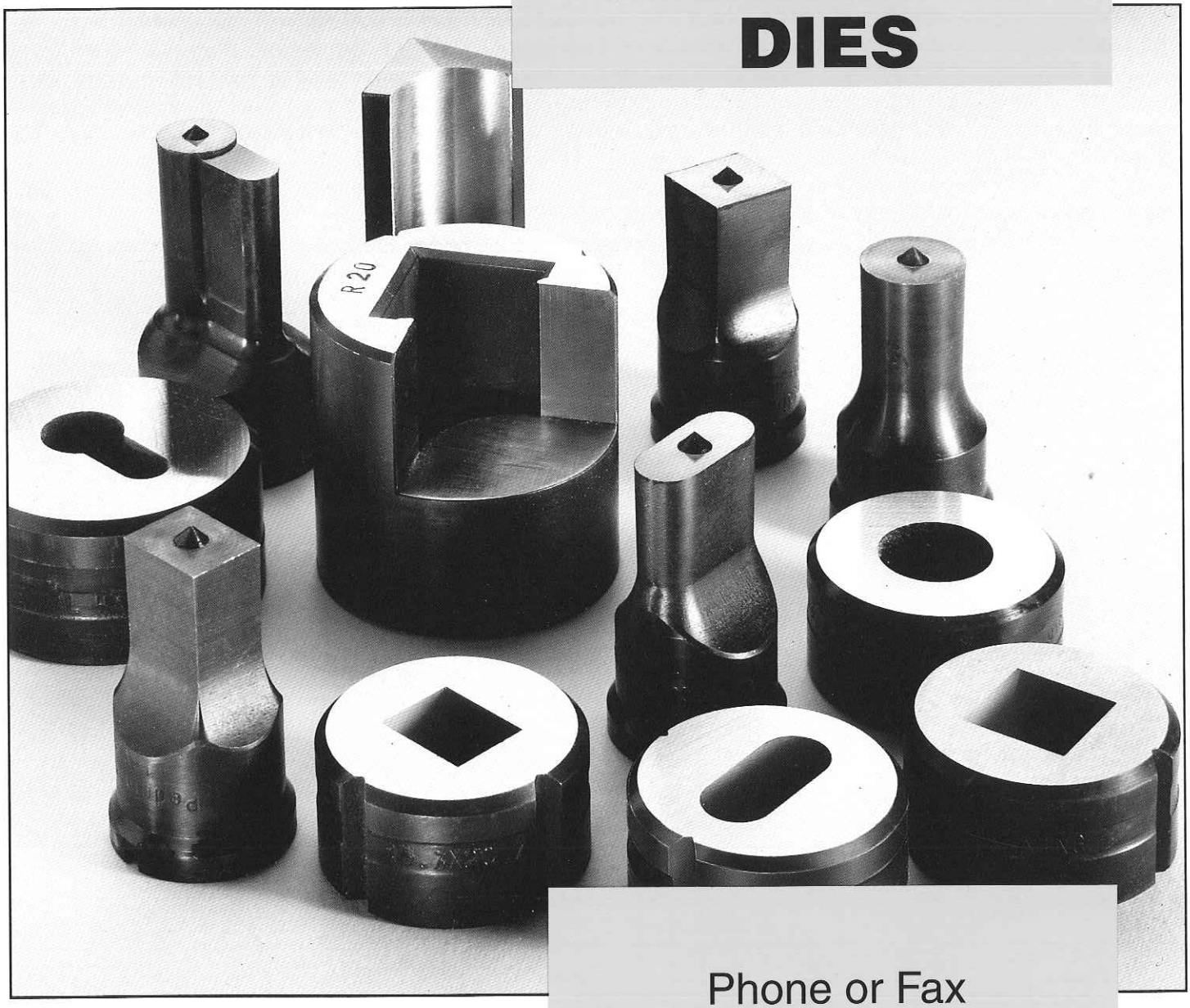
Peddinghaus Corporation, Tool Div.

Innovative Steel Fabricating Technologies

PUNCHES AND DIES



Phone or Fax

1-800-PUNCH IT

for

Stock Deliveries

at Competitive Prices

Sterling MACHINERY EXCHANGE

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Peddinghaus quality and stock deliveries...

Peddinghaus Corporation has established itself as the leader in the engineering and manufacturing of innovative solutions for today's difficult structural steel and plate fabrication applications. These applications demand unique tooling designs to maximize the efficiency of the machine tool to complete the desired task. Such designs are not considered stock items by the various punch and die manufacturers that typically serve the market.

In view of this fact, Peddinghaus Corporation invested extensively in proprietary manufacturing processes and tooling technology to offer its unique tooling from stock at competitive prices. Fabricators can now purchase from stock punches and dies manufactured to the exacting standards that Peddinghaus engineers its fabricating systems. Peddinghaus Corporation Tool Division offers a complete complement of punches and dies as stock items for all Peddinghaus stand alone machines and Peddimat CNC systems, plus tooling for all other structural and plate punching machines and systems.

