



CATALOG 03/2023-US-A.1

SYSTEM THICK TURRET

MACHINE TYPE PRIMA POWER



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TOOLS STATION A TO E

PASS TOOLS FOR YOUR
THICK TURRET SYSTEM - MACHINE TYPE PRIMA POWER

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ps:®beta-V2® I STATION A

DIAMETER UP TO 12,7 MM



HEAD UNIT

Canister for sheet thickness up to 6 mm

Spring

10 mm length adjustment by thread

Oil channel for tool lubrication



PUNCH BODY

Oil channel for tool lubrication

Alignment pin with double D for exact adjustment

Punch body made with premium H-PM®



PUNCH GUIDE

Simple length adjustment in assembled state by pressing the locking button

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Keyway position:
All shapes: 0-90-225°

STRIPPER

Interchangeable stripper plate

ps:®beta-V2® | STATION A

DIAMETER UP TO 12,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY		
Round		4010A01
Square		4010A02
Rectangle		4010A03
Oblong		4010A04
O.D. Ground Special Shape		4010A0G
EDM Required Special Shape		4010A0E

HEAD UNIT		
For all shapes		4090A10

PUNCH BODY (H-PM®)		
Round		4020A01
Square		4020A02
Rectangle		4020A03
Oblong		4020A04
O.D. Ground Special Shape		4020A0G
EDM Required Special Shape		4020A0E

PUNCH GUIDE		
For all shapes		4030A05

STRIPPER		
Round		4040A01
Square		4040A02
Rectangle		4040A03
Oblong		4040A04
O.D. Ground Special Shape		4040A0G
EDM Required Special Shape		4040A0E

DIE (HWS)		
Round		4052A01
Square		4052A02
Rectangle		4052A03
Oblong		4052A04
O.D. Ground Special Shape		4052A0G
EDM Required Special Shape		4052A0E



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
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O-Ring (in punch guide)	4092A51	TICN coating
PU ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU ejector Ø 6x10 (in punch)	4092P06	A-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Cutting part under 1,00 mm

COMPENSATING SHIM FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE
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Not necessary		Additional keyway
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SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIES
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1x0,4 mm/1x0,8 mm/1x1,2 mm	499A1M1	Reinforced die
Shimkeeper (0,5 mm)	499A1M95	H-PM® Quality
		Additional pin hole

ps:® beta-compact I STATION A

DIAMETER UP TO 12,7 MM



HEAD UNIT

Canister for sheet thickness up to 6 mm

Spring

10 mm length adjustment by thread

Oil channel for tool lubrication



PUNCH BODY

Oil channel for tool lubrication

Alignment pin with double D for exact adjustment

Punch body made with premium H-PM®



PUNCH GUIDE

Simple length adjustment in assembled state by pressing the locking button

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Keyway position:

Round: 0°

Square: 0-45°

Rect./Oblong: 0-90-225°

Asym. shapes: 0-90-180-270°

Tool shapes integrated in guide

ps:® beta-compact I STATION A

DIAMETER UP TO 12,7 MM



PART NO.

COMPLETE PUNCH ASSEMBLY		
	Round	4016A01
	Square	4016A02
	Rectangle	4016A03
	Oblong	4016A04
	O.D. Ground Special Shape	4016A0G
	EDM Required Special Shape	4016A0E

HEAD UNIT		
	For all shapes	4094A10

PUNCH BODY (H-PM®)		
	Round	4024A01
	Square	4024A02
	Rectangle	4024A03
	Oblong	4024A04
	O.D. Ground Special Shape	4024A0G
	EDM Required Special Shape	4024A0E

PUNCH GUIDE		
	Round	4036A01
	Square	4036A02
	Rectangle	4036A03
	Oblong	4036A04
	O.D. Ground Special Shape	4036A0G
	EDM Required Special Shape	4036A0E

DIE (HWS)		
	Round	4052A01
	Square	4052A02
	Rectangle	4052A03
	Oblong	4052A04
	O.D. Ground Special Shape	4052A0G
	EDM Required Special Shape	4052A0E

SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
O-Ring (in punch guide)	4092A51	TICN coating
PU ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU ejector Ø 6x10 (in punch)	4092P06	A-MAX coating

- WT-shear
- DOWT-shear
- 2 PT-shear
- 4 PT-shear
- Cutting part under 1,00 mm

COMPENSATING SHIM FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE
Not necessary		Additional keyway

SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIES
1x0,4 mm/1x0,8 mm/1x1,2 mm	499A1M1	Reinforced die
Shimkeeper (0,5 mm)	499A1M95	H-PM® Quality
		Additional pin hole

ps:®beta-V2® | STATION B

DIAMETER UP TO 31,75 MM



HEAD UNIT

Canister for sheet thickness up to 6 mm

Spring

10 mm length adjustment by thread

Oil channel for tool lubrication



PUNCH BODY

Oil channel for tool lubrication

Alignment pin with double D for exact adjustment

Punch body made with premium H-PM®



PUNCH GUIDE

Simple length adjustment in assembled state by pressing the locking button

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Keyway position:
All shapes: 0-90-225°

STRIPPER

Interchangeable stripper plate

ps:® beta-V2® | STATION B

DIAMETER UP TO 31,75 MM

PART NO.



COMPLETE PUNCH ASSEMBLY		
	Round	4010B01
	Square	4010B02
	Rectangle	4010B03
	Oblong	4010B04
	O.D. Ground Special Shape	4010B0G
	EDM Required Special Shape	4010B0E

HEAD UNIT		
	For all shapes	4090B10

PUNCH BODY (H-PM®)		
	Round	4020B01
	Square	4020B02
	Rectangle	4020B03
	Oblong	4020B04
	O.D. Ground Special Shape	4020B0G
	EDM Required Special Shape	4020B0E

PUNCH GUIDE		
	For all shapes	4030B05

STRIPPER		
	Round	4040B01
	Square	4040B02
	Rectangle	4040B03
	Oblong	4040B04
	O.D. Ground Special Shape	4040B0G
	EDM Required Special Shape	4040B0E

DIE (HWS)		
	Round	4052B01
	Square	4052B02
	Rectangle	4052B03
	Oblong	4052B04
	O.D. Ground Special Shape	4052B0G
	EDM Required Special Shape	4052B0E

SPARE PARTS		ADDITIONAL COSTS FOR PUNCH	
O-Ring (in punch guide)	4092B51	TICN coating	
PU ejector Ø 3x6 (in punch)	4092P03	T-MAX coating	
PU ejector Ø 6x10 (in punch)	4092P06	A-MAX coating	

- WT-shear
- DOWT-shear
- 2 PT-shear
- 4 PT-shear
- Cutting part under 1,00 mm

COMPENSATING SHIM FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE	
Not necessary		Additional keyway	

SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIES	
1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1	Reinforced die	
Shimkeeper (0,5 mm)	499B1M95	H-PM® Quality	
		Additional pin hole	

ps:®beta-compact I STATION B

DIAMETER UP TO 31,75 MM



HEAD UNIT

Canister for sheet thickness up to 6 mm

Spring

10 mm length adjustment by thread

Oil channel for tool lubrication



PUNCH BODY

Oil channel for tool lubrication

Alignment pin with double D for exact adjustment

Punch body made with premium H-PM®



PUNCH GUIDE

Simple length adjustment in assembled state by pressing the locking button

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Keyway position:

Round: 0°

Square: 0-45°

Rect./Oblong: 0-45-90-135°

Asym. shapes: 0-90-180-270°

Tool shapes integrated in guide

ps:® beta-compact I STATION B

DIAMETER UP TO 31,75 MM

		PART NO.
COMPLETE PUNCH ASSEMBLY		
	Round	4016B01
	Square	4016B02
	Rectangle	4016B03
	Oblong	4016B04
	O.D. Ground Special Shape	4016B0G
	EDM Required Special Shape	4016B0E

HEAD UNIT		
	For all shapes	4094B10

PUNCH BODY (H-PM®)		
	Round	4024B01
	Square	4024B02
	Rectangle	4024B03
	Oblong	4024B04
	O.D. Ground Special Shape	4024B0G
	EDM Required Special Shape	4024B0E

PUNCH GUIDE		
	Round	4036B01
	Square	4036B02
	Rectangle	4036B03
	Oblong	4036B04
	O.D. Ground Special Shape	4036B0G
	EDM Required Special Shape	4036B0E

DIE (HWS)		
	Round	4052B01
	Square	4052B02
	Rectangle	4052B03
	Oblong	4052B04
	O.D. Ground Special Shape	4052B0G
	EDM Required Special Shape	4052B0E

SPARE PARTS		
	O-Ring (in punch guide)	4092B51
	PU ejector Ø 3x6 (in punch)	4092P03
	PU ejector Ø 6x10 (in punch)	4092P06

COMPENSATING SHIM FOR PUNCH		
	Not necessary	

SET OF COMPENSATING SHIMS FOR DIE		
	1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1
	Shimkeeper (0,5 mm)	499B1M95

ADDITIONAL COSTS FOR PUNCH	
	TICN coating
	T-MAX coating
	A-MAX coating
	WT-shear
	DOWT-shear
	2 PT-shear
	4 PT-shear
	Cutting part under 1,00 mm

ADDITIONAL COSTS FOR PUNCH GUIDE	
	Additional keyway

ADDITIONAL COSTS FOR DIES	
	Reinforced die
	H-PM® Quality
	Additional pin hole



ps:®beta-V2® | STATION C

DIAMETER UP TO 50,8 MM



GUIDE ASSEMBLY

Screw M12

Disc springs for sheet thickness up to 6 mm

Oil channel for tool lubrication

10 mm length adjustment in assembled state by pressing the locking button

Keyway position: 0-90°

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Fast and easy clamping system for stripper

PUNCH BODY

Oil channel for tool lubrication

Punch body made with premium H-PM®

STRIPPER

Interchangeable stripper plate

ps:®beta-V2® | STATION C

DIAMETER UP TO 50,8 MM

	PART-NO.
GUIDE ASSEMBLY	
For all shapes	4030C01
PUNCH BODY (H-PM®)	
Round	4020C01
Square	4020C02
Rectangle	4020C03
Oblong	4020C04
O.D. Ground Special Shape	4020C0G
EDM Required Special Shape	4020C0E
STRIPPER	
Round	4040C01
Square	4040C02
Rectangle	4040C03
Oblong	4040C04
O.D. Ground Special Shape	4040C0G
EDM Required Special Shape	4040C0E
DIE (HWS)	
Round	4052C01
Square	4052C02
Rectangle	4052C03
Oblong	4052C04
O.D. Ground Special Shape	4052C0G
EDM Required Special Shape	4052C0E



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
PU ejector Ø 3x6 (in punch)	4092P03	TICN coating
PU ejector Ø 6x10 (in punch)	4092P06	T-MAX coating
		A-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Additional keyway
		Cutting part under 1,00 mm
COMPENSATING SHIM FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE
Not necessary		Additional keyway
SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIES
1x0,4 mm/1x0,8 mm/1x1,2 mm	499C2M1	H-PM® Quality
		Additional keyway

ps:®beta-V2® SLITTING TOOL | STATION C



GUIDE ASSEMBLY

Screw M12

Disc springs for sheet thickness up to 6 mm

Oil channel for tool lubrication

10 mm length adjustment in assembled state by pressing the locking button

Keyway position: 0-90°

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Fast and easy clamping system for stripper

SLITTING PUNCH HOLDER

2 fixing threads M6

Oil channel for tool lubrication

SLITTING PUNCH

Punch body made with premium H-PM®

STRIPPER

Interchangeable stripper plate

ps:®beta-V2® SLITTING TOOL | STATION C

	PART NO.
GUIDE ASSEMBLY	
For all shapes	4030C01
SLITTING PUNCH HOLDER	
For all shapes	4220CT00
SLITTING PUNCH (MAX. 6,35X50) / (H-PM®)	
Rectangle	4020CT03
Oblong	4020CT04
Trapezoid G09	4020CT0G
Double Trapezoid E03	4020CT0E
STRIPPER	
Rectangle	4040CT03
Oblong	4040CT04
Trapezoid G09	4040CT0G
Double Trapezoid E03	4040CT0E
REVERSIBLE PLATE HOLDER	
	4390CT00
REVERSIBLE PLATE (H-PM®)	
Rectangle	4052CT03
Oblong	4052CT04
Trapezoid G09	4052CT0G
Double Trapezoid E03	4052CT0E



