3.20) grind life.
- Improved die strength.
- Superior roundness and flatness.

STRIPPER:
- Fully OEM compatible.
- Close tolerance opening for superior piece part quality.
- Radiused face to ease installation and reduce sheet marking.

PUNCH GUIDE ASSEMBLY:
- Fully OEM compatible.
- Hardened and ground to reduce turret bore wear.
- Internal and external lubrication grooves to reduce friction.
- High performance disc springs to optimize stripping force throughout the service life of the machine.

[Dimensions in Inches (mm)]

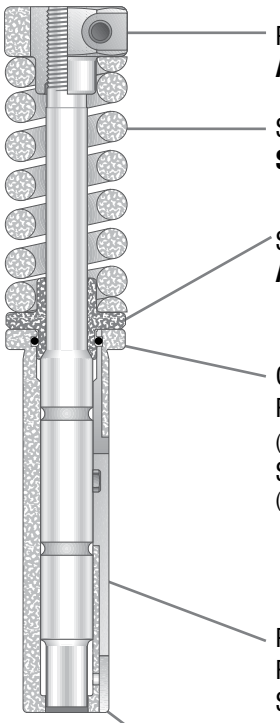
1/2" A STATION	1-1/4" B STATION	2" C STATION	3-1/2" D STATION	4-1/2" E STATION
				
Punch Assembly	Punch Assembly	Punch Guide Assembly	Punch Guide Assembly	Punch Guide Assembly
		Punch Shim	Punch Shim	Punch Shim
 Punch Body	 Punch Body	 Punch Body	 Punch Body	 Punch Body
		 Punch Retainer	 Punch Retainer	 Punch Retainer
 Punch Guide	 Punch Guide	 Slitting Insert	 Slitting Insert	 Slitting Insert
		 Stripper Plate	 Stripper Plate	 Stripper Plate
 Slug Free® Die	 Slug Free® Die	 Slug Free® Die	 Slug Free® Die	 Slug Free® Die
Die Shim	Die Shim	Die Shim	Die Shim	Die Shim

FEATURES INCLUDE:

- OEM compatible
- Hardened and ground guides
- Premium high speed tool steel punches
- Slug Free® die

[Dimensions in Inches (mm)]

½" A STATION ASSEMBLY



Punch Head
A0LA00PH

Stripping Spring
SPR33662

Spring Retainer
A0LA00SR

O-Ring
Round **MIS60548***
(12 minimum)
Shaped **MIS60468***
(12 minimum)

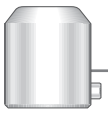
Punch Body
Round **PAAA0A**
Shaped **PAAA_A**

Punch Guide (Includes O-Ring)
Round **S6AA0A**
Shaped **S6AA_A**

Hardware
XPAAAA

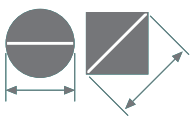
Punch Assembly
Round
Shaped

Complete Assembly
Round
Shaped



Slug Free® Die
Round **D0AA00**
Shaped **D0AA_0**

Die Shims
MSAA
Package of 12 total, 3 each of:
0.008(0.20)
0.016(0.40)
0.032(0.80)
0.048(1.20)



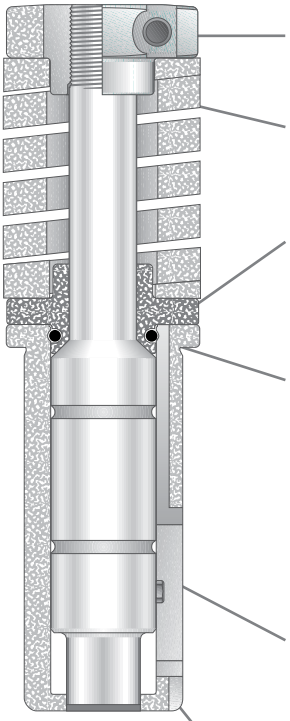
1/2" A Station
Maximum 0.500(12.70)
diameter/diagonal

* Items sold separately
beyond minimum quantity

See page 92 for Add-Ons

[Dimensions in Inches (mm)]

1-¼" B STATION ASSEMBLY



Punch Head
A0LB00PH

Stripping Spring
SPR33689

Spring Retainer
A0LB00SR

O-Ring
MIS60556*
(12 minimum)

Punch Body
Round **PAAB0A**
Shaped **PAAB_A**

Punch Guide
Round **S6AB0A**
Shaped **S6AB_A**

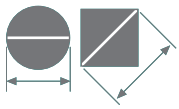
Hardware
XPABAA

Punch Assembly
Round
Shaped

Complete Assembly
Round
Shaped

Slug Free® Die
Round **D0AB00**
Shaped **D0AB_0**

Die Shims
MSAB
Package of 12 total, 3 each of:
0.008(0.20)
0.016(0.40)
0.032(0.80)
0.048(1.20)



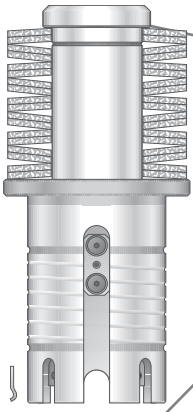
1-1/4" B Station
Maximum 1.250(31.75)
diameter/diagonal

See page 92 for Add-Ons

* Items sold separately beyond minimum quantity

[Dimensions in Inches (mm)]

2” C STATION ASSEMBLY



Punch Guide Assembly
AGLC1

Punch Shims
VSAC
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)

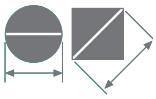
Punch Body
Round **PAAC0A**
Shaped **PAAC_A**

Stripper Plate
Round **S6AC0A**
Shaped **S6AC_A**

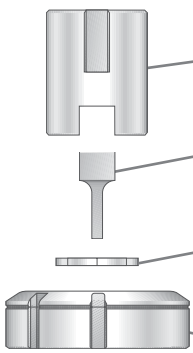
Slug Free® Die
Round **D0AC00**
Shaped **D0AC_0**

Set Assembly
Round
Shaped

Die Shims
MSAC
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)



Maximum
2.000(50.80)
diameter/diagonal



Punch Retainer
A0LC00PR

Slitting Insert
Shaped **P4AP_A**

Die Inserts
Shaped **D0KP_0**

Slitting Die Body
A0LC00SD

Slitting Tool Components

D/L = Diagonal/Length
R C = Radius Corners

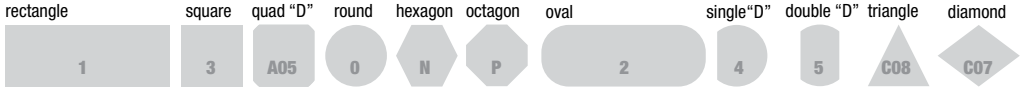
Slitting Insert with Slug Free® Die
2.000(50.80) max. D/L
0.709(18.00) max. width

Slug Free® Die
2.059(52.30) max. D/L
0.768(19.50) max. width

Slitting Insert with Die Inserts
2.000(50.80) max. D/L
0.268(6.80) max. width

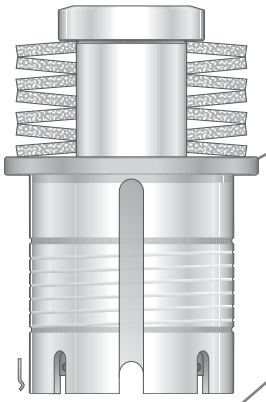
Die Inserts, Rectangles and Ovals
2.028(51.50) max. D/L
0.295(7.50) max. width

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



[Dimensions in Inches (mm)]

3-½" D STATION ASSEMBLY



Punch Guide Assembly
AGLD1

Punch Shims
VSAD
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)

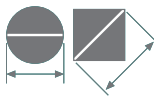
Punch Body
Round **PAAD0A**
Shaped **PAAD_A**

Stripper Plate
Round **S6AD0A**
Shaped **S6AD_A**

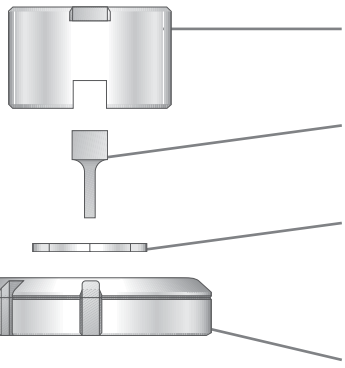
Slug Free® Die
Round **D0AD00**
Shaped **D0AD_0**

Set Assembly
Round
Shaped

Die Shims
MSAD
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)



Maximum
3.500(88.90)
diameter/diagonal



Punch Retainer
A0LD00PR

Slitting Insert
Shaped **P4AQ_A**

Die Inserts
Shaped **D0KQ_0**

Slitting Die Body
A0LD00SD

Slitting Tool Components

D/L = Diagonal/Length
R C = Radius Corners

Slitting Insert with Slug Free® Die
3.500(88.90) max. D/L
0.709(18.00) max. width

Slug Free® Die
3.559(90.40) max. D/L
0.768(19.50) max. width

Slitting Insert with Die Inserts
3.500(88.90) max. D/L
0.315(8.00) max. width

Die Inserts R C ≤ 0.125(3.18)
3.384(85.95) max. length
0.335(8.50) max. width
OR
3.539(89.90) max. length
0.175(4.45) max. width

Die Inserts R C > 0.125(3.18) and Ovals
3.520(89.40) max. length
0.335(8.50) max. width

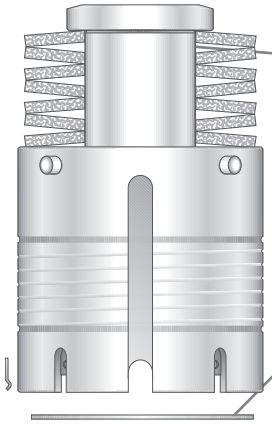
See page 92 for Add-Ons

Lifter "T" Handle

A0LEH

[Dimensions in Inches (mm)]

4-½" E STATION ASSEMBLY



Punch Guide Assembly
AGLE1

Punch Shims
VSAE
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)

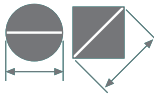
Punch Body
Round **PAAE0A**
Shaped **PAAE_A**

Stripper Plate
Round **S6AE0A**
Shaped **S6AE_A**

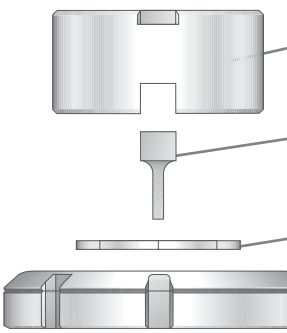
Set Assembly
Round
Shaped

Slug Free® Die
Round **D0AE00**
Shaped **D0AE_0**

Die Shims
MSAE
Package 3 each:
0.016(0.40), 0.032(0.80), 0.048(1.20)



Maximum
4.500(114.30)
diameter/diagonal



Punch Retainer
A0LE00PR

Slitting Insert
Shaped **P4AR_A**

Die Inserts
Shaped **D0KR_0**

Slitting Die Body
A0LE00SD

Slitting Tool Components

D/L = Diagonal/Length
R C = Radius Corners

Slitting Insert with Slug Free® Die
4.500(114.30) max. D/L
0.709(18.00) max. width

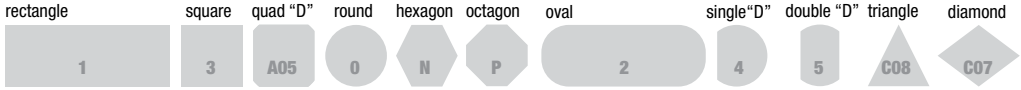
Slug Free® Die
4.559(115.80) max. D/L
0.768(19.50) max. width

Slitting Insert with Die Inserts
4.500(114.30) max. D/L
0.315(8.00) max. width

Die Inserts R C ≤ .125(3.18)
4.411(112.05) max. length
0.335(8.50) Max. width
OR
4.539(115.30) max. length
0.236(6.00) max. width

Die Inserts R C > .125(3.18) and Ovals
4.539(115.30) max. length
0.335(8.50) max. width

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



[Dimensions in Inches (mm)]

Punch Guide Assembly:

This punch guide assembly is designed to fit all thick turret machines with a 6" F station. The guide assembly incorporates many performance features including:

- Hardened guide body.
- High performance disc springs.
- High tensile draw bolt.
- Precision internal punch key.
- Internal and external lubrication grooves.
- Spring steel stripper clips.
- Fully OEM compatible.

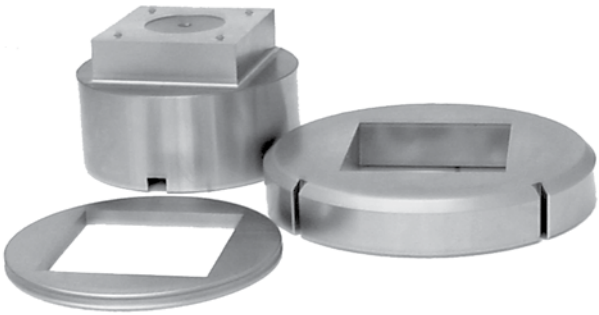
Punches, Strippers, and Dies

Mate offers a comprehensive range of punches, strippers and dies to suit the thick turret 6" F Station.

- High Speed Steel Punches.
- Toughened Strippers.
- Shock Steel Dies.

Special Assembly Applications

Available on request. Contact your Mate applications specialist.



PUNCH GUIDE ASSEMBLY
AGLF1

PUNCH
Round **PAAF0A**
Shaped **PAAF_A**

STRIPPER
Round **S6AF0A**
Shaped **S6AF_A**

DIE
Round **D0KF00**
Shaped **D0KF_0**

PUNCH SHIMS
VSAF

[Dimensions in Inches (mm)]

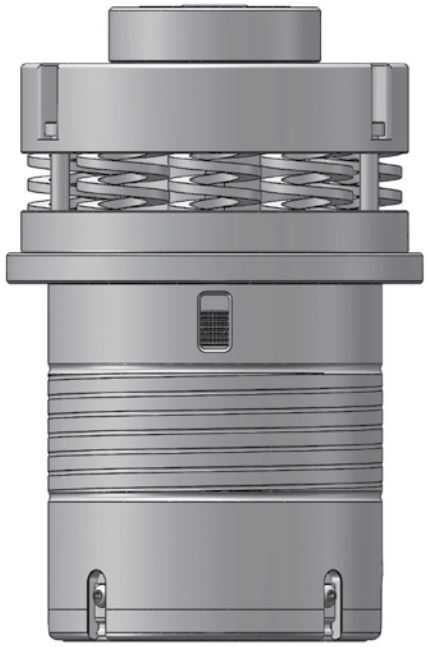
THICK TURRET PUNCH GUIDE ASSEMBLIES WITH ULTRA LIGHT™ SPRING PACKS

Mate Ultra Light™ spring packs provide precise control of the stripping pressure when using any thick turret guide assembly manufactured by Mate. Benefits include:

- Reduced spring pressure to eliminate unwanted sheet marking. Designed for thin or decorative materials.
- Ideal for high polish, textured, pre-painted or reflective metals where finish appearance is critical.
- Quieter punching in all applications. Noise levels reduced by as much as 10 decibels.
- Maximum control over total spring pressure. Combine two sets of springs for nine pressure variations. See table.

Mate punch guide assemblies complete with Mate Ultra Light™ spring packs are now available for popular thick turret tooling styles including:

- Mate Ultra TEC®
- Mate Ultra TEC® Fully Guided
- Mate Ultra XT™
- Original Style Thick Turret



Note: Your existing Mate thick turret guides can be retrofitted with Mate Ultra Light™ spring packs.

TOOL STYLE	STATION	PART NUMBER
Mate Ultra TEC®	2" C	**MATE02395**
	3-1/2" D	**MATE00488**
	4-1/2" E	**MATE01807**
Mate Ultra TEC® Fully Guided	2" C	**MATE00490**
	3-1/2" D	**MATE00491**
	4-1/2" E	**MATE01811**
Mate Ultra XT™	2" C	**MATE00496**
	3-1/2" D	**MATE00497**
	4-1/2" E	**MATE01815**
	6" F	**MATE02072**
Original Style Thick Turret	2" C	**MATE00493**
	3-1/2" D	**MATE00494**
	4-1/2" E	**MATE00495**
	6" F	**MATE02328**
Additional springs for heavier application. (pack of 9)	2" C	**MATE00280**
	3-1/2" D	**MATE00281**
	4-1/2" E	**MATE00281**

Mate Ultra Light™ spring packs are supplied with 9 blue springs. The spring pressure can be altered by removing and/or replacing the springs. Additional red and gold springs are available.

Use the table below to select the spring combination to achieve the desired stripping pressure. The spring pressure is stated as the percentage achieved in the Ultra Light™ guide as compared to an Ultra TEC® disc spring stack.

2" C Station		3-1/2" D Station 4-1/2" E Station	
3 blue	4%	3 blue	5%
6 blue	7%	6 blue	10%
9 blue	10%	3 red	11%
3 gold	12%	9 blue	15%
3 blue + 3 gold	15%	3 blue + 3 red	16%
6 blue + 3 gold	19%	6 blue + 3 red	21%
6 gold	25%	6 red	22%
3 blue + 6 gold	27%	3 blue + 6 red	27%
9 gold	36%	9 red	33%

[Dimensions in Inches (mm)]

Mate's new AMX™ Thick Turret ABS Tooling offers the superior replacement alternative fabricators have been waiting for! AMX Tooling provides 100% worry free compatability with AMADA® ABS assemblies and holders. PLUS, you have the flexibility of using AMX punches with Mate's Ultra TEC® Tooling System. Mate incorporated advanced metallurgy and lubrication delivery systems to prevent galling, slivering, and slug pulling. As with all Mate products, AMX is backed by Best-In-Class service and our 100% Customer Satisfaction Guarantee.

AMX™ PUNCHES

- 100% worry free compatibility with Amada assemblies.
- Holder compatible with Mate Ultra TEC® and Ultra TEC® Fully Guided systems.
- M2 High Speed Steel - OEM equivalent. Superior to other after-market replacements, M2 lasts longer between regrinds.
- Precision gun drilled ABS channels on A and B-station punches.
- Standard external spiral lubrication grooves on A & B-station punches ensures uniform fluid flow for friction free punch-to-guide operation.
- 1/4 degree total back taper reduces galling.
- Hardened pin for precise orientation of punches for improved piece part quality.
- Maxima™ coating and Nitride treatment available for special application needs.

AMX™ A AND B-STATION STRIPPER GUIDES

- Available for A and B-station punches.
- Stripper opening incorporates blips for ABS compatibility.
- Fully hardened and ground for maximum precision and long life.
- Two styles:
  - Rounds, with internal keyway.
  - Shapes, with multiple precision keyways.
- Stripper relieved to allow 0.118(3,00) extra grind life.
- Rounded edges to minimize sheet marking.

AMX™ C, D, AND E STRIPPERS

- Fully compatible with AMADA ABS systems.
- Relieved to allow 0.078(2,00) extra grind life.
- Rounded edges to minimize sheet marking.
- Blips around stripper opening for ABS functionality.