Maximizing the capability of a Peddinghaus CNC Peddimat system, before now, required special modifications by other punch and die manufacturers to fully utilize the entire capability of a Peddimat CNC system. This led to higher prices and longer deliveries for fabricators requiring these punches and dies. Tooling manufactured by Peddinghaus Corporation incorporates all the unique design criteria required on Peddimat CNC systems without any additional charge and can be delivered from Peddinghaus Corporation's extensive inventory. Your tooling inquiries can be answered simply by calling toll free 1-800-PUNCH IT (786-2448).

If you require special tooling for a unique application, our engineering staff can quickly create the required tool on CAD so that even special non-stock tools can be delivered quickly.

By calling toll free 1-800-PUNCH IT (786-2448), you get: Peddinghaus quality and stock deliveries...all at competitive prices.

Punch & Die Style Selection for Peddinghaus Machines & Systems

Punches	Style	142	152	162	272	282	292
	Profile	P	P	P	P	P	P
Fabriline	1/8" Thru 1-1/4"				●	X	
	1-1/4" Thru 1-1/2"					●	
FPB 500/3					●	●	
FPB 1500/3					●		●
FPB 600/3					●		●
F-1120 F-1154 F-1170	Single Tooling				●	X	
	Triple Tooling				●	●	
Anglemasters	600 Series				●		
	800 Series				●		
	1563 Series				●	X	
	2063 Series				●	X	
Portables	45 - 100 Tons				●	X	
Peddicat	360, 400	●		X			
Peddiworkers	440, 550	●		X			
	660, 880	●		X			
	881, 1050, 1100		●				
Peddimasters	44/66, 66/88, 66/110	●		X			
	88/120	●		X			
	110/175, 120/185		●	X			
Peddimax	110/140		●				
	66/110	●					
210 Series	210/11, 210/13	●		X			
	210/16, 210/20		●	X			
	210/25			●			
Bradley			●				
Single End Punches	55/20, 110/20		●	X			
	H-100, H-1400N			●			
	H-140			●			
	210 B20		●				

Dies	Style	121	131	271	271	271	271	281	218	281	291
	Profile/Type	A3	A3	A3	A4	B4	D3	A3	A4	B4	A3
FPB 500/3	5/32" Thru 1-1/16""						●				
	1-1/16" Thru 9/16"			●							
					●				●		
FPB 1500/3				●							●
F-1120 F-1154 F-1170	Single Tooling					●				X	
	Triple Tooling					●				●	
Anglemasters	600 Series					●					
	800 Series					●					
	1563 Series					●					
	2063 Series					●					
Portables	45 - 100 Tons			●							
Peddicat	360, 400	●							X		
	440, 550	●							X		
Peddiworkers	660, 880	●							X		
	881, 1050, 1100		●								
Peddimasters	44/66, 66/88, 66/110	●							X		
	88/120	●							X		
	110/175, 120/185		●						X		
Peddimax	110/140		●								
	66/110	●									
210 Series	210/11, 210/13	●							X		
	210/16, 210/20		●						X		
	210/25								●		
Bradley			●								
Single End Punches	55/20, 110/20		●						X		
	H-100, H-1400N								●		
	H-140								●		
	210 B20		●								

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● = Standard tooling

X= Requires oversize tooling attachments

all at competitive prices.

Ordering Information

The Peddinghaus Corporation Tool Division numbering system is designed to simplify the specific desired criteria (such as keyway or bevel orientation) of the tool to meet your fabrication requirements and to achieve complete compatibility with all fabrication equipment. The various descriptions of style, profile, type, shape and size, are illustrated below to insure compatibility between your machine type and hole requirements.

Punches
142, 152, 162,
272, 282, 292, 412
522, 712, 702

Dies
121, 131, 271,
281, 291, 412
521, 531, 711

Style

XXX-XXX-Size

PROFILE

Flat, Level Face (Disk)

- (A) Standard, Round Die
- (B) Die with Fillet Bevel
- (C) Die with Flat on Side
- (D) Die with Fillet Bevel and Flat
- (E) Die with Eccentric

Serrated

- (H) Round
- (J) Flat on Side

Serrated

- (K) Round
- (L) Flat on Side
- (M) Die with Flat & Fillet Bevel

Punches

- (P) Punch, with Centerpoint

TYPE

1 =No Keyway

2 =Cross Keyed Punch

3 =Relieved Die

4 =Straight Thru Die

SHAPE

A = "Special"

B = Round

C = Square

H = Oblong

K = Rectange

M = Hexagonal

Examples, Standard Orientation For Single Key Tooling

Punches (Top View)

(B) Rounds, no keyway

(C) Squares, symmetrical

(H) Oblongs,

(K) Rectangles

(M) Hexagonals

Dies

Style A, Round Die Pick Orientation H,K, or M

Style B, w/Fillet Bevel

Style D, w/Flat & Fillet Bevel

Style K, Serrated Channel Die

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Peddinghaus Corporation Tool Div.