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
PU ejector Ø 3x6 (in punch)	4092P03	TICN coating
PU ejector Ø 6x10 (in punch)	4092P06	T-MAX coating
		A-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Additional keyway
		Cutting part under 1,00 mm
COMPENSATING SHIM FOR SLITTING PUNCH HOLDER		ADDITIONAL COSTS FOR PUNCH GUIDE
Not necessary		Additional keyway
SET OF COMPENSATING SHIMS FOR REVERSIBLE PLATE		ADDITIONAL COSTS FOR DIES
1x0,4 mm/1x0,8 mm/1x1,2 mm	499CT60	Additional keyway

ps:®beta-V2® I STATION D

DIAMETER UP TO 88,9 MM



GUIDE ASSEMBLY

Screw M12

Disc springs for sheet thickness up to 6 mm

Oil channel for tool lubrication

10 mm length adjustment in assembled state by pressing the locking button

Keyway position: 0-90°

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Fast and easy clamping system for stripper



PUNCH BODY

Oil channel for tool lubrication

Punch body made with premium H-PM®

STRIPPER

Interchangeable stripper plate

ps:®beta-V2® I STATION D

DIAMETER UP TO 88,9 MM

	PART-NO.
GUIDE ASSEMBLY	
For all shapes	4030D01
PUNCH BODY (H-PM®)	
Round	4020D01
Square	4020D02
Rectangle	4020D03
Oblong	4020D04
O.D. Ground Special Shape	4020D0G
EDM Required Special Shape	4020D0E
STRIPPER	
Round	4040D01
Square	4040D02
Rectangle	4040D03
Oblong	4040D04
O.D. Ground Special Shape	4040D0G
EDM Required Special Shape	4040D0E
DIE (HWS)	
Round	4052D01
Square	4052D02
Rectangle	4052D03
Oblong	4052D04
O.D. Ground Special Shape	4052D0G
EDM Required Special Shape	4052D0E



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
PU ejector Ø 3x6 (in punch)	4092P03	TICN coating
PU ejector Ø 6x10 (in punch)	4092P06	T-MAX coating
		A-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Additional keyway
		Cutting part under 1,00 mm
COMPENSATING SHIM FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE
Not necessary		Additional keyway
SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIES
1x0,4 mm/1x0,8 mm/1x1,2 mm	499D2M1	H-PM® Quality
		Additional keyway

ps:®beta-V2® SLITTING TOOL | STATION D



GUIDE ASSEMBLY

Screw M12

Disc springs for sheet thickness up to 6 mm

Oil channel for tool lubrication

10 mm length adjustment in assembled state by pressing the locking button

Keyway position: 0-90°

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Fast and easy clamping system for stripper



SLITTING PUNCH HOLDER

4 fixing threads M6

Oil channel for tool lubrication

SLITTING PUNCH

Punch body made with premium H-PM®

STRIPPER

Interchangeable stripper plate

ps:®beta-V2® SLITTING TOOL I STATION D

	PART NO.
GUIDE ASSEMBLY	
For all shapes	4030D01
SLITTING PUNCH HOLDER	
For all shapes	4220DT00
SLITTING PUNCH (MAX. 6,35X85) / (H-PM®)	
Rectangle	4020DT03
Oblong	4020DT04
Trapezoid G09	4020DT0G
Double Trapezoid E03	4020DT0E
STRIPPER	
Rectangle	4040DT03
Oblong	4040DT04
Trapezoid G09	4040DT0G
Double Trapezoid E03	4040DT0E
REVERSIBLE PLATE HOLDER	
	4390DT00
REVERSIBLE PLATE (H-PM®)	
Rectangle	4052DT03
Oblong	4052DT04
Trapezoid G09	4052DT0G
Double Trapezoid E03	4052DT0E



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
PU ejector Ø 3x6 (in punch)	4092P03	TICN coating
PU ejector Ø 6x10 (in punch)	4092P06	T-MAX coating
		A-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Additional keyway
		Cutting part under 1,00 mm
COMPENSATING SHIM FOR SLITTING PUNCH HOLDER		ADDITIONAL COSTS FOR PUNCH GUIDE
Not necessary		Additional keyway
SET OF COMPENSATING SHIMS FOR REVERSIBLE PLATE		ADDITIONAL COSTS FOR DIES
1x0,4 mm/1x0,8 mm/1x1,2 mm	499DT60	Additional keyway

ps:®beta-V2® SLITTING TOOL | STATION D CLOSE TO CLAMP



GUIDE ASSEMBLY

Screw M12

Disc springs for sheet thickness up to 6 mm

Oil channel for tool lubrication

10 mm length adjustment in assembled state by pressing the locking button

Keyway position: 0-90°

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Fast and easy clamping system for stripper



SLITTING PUNCH HOLDER

4 fixing threads M6

Oil channel for tool lubrication

SLITTING PUNCH

Punch body made with premium H-PM®

STRIPPER

Interchangeable stripper plate

One or two-sided relief for punching close to clamp

ps:®beta-V2® SLITTING TOOL I STATION D

CLOSE TO CLAMP

PART NO.

GUIDE ASSEMBLY		
	For all shapes	4030DTP01

SLITTING PUNCH HOLDER		
	For all shapes	4220DT00

SLITTING PUNCH (MAX. 6,35X85) / (H-PM®)		
	Rectangle	4020DT03
	Oblong	4020DT04
	Trapezoid G09	4020DT0G
	Double Trapezoid E03	4020DT0E

STRIPPER ONE-SIDED FREE		
	Rectangle	4040DTP03-1
	Oblong	4040DTP04-1
	Trapezoid G09	4040DTP0G-1
	Double Trapezoid E03	4040DTP0E-1

STRIPPER TWO-SIDED FREE		
	Rectangle	4040DTP03-2
	Oblong	4040DTP04-2
	Trapezoid G09	4040DTP0G-2
	Double Trapezoid E03	4040DTP0E-2

DIE ONE-SIDED FREE (HWS)		
	Rectangle	4052DTP03-1
	Oblong	4052DTP04-1
	Trapezoid G09	4052DTP0G-1
	Double Trapezoid E03	4052DTP0E-1

DIE TWO-SIDED FREE (HWS)		
	Rectangle	4052DTP03-2
	Oblong	4052DTP04-2
	Trapezoid G09	4052DTP0G-2
	Double Trapezoid E03	4052DTP0E-2

SPARE PARTS		
PU ejector Ø 3x6 (in punch)		4092P03
PU ejector Ø 6x10 (in punch)		4092P06

ADDITIONAL COSTS FOR PUNCH

- TICN coating
- T-MAX coating
- A-MAX coating
- WT-shear
- DOWT-shear
- 2 PT-shear
- 4 PT-shear
- Additional keyway
- Cutting part under 1,00 mm

COMPENSATING SHIM FOR SLITTING PUNCH HOLDER		
Not necessary		

ADDITIONAL COSTS FOR PUNCH GUIDE

- Additional keyway

SET OF COMPENSATING SHIMS FOR DIE		
1x0,4 mm/1x0,8 mm/1x1,2 mm		499D2M1

ADDITIONAL COSTS FOR DIES

- H-PM® Quality
- Additional keyway



ps:®beta-V2® I STATION E

DIAMETER UP TO 114,3 MM



GUIDE ASSEMBLY

Screw M12

Disc springs for sheet thickness up to 6 mm

Oil channel for tool lubrication

10 mm length adjustment in assembled state by pressing the locking button

Keyway position: 0-90°

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Fast and easy clamping system for stripper



PUNCH BODY

Oil channel for tool lubrication

Punch body made with premium H-PM®

STRIPPER

Interchangeable stripper plate

ps:® beta-V2® | STATION E

DIAMETER UP TO 114,3 MM

	PART NO.
GUIDE ASSEMBLY	
For all shapes	4030E01
PUNCH BODY (H-PM®)	
Round	4020E01
Square	4020E02
Rectangle	4020E03
Oblong	4020E04
O.D. Ground Special Shape	4020E0G
EDM Required Special Shape	4020E0E
STRIPPER	
Round	4040E01
Square	4040E02
Rectangle	4040E03
Oblong	4040E04
O.D. Ground Special Shape	4040E0G
EDM Required Special Shape	4040E0E
DIE (HWS)	
Round	4052E01
Square	4052E02
Rectangle	4052E03
Oblong	4052E04
O.D. Ground Special Shape	4052E0G
EDM Required Special Shape	4052E0E



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
PU ejector Ø 3x6 (in punch)	4092P03	TICN coating
PU ejector Ø 6x10 (in punch)	4092P06	T-MAX coating
		A-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Additional keyway
		Cutting part under 1,00 mm
COMPENSATING SHIM FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE
Not necessary		Additional keyway
SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIES
1x0,4 mm/1x0,8 mm/1x1,2 mm	499E2M1	H-PM® Quality
		Additional keyway

ps:®beta-V2® SLITTING TOOL | STATION E



GUIDE ASSEMBLY

Screw M12

Disc springs for sheet thickness up to 6 mm

Oil channel for tool lubrication

10 mm length adjustment in assembled state by pressing the locking button

Keyway position: 0-90°

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Fast and easy clamping system for stripper



SLITTING PUNCH HOLDER

4 fixing threads M6

Oil channel for tool lubrication

SLITTING PUNCH

Punch body made with premium H-PM®

STRIPPER

Interchangeable stripper plate

ps:®beta-V2® SLITTING TOOL | STATION E

	PART NO.
GUIDE ASSEMBLY	
For all shapes	4030E01
SLITTING PUNCH HOLDER	
For all shapes	4220ET00
SLITTING PUNCH (MAX. 6,35X111) / (H-PM®)	
Rectangle	4020ET03
Oblong	4020ET04
Trapezoid G09	4020ET0G
Double Trapezoid E03	4020ET0E
STRIPPER	
Rectangle	4040ET03
Oblong	4040ET04
Trapezoid G09	4040ET0G
Double Trapezoid E03	4040ET0E
REVERSIBLE PLATE HOLDER	
	4390ET00
REVERSIBLE PLATE (H-PM®)	
Rectangle	4052ET03
Oblong	4052ET04
Trapezoid G09	4052ET0G
Double Trapezoid E03	4052ET0E



SPARE PARTS	ADDITIONAL COSTS FOR PUNCH
PU ejector Ø 3x6 (in punch)	4092P03
PU ejector Ø 6x10 (in punch)	4092P06
	TICN coating
	T-MAX coating
	A-MAX coating
	WT-shear
	DOWT-shear
	2 PT-shear
	4 PT-shear
	Additional keyway
	Cutting part under 1,00 mm
COMPENSATING SHIM FOR SLITTING PUNCH HOLDER	ADDITIONAL COSTS FOR PUNCH GUIDE
Not necessary	Additional keyway
SET OF COMPENSATING SHIMS FOR REVERSIBLE PLATE	ADDITIONAL COSTS FOR DIES
1x0,4 mm/1x0,8 mm/1x1,2 mm	499ET60
	Additional keyway

ps:®beta-V2® SLITTING TOOL | STATION E CLOSE TO CLAMP



GUIDE ASSEMBLY

Screw M12

Disc springs for sheet thickness up to 6 mm

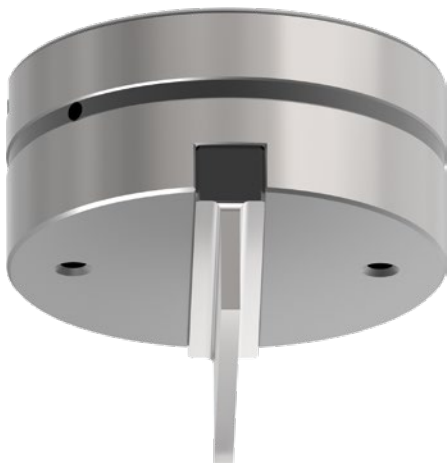
Oil channel for tool lubrication

10 mm length adjustment in assembled state by pressing the locking button

Keyway position: 0-90°

Surface-hardened and polished punch guide for sheet thickness up to 6 mm

Fast and easy clamping system for stripper



SLITTING PUNCH HOLDER

4 fixing threads M6

Oil channel for tool lubrication

SLITTING PUNCH

Punch body made with premium H-PM®



STRIPPER

Interchangeable stripper plate

One or two-sided relief for punching close to clamp

ps:®beta-V2® SLITTING TOOL | STATION E CLOSE TO CLAMP

PART NO.