[Dimensions in Inches (mm)]

A-STATION PUNCH

ROUND	**PMXA0A**
SHAPE	**PMXA_A**

A-STATION STRIPPER GUIDE

ROUND	**SMXA0A**
SHAPE	**SMXA_A**

B-STATION PUNCH

ROUND	**PMXB0A**
SHAPE	**PMXB_A**

B-STATION STRIPPER GUIDE

ROUND	**SMXB0A**
SHAPE	**SMXB_A**

C-E-STATION PUNCHES

ROUND	**PMXC0A**
SHAPE	**PMXC_A**
ROUND	**PMXD0A**
SHAPE	**PMXD_A**
ROUND	**PMXE0A**
SHAPE	**PMXE_A**

C-E-STATION STRIPPERS

ROUND	**SMXC0A**
SHAPE	**SMXC_A**
ROUND	**SMXD0A**
SHAPE	**SMXD_A**
ROUND	**SMXE0A**
SHAPE	**SMXE_A**

PUNCH HEAD ASSEMBLIES

A-STATION	**XPAAMX**
B-STATION	**XPABMX**

AMX SEAL KIT*

A-STATION	**MATE01880**
B-STATION	**MATE01883**

D-E STATION SLITTING SYSTEMS

D-STATION AMX Punch Insert Retainer Assembly	**MATE01988**
E-STATION AMX Punch Insert Retainer Assembly	**MATE01990**
D-STATION Slitting Insert with M4 Material	**P4AQ_A**
E-STATION Slitting Insert with M4 Material	**P4AR_A**

A & B-station punches

A & B-station stripper guides

C-station stripper

D-station stripper

E-station stripper

Add Ons for Rounds and Shapes:

Coating or Treatment for Punches:

	SuperMax™ Coating	Maxima™ Coating or Nitride Treatment
A-Station:		
B-Station:		
C-Station:		
D-Station:		
E-Station:		

Narrow Width:

Round point diameter
0.020(0.51) to 0.061(1.55):

Round point diameter
0.062 (1.55) to 0.092(2.34):

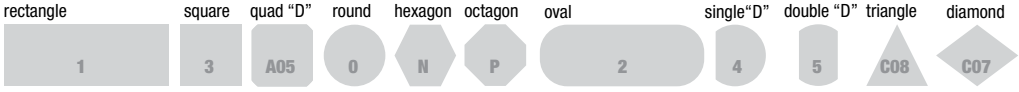
Shape point width
is less than 0.079(2.00):

Non-Standard Angle Setting:

Punches:

*To make your existing Mate A & B-Station Original Style punch head assemblies ABS compatible, use this AMX Seal Kit.

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):

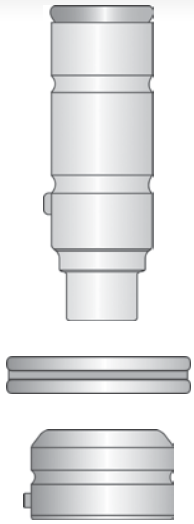


[Dimensions in Inches (mm)]

- DuraSteel™ with superior hardness and toughness for extended interval between regrinds.
- Hardened pin for precise orientation of punches for improved piece part quality.

- Smooth rounded edges to eliminate sheet marking and improve piece part quality.

- Slug Free® die geometry eliminates slug pulling to improve piece part quality and increase tool life.



- 1/4 degree back taper and near polished punch flanks to reduce friction, eliminate galling, and maximize punch life.
- Maxima™ coating available for extreme applications.

- Compatible with existing HP (Series 90) tooling inventory for maximum flexibility.

- Highly wear-resistant tool steel provides optimum balance between hardness and toughness, for extended life.

MATE DURASTEEL™ HIGH PERFORMANCE TOOL STEEL

Mate DuraSteel™ is an air hardening tool steel designed specifically for use in high performance tooling systems.

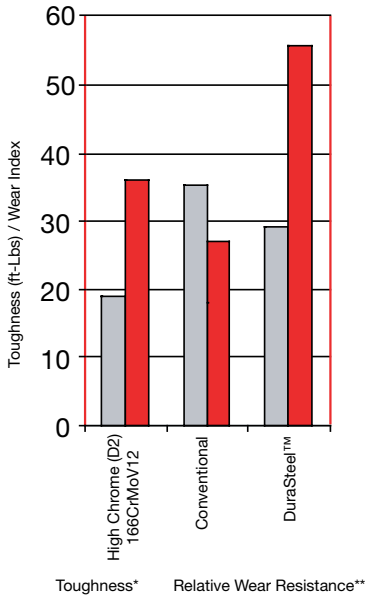
A combination of the chemical composition of Mate DuraSteel and the closely controlled manufacturing process results in an upgrade to conventional High Chrome D2 tool steel. It offers better wear resistance, greater toughness, better compressive strength, and higher attainable hardness.

Mate DuraSteel is a high quality tool steel which has many advantages when compared to alternative tool steels commonly available. These advantages include:

Superior Wear Resistance – Mate DuraSteel offers superior resistance to adhesive- and abrasive-wear to maximize the interval between regrinds.
- Increased Vanadium carbides – harder wearing than chromium carbides for greater resistance to abrasive-wear.
- Increased Tungsten carbides – harder wearing and offer better red hardness; increased resistance to high temperatures which may anneal or damage the material.
- Higher hardness – increased alloy content results in higher effective hardness for better wear resistance.

Increased Toughness – the chemical composition and heat treatment processes used with Mate DuraSteel make it tougher than conventional tool steels in impact strength tests.
- The inclusion of tungsten and vanadium allows the carbon content to be reduced, which increases the toughness.

Better Value – Customer trials have shown that tools manufactured in Mate DuraSteel last 100% longer between regrinds than tools manufactured using conventional tool steels. By increasing the interval between regrinds, the tooling lasts longer and punches many more holes before needing to be replaced.



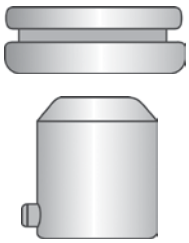
DuraSteel™ Chemical Composition	
Carbon	1.10%
Chromium	7.50%
Vanadium	2.40%
Tungsten	1.15%
Molybdenum	1.60%

[Dimensions in Inches (mm)]

MXC™ Punch - Standard	Part Number	Price
Round	**PXCA0A**	
Shape	**PXCA_A**	
Maxima™ Coating		
MXC™ Punch - ABS Style*		
Round	**PLCA0A**	
Shape	**PLCA_A**	
Maxima™ Coating		
MXC™ Stripper		
Round	**SXCA0A**	
Shape	**SXCA_A**	
Slug Free® Die		
Round	**D0AA00**	
Shape	**D0AA_0**	
Slug Free Light™ Die Option		
Round		
Shape		
Die Shim Package of 12 total, 3 each of: 0.008(0.20) 0.016(0.40) 0.032(0.80) 0.048(1.20)	**MSAA**	

MXC™ Punch Standard Style

MXC™ Punch ABS Style



PUNCH

- DuraSteel™ with superior hardness and toughness for extended interval between regrinds.
- Hardened double-D key for precise orientation of punches for improved piece part quality.
- 1/4 degree back taper and near polished punch flanks to reduce friction, eliminate galling, and maximize punch life.
- Maxima™ coating available to reduce friction in extreme applications. Less friction means less heat build up, less galling and longer tool life.

Option: *M4PM™ steel available for superior perfomance and longevity. (See page 89 for details and additional information.)*

STRIPPER

- Smooth rounded edges to eliminate sheet marking and improve piece part quality.
- Compatible with existing conventional tooling inventory for maximum flexibility.

SLUG FREE® DIE

- Slug Free die geometry eliminates slug pulling to improve piece part quality and increase tool life.
- Highly wear-resistant tool steel provides optimum balance between hardness and toughness, for extended life.

Mate's MXC™ Tooling System is a thick turret punching system which increases tool performance and flexibility, offers extended tool life and allows interchangeability with existing systems. Some features of the MXC system include:

- **DuraSteel™ punches**
- **100% Compatible with:**
  HP™
  HP™ WLS®
  HP™ ABS
- **Compatible with:**
  Ultra TEC®
  Ultra XT™
- **Slug Free® die design**

*ABS Style also works in WLS environment

Mate MXC™ A and B-station tooling is produced under license from Wilson Tool International, Inc.

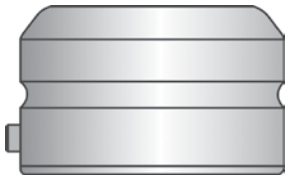
See page 55 for Add-Ons and Accessories

[Dimensions in Inches (mm)]

MXC™ Punch - Standard	Part Number	Price
Round	**PXCB0A**	
Shape	**PXCB_A**	
Maxima™ Coating		
Anti-Rotation Pin	**MATE00752**	
Retaining Ring	**RRI00010**	
MXC™ Punch - ABS Style		
Round***	**PLCB0A**	
Shape***	**PLCB_A**	
Maxima™ Coating		
Anti-Rotation Pin	**MATE00752**	
Retaining Ring	**RRI00010**	
Felt Pad**	**FLT00001**	
MXC™ Stripper		
Round	**SXCB0A**	
Shape	**SXCB_A**	
Retaining Ring*	**MATE00754**	
Slug Free® Die		
Round	**D0AB00**	
Shape	**D0AB_0**	
Slug Free Light™ Die Option		
Round		
Shape		
Die Shim Package of 12 total, 3 each of: 0.008(0.20) 0.016(0.40) 0.032(0.80) 0.048(1.20)	**MSAB**	

MXC™ Punch
Standard Style

MXC™ Punch
ABS Style



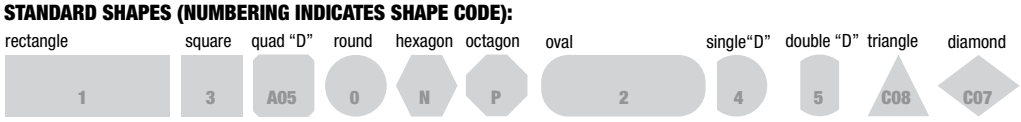
* Stripper retaining ring not included with stripper
** Add felt pad (not included with punch) to ABS style punch to work in WLS® environment
*** MXC™ ABS B-station punches are compatible with Wilson Fully Indexable R series 3 station MT for Finn-Power

Option: *M4PM™ steel available for superior perfomance and longevity. (See page 93for details and additional information.)*

Mate MXC™ A and B-station tooling is produced under license from Wilson Tool International, Inc.

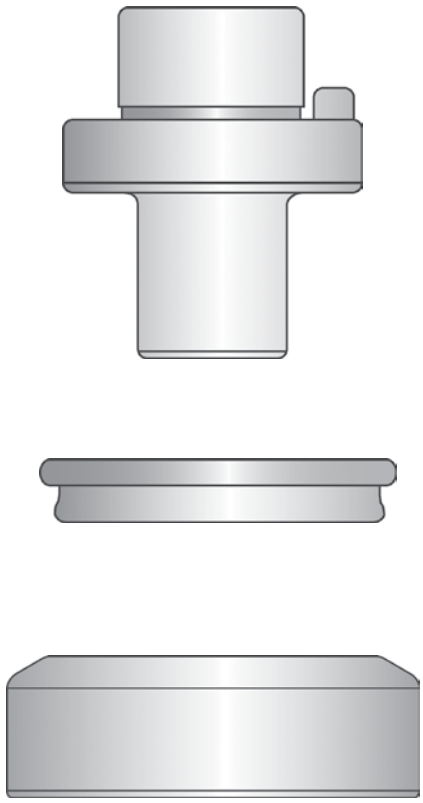
See page 55 for Add-Ons and Accessories

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



[Dimensions in Inches (mm)]

MXC™ Punch - Standard	Part Number	Price
Round	**PXCC0A**	
Shape	**PXCC_A**	
Maxima™ Coating		
Ultra TEC® Adapter	**A0VCWSPA**	
MXC™ Stripper		
Round	**SXCC0A**	
Shape	**SXCC_A**	
Slug Free® Die		
Round	**D0AC00**	
Shape	**D0AC_0**	
Slug Free Light™ Die Option		
Round		
Shape		
Die Shim Package of 9 total, 3 each of: 0.016(0.40) 0.032(0.80) 0.048(1.20)	**MSAC**	



PUNCH
- DuraSteel™ with superior hardness and toughness for extended interval between regrinds.
- Hardened double-D key for precise orientation of punches for improved piece part quality.
- 1/4 degree back taper and near polished punch flanks to reduce friction, eliminate galling, and maximize punch life.
- Maxima™ coating available to reduce friction in extreme applications. Less friction means less heat build up, less galling and longer tool life.

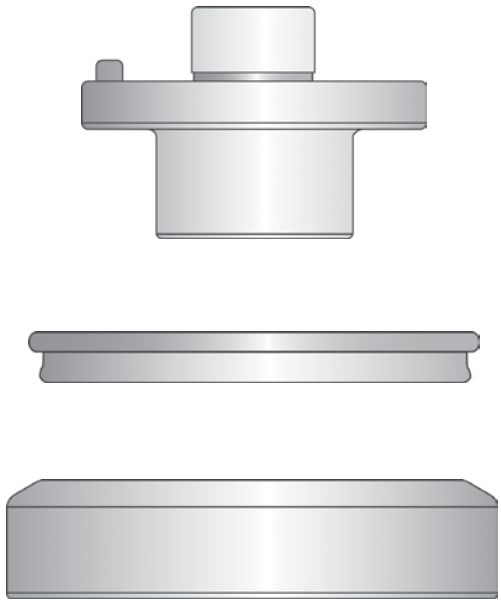
STRIPPER
- Smooth rounded edges to eliminate sheet marking and improve piece part quality.
- Compatible with existing conventional tooling inventory for maximum flexibility.

SLUG FREE® DIE
- Slug Free die geometry eliminates slug pulling to improve piece part quality and increase tool life.
- Highly wear-resistant tool steel provides optimum balance between hardness and toughness, for extended life.

See page 55 for Add-Ons and Accessories

[Dimensions in Inches (mm)]

MXC™ Punch - Standard	Part Number	Price
Round	**PXCD0A**	
Shape	**PXCD_A**	
Maxima™ Coating		
Ultra TEC® Adapter	**A0VDWSPA**	
MXC™ Clamp Clearing Option		
D Station	**PXCW**	
MXC™ Stripper		
Round	**SXCD0A**	
Shape	**SXCD_A**	
Slug Free® Die		
Round	**D0AD00**	
Shape	**D0AD_0**	
Slug Free Light™ Die Option		
Round		
Shape		
Die Shim Package 3 each: 0.016(0.40) 0.032(0.80) 0.048(1.20)	**MSAD**	



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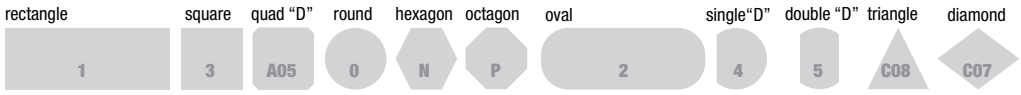
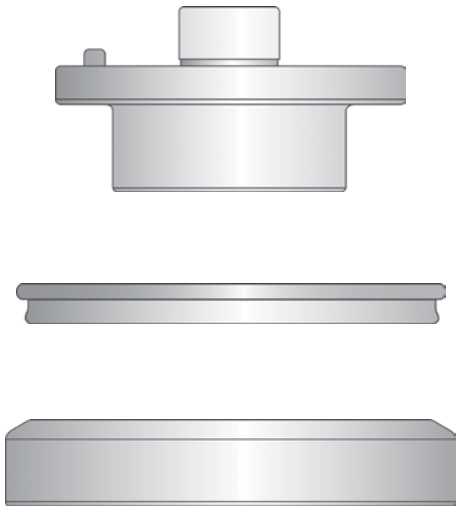
See page 55 for Add-Ons and Accessories

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



[Dimensions in Inches (mm)]

MXC™ Punch - Standard	Part Number	Price
Round	**PXCE0A**	
Shape	**PXCE_A**	
Maxima™ Coating		
Ultra TEC® Adapter	**A0VEWSPA**	
MXC™ Clamp Clearing Option		
E Station	**PXCX**	
MXC™ Stripper		
Round	**SXCE0A**	
Shape	**SXCE_A**	
Slug Free® Die		
Round	**D0AE00**	
Shape	**D0AE_0**	
Slug Free Light™ Die Option		
Round		
Shape		
Die Shim Package 3 each: 0.016(0.40) 0.032(0.80) 0.048(1.20)	**MSAE**	



PUNCH
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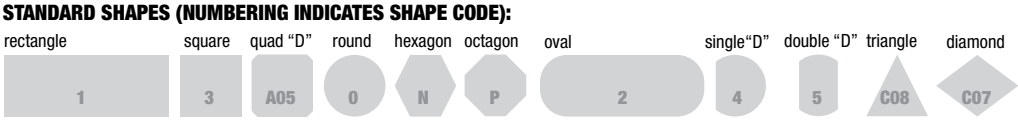
See page 55 for Add-Ons and Accessories

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



[Dimensions in Inches (mm)]

Small Diameter Round Tools
Point diameter 0.031(0.79) - 0.061(1.55) - to punch, stripper and die
Point diameter 0.062(1.56) - 0.092(2.35) - to punch, stripper and die
Narrow Width Shaped Tools
Width is less than 0.079(2.00) - to punch, stripper and die
Angle Setting
Non-Standard Angle Setting - to punch, stripper and die
Coatings
1/2" A Station
1-1/4" B Station
2" C Station
3-1/2" D Station
4-1/2" E Station

MXC™ THICK TURRET TOOLING SYSTEM PARTS & ACCESSORIES

1-1/4" B Station Punch Retaining Ring
RRI00010

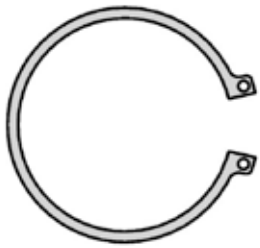
Replacement Part

1-1/4" B Station Punch Anti Rotation Pin
MATE00752

Replacement Part

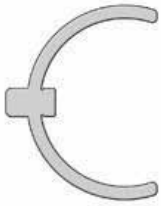
1-1/4" B Station Punch Felt Pad
FLT00001

To convert ABS punch to WLS® style



1-1/4" B Station Stripper Retaining Ring
MATE00754

Replacement Part

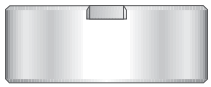


Round Punches Only Anti-rotation Clip
A0VBWBAC

Replacement Part

2" C Station HP™ Punch Adapter
A0VCWSPA

3-1/2" D Station HP™ Punch Adapter
A0VDWSPA



4-1/2" E Station HP™ Punch Adapter
A0VEWSPA

These Punch Adapters allow an HP™ and/or MXC™ punch to be used in an Original Style Thick Turret, Ultra TEC® or Ultra ABS® holder.

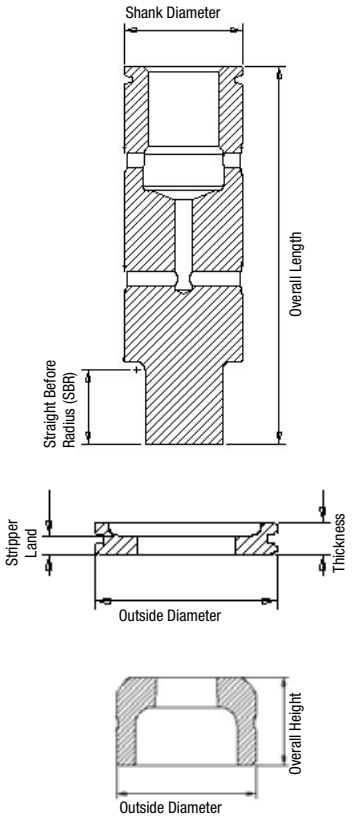
HP™ is a trademark of Wilson Tool International, Inc.