1-800-PUNCH IT (800-786-2448)

Machine Cross Reference Chart

Peddinghaus Corporation Tool Div.
Innovative Steel Fabricating Technologies

Company /Model	Peddinghaus Corporation Tool Div.
Beatty	
#7	412, 152P
	131A
#11	131A
Buffalo (before 1952)	
1/2	522P, 521C
1 1/2	522P, 531P
2 1/2	541C, 141C
Bully	
M404	412P, 131A
M404	162P
	281A
M408	131A
M708	131A
FICEP	
Super 14	152P
	131A
Super 16	162P
	281A
ST Super 16	152P
	131A
Super 20	162P
	281A
UIW-80	152P
	131A
UIW-100	162P
	281A
Franklin	
W & F 530-500	272P
	271A
W & F 550-570	272P
	271A
W & F 5100	272P
	271A
Gairu	
Supreme 13	131A
	142P
Suprema 16	152P
	131A
Suprema 20	152P
	131A
GEKA	
11H	412P, 121A
13H	412P, 121A
16H	152P
	131A
	281A
20H	152P
	131A
	281A
Minicrop	412P, 131A
Microcrop	412P, 131A
Hydracrop 50	412P, 131A
Hydracrop 70	412P, 131A
Maxicrop	412P, 131A
Hydracrop 100	152P
	131A
Hydracrop 150	162P
	281A
	761A
Hydracrop 200	162P
Hendley/Whitmore	
#53	142P, 741A
#54	142P
	131A
#55	152P
	131A
#55 1/2	162P
	281A
HMI	
35-07	412P, 131A
35-14	412P, 162P
	281A
35-19	131A
35DT-19	412P, 131A
50-07	412P, 131A
50-14	162P
	281A
50-19	162P
	281A
50DT-19	162P
	281A
50-25	162P
	281A
50-31	162P
	281A
70-14	162P
	281A
70-31	162P
	281A
90-14	162P
	281A
90-31	162P
	281A
110-14	162P
	281A
110-31	162P
	281A
130-14	162P
	281A
130-31	162P
	281A
small	131A
large	162P
	281A
Hill Acme	
3A	152P, 741A
4	152P, 741A
4A	152P
	131A
5	152P
	131A
6	152P
	131A
6A	152P
	131A
7	162P
	281A
7A	162P
	281A
MW50	152P
	131A
1 1/2 O.S. attachment	162P
	281A
#3 large jaw	142P
#4 large jaw	152P
#5 large jaw	152P
	131A
#6 large jaw	152P
	131A
#7 large jaw	162P
	281A
#3 small jaw	142P
#4 small jaw	152P
#5 small jaw	152P
#6 small jaw	152P
#7 small jaw	162P
Hills and Jones	
#5	131A
#6	152P
#7	162P
Ironcrafter	
<=95 tons	152P
	131A
120-150	162P
	281A
Kingsland	
J-14	152P
	281A
J-18	152P
	281A
Kling Ironworker	
#4 stnd punch	152P, 741A
triple gag punch	142P
triple gag die	131A
stake punch	152P
#7 stnd punch	162P
die lrg archi jaw	281A
triple gag punch	152P
triple gag die	131A
stake punch	162P
Metal Fabricating Systems	
100 Ton	
Portables	272P
	271A
106 Beamlines	272P
	271A
250 Anglelines over 2 1/2	272P
	271A
Bar line	131A
Metalmuncher	
MM35	412P, 131A
MM61	162P
	281A
MM61E	162P
	281A
MM90	162P
	281A
MM90C	162P
	281A
MM110	162P
	281A
GB35	412P, 131A
GB50	162P
	281A
GB90	162P
	281A
GB110	162P
	281A
Midwest	
35	412P, 131A
	152P
50-DE	131A
	152P
80	131A
	152P
80-DE	131A
	152P
100-DE	162P
	281A
Nitto Kohki	
	712P
	711A
Omera	
M-10 Hydro	152P
	131A
115-35S	152P
	131A
13-45S	152P
	131A
16-70S	162P
	281A
20-95S	162P
	281A
OM 1/2	152P
	131A
Edwards Hawthorne & Pittsburg	
Jaws IV	412P
	121A
Large Table	162P
	281A
Promoco	
CH-50	131A
CH-70	152P
	131A
CH-100	152P
	131A
Pirahna	
P-2	412P, 121A
P-3	412P, 121A
P-4	162P
	281A
P120	162P
	281A
Oversize Attch	162P
	281A
Sep-120	162P, 281A
Profel	
PC 120	412P, 271A
PC 200	412P, 271A
Roper Whitney	
No 40	271A
HP 535	271A
HP 535X8	271A
HP 550	271A
HP 550X10	271A
Scotchman	
207	702P
	131A
314C	702P
	131A
314T	702P
	131A
4014CM	702P
	131A
4014TM	702P
	131A
2450	152P
	131A
5075-24M	152P
	131B
6509-24M	152P
	131A
7012-24	152P
	131A
9012-24M	152P
	131A
DO100-24M	152P
	131A
12012-24M	162P
	141A
FI5109-14M	152P
	131A
FI6008-14M	152P
	131A
FI8507-14M	152P
	131A
#1 Oversized Attached	162P
	141A
Sizor	
60 Ton	
Struct Press	272P
	271A
60 Ton	
Beam Punch	271A
Memory NC	
Angle/Channel	
Flat	272P
	271A
Summit	
No 1/2	152P
	131A
TECMA	
No 4	142P
No 6	152P
	121A
No 9	162P
	281A
207	131A
314C-6	131A
314T	131A
4014CM	131A
4014TM	131A
XL Models	152P
	131A
5024	152P
	131A
6509-24M	152P
	131A
7012-24	152P
	131A
M9012-24M	152P
	131A
12012-24M	162P
	141A
Oversize attch	162P
	141A
Trojan	
45 Ton	131A
65 Ton	131A
Uni-Hydro	
20-8	702P, 131A
30-8	702P, 131A
35-14	702P, 131A
T40-14	702P, 131A
42-14	702P, 131A
50-14	702P, 131A
65-14	131A
55-24	131A
	141A
70-24	131A
	141A
120-24	131A
	141A
150-24	131A
Vernet	
UP40	131A
Webb	
All Machines	412P
	121A
Wysong	
300	152P
	131A
W.A. Whitney	
730	682, 271A
730 X 8	682, 271A
750	682, 271A
751	682, 271A
770	272P
	271A
771	272P
	271A
790	272P
	271A
791	272P
	271A
790 X 6	272P
	271A
791 X 18	272P
	271A
790A X 6	272P
	271A
791A X 18	272P
	271A
M 790MBL	272P
	271A
791AX-30	272P
	271A
7150A X 6	272P
7151A X 12	272P
Beamlines	272P
	271A