GUIDE ASSEMBLY		
	For all shapes	4030ETP01

SLITTING PUNCH HOLDER		
	For all shapes	4220ET00

SLITTING PUNCH (MAX. 6,35X111) / (H-PM®)		
	Rectangle	4020ET03
	Oblong	4020ET04
	Trapezoid G09	4020ET0G
	Double Trapezoid E03	4020ET0E

STRIPPER ONE-SIDED FREE		
	Rectangle	4040ETP03-1
	Oblong	4040ETP04-1
	Trapezoid G09	4040ETP0G-1
	Double Trapezoid E03	4040ETP0E-1

STRIPPER TWO-SIDED FREE		
	Rectangle	4040ETP03-2
	Oblong	4040ETP04-2
	Trapezoid G09	4040ETP0G-2
	Double Trapezoid E03	4040ETP0E-2

DIE ONE-SIDED FREE (HWS)		
	Rectangle	4052ETP03-1
	Oblong	4052ETP04-1
	Trapezoid G09	4052ETP0G-1
	Double Trapezoid E03	4052ETP0E-1

DIE TWO-SIDED FREE (HWS)		
	Rectangle	4052ETP03-2
	Oblong	4052ETP04-2
	Trapezoid G09	4052ETP0G-2
	Double Trapezoid E03	4052ETP0E-2

SPARE PARTS		
PU ejector Ø 3x6 (in punch)		4092P03
PU ejector Ø 6x10 (in punch)		4092P06

COMPENSATING SHIM FOR SLITTING PUNCH HOLDER		
Not necessary		

SET OF COMPENSATING SHIMS FOR DIE		
1x0,4 mm/1x0,8 mm/1x1,2 mm		499E2M1



ADDITIONAL COSTS FOR PUNCH

- TICN coating
- T-MAX coating
- A-MAX coating
- WT-shear
- DOWT-shear
- 2 PT-shear
- 4 PT-shear
- Additional keyway
- Cutting part under 1,00 mm

ADDITIONAL COSTS FOR PUNCH GUIDE

- Additional keyway

ADDITIONAL COSTS FOR DIES

- H-PM® Quality
- Additional keyway



MULTITOOL

ps:®multitool

FOR YOUR PRIMA POWER MACHINES

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ps:® MTP8Ri3-16 | INSERTS

FOR MACHINE TYPE PRIMA POWER

SUITABLE FOR SHEET THICKNESS UP TO 6 MM



PART-NO.

PUNCH		
	Round	413161-1
	Square	413162-1
	Rectangle	413163-1
	Oblong	413164-1
	O.D. Ground Special Shape	41316G-1
	EDM Required Special Shape	41316E-1

STRIPPER		
	Round	415161
	Square	415162
	Rectangle	415163
	Oblong	415164
	O.D. Ground Special Shape	41516G
	EDM Required Special Shape	41516E

8-STATION STRIPPER *		
	Optional - shape adaptable stripper	450802000

DIE (HWS)		
	Round	414161
	Square	414162
	Rectangle	414163
	Oblong	414164
	O.D. Ground Special Shape	41416G
	EDM Required Special Shape	41416E

SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
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PU ejector Ø 3x6 (in punch)	4092P03	
PU ejector Ø 6x10 (in punch)	4092P06	

- TICN coating
- T-MAX coating
- A-MAX coating
- WT-shear
- DOWT-shear
- 2 PT-shear
- 4 PT-shear
- Cutting part under 1,00 mm

INDEX	ADDITIONAL COSTS FOR DIES
-------	---------------------------

*** Stripper - adaptable to shape (form)**
 To avoid marks on the sheet surface (e.g. when using polished aluminium), optionally a one 8-station stripper, adaptable to shape, can be used.

- Reinforced die
- H-PM® Quality
- Additional pin hole

SET OF COMPENSATING SHIMS FOR DIE	
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2x0,1 mm/2x0,3 mm/2x0,5 mm	41416US
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ps:®MTP8Ri3-16 | ADAPTER

FOR MACHINE TYPE PRIMA POWER

SUITABLE FOR SHEET THICKNESS UP TO 6 MM

PART-NO.

8-STATION PUNCH HOLDER	
(without punch or stripper inserts)	45080000

8-STATION DIE HOLDER	
(without die inserts)	450802100



ps:® MTP3Ri3-31,75 I INSERTS

FOR MACHINE TYPE PRIMA POWER

SUITABLE FOR SHEET THICKNESS UP TO 6 MM



PART-NO.

PUNCH		
Punch head		450301700
Round		413191
Square		413192
Rectangle		413193
Oblong		413194
O.D. Ground Special Shape		41319G
EDM Required Special Shape		41319E
STRIPPER		
Round		415191
Square		415192
Rectangle		415193
Oblong		415194
O.D. Ground Special Shape		41519G
EDM Required Special Shape		41519E
3-STATION STRIPPER *		
Optional - shape adaptable stripper		450302000
DIE (HWS)		
Round		414191
Square		414192
Rectangle		414193
Oblong		414194
O.D. Ground Special Shape		41419G
EDM Required Special Shape		41419E

SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
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PU ejector Ø 3x6 (in punch)	4092P03	
PU ejector Ø 6x10 (in punch)	4092P06	

- TiCN coating
- T-MAX coating
- A-MAX coating
- WT-shear
- DOWT-shear
- 2 PT-shear
- 4 PT-shear
- Cutting part under 1,00 mm

INDEX	ADDITIONAL COSTS FOR DIES
-------	---------------------------

*** Stripper - adaptable to shape (form)**
 To avoid marks on the sheet surface (e.g. when using polished aluminium), optionally a one 3-station stripper, adaptable to shape, can be used.

- Reinforced die
- H-PM® Quality
- Additional pin hole

SET OF COMPENSATING SHIMS FOR DIE	
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2x0,1 mm/2x0,3 mm/2x0,5 mm	41419US
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ps:®MTP3Ri3-31,75 | ADAPTER

FOR MACHINE TYPE PRIMA POWER

SUITABLE FOR SHEET THICKNESS UP TO 6 MM

PART-NO.

3-STATION PUNCH HOLDER

(without punch or stripper inserts) 450300000

3-STATION DIE HOLDER

(without die inserts) 450301900



ps:® MTP8RiA-12,7 I INSERTS

FOR MACHINE TYPE PRIMA POWER

SUITABLE FOR SHEET THICKNESS UP TO 6 MM



PART-NO.

PUNCH BODY (H-PM®)		
Punch head		453801800
Round		4020A01
Square		4020A02
Rectangle		4020A03
Oblong		4020A04
O.D. Ground Special Shape		4020A0G
EDM Required Special Shape		4020A0E

STRIPPER		
Round		4040A01
Square		4040A02
Rectangle		4040A03
Oblong		4040A04
O.D. Ground Special Shape		4040A0G
EDM Required Special Shape		4040A0E

DIE (HWS)		
Round		4052A01
Square		4052A02
Rectangle		4052A03
Oblong		4052A04
O.D. Ground Special Shape		4052A0G
EDM Required Special Shape		4052A0E

SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
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PU ejector Ø 3x6 (in punch)	4092P03	TICN coating
PU ejector Ø 6x10 (in punch)	4092P06	T-MAX coating
		A-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Cutting part under 1,00 mm

COMPENSATING SHIM FOR PUNCH		ADDITIONAL COSTS FOR DIES
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Not necessary		Reinforced die
		H-PM® Quality
		Additional pin hole

COMPENSATING SHIM FOR DIE		
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2x0,1 mm/2x0,3 mm/2x0,5 mm	41416US	
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ps:®MTP8RiA-12,7 | ADAPTER

FOR MACHINE TYPE PRIMA POWER

SUITABLE FOR SHEET THICKNESS UP TO 6 MM

	PART-NO.
8-STATION HOLDER PIN	
(without punch or stripper inserts)	45380000
8-STATION DIE HOLDER	
(without die inserts)	453802100

	PART-NO.
8-STATION HOLDER I-RAM	
(without punch or stripper inserts)	453800010
8-STATION DIE HOLDER	
(without die inserts)	453802100



ps:® MTP3RiB-31,75 | INSERTS

FOR MACHINE TYPE PRIMA POWER

SUITABLE FOR SHEET THICKNESS UP TO 6 MM



PART-NO.

PUNCH BODY (H-PM®)		
Punch head		450301700
Round		4020B01
Square		4020B02
Rectangle		4020B03
Oblong		4020B04
O.D. Ground Special Shape		4020B0G
EDM Required Special Shape		4020B0E

STRIPPER		
Round		4040B01
Square		4040B02
Rectangle		4040B03
Oblong		4040B04
O.D. Ground Special Shape		4040B0G
EDM Required Special Shape		4040B0E

DIE (HWS)		
Round		4052B01
Square		4052B02
Rectangle		4052B03
Oblong		4052B04
O.D. Ground Special Shape		4052B0G
EDM Required Special Shape		4052B0E

SPARE PARTS		ADDITIONAL COSTS FOR PUNCH
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PU ejector Ø 3x6 (in punch)	4092P03	TiCN coating
PU ejector Ø 6x10 (in punch)	4092P06	T-MAX coating
		A-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Cutting part under 1,00 mm

COMPENSATING SHIM FOR PUNCH		ADDITIONAL COSTS FOR DIES
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Not necessary		Reinforced die
		H-PM® Quality
		Additional pin hole

COMPENSATING SHIM FOR DIE		
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2x0,1 mm/2x0,3 mm/2x0,5 mm	41419US	
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ps:®MTP3RiB-31,75 | ADAPTER

FOR MACHINE TYPE PRIMA POWER

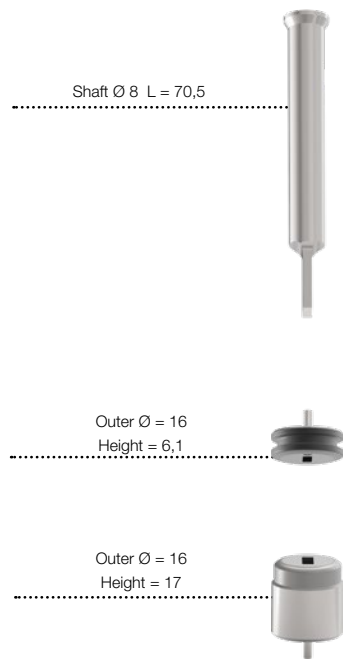
SUITABLE FOR SHEET THICKNESS UP TO 6 MM

		PART-NO.			PART-NO.
3-STATION HOLDER PIN			3-STATION HOLDER I-RAM		
(without punch or stripper inserts)		453300000	(without punch or stripper inserts)		453300010
3-STATION DIE HOLDER			3-STATION DIE HOLDER		
(without die inserts)		450301910	(without die inserts)		450301910



ps:®MTPi24-8 and ps:®MTP16-8 | INSERTS

FOR MACHINE TYPE PRIMA POWER



PART-NO.

PUNCH (H-PM®)		
Round		413121
Square		413122
Rectangle		413123
Oblong		413124
O.D. Ground Special Shape		41312G
EDM Required Special Shape		41312E

STRIPPER		
Round		415121
Square		415122
Rectangle		415123
Oblong		415124
O.D. Ground Special Shape		41512G
EDM Required Special Shape		41512E

DIE (HWS)		
Round		414121
Square		414122
Rectangle		414123
Oblong		414124
O.D. Ground Special Shape		41412G
EDM Required Special Shape		41412E

ADDITIONAL COSTS FOR PUNCHES

- TICN coating
- T-MAX coating
- A-MAX coating
- WT-shear
- DOWT-shear
- 2 PT-shear
- 4 PT-shear
- Cutting part under 1,00 mm

ADDITIONAL COSTS FOR DIES

- Reinforced die
- H-PM® Quality
- Additional pin hole

ps:®MTPi24-8 and ps:®MTP16-8 | ADAPTER

FOR MACHINE TYPE PRIMA POWER

PART-NO.

PART-NO.

PUNCH HOLDER ps:®MTPi24-8	
(without punch or stripper inserts)	454224000-PPX

PUNCH HOLDER ps:®MTP16-8	
(without punch or stripper inserts)	454116000-PPX

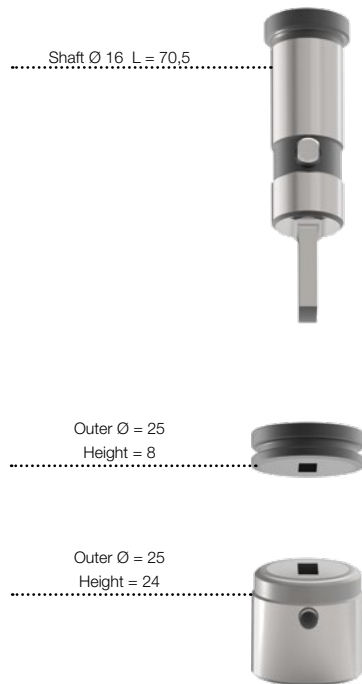
DIE HOLDER ps:®MTPi24-8	
(without die inserts)	454224060X

DIE HOLDER ps:®MTP16-8	
(without die inserts)	454116060X



ps:®MTPi10-16 and ps:®MTP8-16 I INSERTS

FOR MACHINE TYPE PRIMA POWER



PART-NO.