[Dimensions in Inches (mm)]

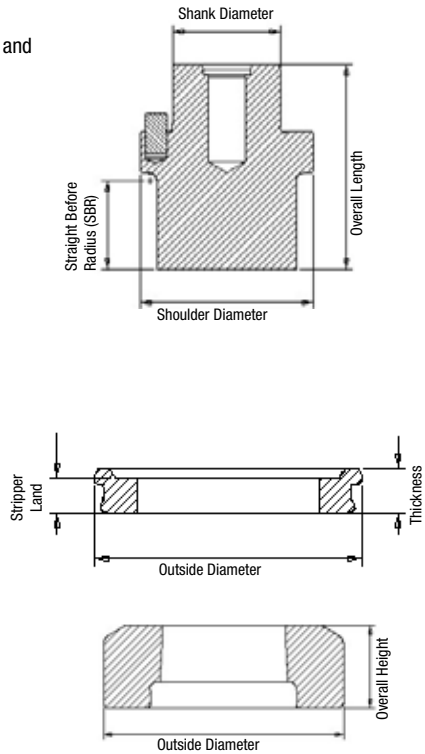
MXC™ CRITICAL DIMENSIONS CHART

MXC™ PUNCH					
Station	**1/2" A**	**1-1/4" B**	**2" C**	**3-1/2" D**	**4-1/2" E**
Part Number	**PXCA or PLCA**	**PXCB or PLCB**	**PXCC**	**PXCD**	**PXCE**
Maximum Punch Diagonal	0.500(12.70)	1.250(31.75)	2.000(50.80)	3.500(88.90)	4.500(114.30)
Overall Length	4.640(117.86)	3.957(100.51)	2.360(59.94)	2.360(59.94)	2.360(59.94)
Shank Diameter	0.624(15.85)	1.249(31.72)	1.250(31.75)	1.250(31.75)	1.250(31.75)
Shoulder Diameter	n/a	n/a	2.000(50.80)	3.500(88.90)	4.500(114.30)
Straight Before Radius	0.740(18.80)	0.740(18.80)	1.004(25.50)	1.004(25.50)	1.004(25.50)
MXC™ STRIPPER					
Part Number	**SXCA**	**SXCB**	**SXCC**	**SXCD**	**SXCE**
Outside Diameter	0.768(19.51)	1.497(38.02)	2.356(59.84)	4.011(101.88)	4.866(123.60)
Thickness	0.272(6.91)	0.272(6.91)	0.390(9.91)	0.390(9.91)	0.390(9.91)
Stripper Land	0.157(3.99)	0.157(3.99)	0.315(8.00)	0.315(8.00)	0.315(8.00)
Slug Free® and Slug Free LIGHT™ DIES					
Part Number	**D0AA**	**D0AB**	**D0AC**	**D0AD**	**D0AE**
Outside Diameter	1.000(25.40)	1.875(47.63)	3.500(88.90)	4.938(125.43)	6.249(158.72)
Overall Height	1.187(30.15)	1.187(30.15)	1.187(30.15)	1.187(30.15)	1.187(30.15)
Die Penetration	0.118(3.00)	0.118(3.00)	0.118(3.00)	0.118(3.00)	0.118(3.00)

For 1/2" A and
1-1/4" B Station
(B station shown)



For 2" C, 3-1/2" D and
4-1/2" E Station
(C station shown)



[Dimensions in Inches (mm)]

Inch Style tooling is designed with features to enhance punching performance, including:

- Premium High Speed Steel which is specially formulated to deliver superior abrasion resistance to extend the interval between regrinds.
- Near polished punch flanks with a 1/4 degree back taper to minimize friction, eliminate galling during stripping and improve piece part quality.
- Minute corner radii to eliminate chipping and extend punch life.
- Superior angularity and concentricity for improved hole quality.
- Thread size clearly marked for ease of use.
- Maxima™ coating available.

1/2" A STATION

Maximum Diagonal
0.500(12.70)

Round **PAJA0A**
Shaped **PAJA_A**

HeavyDuty
Round **PHJA0A**
Shaped **PHJA_A**

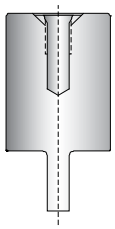
Replacement Clip
MATE02094

1-1/4" B STATION

Maximum Diagonal
1.250(31.75)

Round **PAJB0A**
Shaped **PAJB_A**

HeavyDuty
Round **PHJB0A**
Shaped **PHJB_A**

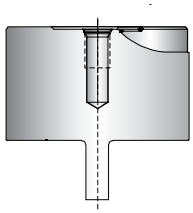


2" C STATION

Maximum Diagonal
2.000(50.80)

Round **PAJC0A**
Shaped **PAJC_A**

HeavyDuty
Round **PHJC0A**
Shaped **PHJC_A**

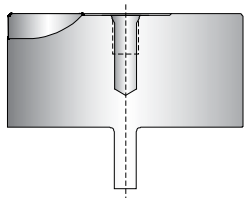


3-1/2" D STATION

Maximum Diagonal
3.500(88.90)

Round **PAJD0A**
Shaped **PAJD_A**

HeavyDuty
Round **PHJD0A**
Shaped **PHJD_A**



4-1/2" E STATION

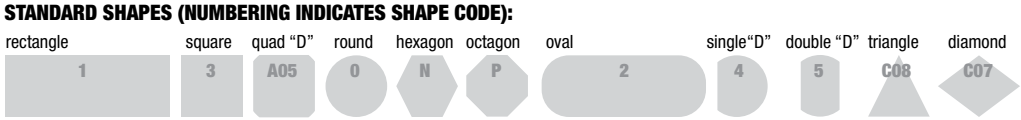
Maximum Diagonal
4.500(114.30)

Round **PAJE0A**
Shaped **PAJE_A**

HeavyDuty
Round **PHJE0A**
Shaped **PHJE_A**

Fully Compatible with Wilson Inch Style

STANDARD SHAPES (NUMBERING INDICATES SHAPE CODE):



[Dimensions in Inches (mm)]

MATE ULTRA® MULTI TOOL 8 STATION ASSEMBLY

UPPER:	LOWER:	
MATE00967	**MATE00968**	Achieved angles: Stations 1, 3, 5, 7: Rounds only Stations 2, 4, 6, 8: 0°, 90°, 225°
	MATE01764 for Danobat machines (more slots).	Achieved angles: Station 1, 3, 7: 90° Station 2, 4, 6, 8: 0°, 90°, 225° Station 5: Rounds Only

SPECIFICATIONS:

Punch point range:	0.020(0.80) to 0.618(15.70)
Tooling:	Ultra® TEC® & Ultra® QCT™ 1/2" A station punches, strippers, and Slug Free® dies
Maximum tonnage:	U.S. 6 Tons - 54 kN - 5.4 Metric Tons
Max material thickness:	6mm (.236")

MATE ULTRA MULTI TOOL 3 STATION ASSEMBLY

UPPER:	LOWER:	
MATE00969	**MATE00970**	Achieved angles: Each station: 0°, 45°, 90°
	MATE01030 for non-indexable machines.	Achieved angles: Station 1, 3: 0°, 90°, Station 2: 0°, 315°
	MATE02371* for Ermaksan single head machines with 103 mm slug hole.	Achieved angles: Each station: 0°, 45°, 90°

* if slug hole is 90mm, use MATE00970

SPECIFICATIONS:

Punch point range:	0.020(.80) to 1.250(31.70)
Tooling:	Ultra TEC® & Ultra® QCT™ 1-1/4" B station punches, strippers, and Slug Free® dies
Maximum tonnage:	U.S. 12 Tons - 107 kN - 11 Metric Tons
Max material thickness:	6mm (.236")

PATENT INFORMATION:
US 7726554 8376215
US 8464928 8152052
CA 2664784
MX 305729 306976 305727
CN 101528427
PAT. PEND

USAGE NOTES:
Requires compatibility with machine ram and programming software.

Contact your punch press machine supplier for compatibility.

Part numbers for Multi Tool assemblies do not include punches and dies.

3 or 8 Station Hardened Shim **MATE02330**

[Dimensions in Inches (mm)]

MATE FULLY INDEXABLE ULTRA UMT-8A MULTI TOOL 8 STATION ASSEMBLY

UPPER: MATE02467 **LOWER: MATE02463**

SPECIFICATIONS

Punch point range:	.020(.51mm) to .618(15.70mm)	
Tooling:	Ultra TEC® & Ultra® QCT™ 1/2" A station punches, strippers, and Slug Free® dies.	
Maximum tonnage:	U.S. 6 Tons - 54 kN - 5.4 Metric Tons.	
Max material thickness:	6mm (.236").	
Achieved angles: (if not using a rotating ram machine)	Station 1: 90° Station 2: 135° Station 3: 180° Station 4: 225°	Station 5: 300° Station 6: 315° Station 7: 0° Station 8: 45°

MATE FULLY INDEXABLE ULTRA UMT-3B MULTI TOOL 3 STATION ASSEMBLY

UPPER: MATE02854 **LOWER: MATE02455**

SPECIFICATIONS

Punch point range:	.020(.51mm) to 1.250(31.70mm)
Tooling:	Ultra TEC® & Ultra® QCT™ 1-1/4" B station punches, strippers, and Slug Free® dies
Maximum tonnage:	U.S. 12 Tons – 107 kN – 11 Metric Tons
Max material thickness:	6mm (.236")
Achieved angles: (if not using a rotating ram machine)	Station 1: 90° Station 2: 180° Station 3: 0°

[Dimensions in Inches (mm)]

MATE ULTRA® IMT™ MULTI TOOL SYSTEMS

FOR PRIMA POWER SHOT PIN MACHINES — 8 STATION AND 3 STATION

MATE FULLY INDEXABLE ULTRA IMT-8A MULTI TOOL 8 STATION ASSEMBLY

Ultra IMT™ 8-Station (not machine specific)

Upper: **MATE01840**
Lower: **MATE00050**

Ultra IMT™ 8-Station (machine specific uppers & lowers)

Upper Only:	**MATE02068**	**JFY MACHINES**
Upper Only:	**MATE02007**	**BAYKAL MACHINES**
Lower Only:	**MATE02060**	**DURMA MACHINES**

SPECIFICATIONS

Punch point range:	.020(.51mm) to .618(15.70mm)
Tooling:	Ultra TEC® & Ultra® QCT™ 1/2" A station punches, strippers, and Slug Free® dies.
Maximum tonnage:	U.S. 7 Tons – 62 kN – 6.3 Metric Tons.
Max material thickness:	6mm (.236").

The fully **indexable Ultra IMT™ 8-Station multi tool** works with Ultra TEC® & Ultra® QCT™ A station punch, strippers and Thick Turret Slug Free® dies up to a maximum punch diagonal of .618" (15,70 mm). The multi tool accepts 8 "mini" stations. The multi tool can achieve any angle setting on the work piece.

MATE FULLY INDEXABLE ULTRA IMT-3B MULTI TOOL 3 STATION ASSEMBLY

Ultra IMT™ 3-Station (not machine specific)

Upper: **MATE01850**
Lower: **MATE00697**

Ultra IMT™ 3-Station (machine specific uppers & lowers)

Upper Only:	**MATE02069**	**JFY MACHINES**
Upper Only:	**MATE02010**	**BAYKAL MACHINES**
Lower Only:	**MATE02058**	**DURMA MACHINES**

SPECIFICATIONS

Punch point range:	.020(.51mm) to 1.250(31.75mm)
Tooling:	Ultra TEC® & Ultra® QCT™ 1-1/4" B station punches, strippers, and Slug Free® dies
Maximum tonnage:	U.S. 12 Tons – 107kN – 11 Metric Tons
Max material thickness:	6mm (.236")

The fully **indexable Ultra IMT™ 3-Station multi tool** works with Ultra TEC® & Ultra® QCT™ B Station punch, strippers and Thick Turret Slug Free® dies up to a maximum punch diagonal of 1.250" (31,75 mm). The multi tool can achieve any angle setting on the work piece.

See Ultra® IMT Product Bulletin for additional information (LIT00745)

*Ultra® IMT is patented under: US: 7,726,554 and 8,152,052 and 8,464,928 and 8,413,561
China: CN 101528427B
Mexico: 306,976 and 305,729
Canada: CA 2,664,784

[Dimensions in Inches (mm)]

Concept: One adjustable length holder can be used with a variety of special forming inserts. The benefits include reduced tooling cost, increased flexibility, and the length of the assembly can be accurately pre-set.

Quick Length Adjustment:
The push-button length adjustment mechanism allows the overall length of the assembly to be set in 0.002(0.05) increments, without disassembly or removal from the machine.

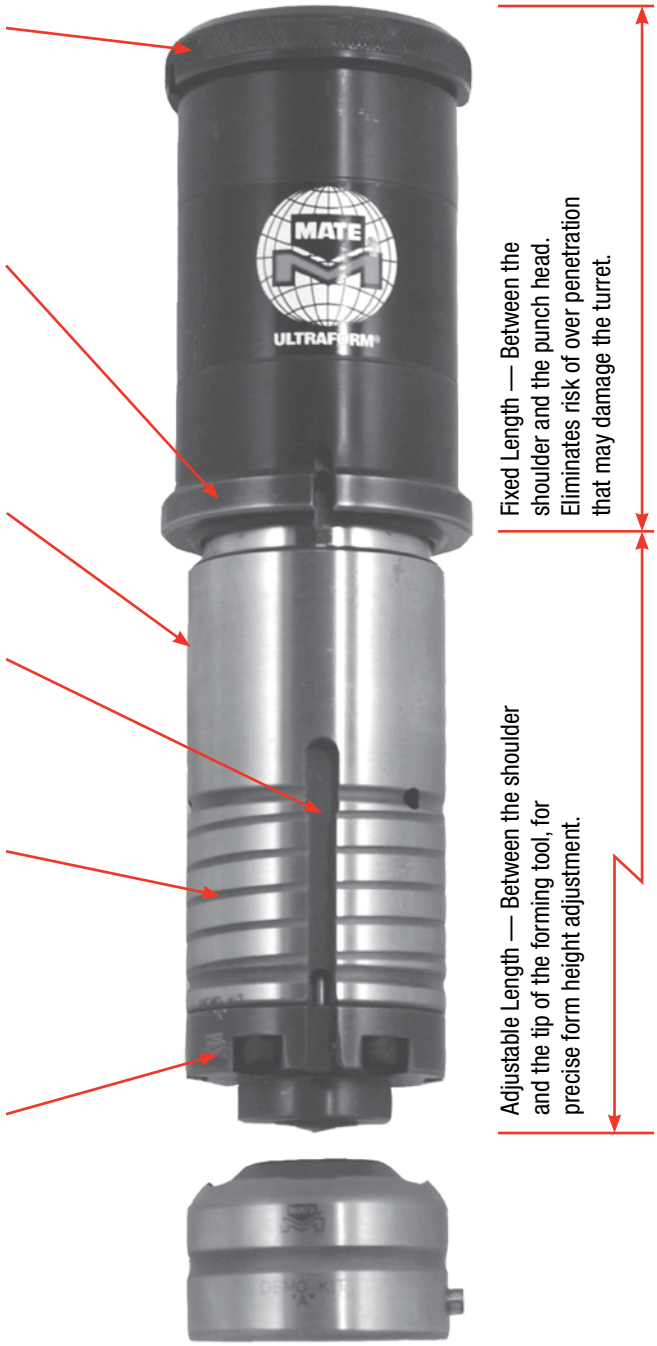
Adjustment Below the Shoulder:
The length adjustment is made below the shoulder of the assembly, thus maintaining the gap between the ram and the tool at top of stroke to prevent the ram from hitting the tool.

Hardened Guides:
The hardened guides, combined with the lubrication grooves, reduce friction and extend turret bore life.

Multiple Angle Settings:
All Ultraform® holders can be set at 0, 90, 180 and 270 degrees as a standard, for maximum flexibility.

Tool Lubrication:
Ultraform® holders provide internal channels and external grease grooves to allow lubrication of forming tools. Ultraform® is compatible with all popular punch press machine tool lubrication systems.

One Holder – Multiple Applications:
The Ultraform® holder system is designed to allow an unlimited number of forming tools to be used with the same holder, which reduces tooling inventory costs.



Available for:
- 1-1/4" B Station
- 2" C Station
- 3-1/2" D Station
- 4-1/2" E Station

[Dimensions in Inches (mm)]

ULTRAFORM®

B Station	**AFKB2**
C Station	**AFKC2**
D Station	**AFKD2**
E Station	**AFKE2**

ULTRAFORM XT™

B Station	**MATE01755**
C Station	**MATE01821**
D Station	**MATE01824**
E Station	**MATE01827**

ULTRAFORM FX™

B Station	**MATE01798**
C Station	**MATE01800**
D Station	**MATE01802**
E Station	**MATE01804**

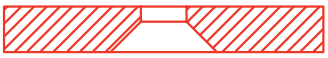
	Ultraform®	Ultraform XT™	Ultraform FX™
Ultraform inserts	•	•	•
Angle setting of 0°, 90°, 180° und 270°	•	•	•
Upper holder, fine length adjustment (0,05 mm)	•		
Upper holder, adjustable length (>0,2 mm)		•	
Fixed Length			•
Length adjustment without tools	•		
Upper holder, adjustable length in turret possible	•		
Hardened guide	•		
Length adjustment under the upper turret	•	•	
Usable with lubricating system of the machine	•	•	•
Available for B - E Station	•	•	•
Available for F Station	•		

[Dimensions in Inches (mm)]

Combine the economy of original style thick turret tooling, with the convenience of integrated tool body construction, and the simplicity of the hexagon shaped punch head. Ideal for hydraulic punch presses with programmable ram control.

Dedicated Countersink Down

Complete Assembly with blank die	**XAABD0B399**
Replacement Countersink Tip	**XAABD0B316**



Dedicated Countersink Up

Complete Assembly with non-spring loaded lower.	**XAABD0B199**

Round Emboss with Dome Top

Complete Assembly with spring loaded lower	**XAABD0E099**

Round Emboss with Flat Top

Complete Assembly with spring loaded lower	**XAABD0E199**

Round Embossed Countersink Up

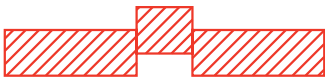
Complete Assembly with spring loaded lower	**XAABD0E999**

Round Extrude Up

Complete Assembly with spring loaded lower	**XAABD0D199**
Replacement Lower Insert	**XAABD0D104**

Single Round Knockout Up

Complete Assembly with spring loaded lower	**XAABD0K199**



Shear Button Up

Complete Assembly with spring loaded lower	**XAABD0S199**
Replacement Lower Insert	**XAABD0S104**

All 1-1/4" B station original style forming tools are designed to your specific material type, thickness, and machine model requirements. Interchangeability between machines is not recommended due to the variations in the shut height between different machines. For fully adjustable and interchangeable forming tools, we recommend the Mate Ultraform® forming tool system.

[Dimensions in Inches (mm)]

VERSADIE™ THICK TURRET INSERT SLITTING DIE

Clamp clearing dies are necessary when maximum sheet usage is required. The ability to punch as close to the clamps as possible reduces both material cost and waste.

Mate Versadie™ takes clamp clearing solutions to a new level with several unique design features. First, with replaceable die inserts, there is no need to replace the entire die. Versadie's inserts are designed to allow for the greatest lengths currently available in the industry, accommodating lengths up to 4.560(115.82mm) for E Stations and 3.560(90.42mm) for D Stations.

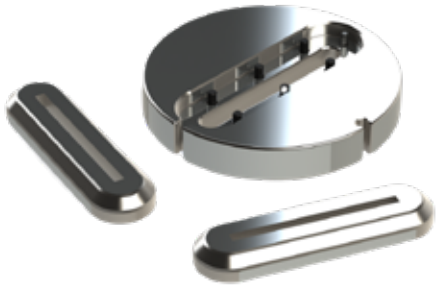
With its tighter tolerances of the insert to the holder, Versadie has superior overall quality.

For superior performance and longevity, Versadie's slitting die insert is made from MPM82 tool steel. Designed for use in high performance tooling systems, MPM82 is a high speed, particle metallurgy steel intended to provide high value and exceptional versatility making it perfect for slitting operations.

MPM82 TOOL STEEL OFFERS:

- Stronger dies that can withstand the most demanding punching operations
- Sharper edges on the die opening
- Increased machine uptime
- Reduced overall tooling costs
- Lower overall production costs

For maximum longevity, the die body allows shimming after the insert is sharpened during routine maintenance. There's no need for special shims—simply use standard thick turret die shims.