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STOCK SQUARE PUNCHES AND DIES

PUNCHES

Sizes	142 PIC	152 PIC	162 PIC	272 PIC	292 PIC	412 PIC
1/4	•	•	•			•
9/32	•	•	•			•
5/16	•	•	•	•		•
11/32	•		•			•
3/8	•	•	•	•		•
13/32	•	•	•	•		•
7/16	•	•	•	•		•
15/32	•	•	•	•		•
1/2	•	•	•	•		•
17/32	•	•	•	•		•
9/16	•	•	•	•		•
19/32	•		•			•
5/8	•	•	•	•		•
21/32	•	•	•	•		•
11/16	•	•	•	•		•
23/32	•		•			
3/4	•	•	•	•		•
25/32	•	•	•	•		•
13/16	•	•	•	•		•
7/8			•	•		
15/16			•			
1			•			
1-1/16			•		•	
1-1/18					•	

DIES

Sizes	121 A3C	131 A3C	271 B4C A4C	271 D4B D4C	271 A3C	281 A4C A3C	291 A3C
9/32	•	•				•	
5/16	•	•				•	
11/32	•	•	•	•	•	•	
3/8	•	•				•	
13/32	•	•	•	•	•	•	
7/16	•	•	•	•	•	•	
15/32	•	•	•	•	•	•	
1/2	•	•	•	•	•	•	
17/32	•	•	•	•	•	•	
9/16	•	•	•	•	•	•	
19/32	•	•	•	•	•	•	
5/8	•	•	•	•	•	•	
21/32	•	•	•	•	•	•	
11/16	•	•	•	•	•	•	
23/32	•	•	•	•	•	•	
3/4	•	•	•	•	•	•	
25/32	•	•	•	•	•	•	
13/16		•	•	•	•	•	
27/32		•	•	•	•	•	
7/8		•	•	•	•	•	
29/32		•				•	
15/16						•	
1						•	
1-1/32						•	
1-1/16						•	
1-3/32						•	
1-1/8						•	•
1-3/16							•

