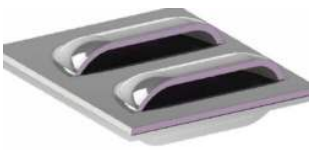
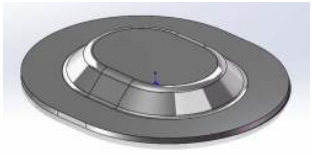
VORMTOEPASSINGEN

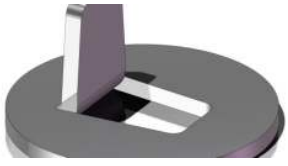
MATE PRECISION TECHNOLOGIES

RESPECT • SUPPORT • INSPIRE









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HPT HOLLAND PRECISION TOOLING

COUNTERSINK

☐ FORM UP ☐ FORM DOWN

MATERIAL TYPE	THICKNESS	MAXIMUM DEPTH
MILD STEEL	≥.047 (1,2) TO< .121 (3,1)	85%
	≥.121 (3,1) TO< .197 (5,0)	60%
	.197≥(5,0)	50%
ALUMINUM	≥.047 (1,2)	85%
STAINLESS STEEL	≥.047 (1,2) TO< .077(2,0)	85%
	≥.077(2,0) TO < .188(3,0)	60%
	.118≥(3,0)	50%

FOR COUNTERSINKS MORE THAN 85% DEPTH MATE RECOMMENDS PILOT NOSE STYLE.

GENERAL INFORMATION

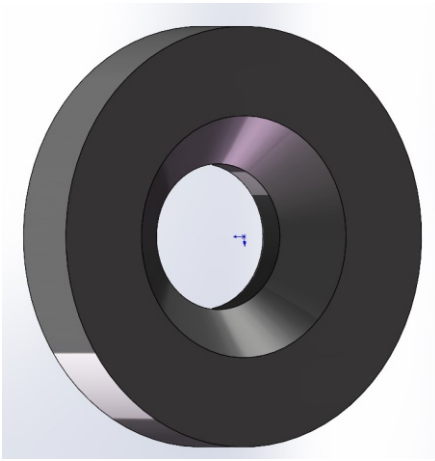
MATERIAL TYPE _____
MATERIAL THICKNESS _____
MACHINE TYPE _____
TOOLING STYLE _____

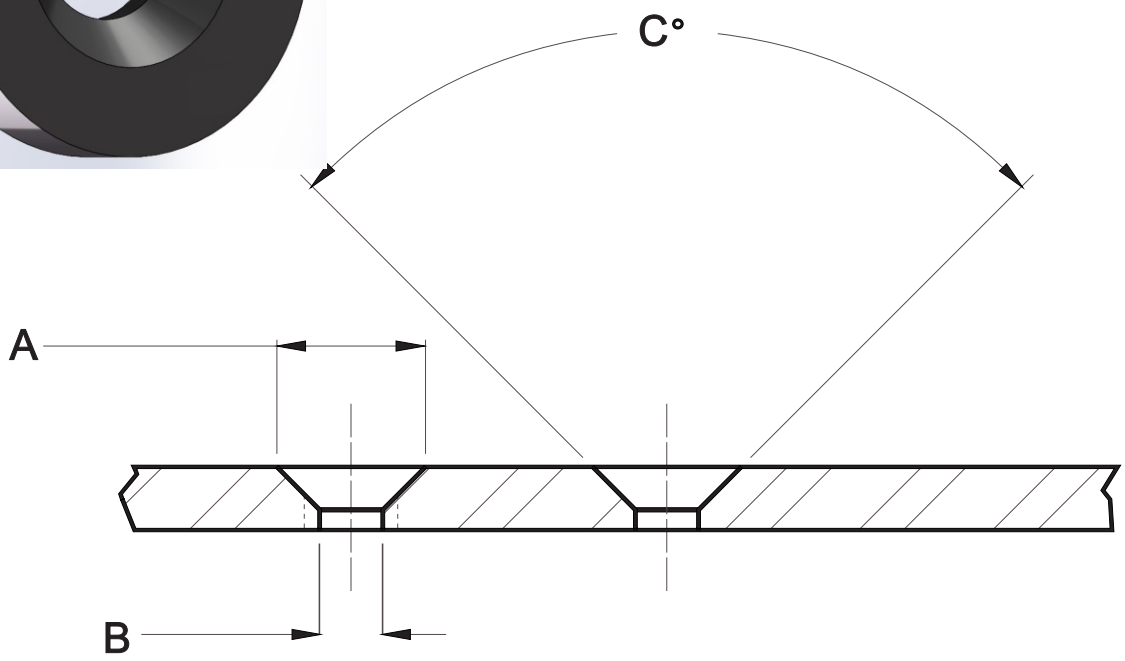
TOOL INFORMATION

SCREW SIZE IF KNOWN _____
A _____
B _____
C° _____

☐ **CHECK BOX IF YOU WOULD LIKE MATE TO DETERMINE PRE PIERCE

IF SCREW SIZE IS KNOWN THEN SKIP OTHER DIMS. KNOWING THE SCREW SIZE ALLOWS MATE TO USE INDUSTRY STANDARDS FOR BEST OUTCOME.





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ROUND EXTRUSION

☐ FORM UP ☐ FORM DOWN

COMMON SCREW THREAD EXTRUSIONS

SIZE	EXTRUSION I.D. CUT THREAD	EXTRUSION I.D. ROLLED THREAD	MAX. MAT'L
M3	2.5 (.098)	2.7 (.108)	1.5 (.060)
M4	3.3 (.130)	3.7 (.146)	1.9 (.075)
M5	4.2 (.165)	4.6 (.183)	2.3 (.090)
M6	5.0 (.197)	5.5 (.216)	2.7 (.105)
M8	6.8 (.266)	7.4 (.293)	2.7 (.105)
M10	8.5 (.334)	9.4 (.369)	2.7 (.105)
#4-40	.089 (2.3)	.100 (2.5)	.048 (1.2)
#5-40	.100 (2.5)	.112 (2.8)	.060 (1.5)
#6-32	.107 (2.7)	.120 (3.0)	.075 (1.9)
#8-32	.136 (3.5)	.150 (3.8)	.075 (1.9)
#10-24	.150 (3.8)	.167 (4.2)	.090 (2.3)
#10-32	.159 (4.0)	.174 (4.4)	.090 (2.3)
#12-24	.173 (4.4)	.194 (4.9)	.090 (2.3)
1/4 - 20	.201 (5.1)	.219 (5.6)	.105 (2.7)
1/4 - 28	.218 (5.5)	.235 (6.0)	.105 (2.7)
5/16 - 18	.257 (6.5)	.275 (7.0)	.105 (2.7)
5/16 - 24	.272 (6.9)	.288 (7.3)	.105 (2.7)
3/8 - 16	.312 (7.9)	.343 (8.7)	.105 (2.7)
3/8 - 24	.332 (8.4)	.343 (8.7)	.105 (2.7)

GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

MACHINE TYPE _____

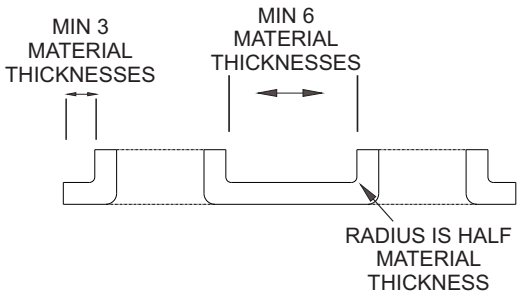
TOOLING STYLE _____

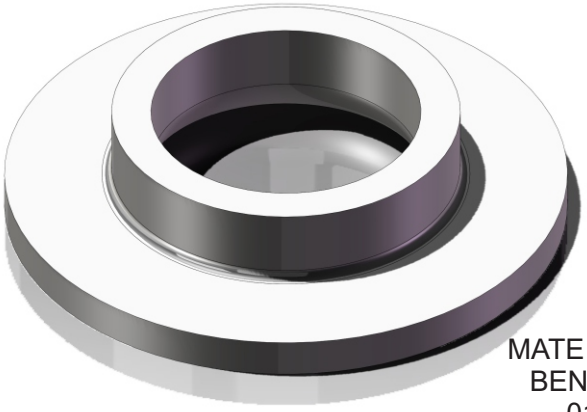
TOOL INFORMATION

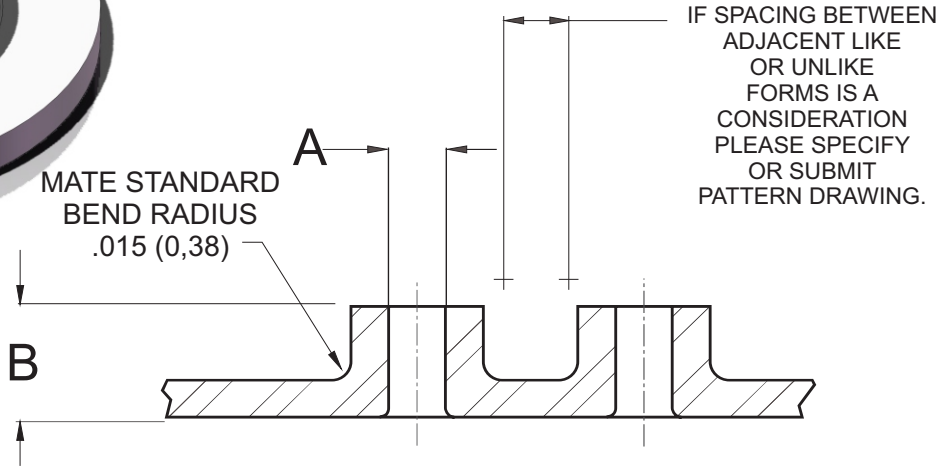
A _____

B _____

☐ **CHECK BOX IF YOU WOULD LIKE MATE TO DETERMINE PRE PIERCE







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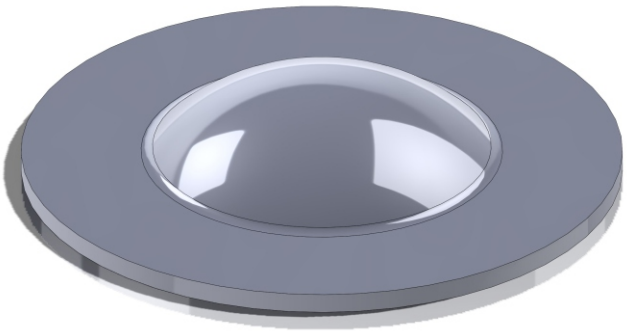
DIMPLE EMBOSS