DIE INSERT

- Premium MPM82 tool steel for superior performance and longevity
- Inch and metric sizes
  - D Station from up to 3.560(90.42mm)
  - E Station from up to 4.560(115.82mm)
- Widths up to .509(12.93mm)
- Mate Slug Free® design

DIE BODY

- S7 Shock-Resisting Tool Steel

SHIMS

- D Station, package of 3 each: 0.016(0.41); 0.032(0.81); 0.048(1.22)
- E Station, package of 3 each: 0.016(0.41); 0.032(0.81); 0.048(1.22)

Insert Shims

PRICING AND PART NUMBERS:

MATE02223	D Station Die Body Assembly
MATE02225	E Station Die Body Assembly
D8AQ_A	D Station Slitting Insert
D8AR_A	E Station Slitting Insert
MSAD	D Station Die Shims (set of 9)
MSAE	E Station Die Shims (set of 9)
MATE02338	D Station Insert Shims (set of 9)
MATE02339	E Station Insert Shims (set of 9)

Die Shims

RECTANGLES – STANDARD			RECTANGLES – SPECIAL SHAPES											
Rectangle	Oval	Double D	Cham Corners	Rad Corners	Rectangle/ Oval	Double Rectangle	Rectangle w/Tabs	Special Rectangle	Cable Opening	Cable Opening w/Tabs	Trapezoid	Elongated Double D	Break-Away	Parallelogram
														

AVAILABLE SHAPES

[Dimensions in Inches (mm)]

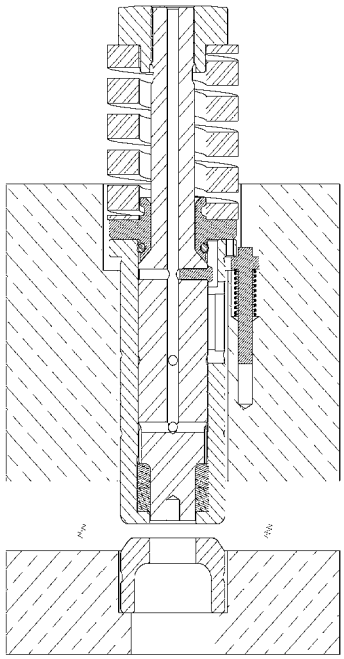
Mate Eliminator™ (patents pending) punch tip lubrication pads assist in keeping the punch tip lubricated during the punching process.

Studies have shown that properly lubricated punch tips help extend tool life and keep the punch from overheating. In many situations, lubrication helps eliminate unwanted galling during the punching process.

Mate Eliminator lubrication pads are easy to install, especially on Mate Ultra TEC® A and B stations. Simply use the punch and stripper to "punch" the hole into the foam. Saturate the pad with 46-68 ISO viscosity hydraulic oil and you're ready for gall-free punching.

MATE ELIMINATOR LUBRICATION PADS:

- Made from polyether filter foam
- Available in A through E stations
- Compatible with all thick turret punch presses
- Made in U.S.A.



STATION	PART NUMBER
A station, qty of 5	**MATE02028**
B station, qty of 5	**MATE02029**
C station, qty of 5	**MATE02030**
D station, qty of 4	**MATE02031**
E station, qty of 4	**MATE02032**

[Dimensions in Inches (mm)]

 | 1295 Lund Boulevard, Anoka, Minnesota 55303 USA. Phone: 763.421.0230 | mate.com
orders@mate.com

MATE PILOT™ TURRET CALIBRATION SYSTEM

The Mate Pilot™ Turret Calibration System is the most accurate system for ensuring precision concentric and angular alignment of thick turret punch press stations available. The Mate Pilot Turret Calibration System operates in two modes:

- **Verification Mode** – Confirm the precise concentric and angular alignment of your turret to maintain high quality piece part production and maximum tool life.
- **Alignment Mode** – Restore the concentric and angular alignment of each station with the same or better precision as the initial machine installation.

THE MATE PILOT™ TURRET CALIBRATION SYSTEM IS SIMPLY THE BEST SYSTEM AVAILABLE.

Accurate:
Each calibration instrument is machined from a single piece of high quality tool steel. The upper and lower halves are separated near the end of the production process, just prior to installation of the hardware. This eliminates the possibility of cumulative tolerances adversely affecting the accuracy of the finished instrument.

Simple to Use:
Install the two halves of the calibration instrument into the turret station to be aligned. Rotate turret to position the station to be aligned under the machine ram. Use the integral adjustment handle to draw the two halves of the calibration instrument together.

The interlocking design of the interface between the two halves causes the loosened die holder assembly to be drawn into concentric and angular alignment relative to the upper bore as the two halves of the calibration instrument engage.

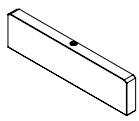
The tri-color light indicates alignment.

- Engaged, but not aligned
- Angularity and concentricity within 0.0012(0.030)
- Angularity and concentricity within 0.0003(0.008)*

Comprehensive:
The Mate Pilot Calibration System is available in all five thick turret station sizes and is also available to suit the Prima-Power Multi-Tool stations. The Mate Pilot Calibration System is available as a set to suit thick turret presses.

Station	Part Number	Package A	Package F
1/2" A	**MATE00670**	•	
1-1/4" B	**MATE00666**	•	•
2" C	**MATE00667**	•	•
3-1/2" D	**MATE00668**	•	•
4-1/2" E	**MATE00669**	•	
Multi-Tool	**MATE00671**		•
Accessory Kit	**MATE00662**	•	•
		MATE00665	**MATE00672**

MATE THICK TURRET LINE UP TOOL ALIGNMENT BAR UPGRADE.
The upgraded bar is larger and easier to use. It allows for easier access for the alignment process.



Line Up Tool Bar **MATE02227**

*Angularity and concentricity within 0.0003(0.008) - Green Indicator Light - is recommended when punching materials with a thicknesses of 0.048(1.20) or less.

[Dimensions in Inches (mm)]

MATE RAPIDSET ADJUSTABLE CANISTERS FOR ORIGINAL STYLE AND AMX™ TOOLING SYSTEMS ARE DESIGNED TO REDUCE YOUR SET-UP TIME AND MAXIMIZE PRODUCTIVITY.

FEATURES INCLUDE:

- Fast, easy punch length adjustment without removal from the guide*…reduces downtime and increases productivity.
- Self-contained, constant pre-loaded spring pack for consistent stripping pressure and reliable operation.
- Consistent die penetration reduces slug pulling.
- Canisters feature textured surface with knurled Griptionᵀᴹ ring for ease of handling.
- Only 1 clamping screw to adjust length.
- 0.315”(8,00mm) grind life in 0.039”(1,00mm) material with 0.118”(3,00mm) die penetration.
- Existing Mate Original Style grind life is much less...only 0.189” 4,82mm)

FULLY COMPATIBLE WITH:

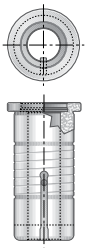
- Mate Original Style tooling
- Mate AMX™ tooling
- Amada Standard Style tooling
- Amada Standard Style ABS tooling
- Wilson Standard Style tooling

MATE02044 Rapidset A Station Canister
MATE02040 Rapidset A Station Seal Kit**
MATE02050 Rapidset B Station Canister
MATE02043 Rapidset B Station Seal Kit**

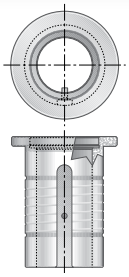
Available for: 1/2” A-station and 1-1/4” B-station
* Shapes only **Required for use in AMX/ABS Environments

[Dimensions in Inches (mm)]

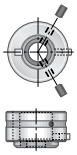
THICK TURRET AND ULTRA® ADAPTERS



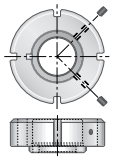
1-1/4" to 1/2"
B to A Station
Punch Guide Adapter
APLG00AD



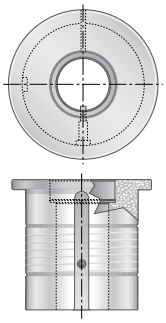
2" to 1-1/4"
C to B Station
Punch Guide Adapter
APLH00AD



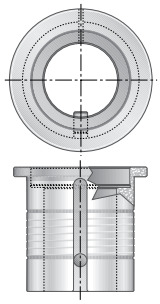
1-1/4" to 1/2"
B to A Station
Die Adapter
ADLG00AD



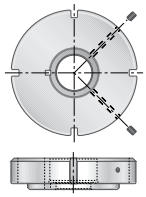
2" to 1-1/4"
C to B Station
Die Adapter
ADLH00AD



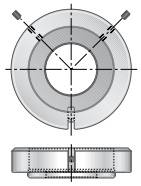
3-1/2" to 1-1/4"
D to B Station
Punch Guide Adapter
APLK00AD



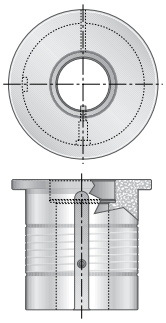
3-1/2" to 2"
D to C Station
Punch Guide Adapter
APLJ00AD



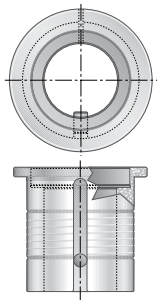
3-1/2" to 1-1/4"
D to B Station
Die Adapter*
ADLK00AD



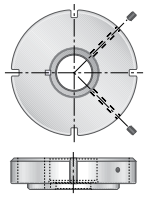
3-1/2" to 2"
D to C Station
Die Adapter*
ADLJ00AD



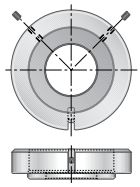
4-1/2" to 1-1/4"
E to B Station
Punch Guide Adapter
APLM00AD



4-1/2" to 2"
E to C Station
Punch Guide Adapter
APLL00AD



4-1/2" to 1-1/4"
E to B Station
Die Adapter
ADLM00AD



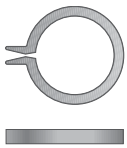
4-1/2" to 2"
E to C Station
Die Adapter
ADLL00AD

*Use this table to select the appropriate die adapter for use in the Prima Power upforming station.
When using a die adapter in an upforming station, the press upper ram stroke may need to be reduced by 0.079(2.00).

	Non-Indexable Upform Station				Indexable Upform Station			
	Piercing		Forming		Piercing		Forming	
3-1/2" D to 1-1/4" B	**MATE00727**		**MATE00725**		**MATE00727**		**MATE00725**	
3-1/2" D to 2" C	**MATE00721**		**ADLJFUAD**		**MATE00721**		**MATE00723**	

[Dimensions in Inches (mm)]

ULTRA® SYSTEM ANTI-ROTATION CLAMPS FOR ROUND PUNCHES



1/2" A Station
Original Style Round Punch
Anti-Rotation Clamp

A0VAASAC

1-1/4" B Station
Original Style Round Punch
Anti-Rotation Clamp

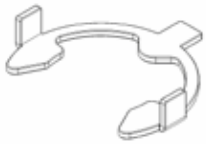
A0VBASAC

1-1/4" B Station HP (Series 90)
Style Punch with hook ring
Anti-Rotation Clip

A0VBWBAC**

1-1/4" B Station Punch
Length Adjustment Clamp
HP (Series 90) Driver Assembly

A0VBWGAC***



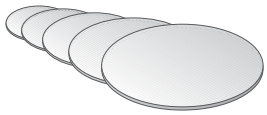
Ultra TEC B Station Anti-Rotation
Clip For Wilson HP Double D
Canister

A0VBWHAC***

Ultra TEC B Station Anti-Rotation
Clip For Wilson HP2 Canister
Assembly

A0VBWKAC***

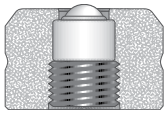
SOFT FACE STRIPPER PADS - ADHESIVE BACKED URETHANE



Soft faced stripper pads for thick turret and Ultra style tooling - 0.009(0.25) thick adhesive backed urethane to prevent material scratching and reduce noise levels.

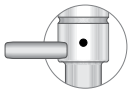
A Station Soft Face Stripper Pad - Package 6	**A0LA00SF**
B Station Soft Face Stripper Pad - Package 6	**A0LB00SF**
C Station Soft Face Stripper Pad - Package 6	**A0LC00SF**
D Station Soft Face Stripper Pad - Package 4	**A0LD00SF**
E Station Soft Face Stripper Pad - Package 4	**A0LE00SF**

MORE ACCESSORIES FOR ULTRA® AND ULTRAFORM®



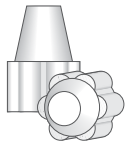
Roller Die for Ultraform®
System Special Applications
(1-1/4" B Station Only)

A0LB00FG



Pin for Original Style Round Punch
when used with Ultra® Guide 1/2" A and
1-1/4" B Station (12 minimum)

MIS60256*



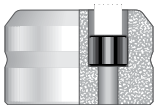
Urethane Slug Ejectors
3 and 6 mm Diameters
(12 minimum)

3 mm Urethane Slug Ejectors

URE40002*

6 mm Urethane Slug Ejectors

URE40010*



Brush Die for Ultraform
System Special Applications
(B thru E Stations)

B Station	**ADLB0001**
C Station	**ADLC0001**
D Station	**ADLD0001**
E Station	**ADLE0001**

Replacement Brush
Assembly for Brush Dies (3 minimum)
*Not compatable with the new plastic Thick Turret brush dies.

Medium India Oil Stone

ST029807

6" Cratex Rubber Abrasive Stick

ST029911

Thick Turret Brush Die

A Station	**MATE01895**
B Station	**MATE01896**
C Station	**MATE01897**
D Station	**MATE01898**
E Station	**MATE01899**

Lifter "T" Handle

A0LEH

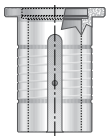
Clip Tool for Ultra® 1-1/4" B Station
Fully Guided Punch Guide
Stripper Clip

MIS59723

* Items sold separately beyond minimum quantity
** Order A0VBWBAC when using Series 90 punches with wire ring and pin or ball.
*** A0VBWGAC, A0VBWHAC & A0VBWGAC adapt canister to allow using Ultra punches but only in Wilson shape guides. Round guides will not work.

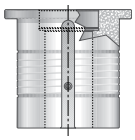
[Dimensions in Inches (mm)]

LVD STYLE TO ACCEPT LVD, THICK TURRET AND ULTRA TEC® GUIDE ASSEMBLIES



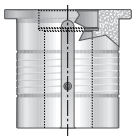
2" to 1-1/4"
LVD C Station to
Thick Turret B Station
Punch Guide
Adapter Assembly

LPLH00AD



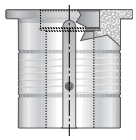
3-1/2" to 1-1/4"
LVD D Station to
Thick Turret B Station
Punch Guide
Adapter Assembly

LPLK00AD



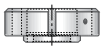
3-1/2" to 2"
LVD D Station to
LVD C Station
Punch Guide
Adapter Assembly

LPPJ00AD



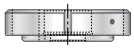
3-1/2" to 2"
LVD D Station to
Thick Turret C Station
Punch Guide
Adapter Assembly

LPLJ00AD



2" to 1-1/4"
C to B Station
Die Adapter

ADLH00AD

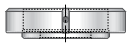


3-1/2" to 1-1/4"
D to B Station
Die Adapter

ADLK00AD

3-1/2" to 2"
D to C Station
Die Adapter

ADLJ00AD



3-1/2" to 2"
D to C Station
Die Adapter

ADLJ00AD

HP (SERIES 90) PUNCH ADAPTERS

C Station HP (Series 90)
Punch Adapter

A0VCWSPA

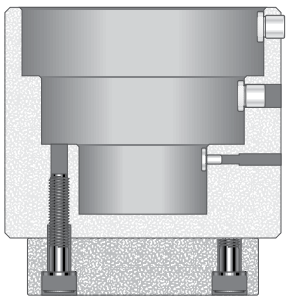
D Station HP (Series 90)
Punch Adapter

A0VDWSPA

E Station HP (Series 90)
Punch Adapter

A0VEWSPA

THICK TURRET - ULTRA® 2" C, 3-1/2" D AND 4-1/2" E STATION TORQUE STAND ASSEMBLY AND ACCESSORIES



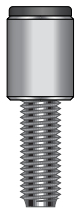
MIS59483
10mm Hex Key
also available sepa-
rately

Ultra TEC® / Thick Turret Torque Stand
Assembly with 3/8" Drive 10mm Hex Key
2" C, 3-1/2" D and 4-1/2" E Stations

MATE00083

Torque Wrench
for use with Torque Stand
Fixed setting at 75 lbs. ft. (102 N • m)

MIS99030



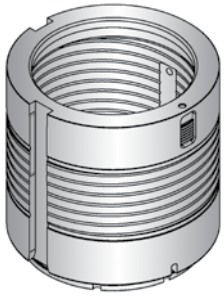
Ultra TEC® Spacer for
Amada Tightening
Fixture 2" C Station

APLEP

[Dimensions in Inches (mm)]

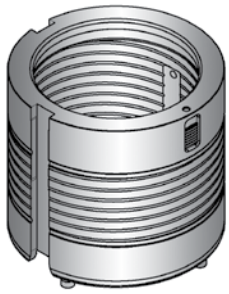
Ultra TEC® Replacement Locking Ring Kit

2" C	**MATE00628**
3-1/2" D	**MATE00629**
4-1/4" E	**MATE00630**



Ultra TEC® Replacement Guide Body Kit

2" C	**MATE00631**
3-1/2" D	**MATE00632**
4-1/4" E	**MATE01808**

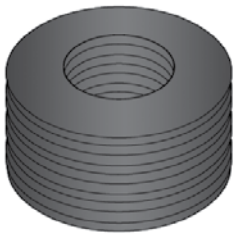


Ultra TEC® Fully Guided Replacement Guide Body Kit

2" C	**MATE00634**
3-1/2" D	**MATE00636**
4-1/4" E	**MATE01812**

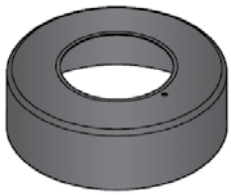
Ultra TEC® Fully Guided Replacement Guide Body Kit (3-slot)

2" C	**MATE00635**
3-1/2" D	**MATE00637**



Ultra TEC® Replacement Spring Kit

2" C	**MIS61647P** (18 springs)
3-1/2" D	**MATE00270** (7 springs)
4-1/4" E	**MATE00270** (7 springs)

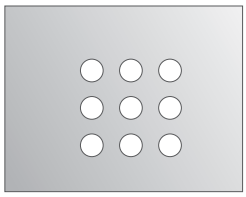


Ultra TEC® Replacement Spring Cover

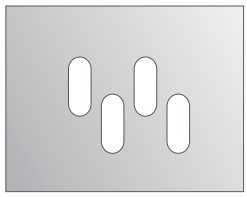
2" C	**MIS99709**
3-1/2" D	**A0VDSTCV**
4-1/4" E	**A0VDSTCV**

[Dimensions in Inches (mm)]

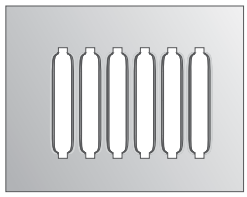
SPECIAL APPLICATIONS



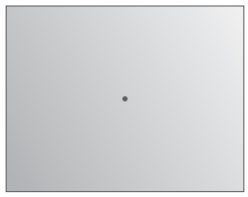
Cluster – Round



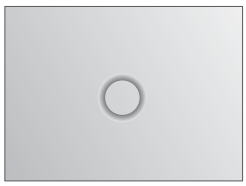
Cluster – Shape



Card Guide

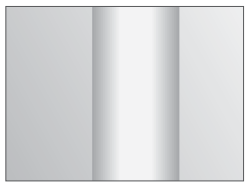


Centerpoint



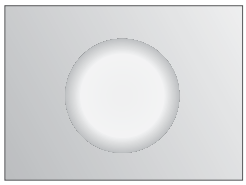
Countersink – Round

Countersink – Shape



Emboss – Beading

Emboss – Edgeform



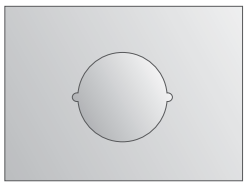
Emboss – Formed (Round and Shaped)