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STOCK ROUND PUNCHES

Sizes	142 PIB	152 PIB	162 PIB	272 PIB	282 PIB	292 PIB	412 PIB	522 PIB	702 PIB	712 PIB
3/16	•	•	•				•	•		
7/32	•	•	•				•	•		
1/4	•	•	•	•			•	•	•	
9/32	•	•	•	•			•	•	•	
5/16	•	•	•	•			•	•	•	
11/32	•	•	•	•			•	•	•	
3/8	•	•	•	•			•	•	•	
13/32	•	•	•	•			•	•	•	
7/16	•	•	•	•			•	•	•	
15/32	•	•	•	•			•	•		
1/2	•	•	•	•			•	•	•	
17/32	•	•	•	•			•	•	•	
9/16	•	•	•	•			•	•	•	•
19/32	•	•	•	•			•	•		
5/8	•	•	•	•			•	•	•	•
21/32	•	•		•			•	•	•	
11/16	•	•	•	•			•	•	•	
23/32	•	•		•			•	•		
3/4	•	•	•	•			•	•	•	•
25/32	•	•	•	•			•	•	•	
13/16	•	•	•	•			•	•	•	•
27/32	•	•		•			•	•		
7/8	•	•	•	•			•	•	•	•
29/32	•	•	•	•			•	•		
15/16	•	•	•	•			•	•	•	•
31/32	•	•	•	•			•	•		
1	•	•	•	•	•	•	•	•	•	
1-1/16	•	•	•	•	•	•	•	•	•	
1-1/8		•	•	•	•	•			•	
1-3/16		•	•	•	•	•			•	
1-1/4		•	•	•	•	•			•	
1-5/16			•		•	•				
1-3/8			•		•	•				
1-7/16			•		•	•				
1-1/2			•		•	•				
1-9/16						•				
1-5/8						•				
1-11/16						•				
1-3/4						•				

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STOCK ROUND DIES

Sizes	121 A3B	131 A3B	141 A3B	271 A3B A4B	271 B4B	271 D3B	281 A4B	281 B4B A3B	291 A3B	521 C3B	531 C3B	711 A3B
13/64	•	•								•	•	
7/32	•	•						•		•	•	
15/64	•	•								•	•	
1/4	•	•						•		•	•	
9/32	•	•		•	•	•		•		•	•	
5/16	•	•		•	•	•		•		•	•	
11/32	•	•		•	•	•		•		•	•	
3/8	•	•		•	•	•		•		•	•	
13/32	•	•		•	•	•		•		•	•	
7/16	•	•		•	•	•		•		•	•	
15/32	•	•		•	•	•		•		•	•	
1/2	•	•		•	•	•		•		•	•	
17/32	•	•		•	•	•		•		•	•	
9/16	•	•		•	•	•		•		•	•	
19/32	•	•		•	•	•		•		•	•	•
5/8	•	•		•	•	•		•		•	•	•
21/32	•	•		•	•	•		•		•	•	•
11/16	•	•		•	•	•		•		•	•	•
23/32	•	•		•	•	•		•		•	•	•
3/4	•	•	•	•	•	•		•		•	•	•
25/32	•	•	•	•	•	•		•		•	•	•
13/16	•	•	•	•	•	•		•		•	•	•
27/32	•	•	•	•	•	•		•		•	•	•
7/8	•	•	•	•	•	•		•		•	•	•
29/32	•	•	•	•	•	•		•		•	•	•
15/16	•	•	•	•	•	•		•		•	•	•
31/32	•	•	•	•	•	•		•		•	•	•
1	•	•	•	•	•	•		•		•	•	•
1-1/32	•	•	•	•	•	•	•	•	•	•	•	
1-1/16	•	•	•	•	•	•	•	•	•	•	•	
1-3/32	•	•		•			•	•	•	•	•	
1-1/8	•	•	•	•			•	•	•	•	•	
1-5/32		•							•			
1-3/16		•	•	•			•	•	•			
1-7/32		•							•			
1-1/4		•	•	•			•	•	•			
1-9/32		•	•	•					•			
1-5/16		•	•	•			•		•			
1-3/8							•		•			
1-7/16							•		•			
1-1/2							•		•			
1-9/16							•		•			
1-5/8									•			
1-11/16									•			
1-3/4									•			
1-13/16									•			

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STOCK OBROUND PUNCHES

Sizes	142 P1H	152 P1H	162 P1H	272 P2H	282 P2H	412 P1H	522 P1H
3/16 x 3/8	•	•				•	•
3/16 x 3/4	•	•				•	•
3/16 x 1	•	•				•	•
7/32 x 7/16	•	•				•	•
7/32 x 3/4	•	•				•	•
7/32 x 1	•	•				•	•
1/4 x 1/2	•	•				•	•
1/4 x 3/4	•	•				•	•
1/4 x 1	•	•		•		•	•
9/32 x 9/16	•	•				•	•
9/32 x 3/4	•	•				•	•
9/32 x 1	•	•				•	•
5/16 x 1/2	•	•				•	•
5/16 x 5/8	•	•				•	•
5/16 x 3/4	•	•				•	•
5/16 x 1	•	•	•	•		•	•
5/16 x 1-1/4		•	•				
11/32 x 11/16	•	•				•	•
11/32 x 1	•	•				•	•
3/8 x 1/2	•	•				•	•
3/8 x 3/4	•	•				•	•
3/8 x 1	•	•	•	•		•	•
13/32 x 13/16	•	•				•	•
13/32 x 1	•	•				•	•
13/32 x 1-1/4		•	•				
7/16 x 9/16	•	•				•	•
7/16 x 3/4	•	•				•	•
7/16 x 7/8	•	•				•	•
7/16 x 1	•	•	•	•		•	•
7/16 x 1-1/4		•	•	•			
7/16 x 1-1/2			•	•			
15/32 x 1	•	•				•	•
1/2 x 1	•	•	•	•		•	•
17/32 x 1	•	•	•			•	•
17/32 x 1-1/4		•	•				
17/32 x 1-1/2			•				
9/16 x 3/4	•	•	•			•	•