☐ FORM UP ☐ FORM DOWN



FILL IN CRITICAL DIMENSIONS ONLY

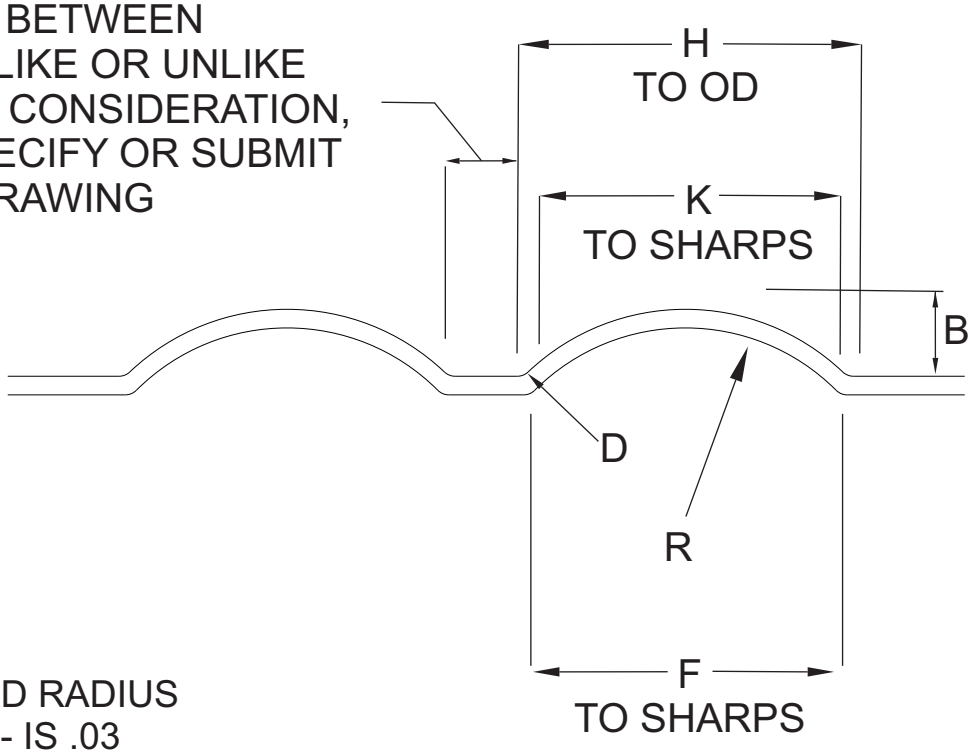
GENERAL INFORMATION

MATERIAL TYPE _____
MATERIAL THICKNESS _____
MACHINE TYPE _____
TOOLING STYLE _____

TOOL INFORMATION

B _____
D _____
F _____
H _____
K _____
R _____

IF SPACING BETWEEN ADJACENT LIKE OR UNLIKE FORMS IS A CONSIDERATION, PLEASE SPECIFY OR SUBMIT PATTERN DRAWING



MATE'S STANDARD RADIUS -DIMENSION D- IS .03

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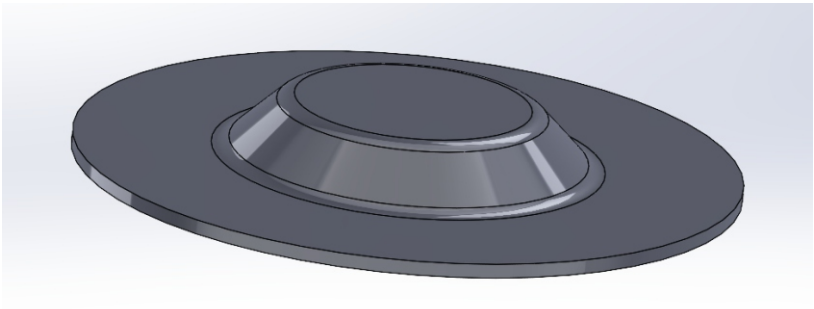
ROUND EMBOSS

☐ FORM UP ☐ FORM DOWN



FILL IN CRITICAL DIMENSIONS ONLY

GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

MACHINE TYPE _____

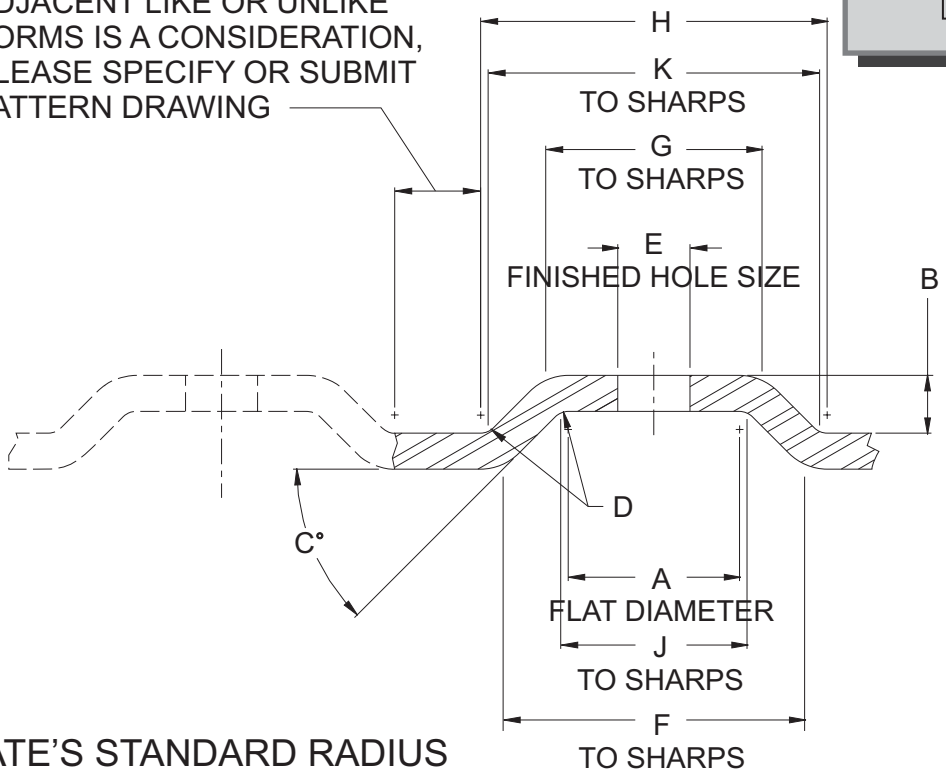
TOOLING STYLE _____

TOOL INFORMATION

B _____
D _____
F _____
H _____
K _____
C _____
G _____
J _____
E** _____

☐ **CHECK BOX IF YOU WOULD LIKE MATE TO DETERMINE PRE PIERCE

IF SPACING BETWEEN ADJACENT LIKE OR UNLIKE FORMS IS A CONSIDERATION, PLEASE SPECIFY OR SUBMIT PATTERN DRAWING



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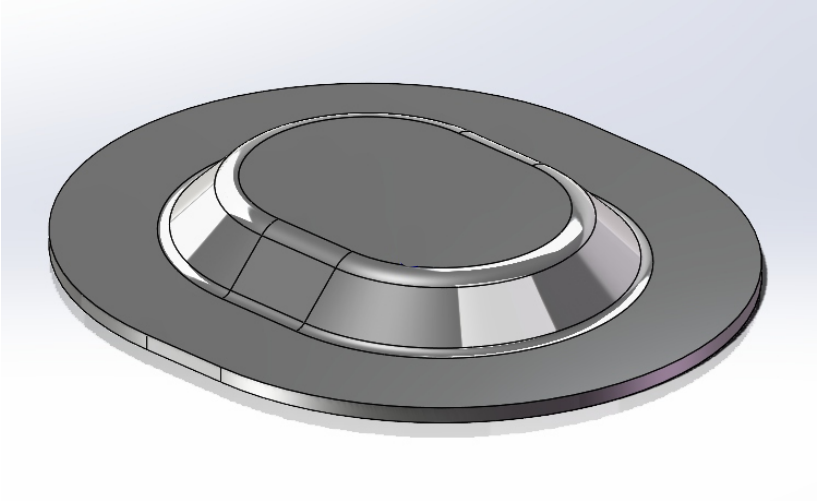
SHAPE EMBOSS