Emboss – Cold Forged

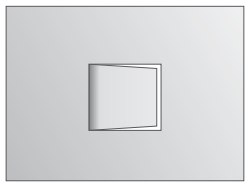
Extrusion – Tapping

Extrusion – Flanged Hole

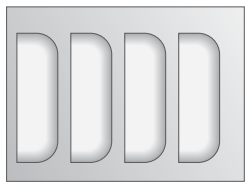
Hinge Tool



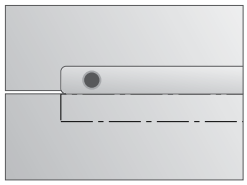
Knockout



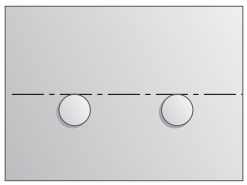
Lance And Form



Louver



Scissortool™

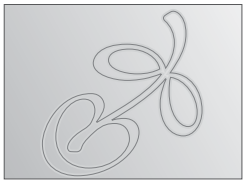


Shearbutton (Round and Shaped)

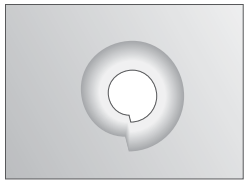
Rollerball™

Sheetmarker™

Stamping – Alpha Numeric



Stamping – V-line



Threadform

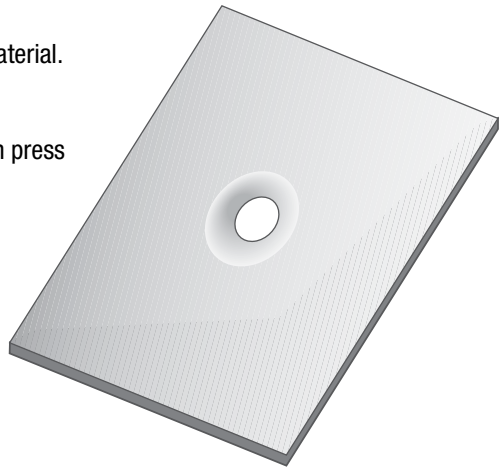
[Dimensions in Inches (mm)]

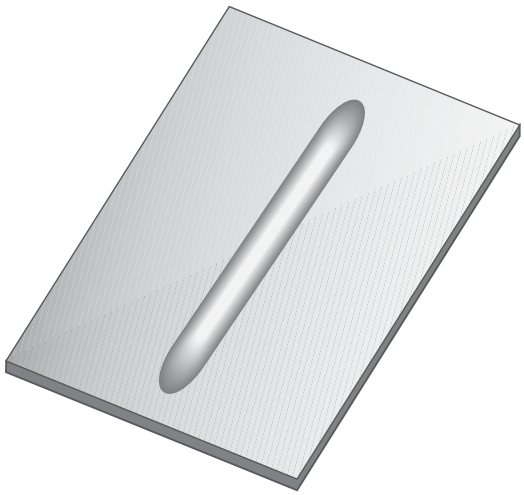
Countersink—Dedicated

Use:
Allows screw and rivet head to sit flush or below the surface of the material.

Typical Application:
- Material thickness from 0.048(1.22) to 0.250(6.35), dependent upon press tonnage capacity.

Comments:
- The shoulder (dedicated) style is generally ordered for one material thickness and screw size.
- The shoulder style coins the surrounding area, producing a clean flat countersink with minimal burring.





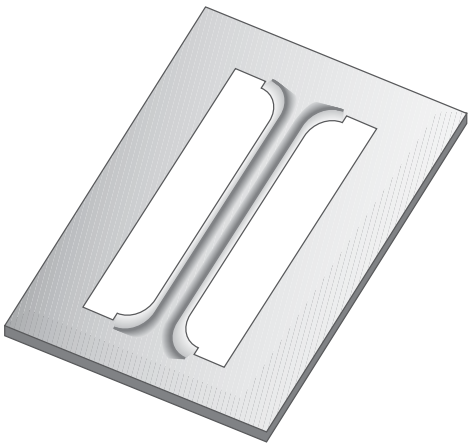
Emboss—Continuous

Use:
As a stiffener to add rigidity to sheet metal panels.

Typical Application:
- Material thickness from 0.027(0.70) to 0.250(6.35), dependent upon press tonnage capacity.

Comments:
- The increment between hits is determined by the cosmetic requirements for the finished part. Smaller increments result in improved appearance.
- The form height should be as low as possible to minimize sheet distortion.

[Dimensions in Inches (mm)]



Card Guide

Use:
As a retainer for printed circuit boards.

Typical Application:
- Material thickness from 0.040(1.00) to 0.078(2.00).
- Maximum recommended top-of-sheet to top-of-form height is 0.125 (3.20).

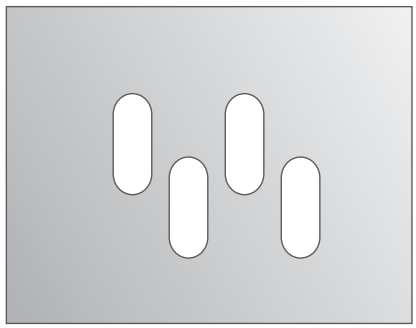
Comments:
- Length of the card guide is dependent upon station size and machine tonnage.
- Also available as a continuous form to increase productivity and flexibility.

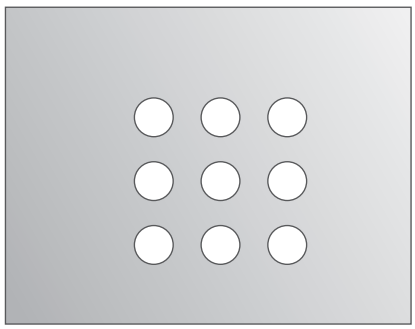
Cluster

Use:
To produce multiple holes with minimal hits.

Typical Application:
- Material thickness from 0.020(0.50) to 0.157(4.00).
- Other constraints dependent upon station size, punch size and shape and press tonnage.

Comments:
- For greater hole uniformity and flatter sheets, spread the punches to avoid punching adjacent holes in the same hit.
- Do not re-punch through previously punched holes to complete a pattern. A single hit tool may be necessary.





[Dimensions in Inches (mm)]

Emboss—Cold Forged

Use:
To produce a logo or design on a part.

Typical Application:
- Material thickness from 0.018(0.46) to 0.118(3.00).
- Best results in material thickness from 0.040(1.00) to 0.078(2.00).
- Maximum size dependent on the tooling style, station size and press tonnage capacity.

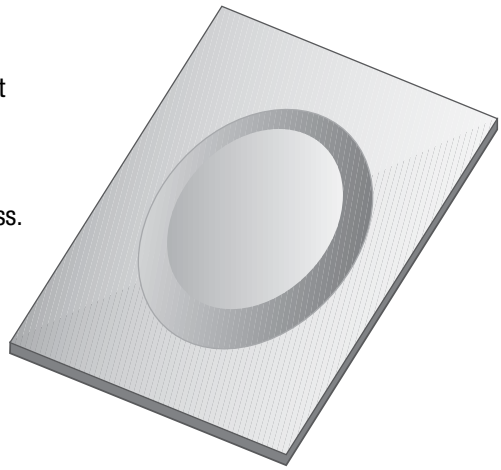
Comments:
- An exact drawing, CAD file, or artwork of logo is required to produce this type of assembly.

Emboss—Formed

Use:
Provides a recess or a protrusion.

Typical Application:
- Material thickness from 0.027(0.70) to 0.250(6.35), dependent upon press tonnage capacity.

Comments:
- Best results are attained when the side wall angle is 45° or less.
- Optimum form height is 3 x the material thickness or less.



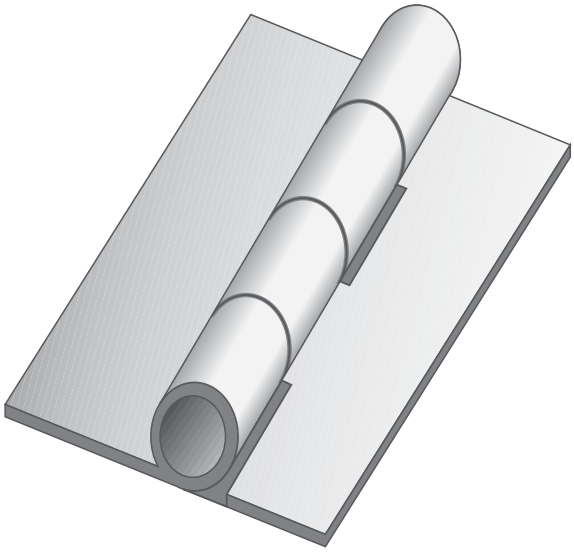
[Dimensions in Inches (mm)]

Extrusion—Tapping

Use:
Threading for screws and increased bearing area for tubes, etc.

Typical Application:
- Material thickness from 0.031(0.80) to 0.106(2.70).
- Overall Height – 2x to 2.5x material thickness.

Comments:
- Additional inverted dies are required to accommodate different material thickness.



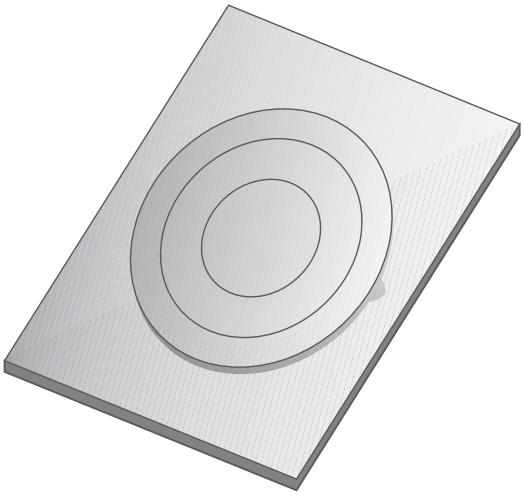
Hinge

Use:
To create hinge knuckles as integral elements on sheet metal components.

Typical Application:
- The range of this application is dependent on a combination of the material thickness, pin diameter and feed gap of the press.

Comments:
- An integral hinge knuckle on a component will eliminate the costly process of purchasing and assembling separate hinges.

[Dimensions in Inches (mm)]



Knockout

Use:
Allows optional pathway for electrical cable.

Typical Application:
- Material thickness from 0.024(0.60) to 0.118(3.00).
- Maximum size dependent upon material type, thickness and press tonnage capacity.

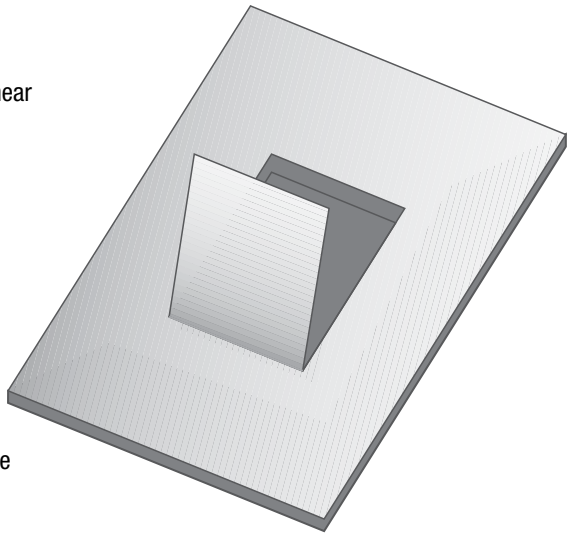
Comments:
- The tool can normally be used with other material thickness within a range. of + or - 0.016(0.41) from design thickness.
- Maintain 0.236(6.00) difference between diameters used for knockout.

Lance And Form

Use:
For air flow, decoration, as card guides, location markers, shear tabs, wire harnesses or clip attachments.

Typical Application:
- Material thickness from 0.020(0.50) to 0.118 (3.00).
- Maximum recommended top-of-sheet to top-of-form height is 0.250(6.40).
- Other limitations include material type, station size, and press tonnage capacity.

Comments:
- The inclusion of a 5° draft angle is recommended to assure reliable operation of open ground forms.



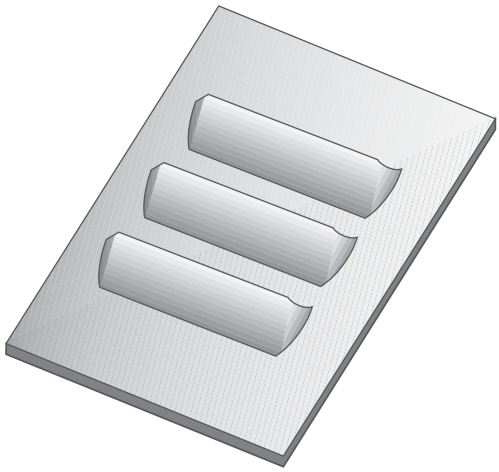
[Dimensions in Inches (mm)]

Louver

Use:
To provide air flow or ventilation.

Typical Application:
- Material thickness from 0.028(0.70) to 0.106(2.70).
- Maximum recommended top-to-top height is 0.255(6.50).

Comments:
- One tool cuts the sheet and produces the form in the same operation.
- The tool is designed for a specific material thickness.



Insert Sizes Available

Fractional	Decimal	Metric
3/32	0.094	2.40
1/8	0.125	3.12
3/16	0.188	4.50
1/4	0.250	6.34

Stamp—Alpha Numeric

Use:
To provide indelible marking of alpha-numeric characters on the top or bottom of the sheet.

Typical Application:
- Material thickness 0.032(0.80) up to machine capacity.
- Characters available in 4 popular sizes. See table.

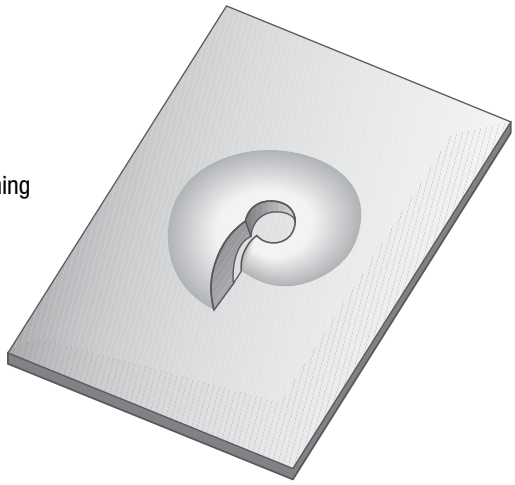
Comments:
- Individual characters can be easily changed.

[Dimensions in Inches (mm)]

Threadform

Use:
To provide a form to accept a sheet metal screw.

Typical Application:
- Material thickness 0.020(0.50) to 0.048(1.20).
- Size is dependent upon screw size selected.
- Thicker material requires a countersink operation or thinning prior to threadforming.



V-Line Inscription

Use:
To produce logos, messages, or symbols.

Typical Application:
- Material thickness from 0.032(0.80) up to machine capacity.
- Maximum size is dependent on station size, size of symbols and characters, and press tonnage capacity.

Comments:
- V-Line Stamping – renders the image with a sharp line stamped into the surface.
- An exact drawing, CAD file, or artwork of logo is required in order to produce this type of assembly.

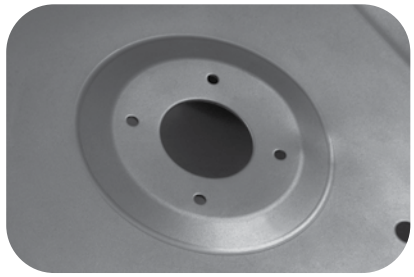
[Dimensions in Inches (mm)]

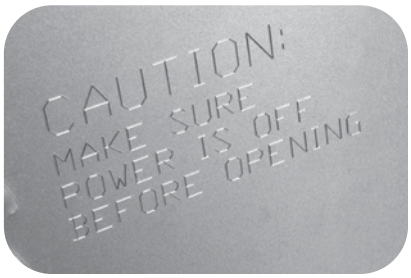
Mate Rollerball™

Use:
The Rollerball™ is an exciting new concept designed by Mate Precision Technologies to take advantage of the extended programming capabilities of hydraulic and other punch presses capable of operating in the x and y axis with the ram down. The Rollerball™ gives you the benefit of making forms not possible with single hit forming tools.

Typical Application:
- Maximum workable material thickness is 0.105(2.70) mild steel.

Comments:
- The press must be capable of holding the ram down while the sheet is moved in the x and/or y.





Mate Sheetmarker™

Use:
For markings or etchings on the surface of sheet metal. The tool uses a diamond pointed insert in a spring loaded holder to create the marking.

Typical Application:
- The Sheetmarker™ Tool can be used on all material types and thicknesses.

Comments:
- A wide variety of results can be produced, ranging from very light etching to fairly deep grooves in the sheet.
- Variations are achieved with a combination of three spring pressures and two insert point angles.

Comments:
- The press must be capable of holding the ram down while the sheet is moved in the x and/or y.

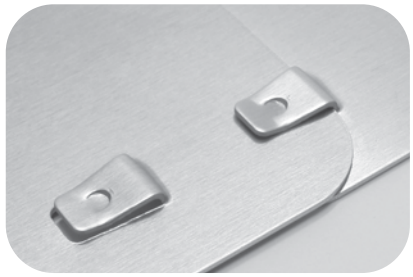
[Dimensions in Inches (mm)]

Mate SnapLock™

Use:
For joining materials, thus eliminating secondary operations such as spot welding, riveting, or fastening with threaded hardware.

Typical Application:
- Material thickness from 0.020(0.50) up to 0.118(3.00).
- Other limitations include material type, station size, and press tonnage capacity.

Comments:
- Suitable for joining materials of dissimilar type and/or thickness.
- Positive locking and locating feature for fast and accurate assembly.



Mate HexLock™

Use:
To provide a reliable and secure method of retaining common threaded fasteners in sheet metal.

Typical Application:
- Material thickness from 0.020(0.50) up to 0.118(3.00).
- Other limitations include material type, station size, and press tonnage capacity.

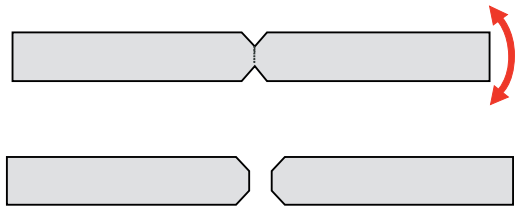
Comments:
- Suitable for hexagon nuts and hexagon headed bolts that conform to DIN933 or DIN934.

[Dimensions in Inches (mm)]

Mate EasySnap™

Use:
Scrapless retention system to allow fabricator to snap punched parts out of sheet metal.

Typical Application:
- Material thickness from 0.020(0.50) up to 0.078(2.00) for mild steel and aluminium, and 0.020(0.50) up to 0.059(1.50) for stainless steel.
- Maximum length of form is 36.00(914.40) depending on material type and thickness.

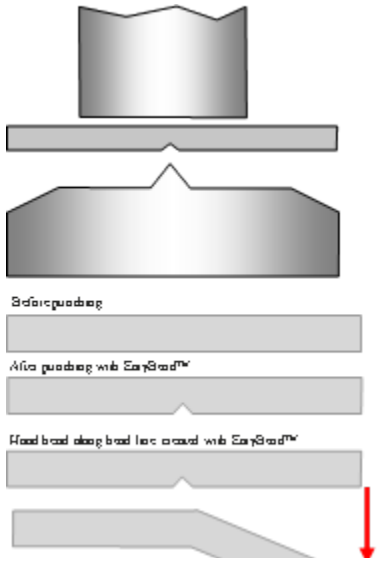


Comments:
- Reduces the need for slitting and micro joints for part retention.
- Material type and thickness must be specified at time of order.