Sizes	142 P1H	152 P1H	162 P1H	272 P1H	282 P1H	412 P1H	522 P1H
9/16 x 1	•	•	•	•	•	•	•
9/16 x 1-1/16	•	•		•		•	•
9/16 x 1-1/4		•	•	•	•		
9/16 x 1-1/2			•		•		
5/8 x 1	•	•	•	•	•	•	•
5/8 x 1-1/4		•	•	•	•		
5/8 x 1-1/2			•		•		
11/16 x 1	•	•	•	•		•	•
11/16 x 1-1/16	•	•		•		•	•
11/16 X 1-1/8		•	•			•	
11/16 x 1-1/4		•	•	•	•		
11/16 x 1-1/2			•		•		
3/4 x 1	•	•	•	•	•	•	•
3/4 x 1-1/4		•	•	•	•		•
3/4 x 1-1/2			•		•		
13/16 x 1	•	•	•	•	•	•	•
13/16 x 1-1/16		•	•	•	•	•	•
13/16 x 1-1/8		•	•	•		•	
13/16 x 1-1/4				•	•	•	•
13/16 x 1-1/2			•		•		
13/16 x 1-3/4				•	•		
7/8 x 1-1/4		•	•				
7/8 x 1-1/2			•		•		
15/16 x 1-1/16		•		•			
15/16 x 1-1/8		•	•	•	•	•	
15/16 x 1-1/4		•	•	•	•		
15/16 x 1-1/2			•		•		
15/16 x 1-3/4							
1 x 1-1/4		•	•				
1 x 1-9/16			•				
1-1/16 x 1-9/16			•				

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STOCK OBROUND DIES

Sizes	121 A3H	131 A3H	271 A4H A3H	271 B3H	271 B4H	281 A4H A3H	281 B4H	521 C3H	531 C3H
7/32 x 13/32	•	•						•	•
7/32 x 25/32	•	•						•	•
7/32 x 1-1/32	•	•						•	•
1/4 x 15/32	•	•						•	•
1/4 x 25/32	•	•						•	•
1/4 x 1-1/32	•	•						•	•
9/32 x 17/32	•	•						•	•
9/32 x 25/32	•	•						•	•
9/32 x 1-1/32	•	•	•	•	•	•	•	•	•
5/16 x 19/32	•	•						•	•
5/16 x 25/32	•	•						•	•
5/16 x 1-1/32	•	•						•	•
11/32 x 17/32	•	•						•	•
11/32 x 21/32	•	•						•	•
11/32 x 25/32	•	•						•	•
11/32 x 1-1/32	•	•	•	•	•	•	•	•	•
11/32 x 1-9/32		•				•			
3/8 x 23/32	•							•	•
3/8 x 1-1/32	•	•						•	•
13/32 x 17/32	•	•						•	•
13/32 x 25/32	•	•						•	•
13/32 x 1-1/32	•	•	•	•	•	•	•	•	•
13/32 x 1-9/32		•							
7/16 x 27/32	•	•						•	•
7/16 x 1-1/32	•	•						•	•
7/16 x 1-9/32		•				•			
15/32 x 19/32	•	•						•	•
15/32 x 25/32	•	•						•	•
15/32 x 29/32	•	•						•	•
15/32 x 1-1/32	•	•	•	•	•	•	•	•	•
15/32 x 1-9/32		•	•			•	•		
15/32 x 1-17/32						•			
1/2 x 1-1/32	•	•						•	•
17/32 x 25/32	•	•						•	•
17/32 x 1-1/32	•	•	•	•	•	•	•	•	•
9/16 x 13/16	•	•						•	•
9/16 x 1-1/32	•	•						•	•
9/16 x 1-1/16	•	•				•		•	•
9/16 x 1-9/32		•				•	•		
9/16 x 1-17/32						•			
19/32 x 25/32	•	•						•	•
19/32 x 1-1/32	•	•	•	•	•	•	•	•	•
19/32 x 1-3/32	•							•	•
19/32 x 1-9/32		•	•			•			