PUNCH (H-PM®)		
Round		413201
Square		413202
Rectangle		413203
Oblong		413204
O.D. Ground Special Shape		41320G
EDM Required Special Shape		41320E

STRIPPER		
Round		415201
Square		415202
Rectangle		415203
Oblong		415204
O.D. Ground Special Shape		41520G
EDM Required Special Shape		41520E

DIE (HWS)		
Round		414201
Square		414202
Rectangle		414203
Oblong		414204
O.D. Ground Special Shape		41420G
EDM Required Special Shape		41420E

ADDITIONAL COSTS FOR PUNCHES

- TICN coating
- T-MAX coating
- A-MAX coating
- WT-shear
- DOWT-shear
- 2 PT-shear
- 4 PT-shear
- Cutting part under 1,00 mm

ADDITIONAL COSTS FOR DIES

- Reinforced die
- H-PM® Quality
- Additional pin hole

ps:®MTPi10-16 and ps:®MTP8-16 | ADAPTER

FOR MACHINE TYPE PRIMA POWER

PART-NO.

PUNCH HOLDER ps:®MTPi10-16	
(without punch or stripper inserts)	454210000-PPX

DIE HOLDER ps:®MTPi10-16	
(without die inserts)	454210060X

PART-NO.

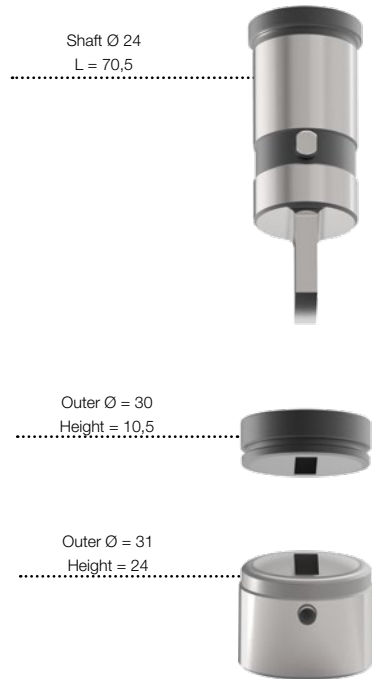
PUNCH HOLDER ps:®MTP8-16	
(without punch or stripper inserts)	454108000-PPX

DIE HOLDER ps:®MTP8-16	
(without die inserts)	454108060X



ps:®MTPi8-24 and ps:®MTP5-24 | INSERTS

FOR MACHINE TYPE PRIMA POWER



PART-NO.

PUNCH (H-PM®)		
Round		413211
Square		413212
Rectangle		413213
Oblong		413214
O.D. Ground Special Shape		41321G
EDM Required Special Shape		41321E

STRIPPER		
Round		415211
Square		415212
Rectangle		415213
Oblong		415214
O.D. Ground Special Shape		41521G
EDM Required Special Shape		41521E

DIE (HWS)		
Round		414211
Square		414212
Rectangle		414213
Oblong		414214
O.D. Ground Special Shape		41421G
EDM Required Special Shape		41421E

ADDITIONAL COSTS FOR PUNCHES

- TICN coating
- T-MAX coating
- A-MAX coating
- WT-shear
- DOWT-shear
- 2 PT-shear
- 4 PT-shear
- Cutting part under 1,00 mm

ADDITIONAL COSTS FOR DIES

- Reinforced die
- H-PM® Quality
- Additional pin hole

ps:®MTPi8-24 and ps:®MTP5-24 | ADAPTER

FOR MACHINE TYPE PRIMA POWER

PART-NO.

PART-NO.

PUNCH HOLDER ps:®MTPi8-24	
(without punch or stripper inserts)	454208000-PPX

PUNCH HOLDER ps:®MTP5-24	
(without punch or stripper inserts)	454105000-PPX

DIE HOLDER ps:®MTPi8-24	
(without die inserts)	454208060X

DIE HOLDER ps:®MTP5-24	
(without die inserts)	454105060X



ps:® MTP3B | INSERTS

FOR MACHINE TYPE PRIMA POWER



PART-NO.

PUNCH (H-PM®)		
	Round	4020B01
	Square	4020B02
	Rectangle	4020B03
	Oblong	4020B04
	O.D. Ground Special Shape	4020B0G
	EDM Required Special Shape	4020B0E

STRIPPER		
	Round	4040B01
	Square	4040B02
	Rectangle	4040B03
	Oblong	4040B04
	O.D. Ground Special Shape	4040B0G
	EDM Required Special Shape	4040B0E

DIE (HWS)		
	Round	4052B01
	Square	4052B02
	Rectangle	4052B03
	Oblong	4052B04
	O.D. Ground Special Shape	4052B0G
	EDM Required Special Shape	4052B0E

ADDITIONAL COSTS FOR PUNCHES

- TICN coating
- T-MAX coating
- A-MAX coating
- WT-shear
- DOWT-shear
- 2 PT-shear
- 4 PT-shear
- Cutting part under 1,00 mm

ADDITIONAL COSTS FOR DIES

- Reinforced die
- H-PM® Quality
- Additional pin hole

ps:®MTP3B | ADAPTER

FOR MACHINE TYPE PRIMA POWER

PART-NO.

PUNCH HOLDER ps:®MTP3B	
(without punch or stripper inserts)	452301001-PPX

DIE HOLDER ps:®MTP3B	
(without die inserts)	452302001X



ps:® MTPi4B+4 | INSERTS

FOR MACHINE TYPE PRIMA POWER



PART-NO.

PUNCH (H-PM®)		
Round	4020B01	
Square	4020B02	
Rectangle	4020B03	
Oblong	4020B04	
O.D. Ground Special Shape	4020B0G	
EDM Required Special Shape	4020B0E	
STRIPPER		
Round	4040B01	
Square	4040B02	
Rectangle	4040B03	
Oblong	4040B04	
O.D. Ground Special Shape	4040B0G	
EDM Required Special Shape	4040B0E	
DIE (HWS)		
Round	4052B01	
Square	4052B02	
Rectangle	4052B03	
Oblong	4052B04	
O.D. Ground Special Shape	4052B0G	
EDM Required Special Shape	4052B0E	

ADDITIONAL COSTS FOR PUNCHES

- TICN coating
- T-MAX coating
- A-MAX coating
- WT-shear
- DOWT-shear
- 2 PT-shear
- 4 PT-shear
- Cutting part under 1,00 mm

ADDITIONAL COSTS FOR DIES

- Reinforced die
- H-PM® Quality
- Additional pin hole

ps:®MTPi4B+4 | ADAPTER

FOR MACHINE TYPE PRIMA POWER

PART-NO.

PUNCH HOLDER ps:®MTPi4B+4	
(without punch or stripper inserts)	452401001-PPX

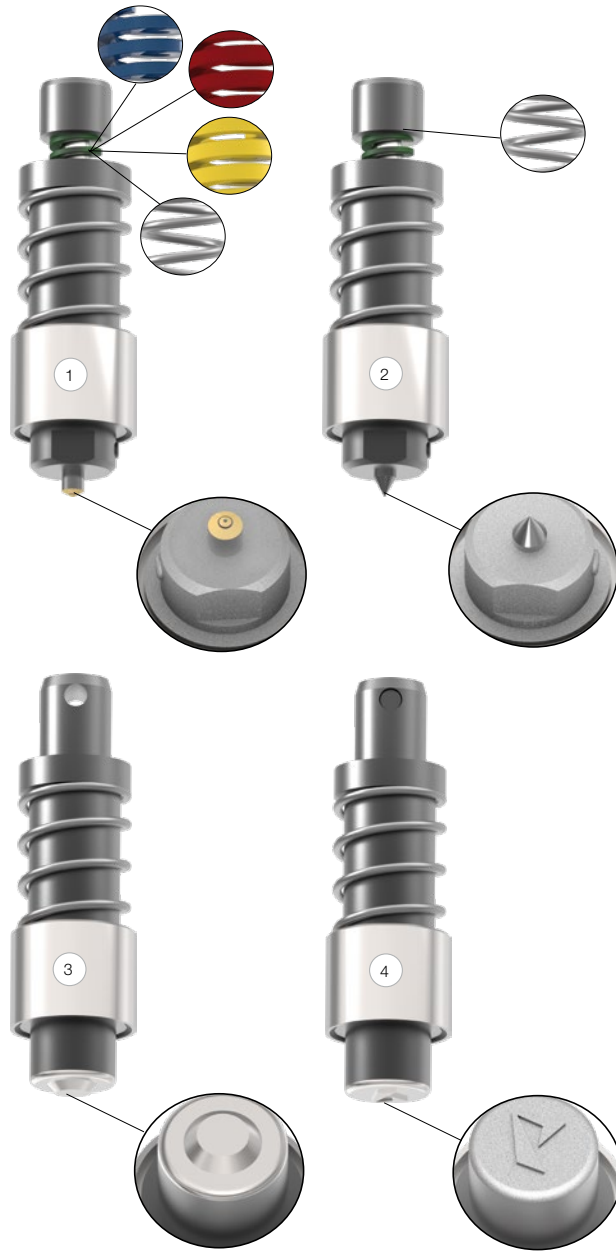
DIE HOLDER ps:®MTPi4B+4	
(without die inserts)	452402001X



ps:® MTPi4B+4 | INSERTS

FOR MACHINE TYPE PRIMA POWER

FOR ENGRAVING, FOIL CUTTING, COUNTERSINKING AND EMBOSSING



	POS.-NO.	PART-NO.
ENGRAVING		
complete set	1	452404101
FOIL CUTTING		
complete set	2	452404106
COUNTERSINKING		
complete set	3	4524041XX
EMBOSSING		
complete set	4	4524041XX

SPARE PARTS

Green spring - soft	91701025A
Blue spring - medium	91701025B
Red spring - hard	91701025C
Yellow spring - very hard	91701025D
Black spring - very soft	916000046
Brass needle (foil cutting)	199103940
Diamond needle (engraving)	199103962

ps:®MTPi4B+4 | ADAPTER

FOR MACHINE TYPE PRIMA POWER

FOR ENGRAVING, FOIL CUTTING, COUNTERSINKING AND EMBOSSING

PART-NO.

PUNCH HOLDER ps:®MTPi4B+4

(without punch or stripper inserts)

452401001-PPX

DIE HOLDER ps:®MTPi4B+4-

(without die inserts)

452402001X





SPECIAL TOOLS

PASS EXTRA TOOLS FOR YOUR
THICK TURRET SYSTEM - MACHINE TYPE PRIMA POWER

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ps:®multi-thread	page 54
ps:®marking-all-in-one	page 56

ps:® multi-thread

FOR MACHINE TYPE PRIMA POWER - STATION Di



UPPER PART

Thread forming into sheet metals up to a thickness of 8 mm

Also usable for extrusions up- and downwards

Oil channel for tool and sheet lubrication

PU stripper to reduce warpage

Universally equippable

THREAD MODULES

Sizes from M2/UNC #2-56 to M10/UNC 3/8"-16 possible

TAP INSERTS

Fast and easy changing of inserts

Automatic selection of the taps via the machine controlling

H-PM® quality with coating

LOWER PART

Pivot-mounted die plate

ps:® multi-thread

FOR MACHINE TYPE PRIMA POWER - STATION Di

PART NO.