☐ FORM UP ☐ FORM DOWN



FILL IN CRITICAL DIMENSIONS ONLY

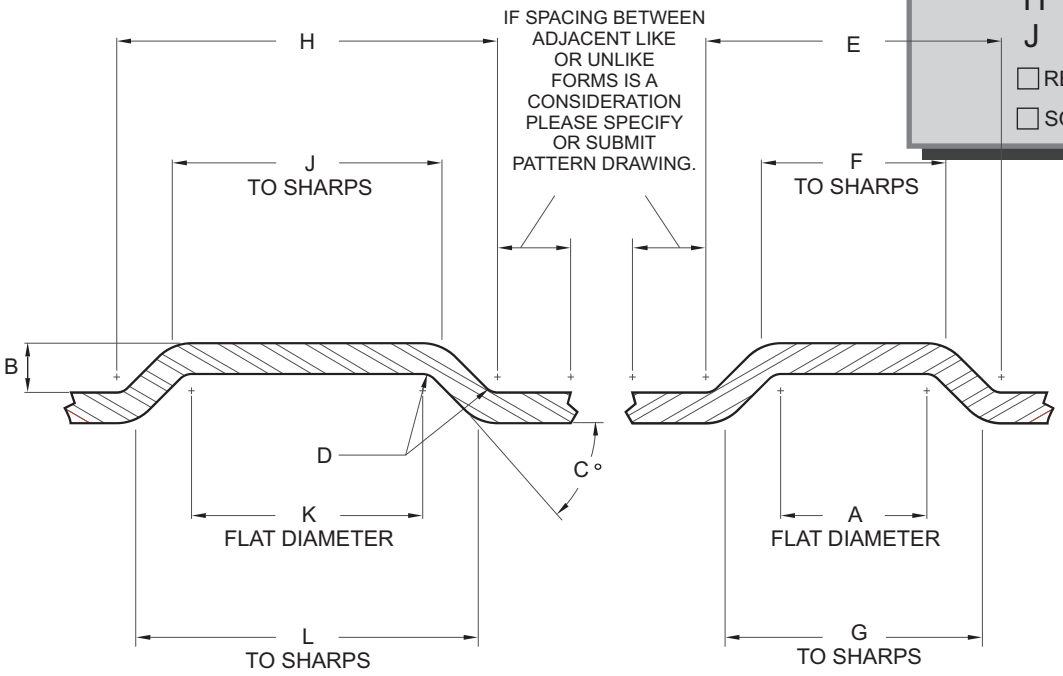
GENERAL INFORMATION

MATERIAL TYPE _____
MATERIAL THICKNESS _____
MACHINE TYPE _____
TOOLING STYLE _____

TOOL INFORMATION

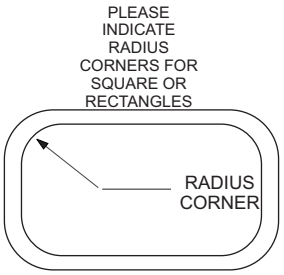
A _____
B _____
C° _____
D _____
E _____
F _____
G _____
H _____
J _____

☐ RECTANGLE ☐ OBROUND
☐ SQUARE ☐ OTHER



FRONT VIEW

SIDE VIEW



TOP VIEW

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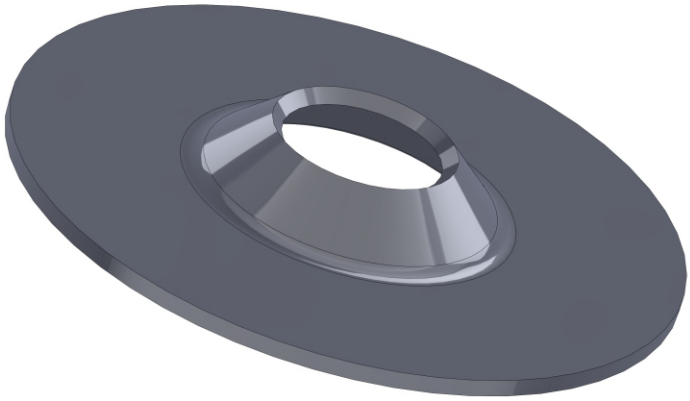
COUNTERSINK EMBOSS

☐ FORM UP ☐ FORM DOWN



FILL IN CRITICAL DIMS ONLY

GENERAL INFORMATION

MATERIAL TYPE _____
MATERIAL THICKNESS _____
MACHINE TYPE _____
TOOLING STYLE _____

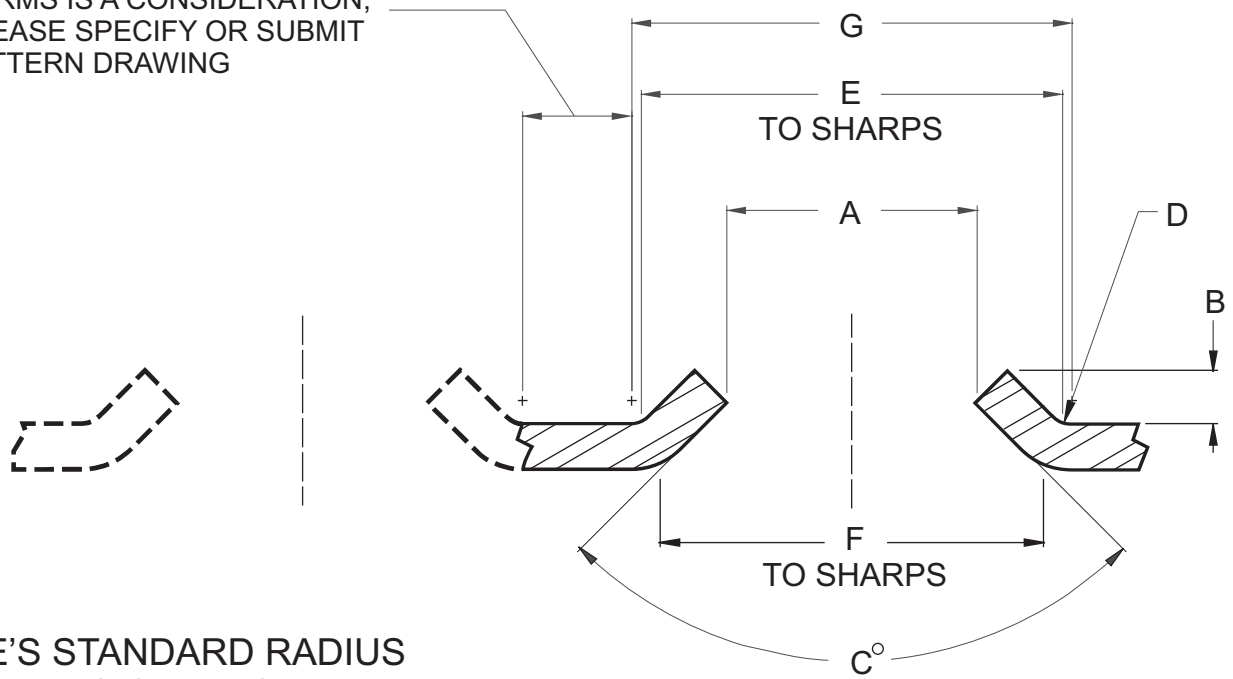
TOOL INFORMATION

A _____
B _____
C° _____
D _____
E _____
F _____
G _____

☐ **CHECK BOX IF YOU WOULD LIKE MATE TO DETERMINE PRE PIERCE

IF SPACING BETWEEN ADJACENT LIKE OR UNLIKE FORMS IS A CONSIDERATION, PLEASE SPECIFY OR SUBMIT PATTERN DRAWING

ONLY 3 DIMENSIONS REQUIRED



MATE'S STANDARD RADIUS -DIMENSION D- IS .030

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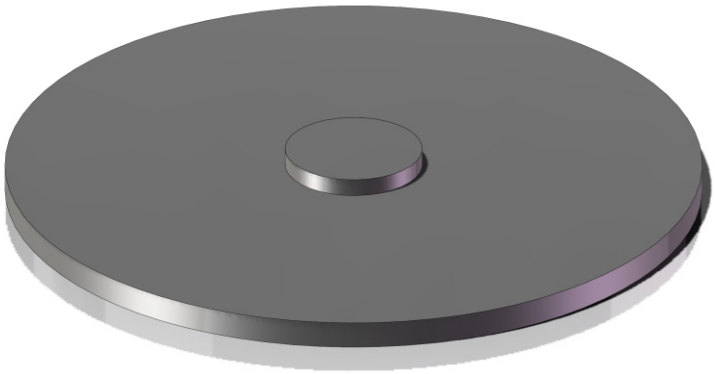
SHEAR BUTTON