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STOCK OBROUND DIES

Sizes	121 A3H	131 A3H	271 A4H A3H	271 B3H	271 B4H	281 A4H A3H	281 B4H	521 C3H	531 C3H
5/8 x 13/16	•	•						•	•
5/8 x 1-1/16	•	•	•	•	•	•	•	•	•
5/8 x 1-5/16		•	•			•	•		
5/8 x 1-9/16						•			
21/32 x 1-1/32	•	•	•	•	•	•	•	•	•
11/16 x 1-9/32									
11/16 x 1-1/16	•	•	•	•	•	•	•	•	•
11/16 x 1-5/16		•	•			•			
11/16 x 1-9/16						•			
23/32 x 1-1/32	•	•	•	•	•	•	•	•	•
23/32 x 1-3/32	•	•	•					•	•
23/32 x 1-5/32	•	•							
23/32 x 1-9/32		•	•			•			
3/4 x 1-1/16	•	•	•	•	•	•	•	•	•
3/4 x 1-5/16		•	•			•			
3/4 x 1-9/16						•			
25/32 x 1-1/32	•	•	•	•	•	•	•	•	•
25/32 x 1-9/32		•	•			•			
13/16 x 1-1/16	•	•	•	•	•	•	•	•	•
13/16 x 1-5/16		•	•			•			
13/16 x 1-9/16						•			
27/32 x 1-1/32	•	•	•	•	•	•	•	•	•
27/32 x 1-3/32	•							•	•
27/32 x 1-5/32	•	•	•			•		•	•
27/32 x 1-9/32		•	•			•			
7/8 x 1-1/16	•	•	•	•	•	•	•	•	•
7/8 x 1-1/8									
7/8 x 1-3/16			•			•			
7/8 x 1-5/16		•	•			•			
7/8 x 1-9/16						•			
29/32 x 1-9/32		•	•			•			
15/16 x 1-5/16		•	•			•			
15/16 x 1-9/16						•			
1 x 1-1/8									
31/32 x 1-9/32		•	•			•			
31/32 x 1-5/32	•	•							
1 x 1-3/16		•				•			
1 x1-5/16		•				•			
1-1/16 x 1-5/16		•							

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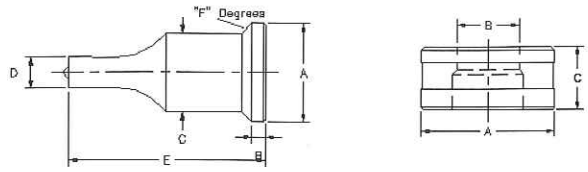
Punch & Die Dimensions

Punch & Die Dimensions



Punch Style	A	B	C	D	E	F
142	1 5/32	13/64	1 1/32	1 1/16	1 15/16	30°
152	1 3/8	11/64	1 7/32	1 1/4	2 3/8	30°
162	1 11/16	11/64	1 17/32	1 9/16	2 11/16	30°
272	1 9/16	7/32	1 1/4	1 1/4	3 1/8	45°
282	1 3/4	7/32	1 1/2	1 1/2	3 1/8	45°
292	2	7/32	1 3/4	1 3/4	3 1/8	45°
412	1 1/4	1/4	1 1/16	1 1/8	2 1/8	30°
522	1 1/4	1/8	1 1/16	1 1/8	2	45°

Die Style	A	B	C
121	1 13/16	1 1/8	1 1/8
131	2	1 3/8	1
141	2 1/2	1 5/8	1 1/4
271	2 1/8	1 9/16	1
281	2 3/8	1 9/16	1 1/4
291	2 1/2	1 13/16	1
521	2	1 1/8	1 1/8
531	2 3/8	1 1/8	1 1/4

Conversion Chart for Punches and Dies

Peddimat Systems and Portable Punch Tooling

Peddinghaus Corporation	American Punch	Cleveland Steel Tool	Cleveland Punch & Die	Marchant Corporation
Punches	Punches			
272P1-	164	64	C-770	124
282P1-	165	65	282	125
292P1-	168		292	
Dies	Dies			
271A	347	47	C-740	132
281A	319	419	62	85
291A	391		291	

Steelworkers and Single End Punches

Peddinghaus Corporation	American Punch	Cleveland Steel Tool	Cleveland Punch & Die	Marchant Corporation
Punches	Punches			
142P1	116	216	12	34
152P1	121	221	20	40
162P1	128	228	26	45
412P1	119	219	16	37
522P1-	6640	P66	664	56
Dies	Dies			
121A	313	413	55	81
131A	317	417	59	82
141A	320	420	65	86
521A	1400	D14	201	99
531A	6650	D66	202	100

SELECT THE RIGHT TONNAGE FOR YOUR WORK

USE OF TONNAGE CHART - To punch metal with a different strength than 60,000 PSI (shear strength), use multipliers to calculate the tonnage required for a given hole size.