TOOL - COMPLETE (ALL INCLUSIVE)

Upper part incl.	
6 thread modules (metric): M2,5; M3; M4; M5; M6; M8	
Set tap inserts (5 pce / each size)	45160005
Complete die	
Complete assembling set	

UPPER PART - COMPLETE

Without modules and tap inserts	451601005
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THREAD MODULES - COMPLETE (WITHOUT TAP INSERTS)

Type 38	M2	451610020
Type 43	M2,5 and UNC #2- 56	451610025
Type 48	M3 and UNC #3- 48	451610030
Type 61	UNC #4- 40 and UNC #5- 40	451610037
Type 67	M4	451610040
Type 76	M5 and UNC 6- 32 and UNC 8- 32	451610050
Type 95	M6 and UNC 10- 24 and UNC 12- 24	451610060
Type 119	M8 and UNC 1/4"-20	451610080
Type 134	UNC 5/16"-18	451610087
Type 143	M10 and UNC 3/8"-16	451610100

TAP INSERTS

M2	924GF1492
M2,5	924GF1401
M3	924GF1402
M4	924GF1404
M5	924GF1405
M6	924GF2401
M8	924GF2402
M10	924GF2403
UNC #2-56	924GFUC05
UNC #3-48	924GFUC10
UNC #4-40	924GFUC15
UNC #5-40	924GFUC20
UNC #6-32	924GFUC25
UNC #8-32	924GFUC30
UNC #10-24	924GFUC35
UNC #12-24	924GFUC40
UNC 1/4"-20	924GFUC45
UNC 5/16"-18	924GFUC50
UNC 3/8"-16	924GFUC55

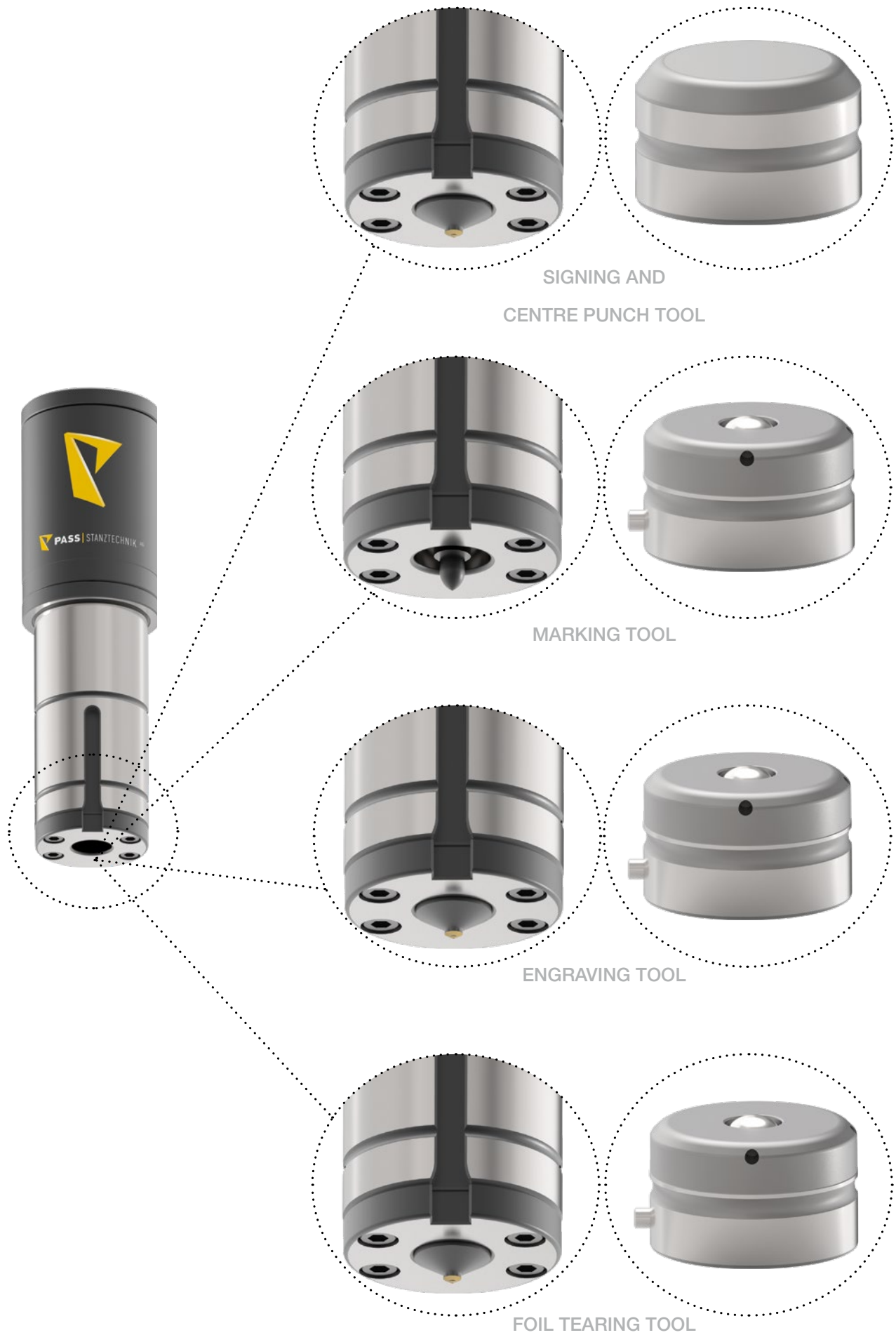
DIE - COMPLETE

for all thread sizes	451621000
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ASSEMBLING SET - COMPLETE

Torque wrench / grease gun / rig pin 6 mm / auxiliary assembling ring / socket wrench 4 mm / Molykote grease	451603000
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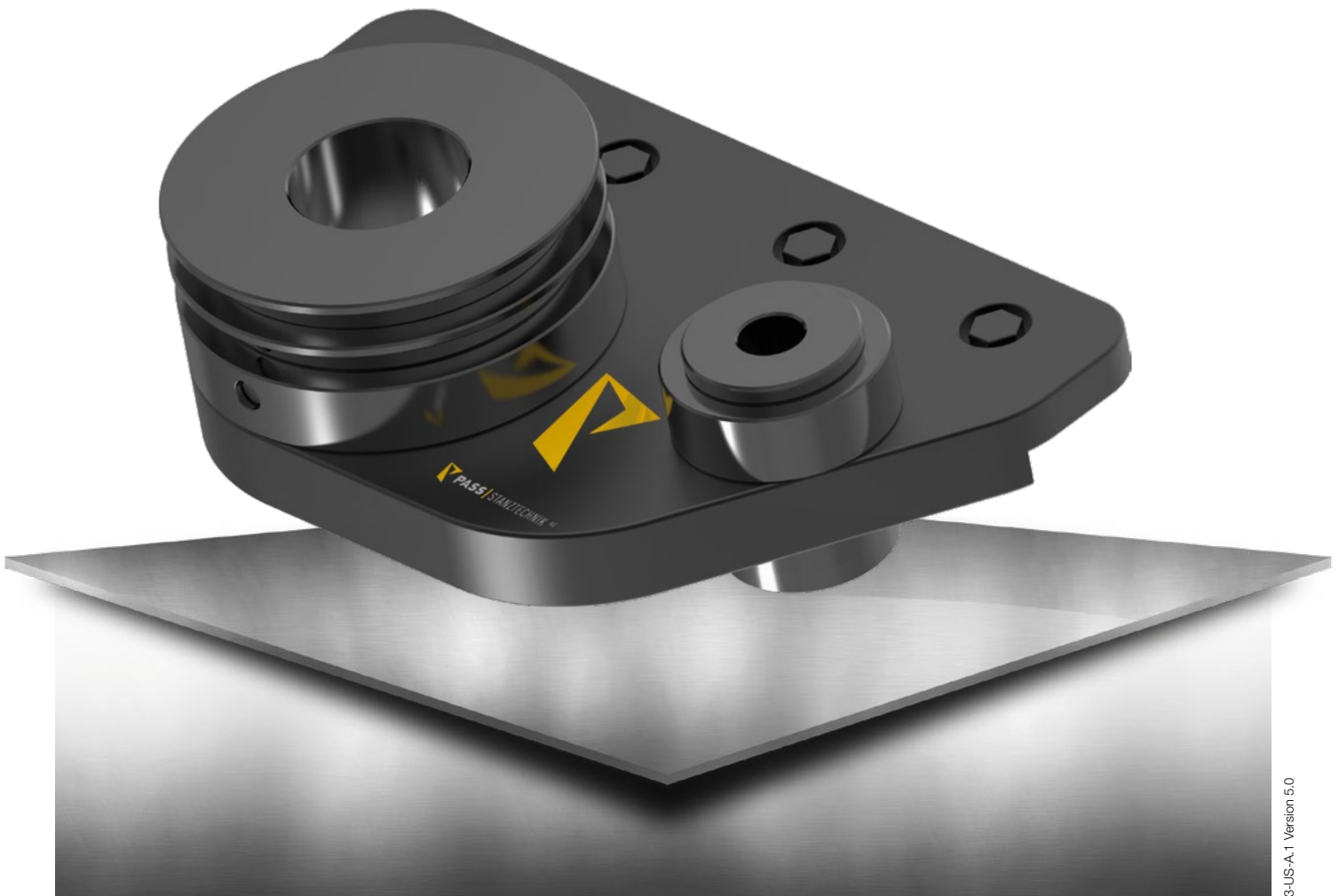
PART-NO.

ps:®marking-all-in-one	complete set	499104000
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SPARE PARTS

Center punch needle made of H-PM®	199103930
Engraving needle with diamond point	199103962
Foil tearing needle made of brass	199103940
Marking pen	499104036



ACCESSORIES

PASS ACCESSORIES FOR YOUR
THICK TURRET SYSTEM - MACHINE TYPE PRIMA POWER

Index

ps.® assembly-element	page 60
PASS assembling set	page 61
PASS adapter	page 62
PASS dies	page 63
PASS Alignment Tools	page 64
PASS T-Handle	page 65

STATION A



STATION B



STATION C



STATION D



STATION E



EQUIPPED BASE PLATE

PART NO.

SOCKET SET INCL. BASE PLATE

Set consists of: 5 sockets (Stat. A-E) + 1 base plate	499M18000
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ADDITIONAL SOCKETS

Pi135	499M18007
P110	499M18008

P110



Pi135

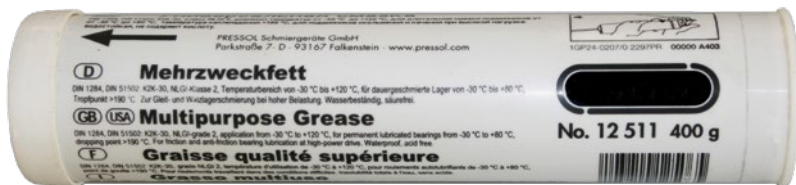


PASS ASSEMBLING SET

FOR PASS GUIDE ASSEMBLY STAT. C, D, E / FOR ps:®multitool STAT. D /
FOR ps:®multi-thread®

PART-NO.

COMPLETE ASSEMBLING SET	
Torque wrench / 25-130 Nm	
incl. 4 socket wrench	
SW 8 / SW 10 / SW 12 / SW 14	
Multipurpose grease 400 gr.	
Triangular whetstone	
Diamond needle file with quick-acting clamp	
Total price	499MONKIT



PASS ADAPTER

PUNCH ADAPTER

Surface-hardened and polished



DIE ADAPTER

Surface-hardened and polished

2 clamping screws



	STATION	PART NO.
MACHINE TYPE: TURRET PUNCHING MACHINES		
Punch adapter	B/A	401BAS1
Die adapter ⁽¹⁾ (⁴)	B/A	401BAM1
Punch adapter	C/B	401CBS1
Die adapter ⁽¹⁾ (⁴)	C/B	401CBM1
Punch adapter	D/A	401DAS1
Die adapter ⁽¹⁾ (⁴)	D/A	401DAM1
Punch adapter	D/B	401DBS1
Die adapter ⁽¹⁾ (⁴)	D/B	401DBM1
Die adapter ⁽³⁾ (⁴) upforming	D/B	499400435
Punch adapter	D/C	401DCS1
Die adapter ⁽¹⁾ (²)(⁴)	D/C	401DCM1
Die adapter ⁽³⁾ (⁴) upforming	D/C	499400434

⁽¹⁾ max. stamping and punching force: 70 kN

⁽²⁾ assembled die is 2 mm above table level

⁽³⁾ only usable for PRIMA POWER machines

⁽⁴⁾ height h = 26 mm

MACHINE TYPE: COIL & BUSBAR PUNCHING MACHINES		
Punch adapter	B/A	401BAS3
Die adapter ⁽⁵⁾	B/A	401BAM3
Punch adapter	C/B	401CBS3
Die adapter ⁽⁵⁾	C/B	401CBM3
Punch adapter	D/A	401DAS3
Die adapter ⁽⁵⁾	D/A	401DAM3
Punch adapter	D/B	401DBS3
Die adapter ⁽⁵⁾	D/B	401DBM3
Punch adapter	D/C	401DCS3
Die adapter ⁽⁵⁾	D/C	not usable

⁽⁵⁾ height h = 30 mm

PASS DIES

WITH BRUSH INSERTS

	STATION	PARTNO.
PASS DIES WITH BRUSH INSERTS		
1x Ø13	A	441711A01
3x Ø13	B	441711B01
7x Ø13	C	441711C01
19x Ø13	D	441711D01
35x Ø13	E	441711E01