Mate EasyBend™

Use:
Create bend lines suitable for subsequent hand bending operations. Ideal for intricate fabricated assemblies where conventional press break forming techniques are impractical. Simply bend along the bend line for quick, accurate, and convenient forms.

Typical Application:
- Material thickness from 0.020(0.50) up to 0.078(2.00) for mild steel and aluminium, and 0.020(0.50) up to 0.059(1.50) for stainless steel.
- Maximum length of form is 36.00(914.40) depending on material type and thickness.



Comments:
- Eliminates secondary operations.
- Material type and thickness must be specified at time of order.

[Dimensions in Inches (mm)]

Mate Square ShearButton™

Use:
Square ShearButton reduces the need for slitting and micro-joints for part retention in thicker materials. Simply snap punched components out of thicker sheet metal with a clean, smooth edge.

Typical Application:
- Nesting parts in a large sheet
- Square ShearButton may be used with a variety of material types, including stainless steel, aluminum, cold roll steel and more.
- Very large or heavy parts with minimal micro-joints. The Square Shearbutton tabs are much stronger than the traditional micro-joint, so fewer are needed.
- Rounded part corners where a corner micro-joint is not possible

Comments:
- Available in form up and form down.
- Depths and heights may be adjusted to suit the user's application.

Mate Hybrid ThreadForm™

Use:
In many industries, there's a need to join two pieces of material using a threaded machine screw. If the thread pitch is greater than the material thickness, then a conventional threadform tool is a great solution. Unlike a conventional threadform tool, the Hybrid Threadform tool thins the material in the center of the form, and creates the threadform helix in just one operation.

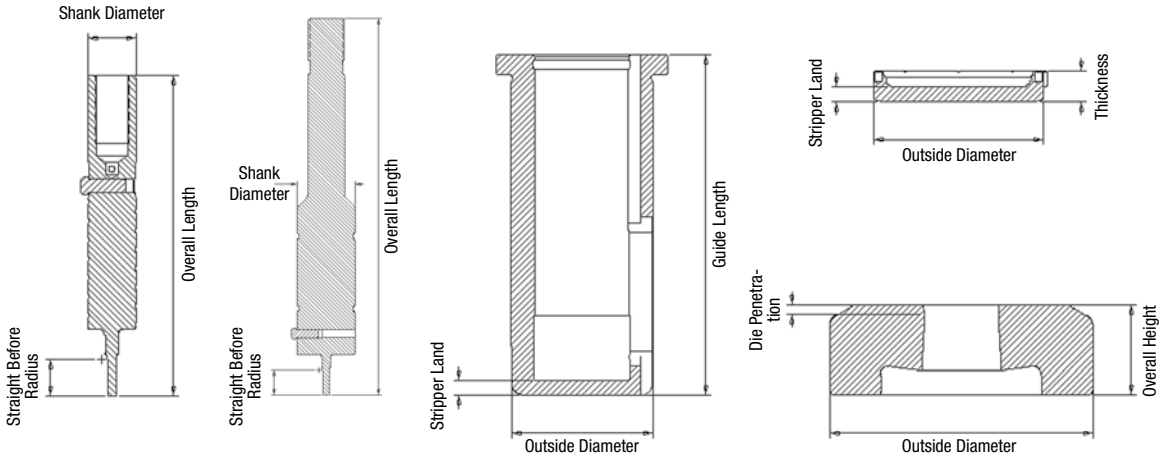
Typical Application:
- Eliminates secondary operations
- Eliminates tapping operations
- Reduces debris in the machine caused by tapping
- Reduces component cost by eliminating any special fasteners

Comments:

[Dimensions in Inches (mm)]

CRITICAL DIMENSIONS

Station	1/2" A	1-1/4" B	2" C	3-1/2" D	4-1/2" E	6" F
Maximum Punch Diagonal	0.500(12.70)	1.250(31.75)	2.000(50.80)	3.500(88.90)	4.500(114.30)	6.000(152.40)
Ultra TEC® Punch						
Part Number	PAUA	PAUB	PAAC	PAAD	PAAE	PAAF
Overall Length	4.245(107.82)	3.957(100.51)	3.786(96.16)	3.313(84.15)	3.353(85.17)	3.745(95.12)
Shank Diameter	0.630(15.99)	1.250(31.75)	2.007(50.98)	3.520(89.41)	4.520(114.81)	6.043(153.49)
Straight Before Radius*	0.740(18.80)	0.740(18.80)	1.005(25.53)	1.005(25.53)	1.043(26.49)	1.045(26.54)
Ultra TEC® Stripper						
Part Number	S6KA	S6KB	S6KC	S6KD	S6KE	
Outside Diameter	0.751(19.07)	1.500(38.10)	2.249(57.12)	3.825(97.16)	4.759(120.88)	
Thickness	0.272(6.91)	0.272(6.91)	0.394(10.01)	0.394(10.01)	0.394(10.01)	
Stripper Land	0.157(3.99)	0.157(3.99)	0.315(8.00)	0.315(8.00)	0.315(8.00)	
Metric (Original) Style Punch						
Part Number	PAAA	PAAB	PAAC	PAAD	PAAE	PAAF
Overall Length	8.169(207.49)	8.169(207.49)	3.786(96.16)	3.313(84.15)	3.353(85.17)	3.745(95.12)
Shank Diameter	0.630(16.00)	1.250(31.75)	2.007(50.98)	3.520(89.41)	4.520(114.81)	6.043(153.49)
Straight Before Radius*	0.664(16.87)	0.740(18.80)	1.005(25.53)	1.005(25.53)	1.043(26.49)	1.045(26.54)
Original Style Stripper						
Part Number	S6AA	S6AB	S6AC	S6AD	S6AE	S6AF
Guide/Stripper Outside Diameter	1.020(25.91)	1.883(47.83)	2.007(50.98)	3.520(89.41)	4.520(114.81)	6.450(163.83)
Guide Length/Stripper Thickness	4.448(112.98)	4.528(115.01)	0.394(10.01)	0.394(10.01)	0.394(10.01)	.394(10.01)
Stripper Land	0.197(5.00)	0.197(5.00)	0.394(10.01)	0.394(10.01)	0.394(10.01)	.394(10.01)
Slug Free® Die						
Part Number	D0AA	D0AB	D0AC	D0AD	D0AE	D0AF
Outside Diameter	1.000(25.40)	1.875(47.63)	3.500(88.90)	4.938(125.43)	6.249(158.72)	8.265(209.93)
Overall Height	1.187(30.15)	1.187(30.15)	1.187(30.15)	1.187(30.15)	1.187(30.15)	1.383(35.13)
Die Penetration	0.118(3.00)	0.118(3.00)	0.118(3.00)	0.118(3.00)	0.118(3.00)	.118(3.00



*** The Straight Before Radius (SBR) dimension may be reduced for small diameters and narrow widths. Consult your application specialists.**

[Dimensions in Inches (mm)]

PUNCH MAINTENANCE

You can greatly extend overall punch life by sharpening whenever the edge dulls to a 0.005(0.13) radius. At this point, just a small amount of sharpening will "touch up" the cutting edge. Frequent touch up works better than waiting for the punch to become very dull. The tool lasts longer and cuts cleaner with less punching force.

Maximum amount of sharpening depends on thickness of material being punched, size of punch (length and width), and punch press station.

1. To sharpen, clamp the punch squarely in a Vee Block on the magnetic chuck of a surface grinder. Only 0.001 to 0.002 (0.03 to 0.05) should be removed in one "pass". Repeat until tool is sharp, normally 0.005-0.010(0.13-0.25) total.
2. Use a standard vitrified bond, aluminum oxide wheel: hardness range "D" to "J"; grain size 46 to 60. A "ROSE" wheel made especially for grinding high speed steel is a good choice but not mandatory.
3. Dress the wheel using a rigid single or multi-point diamond: downfeed 0.0002-0.0008 (0.005-0.020); crossfeed quickly 20-30 in/min (508-762 mm/min).
4. Apply coolant with as much force and as close to the tool and wheel as is practical. Use a good general purpose grinding coolant used to the manufacturer's specifications.
5. Feeds and feed rates: A, Downfeed (wheelhead), 0.001 - 0.003 (0.03-0.08); B, Crossfeed (infeed), 0.005-0.010 (0.13-0.25); for nitrided punches, 0.002-0.007(0.05-0.18); C, Traverse (sideways), 100-150 in/min (2,540-3,810 mm/min).
6. After the sharpening, lightly stone the sharp cutting edges to remove any grinding burrs and to leave a 0.001-0.002 (0.03-0.05) radius. This reduces risk of chipping.
7. Demagnetize the punch and spray on a light oil to prevent corrosion.

DIE MAINTENANCE

As with punches, keep dies clean and watch for wear. Use the same sharpening procedures — hold die on surface grinder's magnetic chuck; use same wheel and feed rates. Check die thickness after each sharpening and add shims as necessary.

CONSIDERATIONS IN GRINDING

A grinding wheel's abrasive particles, in effect, are break-away "teeth". These teeth can be made from a variety of very hard, abrasion resistant materials, such as diamond, borozon and, most commonly, aluminum oxide.

The abrasive particles are embedded in a softer matrix material and meant to fracture loose from the matrix as cutting pressure becomes greater. Cutting pressure can increase from raising the feed rate or from dulling of abrasive particles. Pressure causes surface particles to fracture or break free from the wheel matrix and expose new sharp edges, resulting in the wheel's sharpness.

For our purposes, in selecting a vitrified bond aluminum oxide wheel, we need only be concerned with two variables: hardness and coarseness of the wheel. Hardness refers to the bond strength of the matrix. Coarseness refers to the size and concentration of the abrasive particles (grit).

Generally speaking, harder materials require softer wheels — softer materials require harder wheels. Grinding a harder and/or more abrasive resistant material, such as hardened tool steel, dulls abrasive particles quickly. The wheel then needs increased feed forces. A softer wheel allows spent particles to break loose from the matrix more easily. The newly exposed sharp edges will cut rather than rub and tear at the workpiece. Less pressure is required and the wheel runs cooler.

Coarse wheels with large, widely spaced abrasive particles perform less cutting per revolution and allow greater "chip" clearance. The wheel stays cleaner. Friction is reduced.

Balancing hardness and coarseness results in a wheel that stays sharp and clean to optimize cutting action. It meets the grinding objective of removing material from the workpiece while expending a minimal amount of wheel energy. Wheel energy losses largely translate to workpiece heating. Workpiece heating, in turn, will result in softened and/or highly stressed tools which will not perform well. Hardened tool steels are particularly vulnerable.

It is generally desirable to use a softer "G" or "H" hardness wheel with a grit concentration/size of about forty-six.

A-2 and S-7 STEEL

Grinding Wheel Hardness: **G-J**
Grit: **46-60**

M-2 and M4PM™ STEEL

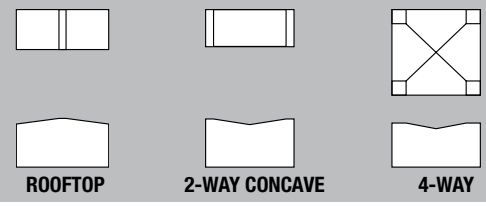
Grinding Wheel Hardness: **D-G**
Grit: **46-60**

[Dimensions in Inches (mm)]

PUNCH SHEAR RECOMMENDATIONS

STATION	DESCRIPTION	STANDARD	ALTERNATIVE
1/2" A	Rounds and Shapes	None	None
1-1/4" B	Rounds and Shapes	None	None
2" C	Rounds	None	2-Way Concave
	Rectangles Width ≤ 0.188(4.78)	None	Rooftop
	Rectangles Width ≤ 0.188(4.78)	None	2-Way Concave
	Squares	None	4-Way
3-1/2" D	Rounds	None	2-Way Concave
	Rectangles Width ≤ 0.188(4.78)	None	Rooftop
	Rectangles Width ≤ 0.188(4.78)	None	2-Way Concave
	Squares	None	4-Way
4-1/2" E	Rounds	Rooftop	2-Way Concave
	Rectangles Width ≤ 0.188(4.78)	Rooftop	Rooftop
	Rectangles Width ≤ 0.188(4.78)	Rooftop	2-Way Concave
	Squares	Rooftop	4-Way

ALTERNATIVE SHEARS

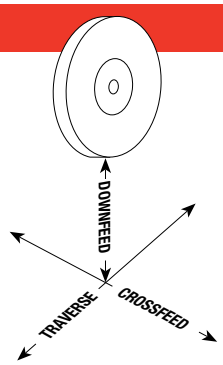


FEED RATES PER PASS

Downfeed:
0.001-0.003(0.03-0.08)

Crossfeed:
0.010(0.25)

Traverse:
100-150 in/min.
(2.50-3.80 m/min.)



WHEELHEAD

FIXING SHARPENING PROBLEMS

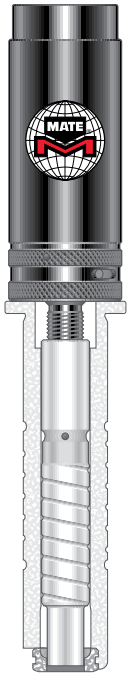
PROBLEM:	CAUSE:	CURE:
Discoloration** and/or surface cracks	Insufficient coolant	Increase or redirect flow.
	Improper wheel	Use coarser grain, softer grade grinding wheel.
	Improper dress	Drop wheelhead 0.0002-0.0004 (0.005-0.010) and redress. Move crossfeed approx. 50 in/min. (1.25 m/min.)
Harsh cutting sound and/or poor surface finish	Excessive stock removal	Less downfeed; lower crossfeed rate
	Improper wheel	Use coarser grain, softer grade grinding wheel.
	Improper dress or glazed wheel	Redress wheel, break glaze on wheel surface

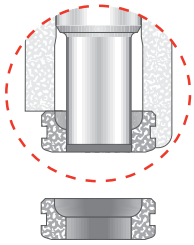
**Dark discoloration indicates damage not necessarily limited to the tool surface. Removal of burned surface will not rectify damage. Recommend replacement of the tool.

[Dimensions in Inches (mm)]

ULTRA TEC® GRIND LIFE COMPARISION ½" A STATION

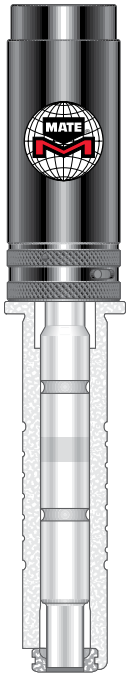
1/2" A Station Ultra TEC® with Ultra® Punch



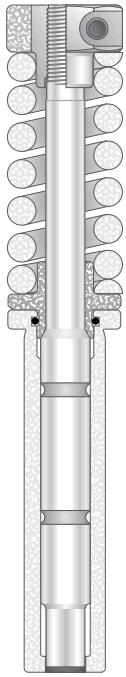


Ultra® Stripper with 0.118(3.0) Relief

1/2" A Station Ultra TEC® with Original Style Punch

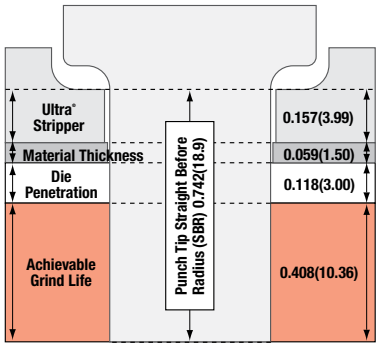


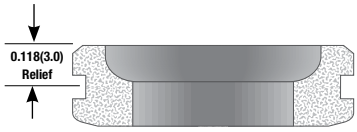
1/2" A Station Original Style



VALUE COMPARISON - 0.408(10.36) grind life when used with 0.059(1.50) material

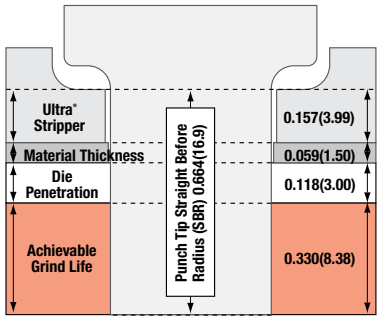
Mate Ultra TEC® System w/Ultra® Punch

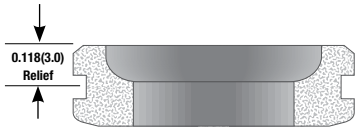




Ultra® System Stripper

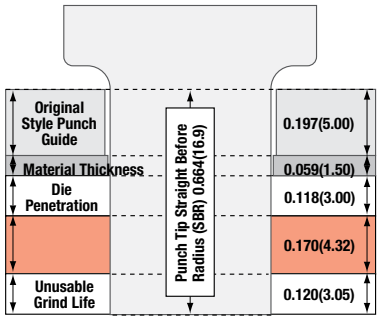
Mate Ultra TEC® System w/Original Style Punch





Ultra® System Stripper

Original Style



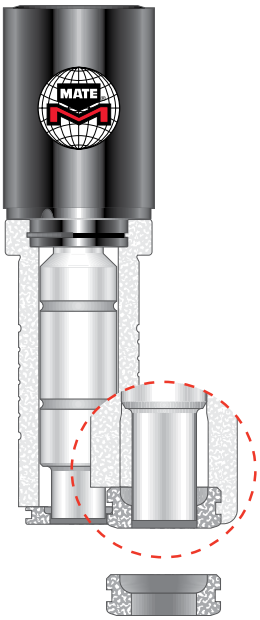
*Limited by punch head position

Original Style Punch Guide

[Dimensions in Inches (mm)]

