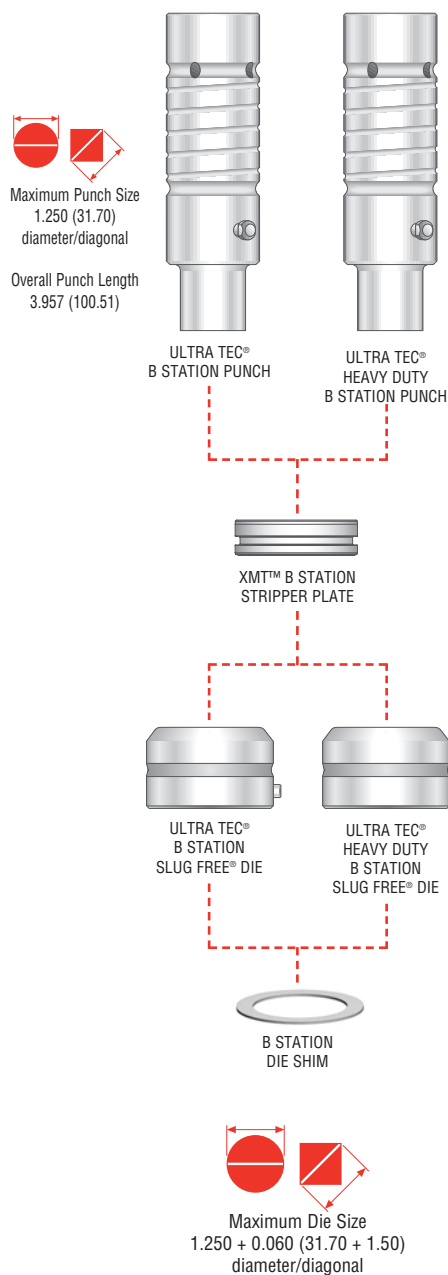


TOOLING FOR EUROMAC MULTI TOOLS XMTE4

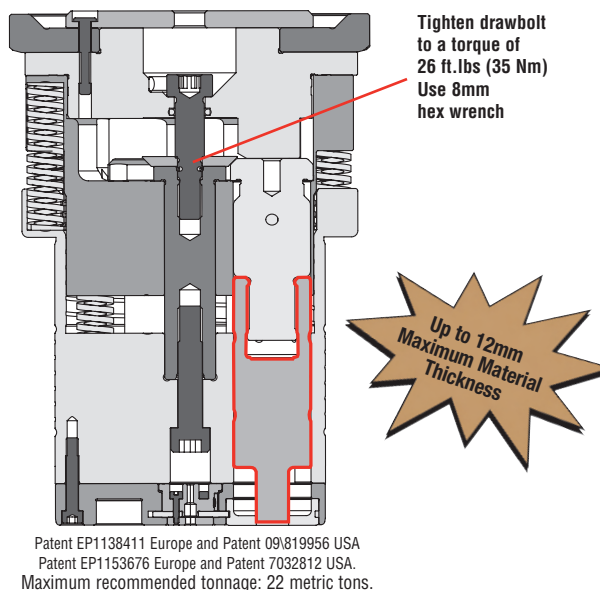
B STATION



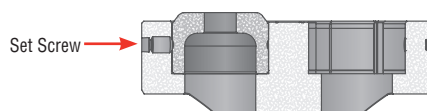
For replacement strippers on
MTE4 use standard Ultra B-Station
stripper. See Page 3.

**See machine manual
for more information**

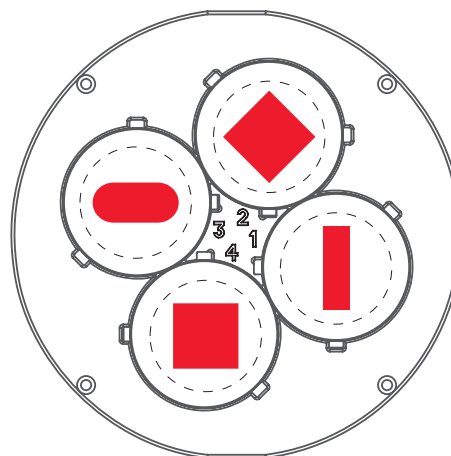
XMTE4 Upper Assembly



XMTE4 Die Holder (side view)



XMTE4 Die Holder (die view)



0° angle setting is always at 3 o'clock. By properly selecting
the station, all shaped tools can be set at 0°, 45°, 90°, 135°,
180°, 225°, 270°, or 315°.

TOOLING FOR EUROMAC 4 STATION MULTI TOOL

EUROMAC

Dimensions in inches (millimeters)



TOOLING FOR EUROMAC MULTI TOOLS XMTE6 (LONG)

XMT™ Punch

24 mm



Maximum 0.945 (24.00)
diameter/diagonal

Overall Punch Length
3.937 (100.00)