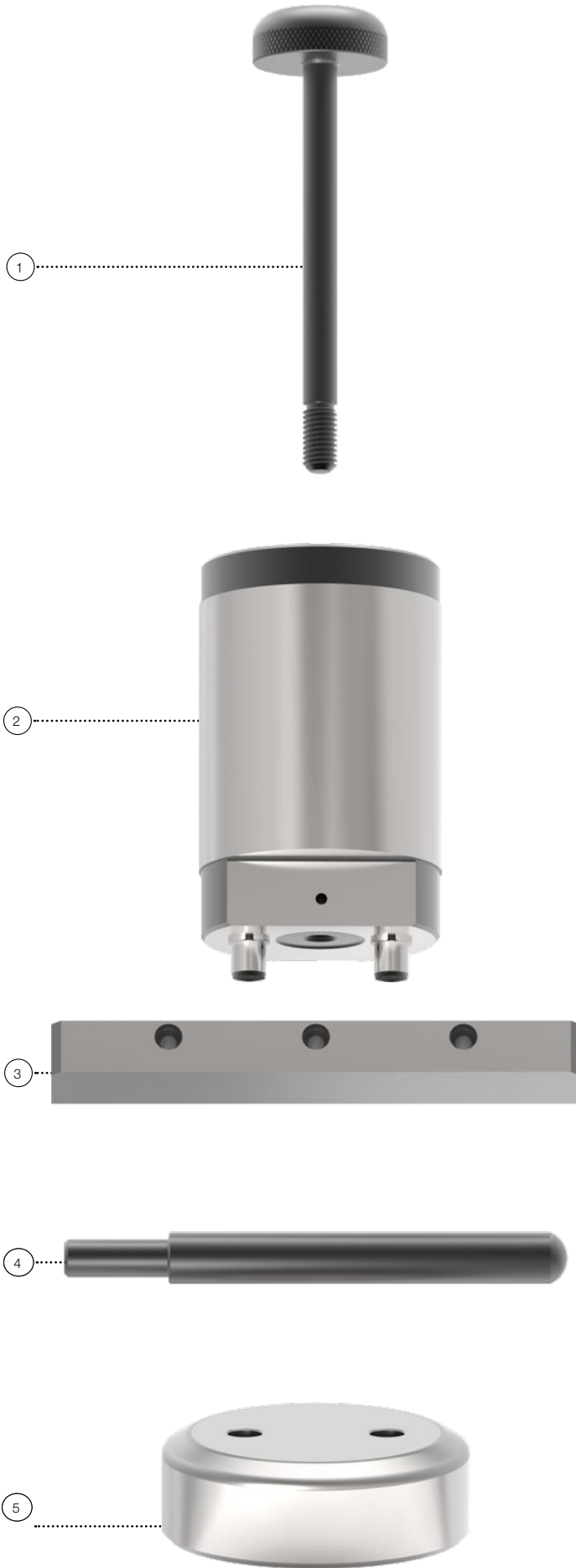


SPARE PARTS

Brush inserts Ø 13 mm (piece)

200B00

PASS ALIGNMENT TOOLS



	STATION	POSITION	PART-NO.
ALIGNMENT TOOLS			
Alignment punch	A	*	499701A01
Alignment die	A	*	499701A06
Alignment punch	B	*	499701B01
Alignment die	B	*	499701B06
Alignment punch	C	2	499701C01
Alignment die	C	5	499701C06
Alignment punch	D	*	499701D01
Alignment die	D	*	499701D06
Alignment punch	E	*	499701E01
Alignment die	E	*	499701E06
Adjusting bar	A-E	3	499701Z01
Handle	A-E	1	499701Z11
Alignment rod	A-E	4	499701Z21

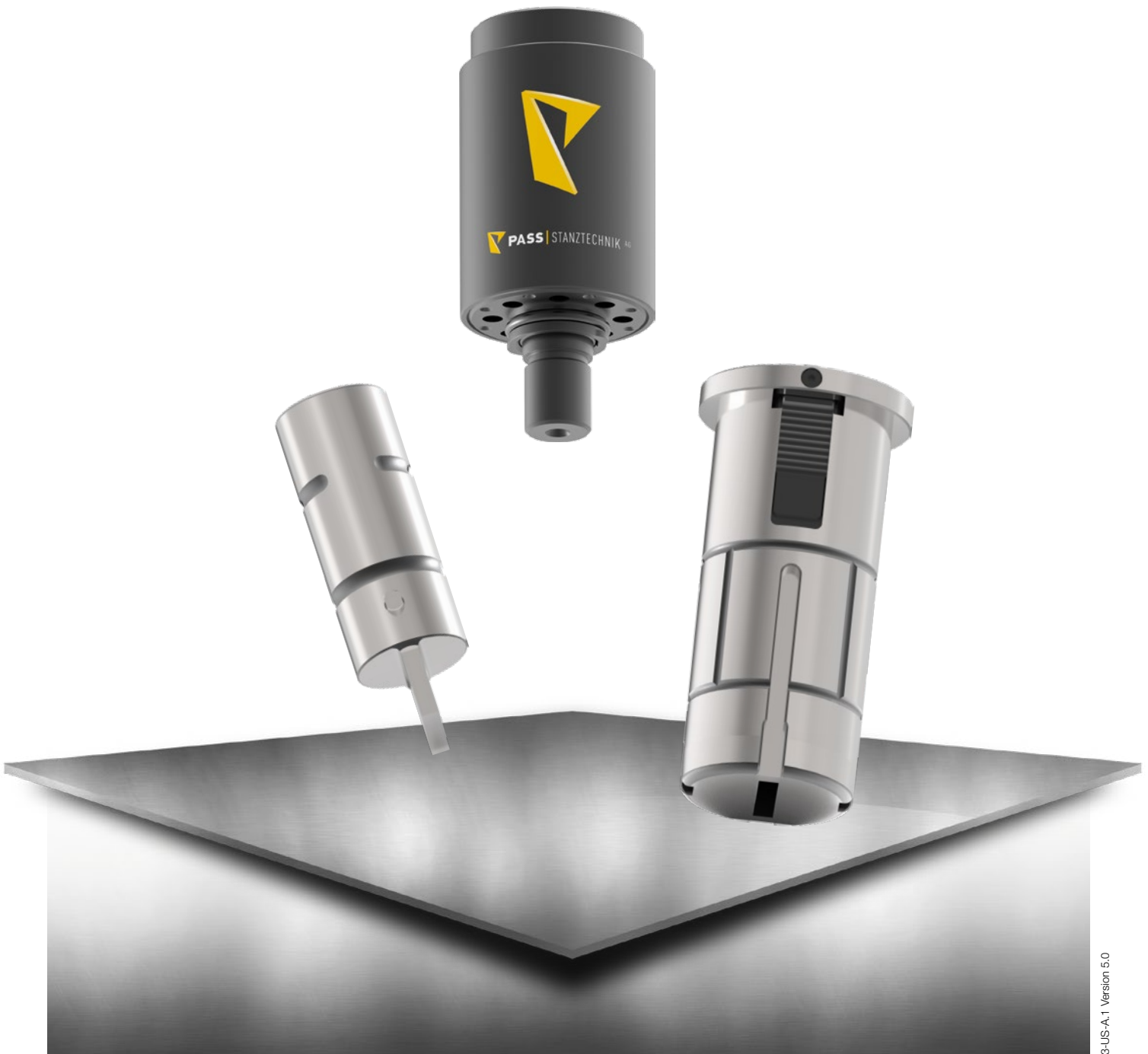
* no picture

PASS T-HANDLE

PART NO.

T-HANDLE		
M14	999000024	
M20	999000028	





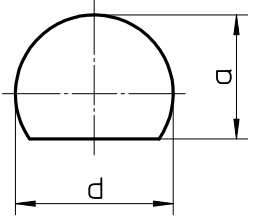
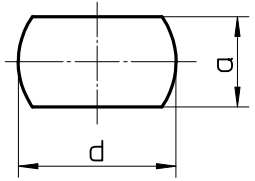
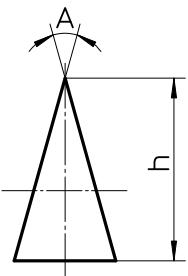
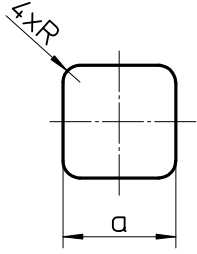
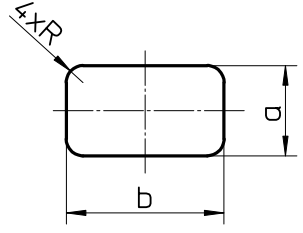
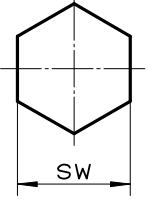
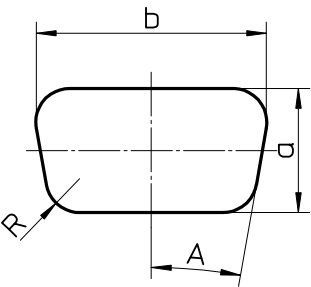
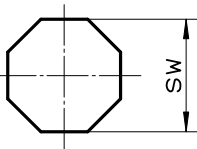
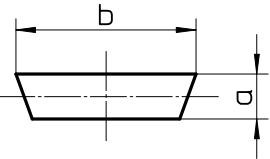
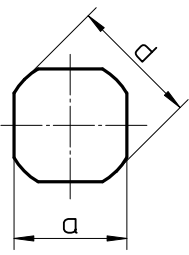
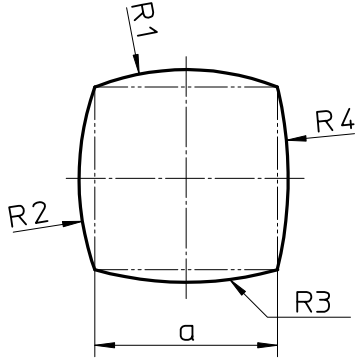
TECHNICAL INFORMATION

INFORMATION ABOUT OUR TOOLS FOR YOUR THICK TURRET SYSTEM - MACHINE TYPE PRIMA POWER

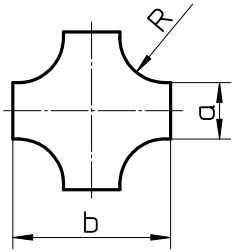
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EDM Required Special Shapes	page 69
PASS tool variety	page 70
Lifetime of tools Regrind advice	page 71
PASS coating versions / Draw-polishing	page 72
Die versions	page 73
Punches with different shear types	page 74
PASS Back taper on punches	page 75
PASS corner radius on punches	page 76
PASS punches with reinforced shoulder	page 77

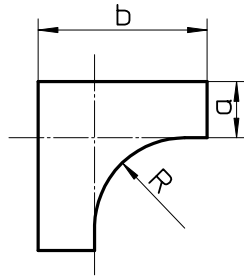
O.D. GROUND SPECIAL SHAPES

 <p>G01</p>	 <p>G02</p>	 <p>G03</p>
 <p>G04</p>	 <p>G05</p>	 <p>G06</p>
 <p>G07</p>	 <p>G08</p>	 <p>G09</p>
 <p>G10</p>	 <p>G11</p>	

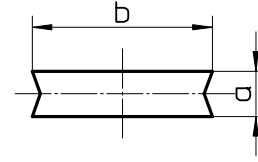
EDM REQUIRED SPECIAL SHAPES



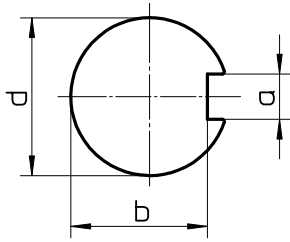
E01



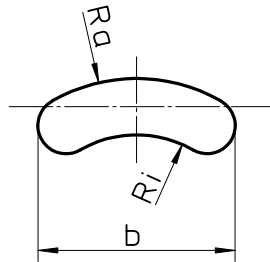
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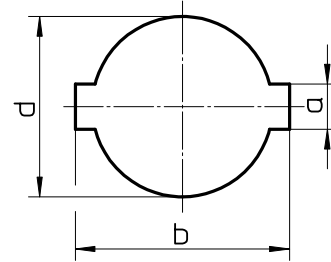
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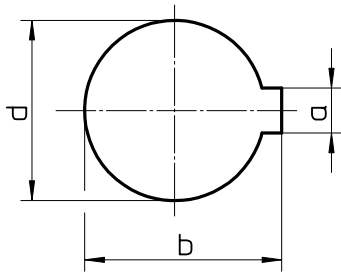
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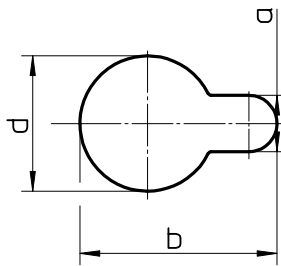
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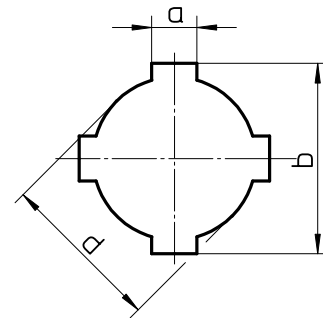
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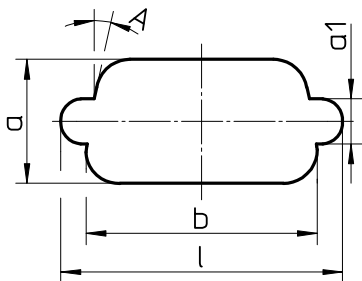
E07



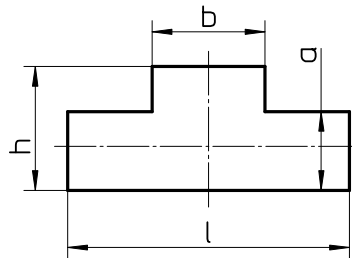
E08



E09



E10



E11

PASS TOOL VARIETY

HWS

HWS tools are made of a secondary hardened cold work steel with superior toughness. This type of steel is especially suitable for dies.