☐ FORM UP ☐ FORM DOWN



GENERAL INFORMATION

MATERIAL TYPE _____

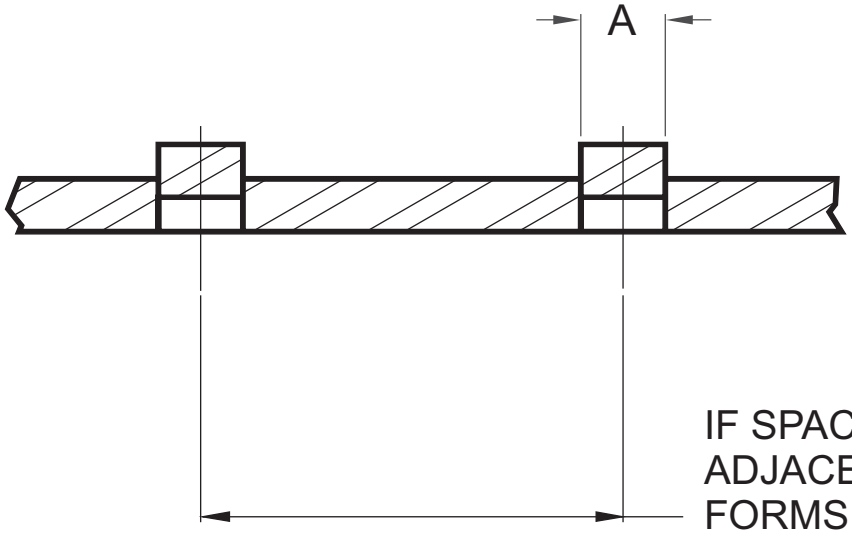
MATERIAL THICKNESS _____

MACHINE TYPE _____

TOOLING STYLE _____

TOOL INFORMATION

A _____



IF SPACING BETWEEN ADJACENT LIKE OR UNLIKE FORMS IS A CONSIDERATION, PLEASE SPECIFY OR SUBMIT PATTERN DRAWING

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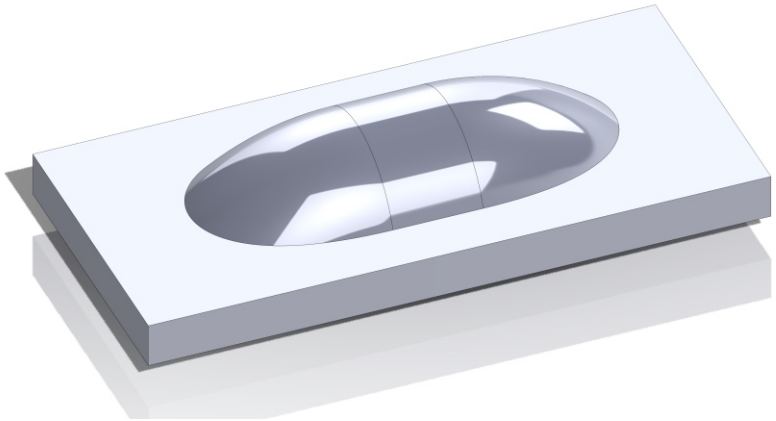
CONTINUOUS BEAD

☐ FORM UP ☐ FORM DOWN



FILL IN CRITICAL DIMENSIONS ONLY

GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

MACHINE TYPE _____

TOOLING STYLE _____

TOOL INFORMATION

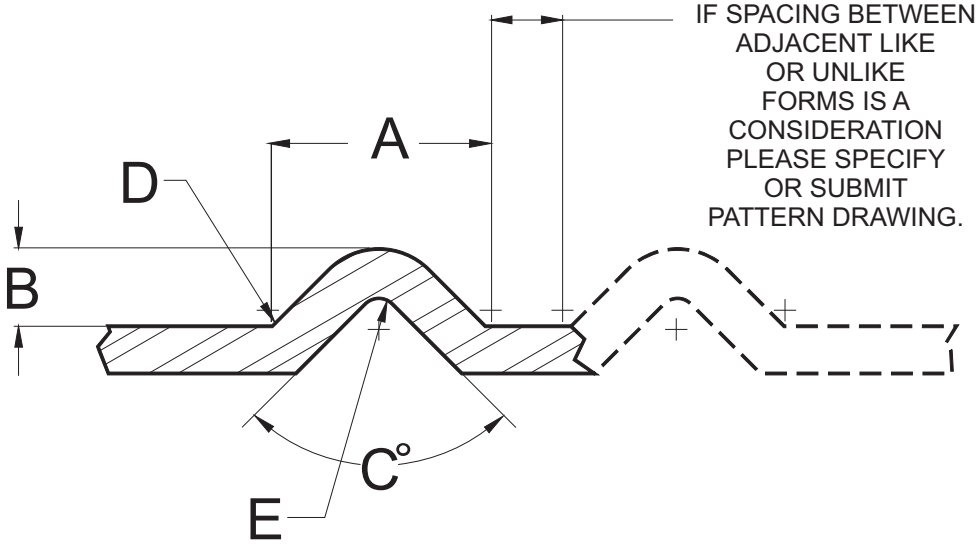
A _____

B _____

C° _____

D _____

E _____



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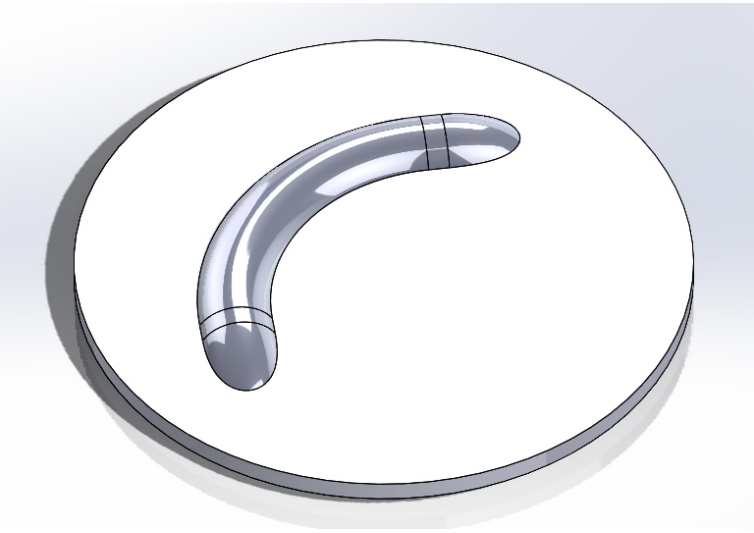
CONTINUOUS CURVED BEAD

☐ FORM UP ☐ FORM DOWN



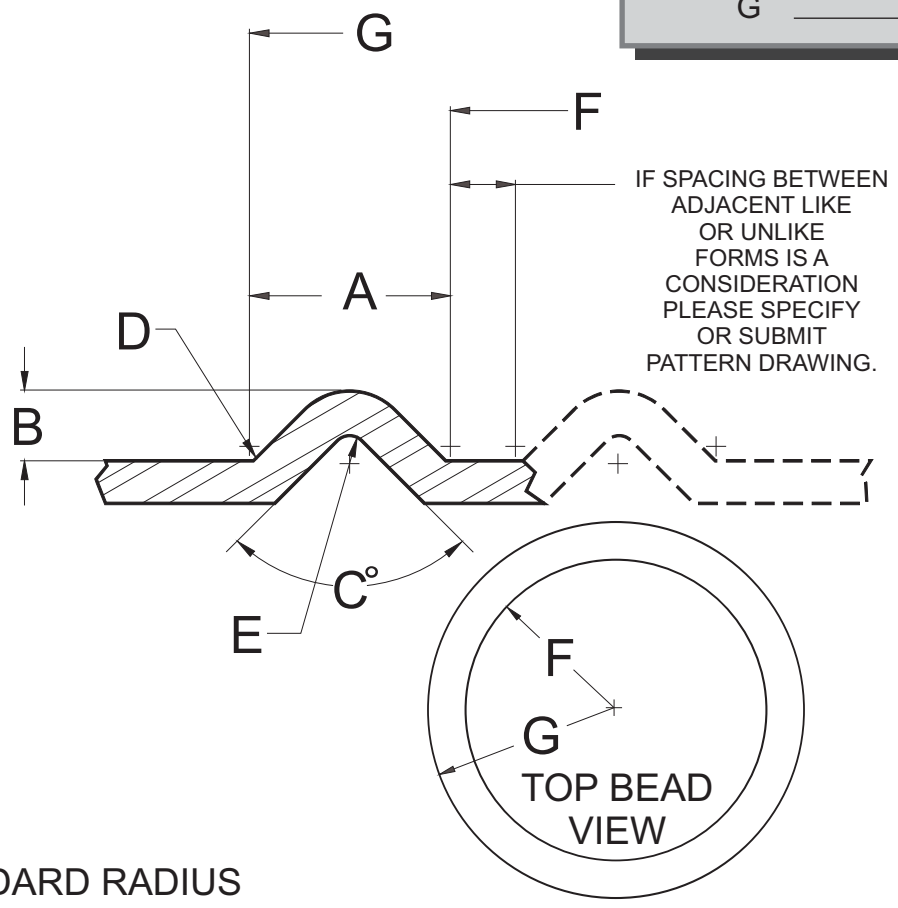
FILL IN CRITICAL DIMS ONLY

GENERAL INFORMATION

MATERIAL TYPE _____
MATERIAL THICKNESS _____
MACHINE TYPE _____
TOOLING STYLE _____

TOOL INFORMATION

A _____
B _____
C° _____
D _____
E _____
F _____
G _____



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-DIMENSION D- IS .03.