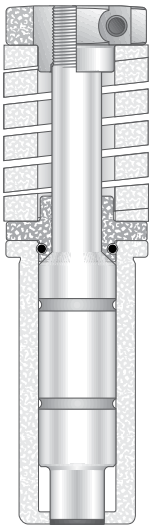
ULTRA TEC® GRIND LIFE COMPARISION 1-¼" B STATION

1-1/4" B Station Ultra®



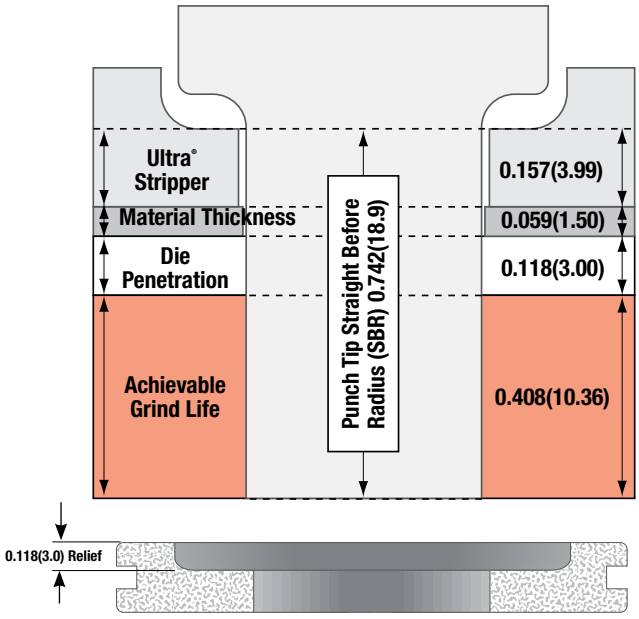
Ultra® Stripper with 0.118(3.0) Relief

1-1/4" B Station Original Style



1-1/4" B Station Original System Punch Guide

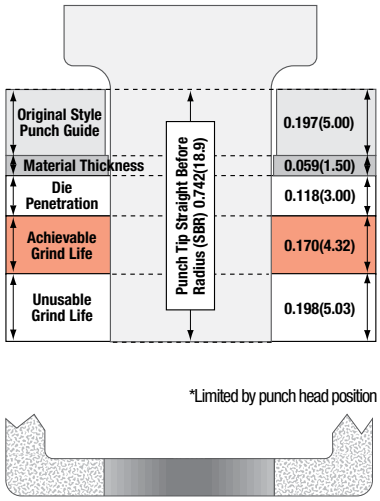
Mate Ultra® System



Ultra® System Stripper

VALUE COMPARISON - 0.408(10.36) grind life when used with 0.059(1.50) material

Original Style

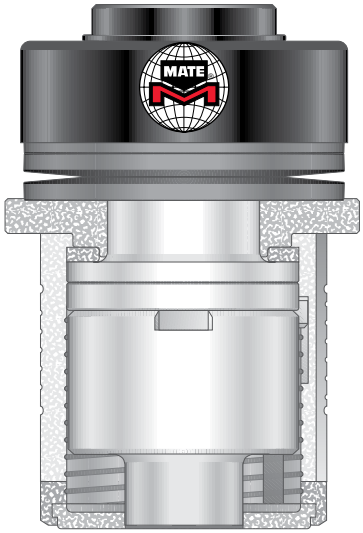


*Limited by punch head position

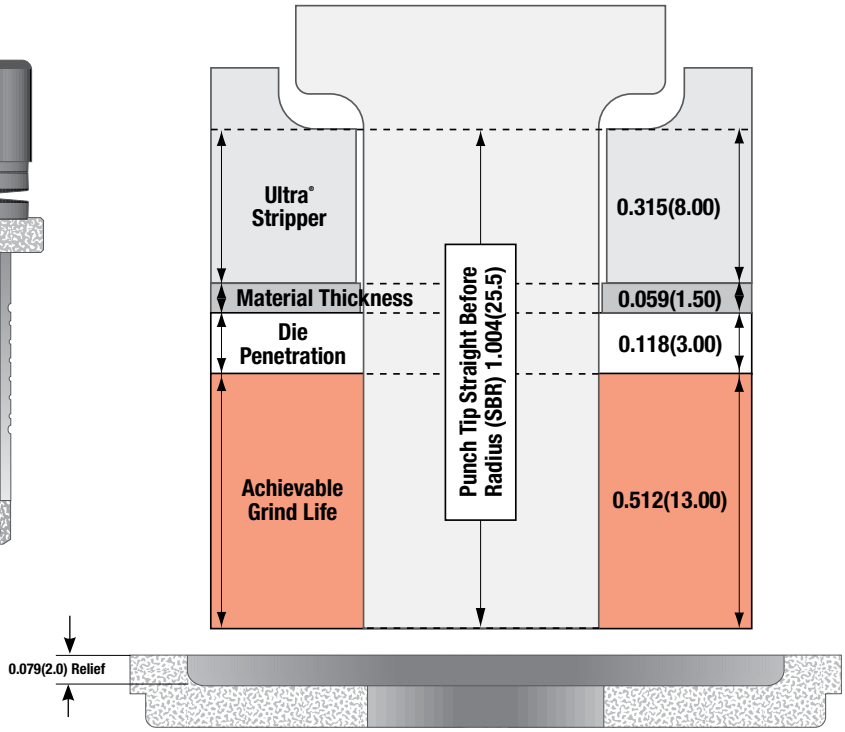
Original Style Punch Guide

[Dimensions in Inches (mm)]

4-1/2" D Station Ultra®

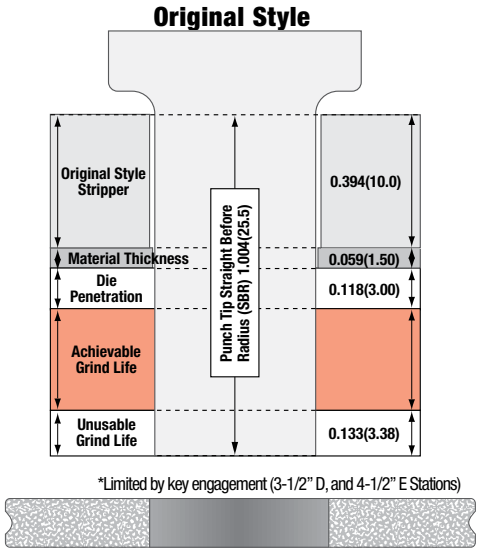


Mate Ultra® System



VALUE COMPARISON - 0.512(13.00) grind life when used with 0.059(1.50) material

Original Style



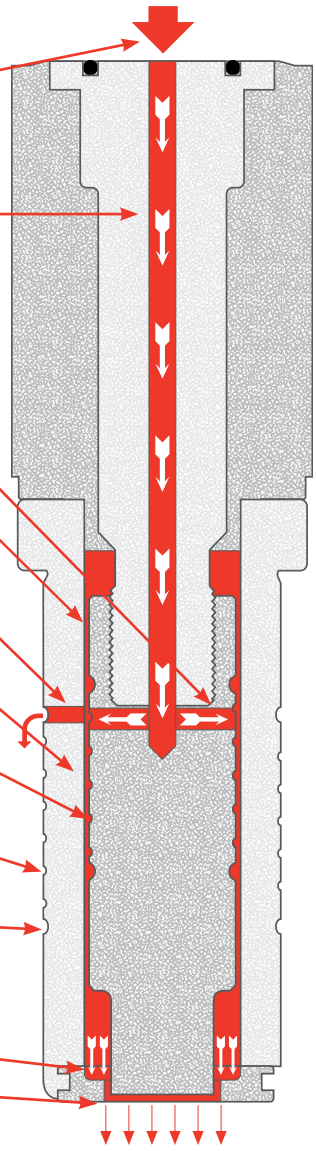
Original Style Stripper

[Dimensions in Inches (mm)]

ULTRA® TOOL LUBRICATION SYSTEM ½" A AND 1-¼ B STATION

Machines equipped with tool lubrication systems introduce a lubrication fluid (oil, or an oil/air mixture) into the top of the tooling system. This diagram shows the method of transporting this fluid throughout the Ultra® tooling system in the 1/2" A (not show) and 1-1/4" B station (as shown) system.

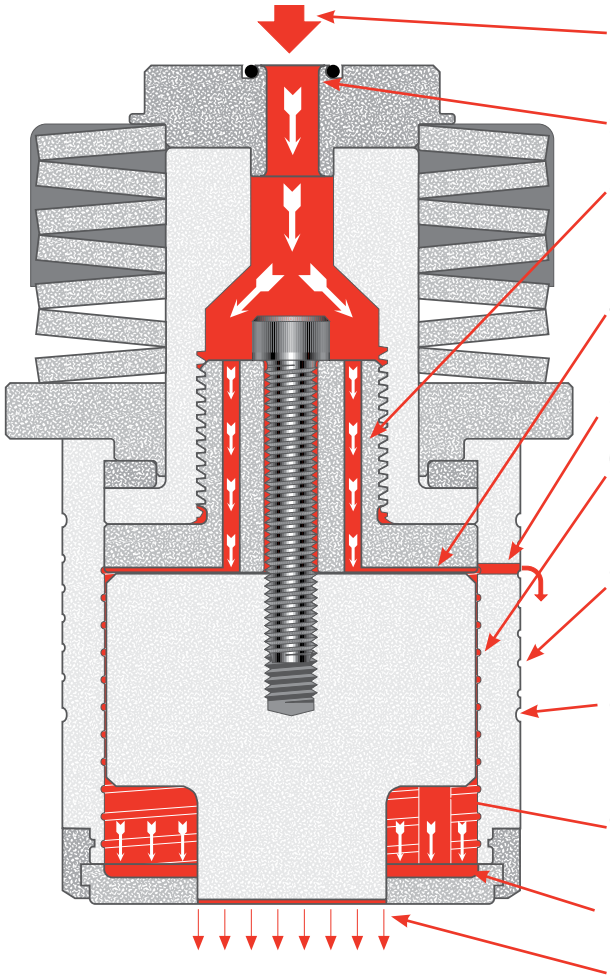
1. The lubrication fluid – is introduced at the top of the tool by the machine mechanism.
2. It travels through the center of the assembly.
3. It flows through four fluid transportation holes in the punch. Two holes have been shown here. The four holes are at 90 degrees from each other.
4. The lubrication fluid reaches the interior wall of the Ultra guide.
5. The lubrication fluid also reaches the exterior of the guide.
6. There are internal keyways (Three for 1/2 A, Five for 1-1/4 B-Station) in the Ultra guide for punch angle settings. One keyway will be obstructed with the key of the punch. The lubrication fluid moves through the remaining four unobstructed keyways to the stripper pooling area.
7. The punch spiral grooves evenly distribute the lubrication fluid around the entire interior of the guide.
8. The exterior spiral grooves evenly distribute the lubrication fluid around the entire guide between the guide and the turret bore.
9. The exterior spiral grooves do not extend beyond the turret bore. This keeps the lubrication on the contact surfaces and prevents the fluid from draining onto the work surface.
10. Stripper pooling area.
11. For Ultra ABS® Only: Fluid is expelled through the small reliefs in the stripper next to the punch.



Ultra ABS® is licensed under U.S. Patent No. 4,977,804 and corresponding foreign patents and patent applications, and authorized for use only on punch press machines manufactured by, for, or under license from Amada Company, Ltd.

[Dimensions in Inches (mm)]

Machines equipped with tool lubrication systems introduce a lubrication fluid (oil, or an oil/air mixture) into the top of a tooling system. This diagram shows the method of transporting this mixture throughout the Ultra® tooling system in the 2" C, 3-1/2" D (as shown), and the 4-1/2" E station system.



1. The lubrication fluid is introduced at the top of the tool by the machine mechanism.
2. It travels through the center of the assembly.
3. It flows through three fluid transportation holes. Two holes have been shown here.
   The three holes are at 120 degrees from each other.
4. The lubrication fluid reaches the interior wall of the guide as it flows through three channels.
5. The lubrication fluid also reaches the exterior of the guide.
6. The interior spiral grooves evenly distribute the lubrication fluid around the entire punch between the punch and the guide.
7. The exterior spiral grooves evenly distribute the lubrication fluid around the entire guide between the guide and the turret bore.
8. The exterior spiral grooves do not extend beyond the turret bore. This keeps the lubrication on the contact surfaces and prevents the fluid from draining onto the work surface.
9. There are three vertical interior guide grooves that transport the fluid to the stripper pooling area.
10. Stripper pooling area.
11. For Ultra ABS® Only:
    Fluid is expelled through the small reliefs in the stripper next to the punch.

[Dimensions in Inches (mm)]

WHAT IS MATE'S SUPERMAX™ COATING? Mate SuperMax™ is a **proprietary** next generation coating applied using the latest nano-layer technology. Specifically formulated for punch press tooling, SuperMax's harder, denser film provides a lubricious coating greatly increasing wear resistance and lowering friction coefficients about 20%. Lower friction means less heat build-up, less galling and longer tool life. SuperMax is particularly good for adhesive wear tooling applications. The lubricity is also beneficial when punching sharp cornered shapes with a 90 degree or smaller angle.

In customer testing, SuperMax outperforms currently available premium coatings by 2 to 8 times, depending on the application. SuperMax can be applied to M4PM™, M2, and Durasteel™ punches.

WHAT IS MAXIMA™ COATING?
Maxima is a multilayer Zirconium Titanium Nitride coating that is hard, wear resistant, and lubricious. It acts as a barrier between the punch and the sheet metal being punched and, because of its exceptional lubricity, greatly improves stripping. Maxima is an extremely hard, wear resistant, slippery material which reduces the friction that occurs during the stripping portion of the punching cycle, it is particularly good for adhesive wear tooling applications. Less friction means less heat build up, less galling and longer tool life. The lubricity is also beneficial when punching sharp cornered shapes with a 90 degree or smaller angle.

In real life applications, Maxima has increased tool life by a factor of 2 to 10 times, keeping tools in production longer with increased up time. Maxima can be applied to M-2, M4PM™, and Durasteel™.

WHAT IS NITRIDE TREATMENT?
Nitride is an optional heat treatment for abrasive and adhesive wear environments when punching thin materials. It is a surface treatment which becomes an integral component of the structure of the material itself, therefore extending tool life.

Punches with Nitride Treatment are recommended for punching abrasive materials such as fiberglass or materials that cause galling such as stainless steel, galvanized steel, and aluminum. It is also recommended for high speed punching (see below for nibbling limitations). Nitride can be applied to M-2 and M4PM™ tool steel.

APPLICATION RECOMMENDATIONS:

COATING OR TREATMENT	3000 & 5000 Series Aluminum	Galvanized Steel	Stainless Steel	Stainless Steel Under 14 gauge	Cold Rolled Steel	Vinyl Coated Materials	Pre-painted Materials Under 16 gauge	Fiberglass
SuperMax™	X	X	X	X	X	X	X	X
Maxima™	X	X	X	X		X	X	
Nitride	X			X	X		X	X

SHAPE	MINIMUM PUNCH SIZE FOR **SUPERMAX™ COATING**	MINIMUM PUNCH SIZE FOR **MAXIMA™ COATING**	MINIMUM PUNCH SIZE FOR **NITRIDE TREATMENT**	MINIMUM PUNCH SIZE FOR **NITRIDE WHEN NIBBLING**
Round	Minimum diameter = 0.098(2.50)	Minimum diameter = 0.098(2.50)	Minimum diameter = 0.158(4.01)	Minimum diameter = 0.500(12.70)
Rectangle	If length is > 0.250(6.35) The minimum width is 0.060(1.50) If length is < 0.250(6.35) The minimum width is 0.098(2.50)	If length is >0.250(6.35) The minimum width is 0.060(1.50) If length is <0.250(6.35) The minimum width is 0.098(2.50)	Minimum width = 0.158(4.01)	Minimum width = 0.500(12.70)
Oval	If length is > 0.250(6.35) The minimum width is 0.060(1.50) If length is < 0.250(6.35) The minimum width is 0.098(2.50)	If length is >0.250(6.35) The minimum width is 0.060(1.50) If length is <0.250(6.35) The minimum width is 0.098(2.50)	Minimum width = 0.158(4.01)	Minimum width = 0.500(12.70)
Square	Minimum width = 0.098(2.50)	Minimum width = 0.098(2.50)	Minimum width = 0.158(4.01)	Minimum width = 0.500(12.70)
Others	Consult a Mate application specialist			

* Mate's SuperMax tooling can be identified by its subtle matte finish and a protective green tip when shipped.

** If you require a smaller minimum punch size, contact a Mate Application Specialist

[Dimensions in Inches (mm)]

M4PM™ is a high speed, particle metallurgy tool steel designed for use in high performance tooling systems.

A combination of the chemical composition of M4, the particle metallurgy manufacturing process, and the triple temper heat treatment process, produces M4PM: the world's finest tool steel for use in punching tools.

M4PM is a very homogeneous, high quality tool steel which has many advantages when compared to alternative tool steels commonly available. These advantages include:

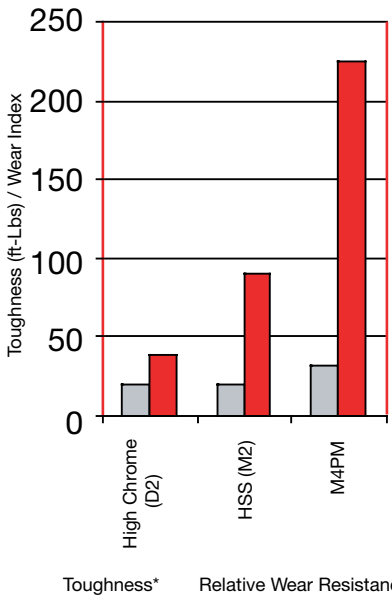
Superior Wear Resistance – 100% better wearing, M4PM offers superior resistance to adhesive- and abrasive-wear to maximize the interval between regrinds.

- More uniform distribution of smaller carbides—results in improved ductility (adhesive-wear) while still providing abrasive-wear resistant carbides over the entire surface of the material.
- 100% more Vanadium carbides—harder wearing for greater resistance to abrasive-wear.
- Increased Tungsten carbides—harder wearing and offer better red hardness; increased resistance to high temperatures which may anneal or damage the material.
- Higher hardenability—increased alloy content results in higher effective hardness for better wear resistance.

Increased Toughness – the molecular structure of M4PM is 50% tougher than conventional tool steels in impact strength tests.

- Triple temper heat treatment process—ensures full conversion of the material matrix. Results in fully tempered martensite and reduced internal stress, together with better dimensional stability.
- More uniform distribution of smaller carbides—offsets the effects of increased alloy content. Results in a more "interlocked" material matrix for significantly reduced tool breakage and edge chipping. See micrograph.

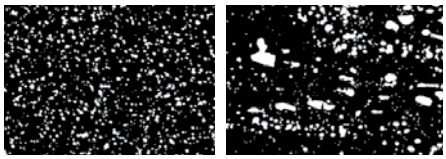
Better Value – customer trials have shown that tools manufactured in M4PM last 100% longer between regrinds than tools manufactured using conventional High Speed Steel. By increasing the interval between regrinds, the tooling lasts longer and punches many more holes before needing to be replaced.



International Material Standards			
	D2	M2	M4PM
JIS	SKD 11	SKH 51	SKH 54
WNr	1.2379	1.3343	none
DIN	X155 CrVMo 12-1	HS 6-5-2	none

M4PM Chemical Composition	
Carbon	1.42%
Chromium	4.00%
Vanadium	4.00%
Tungsten	5.50%
Molybdenum	5.25%

Micrograph shows that the particle metallurgy process produces a very homogeneous, high quality tool steel with superior wear resistance, toughness and dimensional stability.



M4PM™ | Conventional Tool Steel

*Toughness: Charpy C-Notch impact strength test.
**Relative Wear Resistance: 10x Cross cylinder adhesive wear test.
Based upon steel manufacturers data.