XMT™ Stripper

24 mm



XMT™ SLUG FREE® Die

24 mm

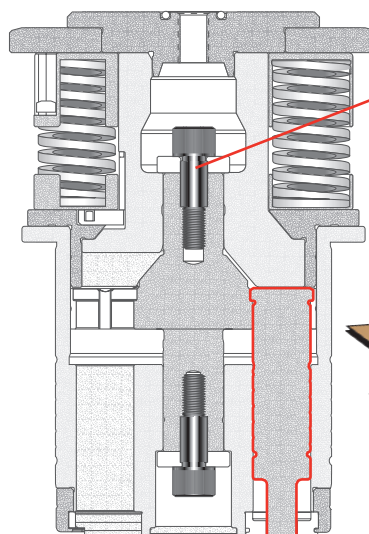


Maximum 0.945 + 0.016 (24.00 + 0.40)
diameter/diagonal

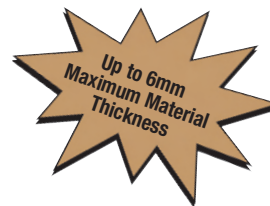
Die Shim



XMTE6 Upper Assembly

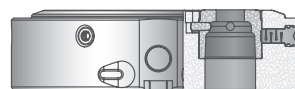


Tighten drawbolt
to a torque of
26 ft.lbs (35 Nm)
Use 8mm
hex wrench



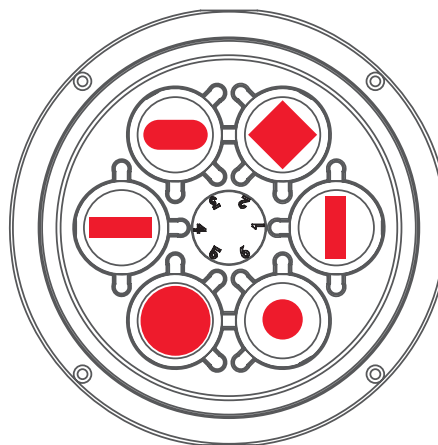
Patent EP1138411 Europe and Patent 09/819956 USA
Patent EP1153676 Europe and Patent 7032812 USA

XMTE6 Die Holder (side view)



Set Screw

XMTE6 Die Holder (die view)



0° angle setting is always at 3 o'clock. By properly selecting the station, all shaped tools can be set at 0°, 45°, 90°, 135°, 180°, 225°, 270°, or 315°.

As material thickness increases over 0.157 (4.00), then maximum punch diameter decreases.

Mild Steel Example:

Thickness	Max Diameter
0.157 (4.00)	0.898 (22.80)
0.197 (5.00)	0.878 (22.30)
0.236 (6.00)	0.862 (21.90)
0.250 (6.35)	0.858 (21.80)
0.276 (7.00)	0.846 (21.50)
0.315 (8.00)	0.827 (21.00)
0.354 (9.00)	0.807 (20.50)
0.394 (10.00)	0.783 (19.90)
0.433 (11.00)	0.701 (17.80)
0.472 (12.00)	0.677 (17.20)
0.500 (12.70)	0.638 (16.20)

XMT punch grind life is 0.106(2.69) for materials up to 0.334(8.48) thick at recommended die penetration.

Grind life is reduced at a ratio of 1:1 as material thickness increases above 0.334(8.48).

Reducing die penetration enables additional holes to be punched, but increases the possibility of slug pulling.



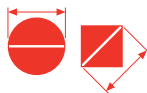
Dimensions in inches (millimeters)

TOOLING FOR EUROMAC MULTI TOOLS XMTE10

XMT™ Punch

12.7 mm

24 mm



Maximum 0.945 (24.00)
diameter/diagonal

Overall Punch Length
3.937 (100.00)

XMT™ Stripper

12.7 mm

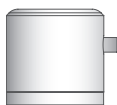
24 mm



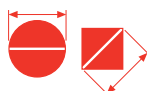
XMT™ SLUG FREE® Die

12.7 mm

24 mm



Maximum 0.500 + 0.021
(12.70 + 0.54)
diameter/diagonal

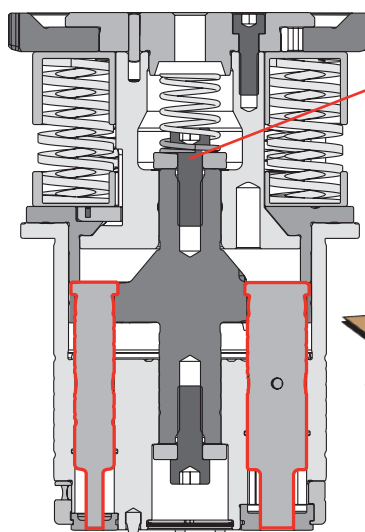


Maximum 0.945 + 0.016
(24.00 + 0.41)
diameter/diagonal

Die Shims



XMTE10 Upper Assembly



Tighten drawbolt
to a torque of
26 ft.lbs (35 Nm)
Use 8mm
hex wrench



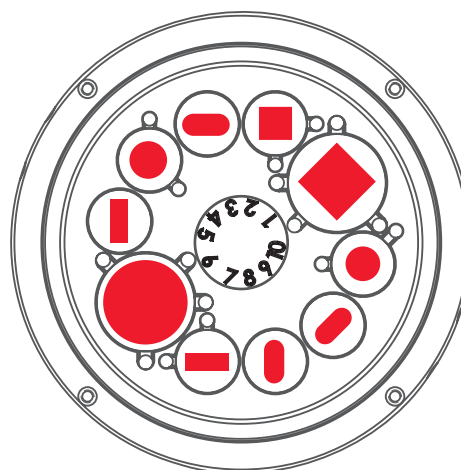
Patent EP1138411 Europe and Patent 09/819956 USA
Patent EP1153676 Europe and Patent 7032812 USA

XMTE10 Die Holder (side view)



Set Screw

XMTE10 Die Holder (die view)



0° angle setting is always at 3 o'clock. By properly selecting the station, all shaped tools can be set at 0°, 45°, 90°, 135°, 180°, 225°, 270°, or 315°.

EUROMAC

Dimensions in inches (millimeters)

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