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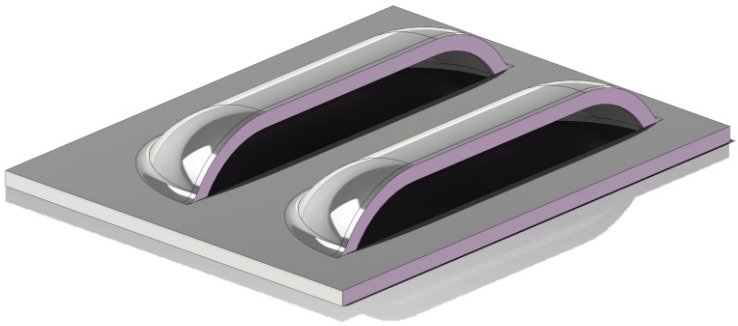
LOUVER RADIUS BACK



GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

MACHINE TYPE _____

TOOLING STYLE _____

TOOL INFORMATION

A _____

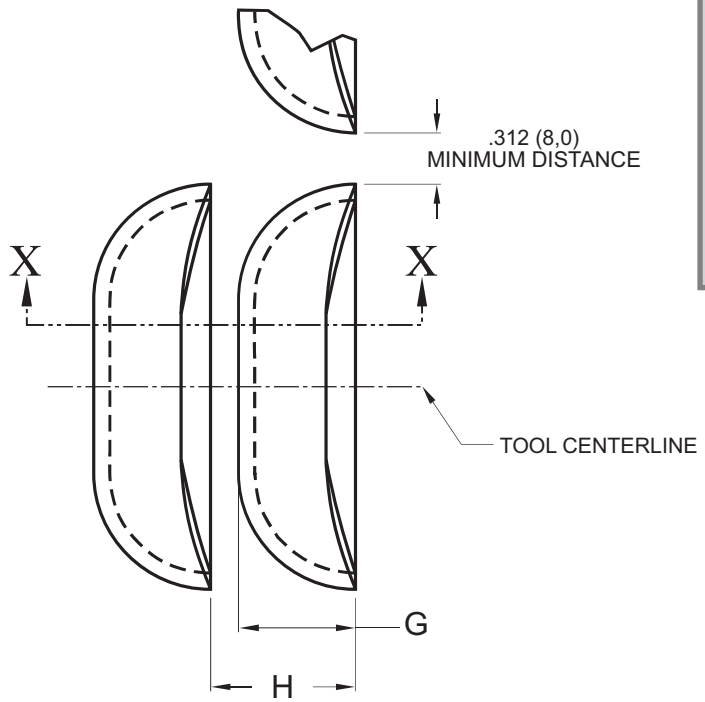
B _____

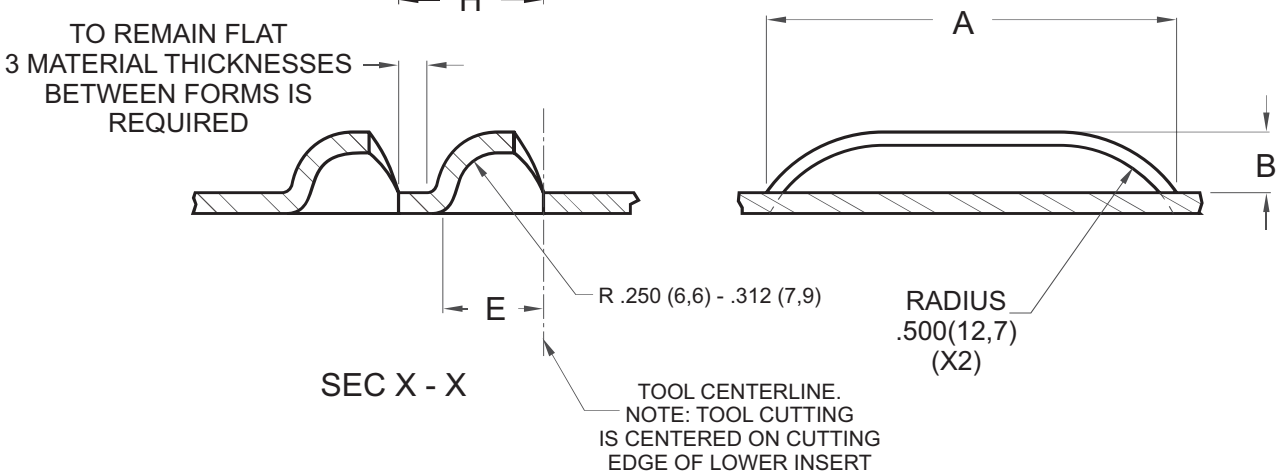
E _____

G _____

H _____

MATE'S STANDARD BEND RADIUS ON THE BACKSIDE OF THE LOUVER IS .03.





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LOUVER OPEN END

GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

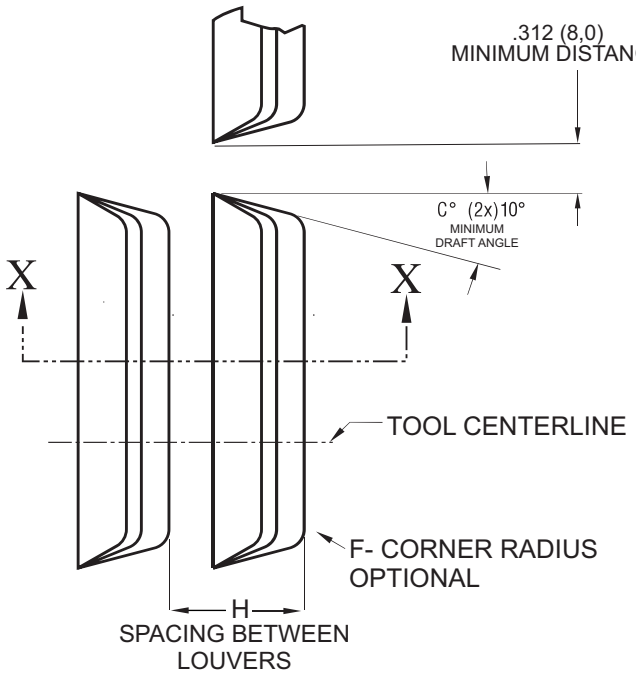
MACHINE TYPE _____

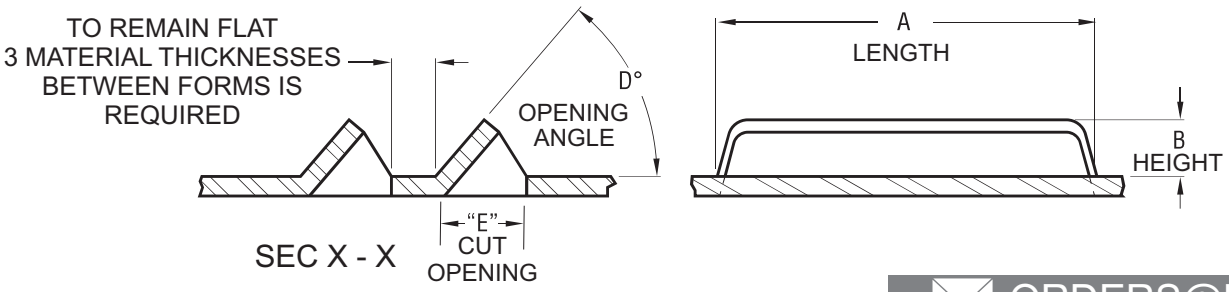
TOOLING STYLE _____

TOOL INFORMATION

A _____
B _____
C° _____
D° _____
E _____
F _____

MATE'S STANDARD BEND RADIUS ON THE BACKSIDE OF THE LOUVER IS .03. STANDARD CORNER RADIUS IS .03.





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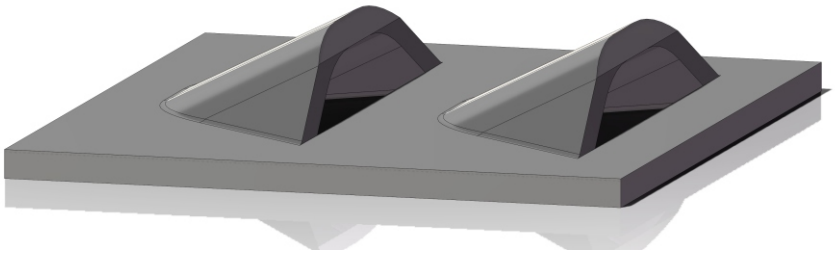
CONTINUOUS LOUVER



GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

MACHINE TYPE _____

TOOLING STYLE _____

TOOL INFORMATION

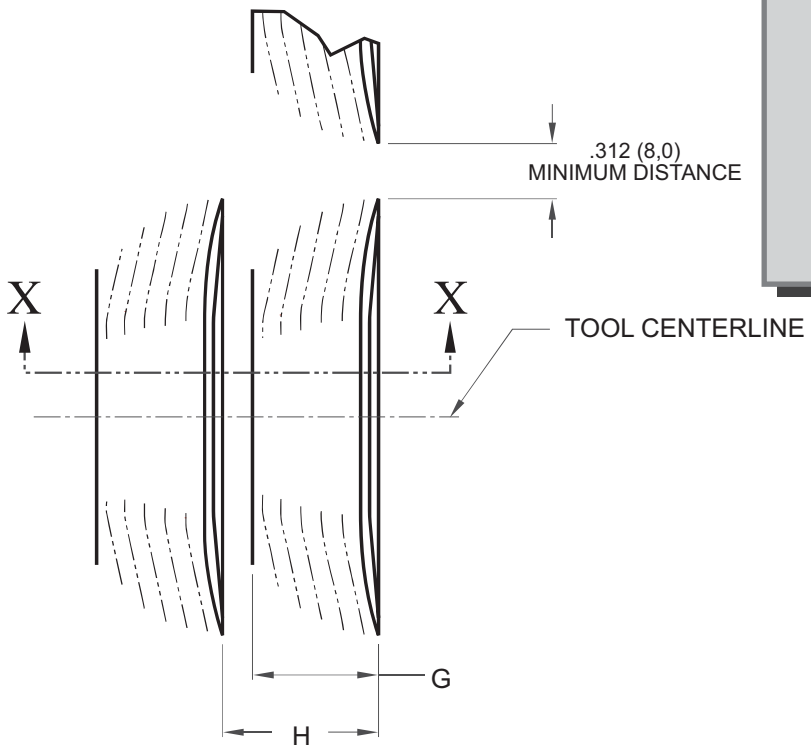
B _____

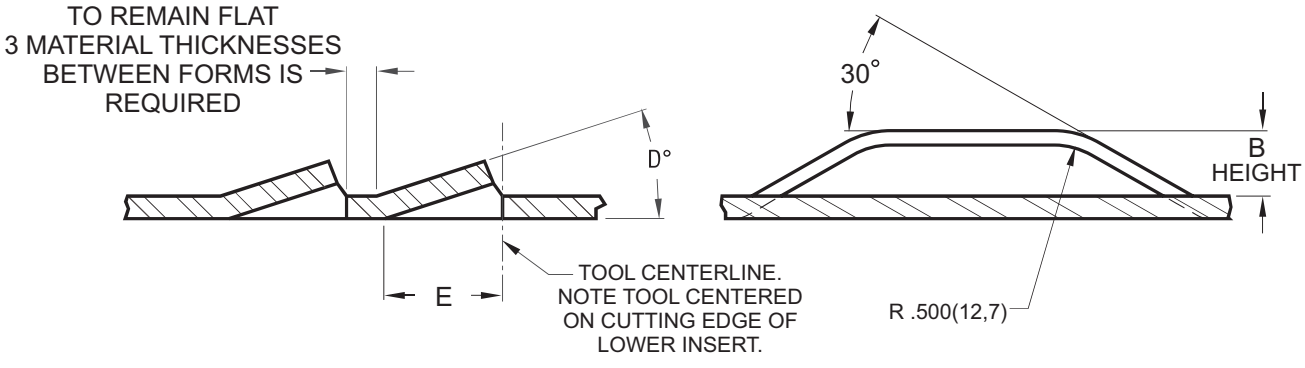
D° _____

E _____

G _____

H _____





SEC X - X

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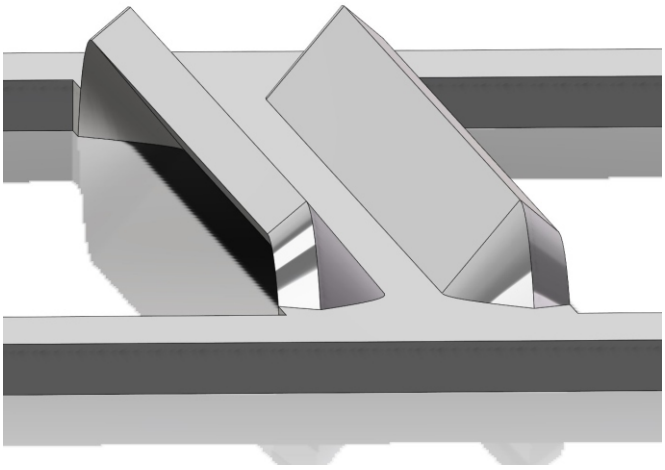
CARD GUIDE

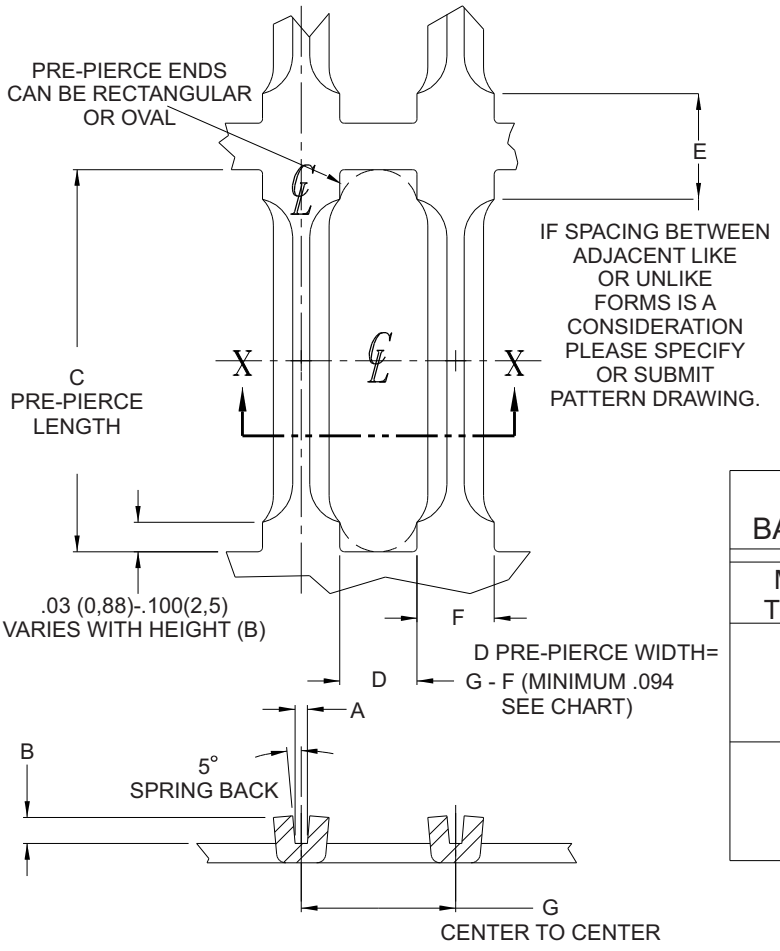
GENERAL INFORMATION

MATERIAL TYPE _____
MATERIAL THICKNESS _____
MACHINE TYPE _____
TOOLING STYLE _____

TOOL INFORMATION

A _____
B _____
C° _____
D _____
E _____
F _____
G _____





SECTION X-X

RECOMMENDED PRE-PIERCE TABLE
BASED ON .076 (1,91) CARD GUIDE WIDTH

MATERIAL THICKNESS	B	F
.059 (1,5)	.080 (2,0) .090 (2,3) .100 (2,5) .125 (3,2)	.284 (7,2) .304 (7,7) .324 (8,2) .374 (9,5)
.048 (1,2)	.080 (2,0) .090 (2,3) .100 (2,5) .125 (3,2)	.274 (7,0) .294 (7,5) .314 (8,0) .364 (9,2)

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REV B 7/25/2025

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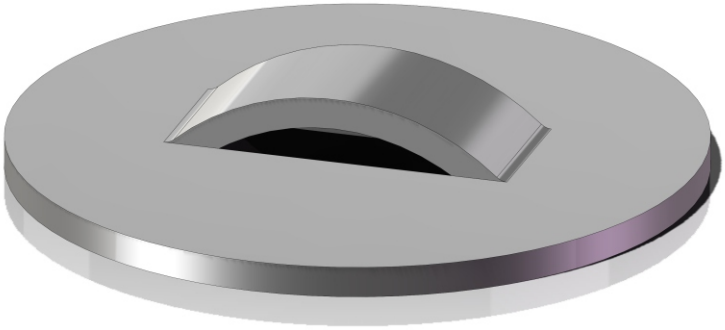
SINGLE BRIDGE/SPRING CLAMP