Advantages for customer:

- excellent cost in accordance to performance

H-PM®

H-PM® tools are produced with steel made on powder-metallurgical base with a high degree of purity.

This guarantees a segregational uniformed microstructure in the complete cross-section of the tool.

Advantage for customer:

- excellent cost in accordance to performance
- good stability for edges by increased toughness
- high tool lifetime due to the uniformed microstructure
- increased current hit-flex-capability; suitable as an excellent base for dies

X3-PM

The X3-PM tools are made of a high-end powder-metallurgical steel with the best possible performance characteristics for punches in the punching technology due to the best possible degree of purity.

The segregational uniformed microstructure with high vanadium concentration in the complete cross-section of the punch guarantees best possible wear resistance regarding tool lifetime.

Advantage for customer:

- best efficiency by multiple increase of the punch hit count
- best possible stability for cutting edges
- extremely high abrasion resistance
- utmost compressive strength

X8-PM

The X8-PM tools are made of a high-end powder-metallurgical steel with the best possible performance characteristics for dies in the punching technology caused by best possible degree of purity.

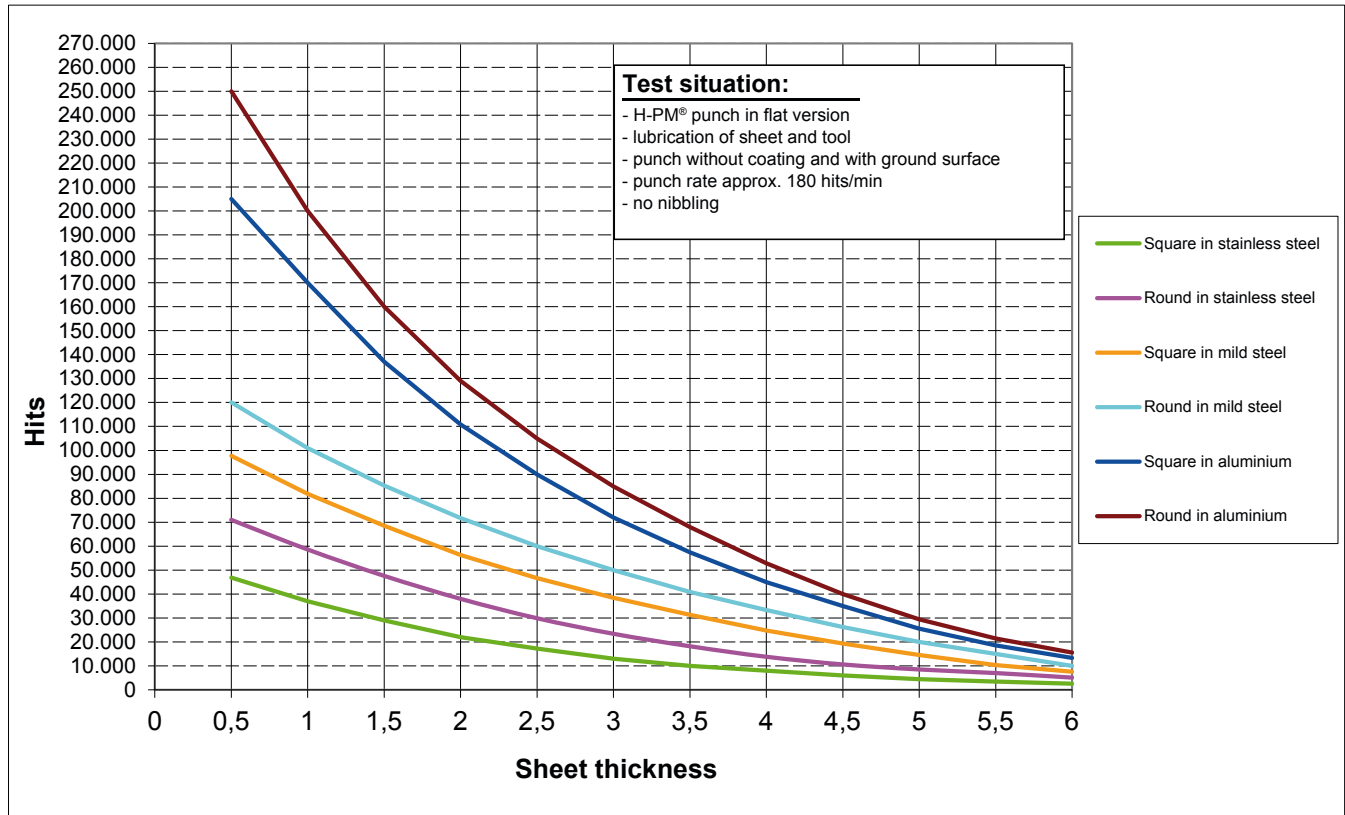
The high ductility of the segregational uniformed microstructure guarantees best possible fatigue limit. This kind of steel is especially suitable for dies with risk-breakage in regard to special shapes.

Advantage for customer:

- best possible absorption of hit-flex stress; prevents fatigue breakage
- high abrasion resistance

LIFETIME OF TOOLS | REGRIND ADVICE

PASS punches and dies are made of high-end special steel in order to guarantee best lifetime of tools together with high robustness.



INFLUENCING FACTORS	FACTOR
Galvanised steel / stainless steel with foil / aluminium anodised	0,5 - 0,8
No sheet lubrication	0,4 - 0,6
Punch coating (TiCN for stainless steel / T-MAX for galvanised steel / A-MAX for aluminium)	2,0 - 4,0
PASS X3-PM punch	6,0 - 10,0
Nibbling	0,7 - 0,9
Notching	0,5 - 0,7
Shear	0,8 - 0,9
Punching rate > 300 hits / min.	0,8 - 0,9
Cutting part with EDM surface	0,4 - 0,8
Cutting part with polished surface	1,5 - 3,0
Cutting part smaller than 1,5x sheet thickness	0,6 - 0,8
Cutting part smaller than 1,0x sheet thickness	0,3 - 0,5
Using of a too small clearance	0,4 - 0,9

An average decrease of the tool life of 5 - 10 % per regrind has to be taken in account for the first regrind.

PASS COATING VERSIONS / DRAW-POLISHING

TO REDUCE MATERIAL BUILD-UP

H-PM® tools are produced with steel made on powder-metallurgical base with a high degree of purity to fulfill the highest punching demands.

Furthermore we attach great importance to a high quality hardening process by repeated temporing and deep-freeze subsequently.

This process guarantees an extremely high hardness with an outstanding wear resistance of our punching tools.

Associated with modern production methods (grinding of the cutting edges with special grinding wheels) we can ensure that the wide range of different sheet qualities can be punched up to 1.600 N/mm² – no matter if it concerns mild alloyed aluminium, mild steel, stainless steel or spring band steel.

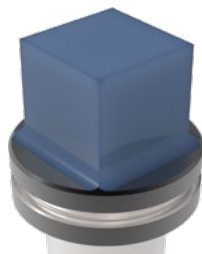
A high punch hardness as well as an excellent grinding surface are important in order to counteract the problem with edge-up.

Tests show us that the well-known TiCN coating is a good coating to increase the lifetime (especially working with stainless steel). However, the problem of material buildup on the edges have not really been counteracted.

Built-up edges are known especially when working with

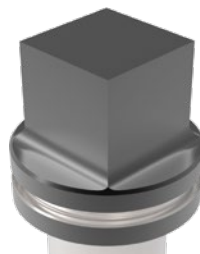
- galvanised steel
- aluminium

After specialized tests at PASS Tooling the below mentioned coatings turned out to be the most successful coatings:



TiCN

for working with
stainless steel



A-MAX

for dry processing with
aluminium sheet



T-MAX

for working with
galvanised sheet / zincor

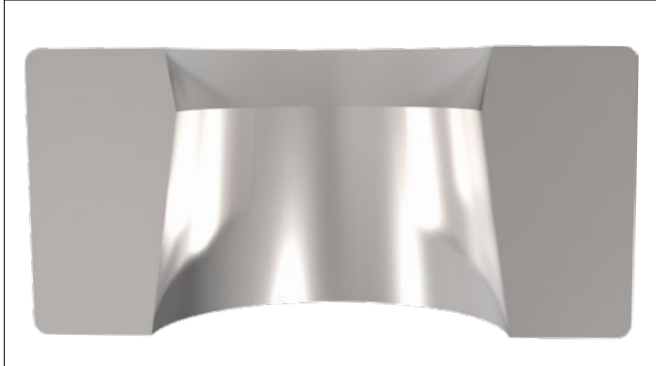
We recommend draw-polished punch edges to increase tool lifetime and reduce material build up (prices on request):



DIE VERSIONS

SLUG-STOP AND SLUG-SNAP (AVOID THE BUILD-UP OF THE SLUGS)

SLUG-STOP (STANDARD)



PASS dies for tooling system THICK TURRET are produced in standard version with a slug-stop version (without additional costs).

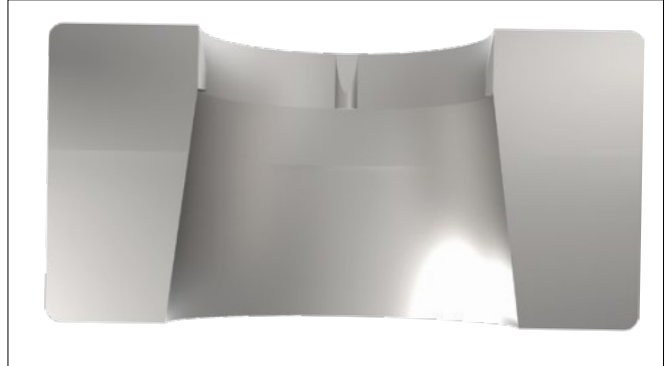
This means that the upper part of the cutting part is produced with a negative angle.

The slug will be held with the complete circumference in the die.

This is not recommended for:

- shapes smaller than 1,25 mm
- clearance smaller 0,1 mm

SLUG-SNAP (SPECIAL VERSION - ADDITIONAL COSTS)



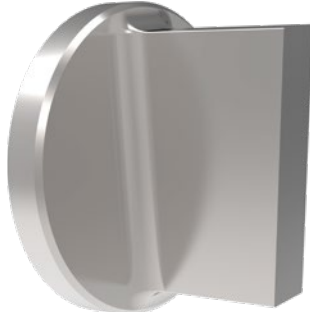
Alternatively we offer our slug-snap version (additional costs).

In this case special holding bolts are included in the die, clamping the slug positively (better than the slug-stop version).

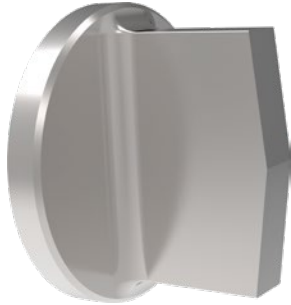
The slug-snap version is also more convenient for shapes smaller than 1,25 mm and clearance smaller 0,1 mm.