EXAMPLE: To punch a 15/16" diameter hole through 3/4", ASTM-A36, 60,000 PSI (shear strength), the tonnage required is 66.3 tons. The multiplier for 50 carbon steel then would be 1.17 X 66.3 = 77.57 tons to punch the tougher steel.

MULTIPLIER CHART

Material	Shear Strength Per Sq. In.	Multiplier
Structural ASTM-A7	50,000 p.s.i.	.83
Firebox Steel & Boilerplate	55,000 p.s.i.	.92
ASTM-A36	60,000 p.s.i.	.96
ASTM-A572 Grade 50	60,000 p.s.i.	1.00
Cor-Ten ASTM-A242	66,000 p.s.i.	1.10
Steel, 50 Carbon	70,000 p.s.i.	1.17
Structural T-1	90,000 p.s.i.	1.50

TONS PRESSURE REQUIRED TO PUNCH A572 GRADE 50 STRUCTURAL STEEL

Hole Diameter in Inches

Metal Gage	Thickness (in.)	1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	13/16	7/8	15/16	1	1 1/16	1 1/8	1 3/16	1 1/4	1 5/16	1 3/8	1 7/16	1 1/2
1/8 or 11	0.120	1.4	2.1	2.8	3.5	4.2	4.9	5.7	6.4	7.1	7.8	8.5	9.2	9.9	10.6	11.3	12.0	12.7	13.4	14.1	14.8	15.6	16.3	17.0
10	0.135	1.6	2.4	3.2	4.0	4.8	5.6	6.4	7.2	7.9	8.7	9.5	10.3	11.1	12.0	12.7	13.5	14.3	15.1	15.9	16.7	17.5	18.3	19.1
3/16	0.187	2.2	3.3	4.4	5.5	6.6	7.7	8.8	9.9	11.0	12.1	13.2	14.3	15.4	16.5	17.6	18.7	19.8	20.9	22.0	23.1	24.2	25.4	26.4
1/4	0.250	2.9	4.4	5.9	7.4	8.8	10.3	11.8	13.2	14.7	16.2	17.7	19.1	20.6	22.1	23.6	25.0	26.5	28.0	29.5	30.9	32.4	33.9	35.3
5/16	0.312		5.5	7.3	9.2	11.0	12.9	14.7	16.5	18.4	20.2	22.1	24.0	25.7	27.6	29.4	31.3	33.0	34.9	36.8	38.6	40.4	42.3	44.1
3/8	0.375			8.8	11.0	13.3	15.5	17.7	19.9	22.1	24.3	26.5	28.7	31.0	33.1	35.3	37.6	39.7	42.0	44.2	46.3	48.6	50.8	53.0
1/2	0.500					17.7	20.6	23.6	26.5	29.4	32.4	35.3	38.3	41.2	44.2	47.1	50.0	52.9	55.9	58.9	61.8	64.8	67.8	70.6
5/8	0.625							29.5	33.1	37.0	40.5	44.2	48.0	51.5	55.2	59.0	62.6	66.2	69.9	73.7	77.2	81.0	84.7	88.3
3/4	0.750									44.2	48.6	53.0	57.4	62.0	66.3	70.7	75.0	79.4	83.9	88.4	92.7	97.2	101.7	106.0
7/8	0.875											62.0	67.0	72.2	77.3	82.5	87.7	92.7	97.9	103.2	108.1	113.4	118.6	123.6
1	1.00												76.6	82.5	88.3	94.3	100.0	106.0	111.9	117.9	123.6	129.6	135.6	141.3
1 1/8	1.125														99.4	106.0	113.0	119.0	125.9	132.6	139.0	145.8	152.5	159.0

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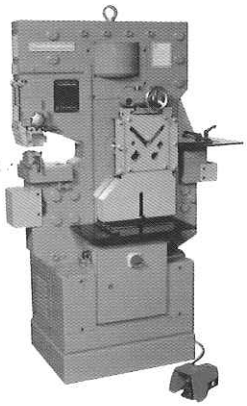

Peddiworker 1050

Hydraulic 110/20
Single End Punch

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Peddinghaus Corporation, Tool Div.
Innovative Steel Fabricating Technologies

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Peddinghaus Corporation
300 North Washington Ave.
Bradley, IL 60915
USA
Phone - (1) 815-937-3800
Fax - (1) 815-937-4003

Peddinghaus Corp. U.K. Ltd.
Unit 6
Queensway Link Industrial Estate
Strafford Park 17
Telford TF3 3DN
UK
Tel: - 10952-200-377
Fax - 10952-292-877

Peddinghaus Anlagen & Maschinen GmbH
Postfach 1820
D-58262 Gevelsberg
Germany
Phone - (49) 2332-13916
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