☐ FORM UP ☐ FORM DOWN



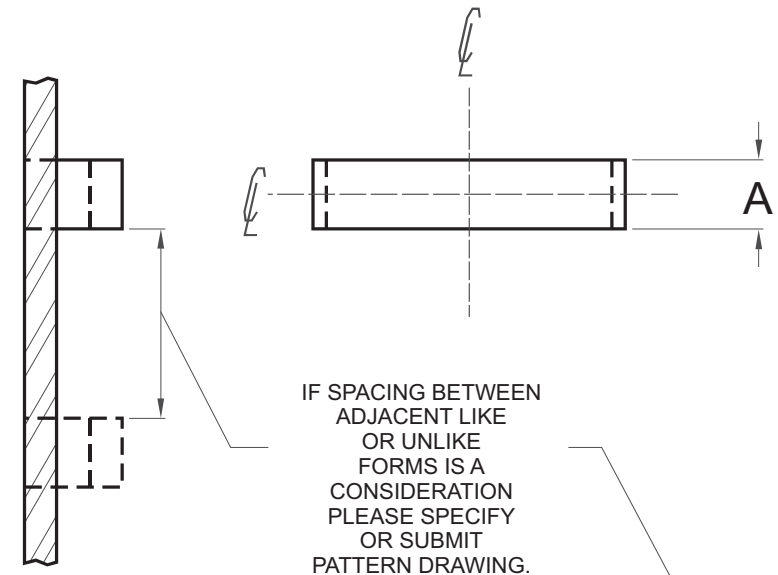
GENERAL INFORMATION

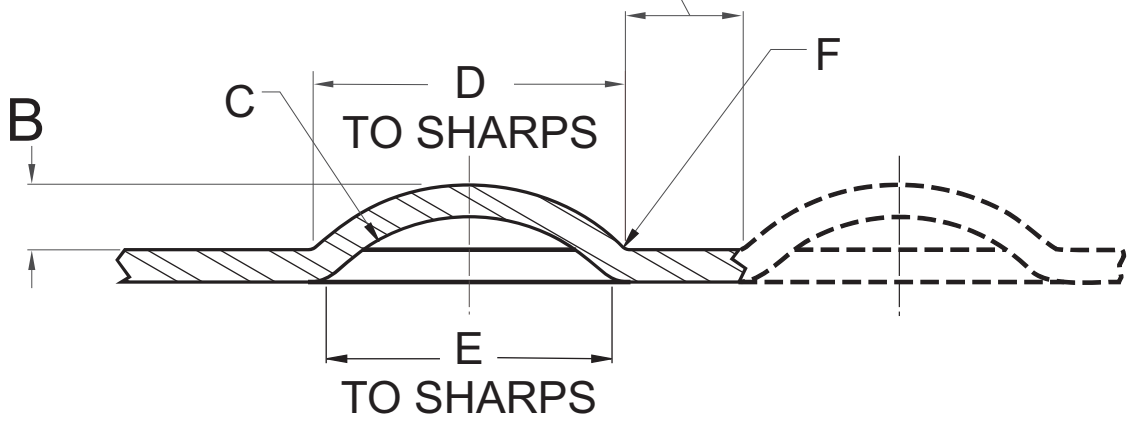
MATERIAL TYPE _____
MATERIAL THICKNESS _____
MACHINE TYPE _____
TOOLING STYLE _____

TOOL INFORMATION

A _____
B _____
C _____
D _____
E _____
F _____

FILL IN CRITICAL DIMS ONLY





MATE'S STANDARD RADIUS -DIMENSION F- IS .03.

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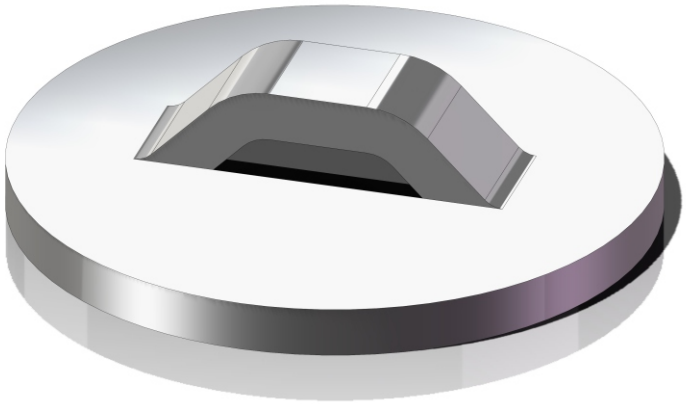
HPT
HOLLAND PRECISION TOOLING

SINGLE BRIDGE/CABLE CLAMP

☐ FORM UP ☐ FORM DOWN



FILL IN CRITICAL DIMS ONLY

GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

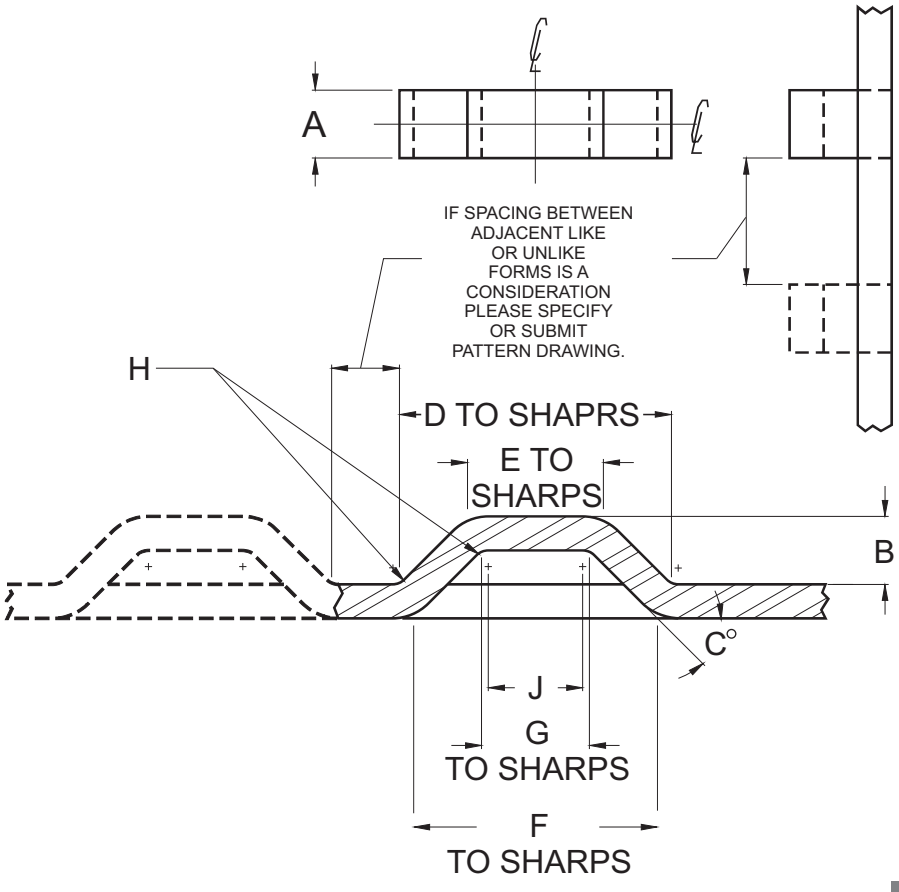
MACHINE TYPE _____

TOOLING STYLE _____

TOOL INFORMATION

A _____
B _____
C° _____
D _____
E _____
F _____
G _____
H _____
J _____

MATE'S STANDARD RADIUS
-DIMENSION H- IS .030



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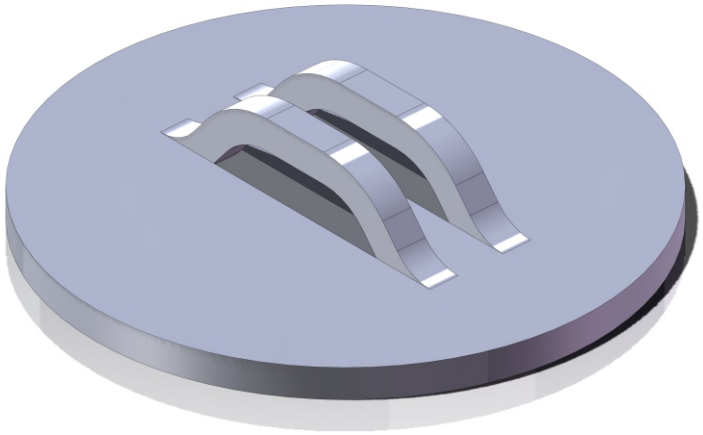
DOUBLE BRIDGE/CARD GUIDE



