



Ultra Light™ Precision Stripping System

for Use on Thin or Decorative Materials

PRECISION CONTROL OF STRIPPING FORCE FOR HIGH QUALITY PRECISION PUNCHING...

- Reduce spring pressure to eliminate unwanted sheet marking! Designed for thin or decorative materials!
- Perfect for high polish, textured, pre-painted or reflective metals where finish appearance is critical!
- Quieter punching in all applications! Reduce noise levels by as much as 10 decibels!
- Maximum control over total spring pressure! Combine two spring sets for nine pressure variations!

1/2" A STATION

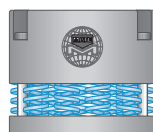


ULTRA LIGHT
SPRING CANISTER
ULTRA® STYLE
MATE00276

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



ULTRA LIGHT
SPRING CANISTER
METRIC STYLE
MATE00278



ULTRA LIGHT
SPRING
ASSEMBLY
MATE00038

MATE00038 is assembled with 9 medium pressure blue springs

2" C STATION



(package of 9)
HEAVY
PRESSURE
GOLD SPRINGS
MATE00280

Ultra Light stripping force spring combinations compared to disc spring stack (%)

3 Blue	4%
6 Blue	7%
9 Blue	10%
3 Gold	12%
3 Blue + 3 Gold	15%
6 Blue + 3 Gold	19%
6 Gold	24%
3 Blue + 6 Gold	27%
9 Gold	36%

Chart 1

1 1/4" B STATION

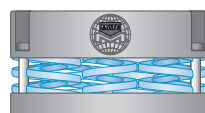


ULTRA LIGHT
SPRING CANISTER
ULTRA® STYLE
MATE00277

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



ULTRA LIGHT
SPRING CANISTER
METRIC STYLE
MATE00279



ULTRA LIGHT
SPRING
ASSEMBLY
MATE00033

MATE00033 is assembled with 9 medium pressure blue springs

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



(package of 9)
MEDIUM HEAVY
PRESSURE
RED SPRINGS
MATE00281

Ultra Light stripping force spring combinations compared to disc spring stack (%)

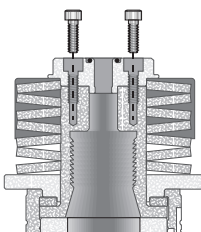
3 Blue	5%
6 Blue	10%
3 Red	11%
9 Blue	15%
3 Blue + 3 Red	16%
6 Blue + 3 Red	21%
6 Red	22%
3 Blue + 6 Red	27%
9 Red	33%

Chart 2

INSTRUCTIONS FOR 2" C, 3 1/2" D AND 4 1/2" E STATION

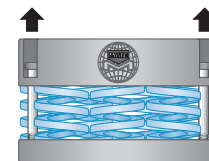
To disassemble the holder to access the springs:

1. Use metric hex key (see chart) to loosen the four head bolts that hold the punch head onto the guide assembly.
2. Loosen each bolt 1/4 turn at a time, alternately loosening bolts symmetrically. Doing this allows a slow expansion of the springs until there is no preload pressure. The bolts will have some thread engagement when the springs are not preloaded. Failure to remove bolts in this manner may cause injury.
3. The punch head can now be removed.
4. Remove existing disc spring stack.
5. Clean guide surfaces.
6. Place the Ultra Light Spring Assembly onto the guide.
7. Reinstall the punch head.
8. Reinstall and tighten the head bolts. It is recommended to use a drop of Loctite 242 on each bolt and tighten to specific torque setting. (see chart)



To change springs in the Ultra Light Spring Assembly:

1. Place the Ultra Light spring Assembly in a vise and tighten slightly to relieve spring pressure.
2. Use 3mm hex key to loosen the three M5 shoulder bolts that hold the Ultra Light Spring Assembly together.
3. Loosen each bolt 1/4 turn at a time. Doing this allows a slow expansion of the springs until there is no preload pressure. The bolts will have some thread engagement when the springs are not preloaded.
4. Remove the upper portion of the Ultra Light Spring Assembly.
5. Modify the spring configuration symmetrically using any option listed on Chart 1 for 2" C station or Chart 2 for 3 1/2" D and 4 1/2" E station.
6. Replace the upper portion of the Ultra Light Spring Assembly.
7. Reinstall and tighten the shoulder bolts to 62 inch lbs (6.9 Nm) of torque. It is recommended to use a drop of Loctite 242 on each bolt before tightening.



Station	Hex Key	Head Bolt	Torque Nm	Torque inch lbs
2" C station head bolt	5mm	6mm	19	170
3 1/2" D station head bolt	6mm	8mm	45	410
4 1/2" E station head bolt	6mm	8mm	45	410

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