PUNCHES WITH DIFFERENT SHEAR TYPES

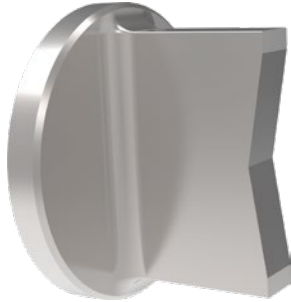
WT



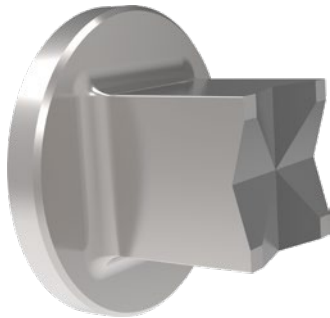
DOWT



2 PT



4 PT



DESCRIPTION

WT
Advantage easy regrindable

Disadvantage lateral forces

DOWT
Advantages easy regrindable
no lateral forces

Disadvantage only reasonable for big shapes

2 PT
Advantages no lateral forces
optimal die cutting

Disadvantages only reasonable for big and slim shapes
difficult to regrind

4 PT
Advantages no lateral forces
optimal die cutting
suitable for trimming

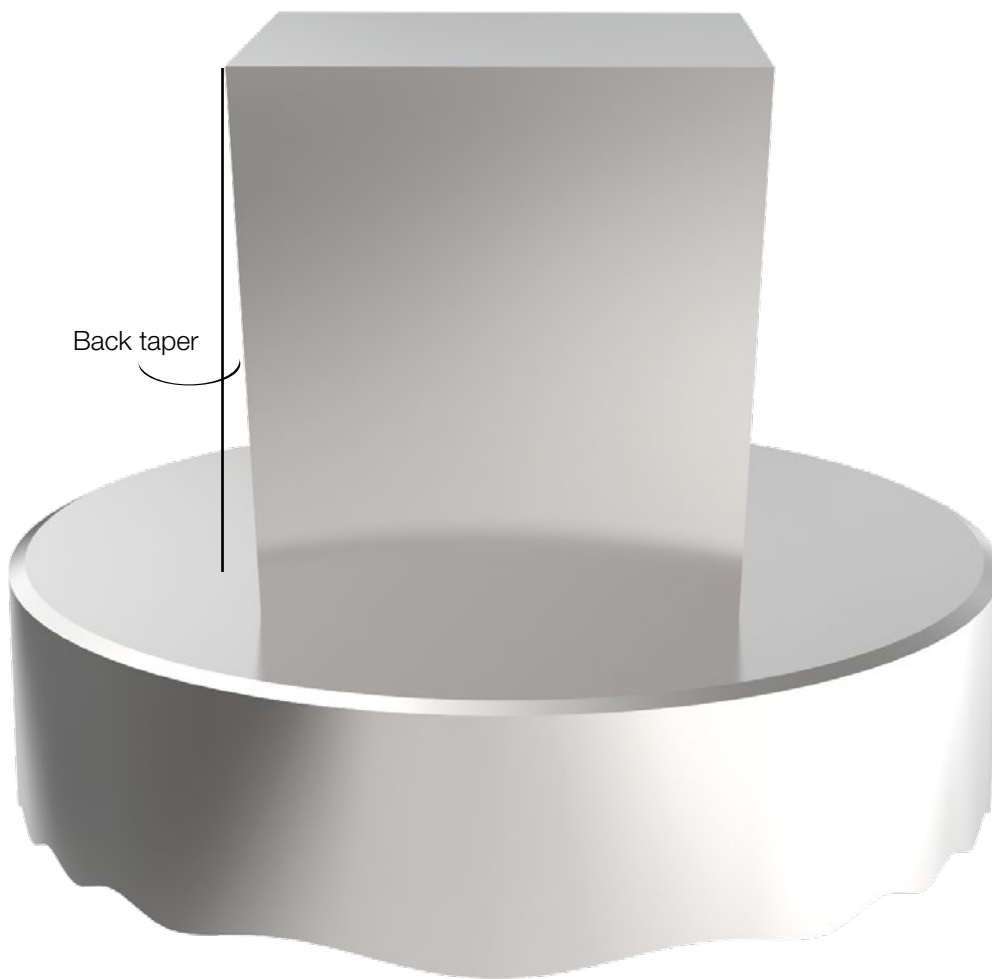
Disadvantages only reasonable for big shapes
difficult to regrind

PASS BACK TAPER ON PUNCHES

PASS punches are normally produced with back taper to reduce galling and premature punch wear.

However it should be mentioned that back taper is very important when punching materials such as stainless steel or very thick material to reduce galling and eliminate breakage of the tool corners and edges.

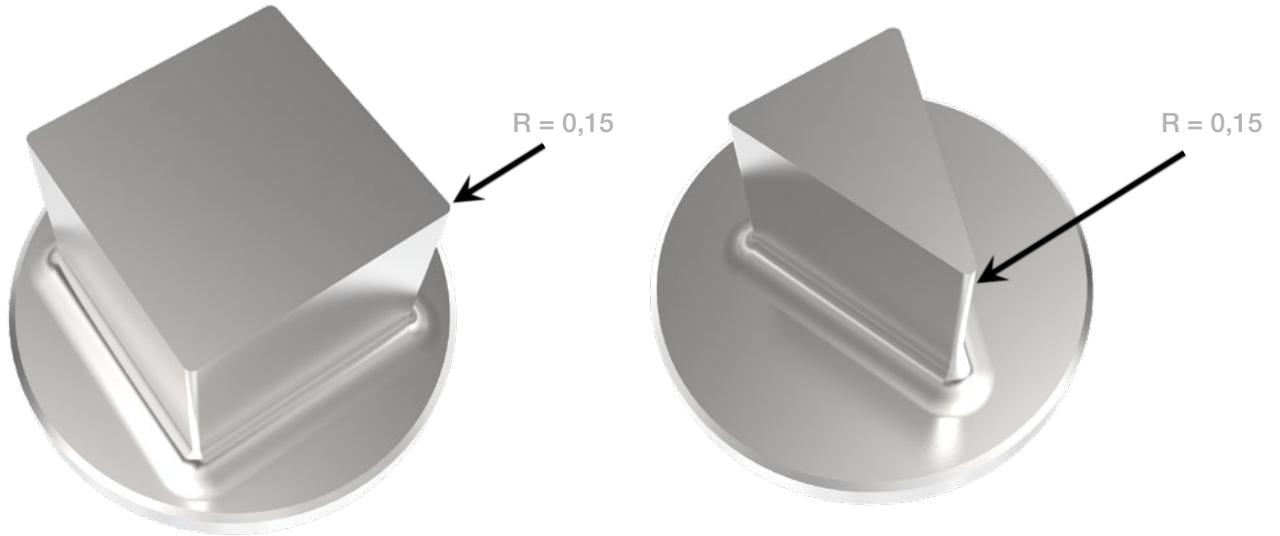
We recommend a line polished version for cutting parts, which have to be produced sink-eroded (special shape with internal shape, e.g. cross-form, U-form, etc.) and in high quality sheets.



PASS CORNER RADIUS ON PUNCHES

PASS punches are automatically produced with corner radius $R = 0,15$ mm. This process increases the lifetime as the corner abrasive wear will be decreased considerably.

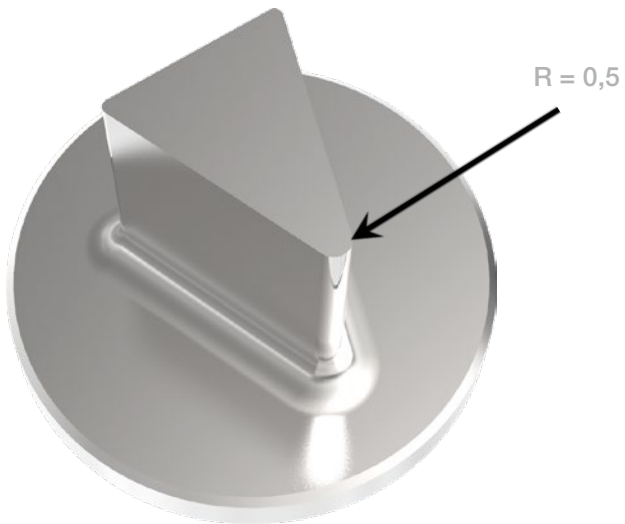
E.g.: square and triangle punch



The corner radius can be changed on customer's request.

E.g.:

$R = 0,5$ mm instead of $R = 0,15$ mm for stainless steel in order to increase tool life.



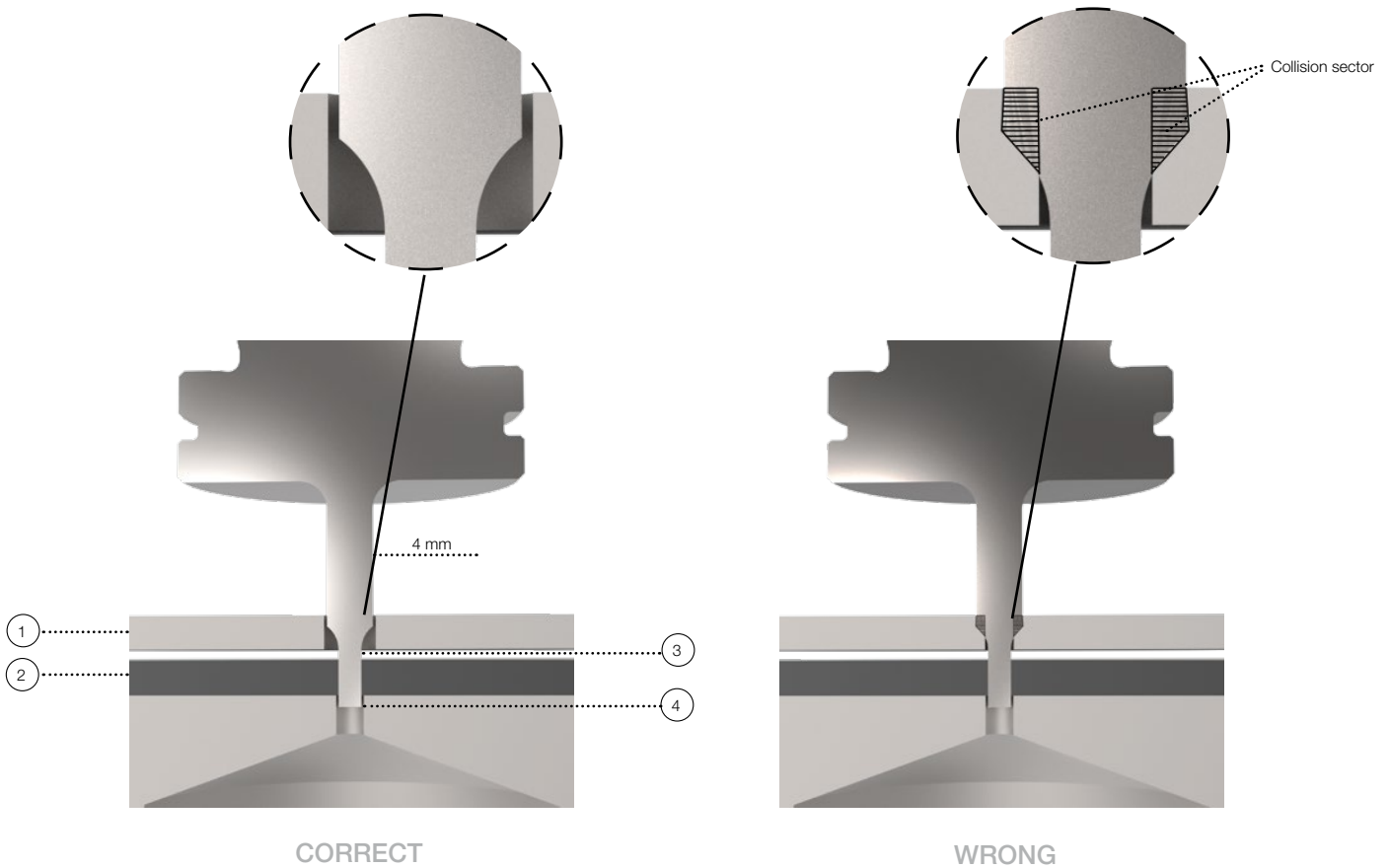
PASS PUNCHES WITH REINFORCED SHOULDER

All PASS punches are produced with a 4 mm reinforced shoulder as soon as the cutting section is required smaller than 4 mm.

This guarantees that you will get a tool with highest stability in order to punch also thicker and high-strength sheets.

However, the correct stripper size has to be selected in subject to machine type, tool design, sheet thickness (1), punching depth (2), stripper thickness (3) and stripper overlap (4).

It might be possible that it gets necessary to use a stripper with an appropriate big shape (width min. 4,5 mm) in order to get sure that the reinforced punch shoulder can immerse into the stripper.



SALVAGNINI | **THICK TURRET** | **TRUMPF**



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