[Dimensions in Inches (mm)]

ADD-ONS

General
Radius Corners
Non-Standard Straight Before Radius (SBR) Dimension
Special Angle Settings
Optional Shear (Limited Options)

Small Diameter Round Tools
Diameter 0.031(0.79) to 0.061(1.55)
Diameter 0.062(1.56) to 0.092(2.34)

Narrow Width Shaped Tools
Widths under 0.079(2.00)

Station Jumper
1-1/4" B Station - if diagonal dimension is <0.500(12.70)
2" C Station - if diagonal dimension is <1.250(31.70)
3-1/2" D Station - if diagonal dimension is <2.000(50.80)
4-1/2" E Station - if diagonal dimension is <3.500(88.90)
6" F Station - if diagonal dimension is <4.500(114.30)

SuperMax™ Coating
1/2" A Station
1-1/4" B Station
2" C Station
3-1/2" D Station
4-1/2" E Station
6" F Station
Slitting Punch Insert

Maxima™ Coating / Nitride Treatment
1/2" A Station
1-1/4" B Station
2" C Station
3-1/2" D Station
4-1/2" E Station
6" F Station
Slitting Punch Insert

Slug Free Light™ Die Geometry - See page 9
1/2" A Station
1-1/4" B Station
2" C Station
3-1/2" D Station
4-1/2" E Station

M4PM™ Tool Steel
Ultra TEC® — 1/2" A Station
Ultra TEC® — 1-1/4" B Station
MXC™ — 1/2" A Station
MXC™ — 1-1/4" B Station

[Dimensions in Inches (mm)]

 | 1295 Lund Boulevard, Anoka, Minnesota 55303 USA. Phone: 763.421.0230 | mate.com
orders@mate.com

STATION	CONFIGURATION
ULTRA TEC®	
1/2" A	Canister and guide with Ultra® punch and stripper
1-1/4" B	Canister and guide with Ultra® punch and stripper
2" C	Original punch and Ultra® stripper
3-1/2" D	Original punch and Ultra® stripper
4-1/2" E	Original punch and Ultra® stripper
MATE ULTRA QCT™	
1/2" A	Canister and guide with QCT punch driver and insert, and Ultra stripper
1-1/4" B	Canister and guide with QCT punch driver and insert, and Ultra stripper
MATE ULTRA TEC® METRIC	
1/2" A	Canister and guide with Metric punch and stripper
1-1/4" B	Canister and guide with Metric punch and stripper
MATE ULTRA TEC® QCT METRIC	
1/2" A	Canister and guide with Metric QCT punch driver and insert, and Ultra stripper
1-1/4" B	Canister and guide with Metric QCT punch driver and insert, and Ultra stripper
ULTRA TEC® FULLY GUIDED	
1-1/4" B	Canister and guide with Ultra® punch and guided stripper
2" C	Original punch and guided stripper
3-1/2" D	Original punch and guided stripper
4-1/2" E	Original punch and guided stripper
ULTRA TEC® FULLY GUIDED CLAMP CLEARING	
3-1/2" D	punch insert, Clamp Clearing stripper
4-1/2" E	punch insert, Clamp Clearing stripper
ULTRA XT	
1/2" A	Canister and guide with Ultra® punch and Ultra® stripper
1-1/4" B	Canister and guide with Ultra® punch and Ultra® stripper
2" C	Original punch and Original stripper
3-1/2" D	Original punch and Original stripper
4-1/2" E	Original punch and Original stripper
6" F	Original punch and Original stripper
MATE ULTRA XT QCT™	
1/2" A	Canister and guide with QCT punch driver and insert, and Ultra stripper
1-1/4" B	Canister and guide with QCT punch driver and insert, and Ultra stripper
ULTRA XT METRIC	
1/2" A	Canister and guide with Metric punch and Ultra® stripper
1-1/4" B	Canister and guide with Metric punch and Ultra® stripper
MATE ULTRA XT METRIC QCT™	
1/2" A	Canister and guide with Metric QCT punch driver and insert, and Ultra stripper
1-1/4" B	Canister and guide with Metric QCT punch driver and insert, and Ultra stripper
RAPIDSET METRIC QCT™	
1/2" A	Canister and Original stripper guide with Metric QCT punch driver and insert
1-1/4" B	Canister and Original stripper guide with Metric QCT punch driver and insert
RAPIDSET OS	
1/2" A	Canister with Original punch and stripper guide
1-1/4" B	Canister with Original punch and stripper guide
RAPIDSET AMX	
1/2" A	Canister with AMX punch and stripper guide
1-1/4" B	Canister with AMX punch and stripper guide
RAPIDSET AMX QCT™	
1/2" A	Canister and AMX stripper guide with AMX QCT punch driver and insert
1-1/4" B	Canister and AMX stripper guide with AMX QCT punch driver and insert
ORIGINAL STYLE THICK TURRET	
1/2" A	Upper Assembly, including Original punch and stripper
1-1/4" B	Upper Assembly, including Original punch and stripper
2" C	Original punch and Original stripper
3-1/2" D	Original punch and Original stripper
4-1/2" E	Original punch and Original stripper
6" F	Original punch and Original stripper
METRIC QCT™ THICK TURRET	
1/2" A	Upper Assembly, including Original punch and stripper
1-1/4" B	Upper Assembly, including Original punch and stripper
AMX	
1/2" A	Upper Assembly, including AMX punch and stripper
1-1/4" B	Upper Assembly, including AMX punch and stripper
2" C	AMX punch and stripper
3-1/2" D	AMX punch and stripper
4-1/2" E	AMX punch and stripper

[Dimensions in Inches (mm)]

THICK TURRET COMPATIBILITY CHART

	Tool Style	Mate Part Number	Ultra TEC®	Ultra XT™	Ultra ABS®	Mate OS	Ultra ABS 14mm Bolt Guide Assembly	RapidSet™	Ultra MT, UMT and MT 3 or 8 Station	HP™ & HP2™	HP™ WLS & HP2™ WLS®	HP™ ABS & HP2™ ABS	Wilson Inch Style	Amada Standard	Amada ABS	Amada Z-Standard	Amada Z-ABS	Amada NEX Standard	Amada NEX ABS	Amada GT7	Amada Alpha	Wilson HP ABS 3 Station MT: 93307*	Wilson MT16R 45292	Wilson MT3R 45293	Wilson MT3B	Wilson MT16 45276	Wilson Nissinnbo MT8 38022	Wilson MTX3R & MTX8R
1/2" A Station																												
Punch	Ultra® QCT™	MATE02404*	•	•					•																			
	Metric QCT™ Keyed Rounds/Shapes	MATE02519*	•	•		•		•																				
	Metric QCT™ Keyless Rounds	MATE02520*	•	•		•		•																				
	MXC QCT™ Keyed Rounds/Shapes	MATE02546*								•										•								•
	MXC QCT™ Keyless Rounds	MATE02545*								•										•								•
	MXC QCT™ ABS Keyed Rounds/Shapes	MATE02544*									•	•								•								•
	MXC QCT™ ABS Keyless Rounds	MATE02543*									•	•								•								•
	AMX™ QCT™ Keyed Rounds/Shapes	MATE02551*	•	•14	•	•		•							•		•		•									
	AMX™ QCT™ Keyless Rounds	MATE02553*	•	•14	•	•		•							•		•		•									
	Ultra TEC® Punch	PAUA	•	•					•																			
	Metric (Original) Punch	PAAA	•6	•6		•		•						•				•										
	Ultra ABS® Punch	PAYA			•				•																			
	Inch Style	PAJA											•															
	AMX™	PMXA	•	•14	•	•		•							•		•		•									
	MXC™ Std	PXCA								•										•								•
	MXC™ ABS	PLCA									•	•								•								•
Stripper	Ultra TEC®	S6KA	•	•					•																			
	Original Style (Stripper Guide)	S6AA				•		•						•				•										
	Ultra ABS®	S6YA			•				•																			
	AMX™ (Stripper Guide)	SMXA						•						•4	•	•4	•	•4	•									
	MXC™	SXCA								•	•	•								•								•
Die	Slug Free® Die	D0AA	•	•	•	•		•	•	•	•	•	•	•	•	•	•	•	•	•								•
	Standard Die	D0KA	•	•	•	•		•	•	•	•	•	•	•	•	•	•	•	•	•								•
Clip	For Metric (Original) Round Punch	A0VAASAC	•5	•5	•5																							
1-1/4" B Station																												
Punch	Ultra® QCT™	MATE02401*	•	•					•	•1																		
	Metric QCT™ Keyed Rounds/Shapes	MATE02521*	•	•		•		•																				
	Metric QCT™ Keyless Rounds	MATE02522*	•	•		•		•																				
	MXC QCT™ Keyed Rounds/Shapes	MATE02525*	•13	•13	•13				•13	•										•								•
	MXC QCT™ Keyless Rounds	MATE02524*	•13	•13	•13				•13	•										•								•
	MXC QCT™ ABS Keyed Rounds/Shapes	MATE02526*	•13		•13						•	•								•		•		•				•
	MXC QCT™ ABS Keyless Rounds	MATE02528*	•13		•13						•	•								•		•		•				•
	AMX™ QCT™ Keyed Rounds/Shapes	MATE02552*	•	•14	•	•		•									•		•									
	AMX™ QCT™ Keyless Rounds	MATE02553*	•	•14	•	•		•									•		•									
	Ultra TEC® Punch	PAUB	•	•					•	•1																		
	Metric (Original) Punch	PAAB	•6	•6		•		•						•				•										
	Ultra ABS® Punch	PAYB			•				•	•1																		
	Inch Style	PAJB	•9	•9									•															
	AMX™	PMXB	•	•14	•	•		•									•		•									
	MXC™	PXCB	•13	•13	•13				•13	•										•								•
	MXC™ ABS	PLCB	•13		•13						•	•								•		•		•				•
Stripper	Ultra TEC®	S6KB	•	•					•	•	•	•																
	Original Style (Stripper Guide)	S6AB				•		•						•				•										
	Ultra ABS®	S6YB			•				•		•	•																
	AMX™ (Stripper Guide)	SMXB						•						•4	•	•4	•	•4	•									
	MXC™	SXCB	•17	•17					•16	•	•	•								•				•				•
Die	Slug Free® Die	D0AB	•	•	•	•		•	•	•	•	•	•	•	•	•	•	•	•	•								•
	NON-Slug Free® Die	D0KB	•	•	•	•		•	•	•	•	•	•	•	•	•	•	•	•	•								•
Clip	For Metric (Original) Round Punch	A0VBASAC	•5	•5	•5																							
	HP Round Punch Retaining Ring	A0VBWBAC	•10	•10	•10																							
	HP Round Punch Wire Hook	A0VBWSAC	•10	•10	•10																							
	For Wilson HP Canister	A0VBWGAC								•11	•11	•11																
	For Wilson HP2 Canister	A0VBWKAC								•12	•12	•12																
	For Wilson HP Double D Canister	A0VBWHAC								•11	•11	•11																

THICK TURRET COMPATIBILITY CHART

	Tool Style	Mate Part Number	Ultra TEC®	Ultra XT™	Ultra ABS®	Mate QS	Ultra ABS 14mm Bolt Guide-Assembly	Ultra MT, UMT and IMT 3 or 8 Station	HP™ & HP2™	HP™ WLS® & HP2™ WLS®	HP™ ABS & HP2™ ABS	Wilson Inch Style	Amada Standard	Amada ABS	Amada Z-Standard	Amada Z-ABS	Amada MEX Standard	Amada MEX ABS	Amada GT7	Amada Alpha	Wilson HP ABS 3 Station 39307*	Wilson MT8R 45292	Wilson MT9R 45233	Wilson Multi Tool MT3B	Wilson Multi Tool MT18 45276	Wilson Nissinbo MT8 39022
2" C, 3-1/2" D, and 4-1/2" E Stations																										
Punch	Original Style (M12 bolt)	PAA	•	•	•	•	•8						•		•2					•2						
	Inch Style (1/2-13 bolt)	PAJ			•							•														
	AMX™ (M14 Threads)	PMX					•									•				•7						
	AMX™ Slitting Retainer D Station	MATE001988					•							•		•				•7						
	AMX™ Slitting Retainer E Station	MATE001990					•							•		•				•7						
	MXC™	PXC	•15	•15	•15				•	•																
Stripper	Ultra TEC®	S6K	•																							
	Original Style (Stripper Guide)	S6A		•		•							•		•3					•3						
	Ultra ABS®	S6Y			•																					
	AMX™ (Stripper Guide)	SMX												•		•				•						
	MXC™	SXC		•		•			•	•	•								•	•						
Die	Slug Free® Die	DOA	•	•	•	•	•		•	•	•	•	•	•	•	•			•	•						
	Standard Die	DOK	•	•	•	•	•		•	•	•	•	•	•	•	•			•	•						
Ultra M14 Bolt Conversion Package	C Station	MATE00651	•	•	•																					
	D Station	MATE00652	•	•	•																					
	E Station	MATE00653	•	•	•																					
MTG Multi Tool																										
Punch	3 Station	PMSQ																						•		
	Long 8 Station	PNSR																							•	
Stripper	3 Station	SMSQ																			•		•	•		
	Long 8 Station	SNSR																				•			•	•
Die	3 Station Slug Free	DESQ																			•		•	•		
	3 Station Non-Slug Free	DFSQ																			•		•	•		
	Long 8 Station Slug Free	DGSR																				•			•	•
	Long 8 Station Non-Slug Free	DJSR																				•			•	•

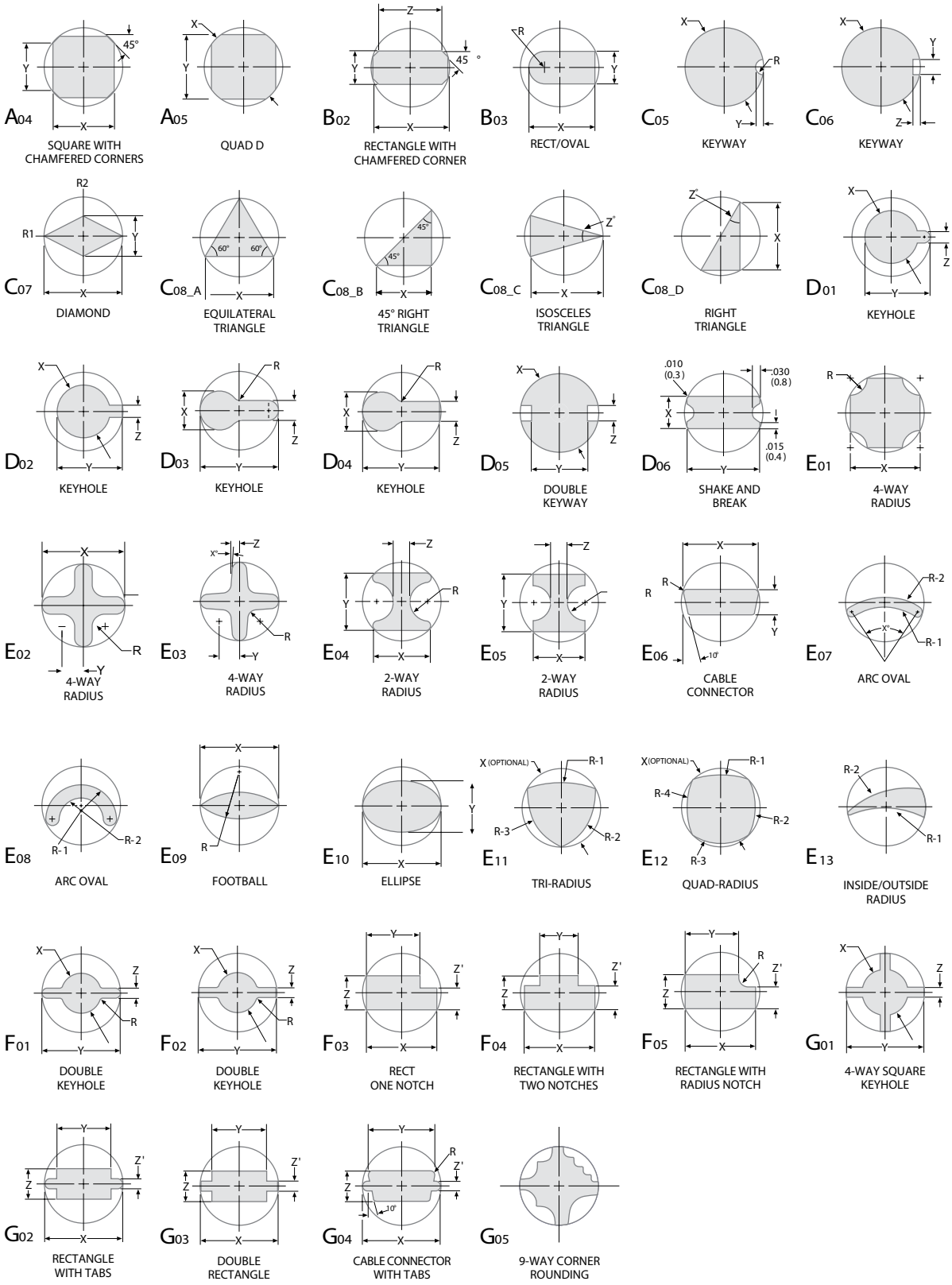
1. Ultra round or shape punches only work in shape guides using clip A0VBWHAC for HP canisters and clip A0VBWKAC for HP2 canisters.
2. Requires the optional M12 bolt to be installed into the guide assembly
3. Requires use of optional Original style strippers
4. Pin must be removed from stripper guide
5. Clip attaches to competitive round punches without pin or key
6. Requires use of Ultra Metric canister
7. Requires the M14 bolt option
8. Must switch to the M12 bolt and centering washer
9. Requires Inch Style Canister
10. Clip attaches to Wilson HP punch after removing original hardware
11. Clip attaches to Wilson HP canister
12. Clip attaches to Wilson HP2 canister
13. Shapes only: Remove retaining ring assembly. Rounds will not work (IMT manufactured after 07/2014 and UMT — Rounds & Shapes work with ring attached)
14. Rounds only
15. Requires using punch adapter A0VCWSPA (C station), A0VDWSPA (D station), A0VEWSPA (E station)
16. 3 station only
17. Compatible if guide has horizontal groove on lower lead-in diameter

* QCT™ (Quick Change Tooling) punch drivers require compatible punch inserts for operation. See mate.com for more details.

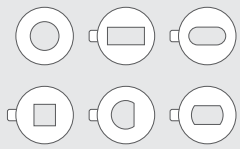
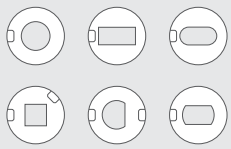
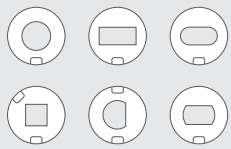
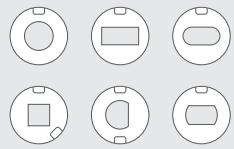
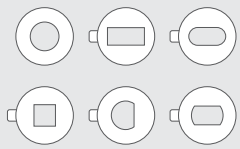
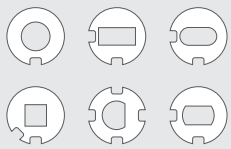
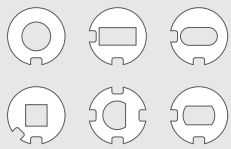
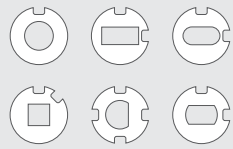
** Wilson Adjustable Length HP ABS punches 3 station 35307 for Strippit

[Dimensions in Inches (mm)]

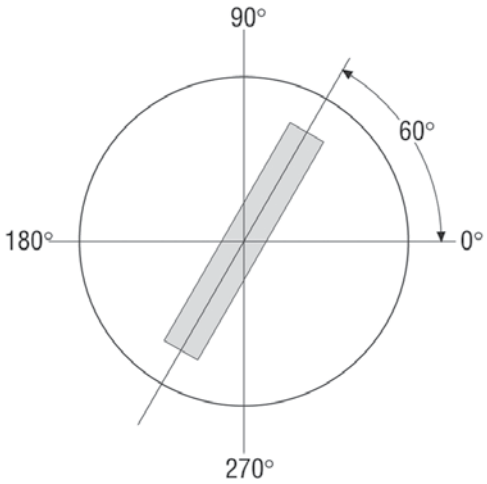
SPECIAL SHAPES FOR THICK TURRET TOOLING



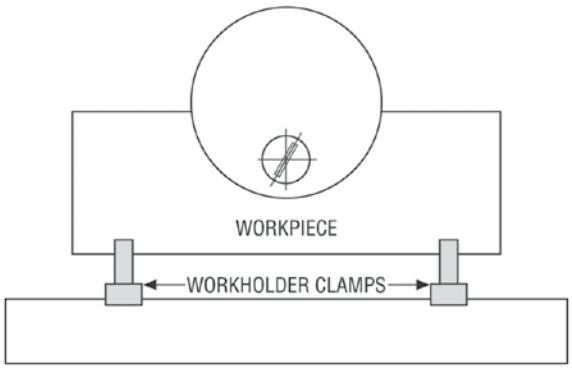
[Dimensions in Inches (mm)]

	1/2" A STATION 1 1/4" B STATION	2" C STATION	3 1/2" D STATION	4 1/2" E & F STATION
PUNCHES				
DIES				

TOP DIE VIEW
CARTESIAN COORDINATE SYSTEM



TOP DIE OF TURRET



[Dimensions in Inches (mm)]

MATE PRECISION TECHNOLOGIES GLOBAL COVERAGE

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