FILL IN CRITICAL DIMS ONLY

GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

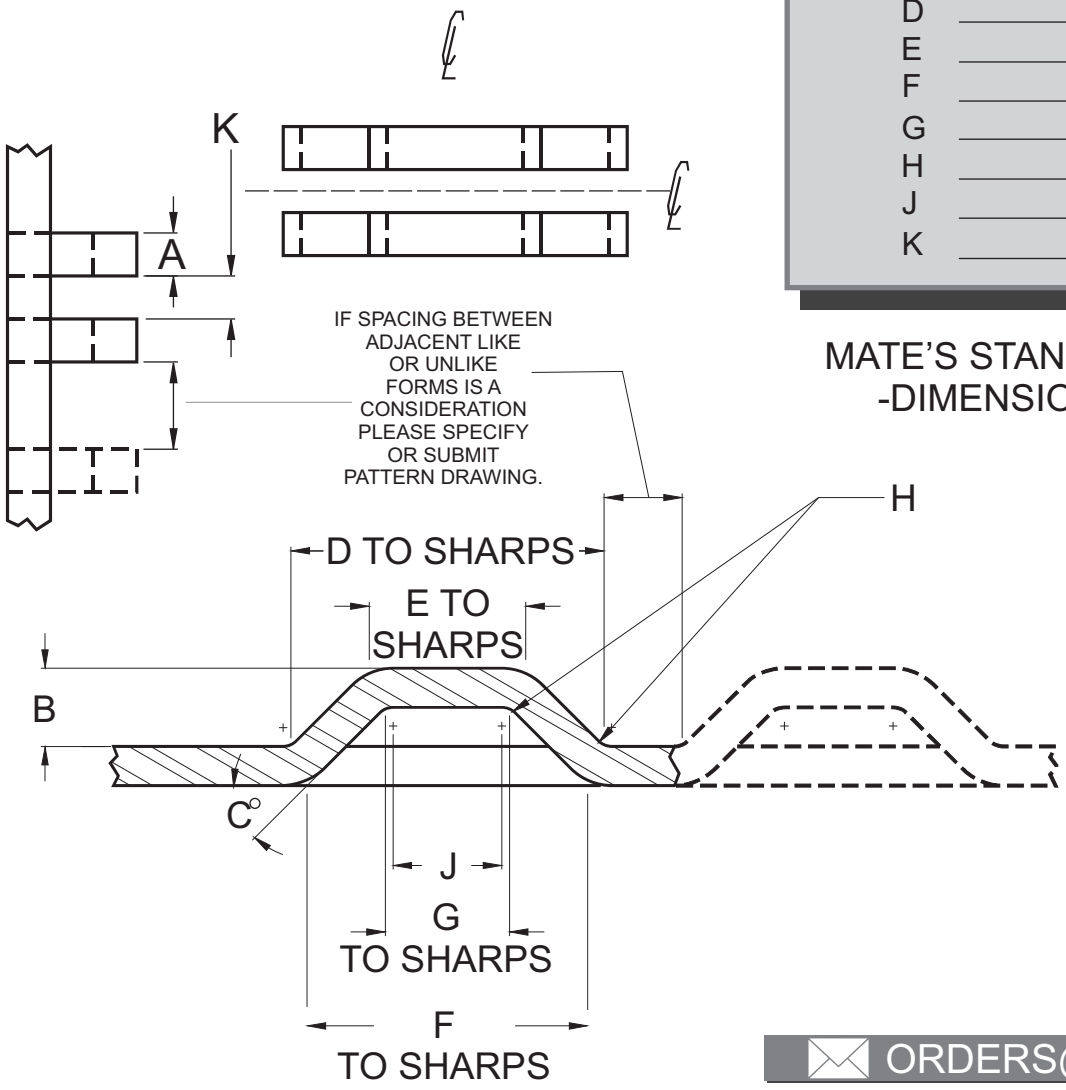
MACHINE TYPE _____

TOOLING STYLE _____

TOOL INFORMATION

A _____
B _____
C° _____
D _____
E _____
F _____
G _____
H _____
J _____
K _____

MATE'S STANDARD RADIUS
-DIMENSION H- IS .03.



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DOUBLE BRIDGE RADIUSED CARD GUIDE

☐ FORM UP ☐ FORM DOWN

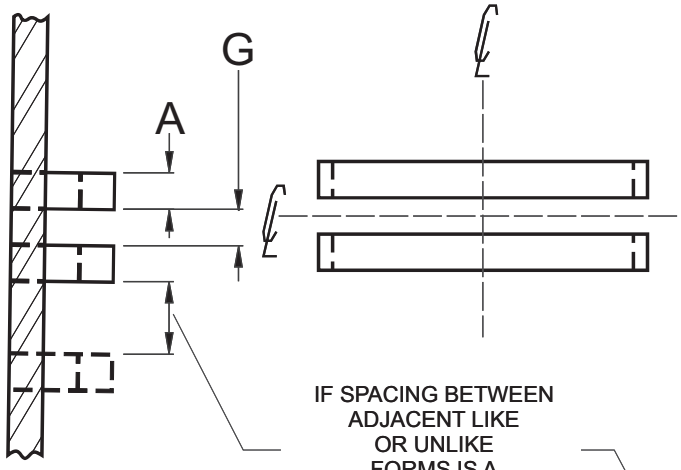
FILL IN CRITICAL DIMS ONLY

GENERAL INFORMATION

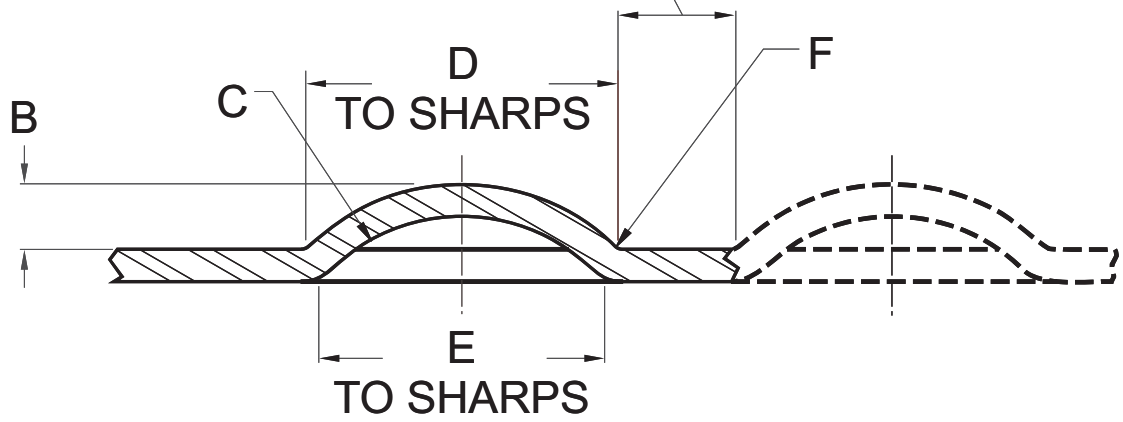
MATERIAL TYPE _____
MATERIAL THICKNESS _____
MACHINE TYPE _____
TOOLING STYLE _____

TOOL INFORMATION

A _____
B _____
C _____
D _____
E _____
F _____
G _____



IF SPACING BETWEEN ADJACENT LIKE OR UNLIKE FORMS IS A CONSIDERATION PLEASE SPECIFY OR SUBMIT PATTERN DRAWING.



MATE'S STANDARD RADIUS -DIMENSION F- IS .03.

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SCREW POCKET

COMMON SCREW THREAD HOLES

SIZE	HOLE ID CUT THREAD	HOLE ID ROLLED THREAD
M3	2.5 (.098)	2.7 (.108)
M4	3.3 (.130)	3.7 (.146)
M5	4.2 (.165)	4.6 (.183)
#4-40	.089 (2.3)	.100 (2.5)
#5-40	.100 (2.5)	.112 (2.8)
#6-32	.107 (2.7)	.120 (3.0)
#8-32	.136 (3.5)	.150 (3.8)
#10-24	.150 (3.8)	.167 (4.2)
#10-32	.159 (4.0)	.174 (4.4)
#12-24	.173 (4.4)	.194 (4.9)
1/4 - 20	.201 (5.1)	.219 (5.6)
1/4 - 28	.218 (5.5)	.235 (6.0)

GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

MACHINE TYPE _____

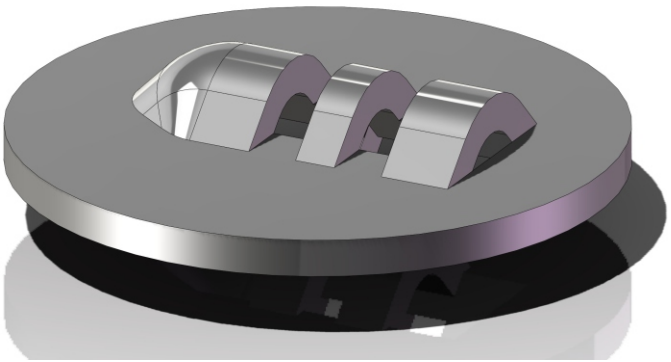
TOOLING STYLE _____

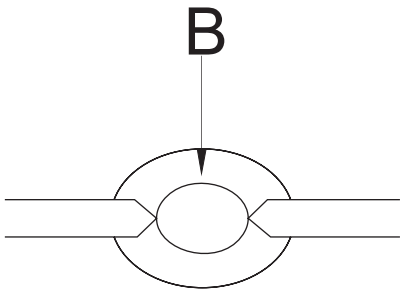
TOOL INFORMATION

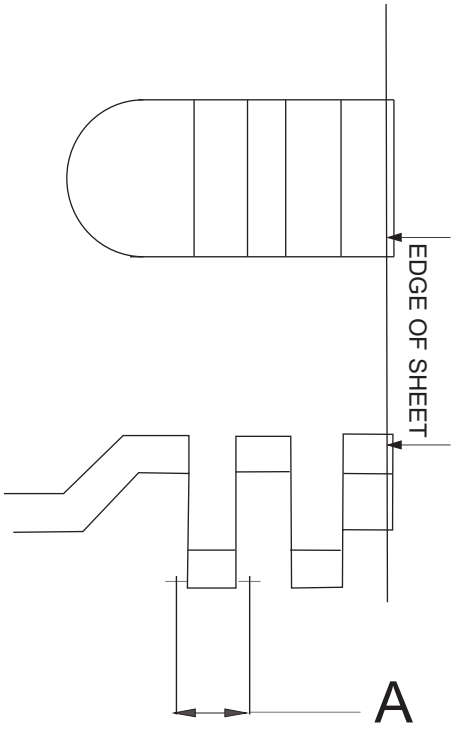
A _____

B _____

STANDARD CONFIGURATION 3 FORMS UP AND 2 FORMS DOWN







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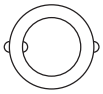
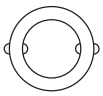
KNOCKOUT DOUBLE DIAMETER

☐ FORM UP ☐ FORM DOWN

MATE STANDARDS

TAB LOCATION		
AØ OR BØ	LOWER	UPPER
0- 1.374 (0,00-34,90)		
1.375 TO MAX (34,93) TO MAX		

TAB SIZE		
MATERIAL THICKNESS	C	D
.020-.045(0,51-1,14)	.060(1,52)	.030(0,76)
.046-.070(1,16-1,78)	.090(2,29)	.050(1.27)
.071-.097(1,80-2,46)	.120(3,05)	.060(1,52)
.098-.127(2,49-3,23)	.180(4,57)	.090(2,29)
.128-.179(3,25-4,55)	.250(6,35)	.125(3,18)

GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

MACHINE TYPE _____

TOOLING STYLE _____

TOOL INFORMATION

AØ _____

BØ _____

IF NOT MATE STANDARD TAB SIZE:

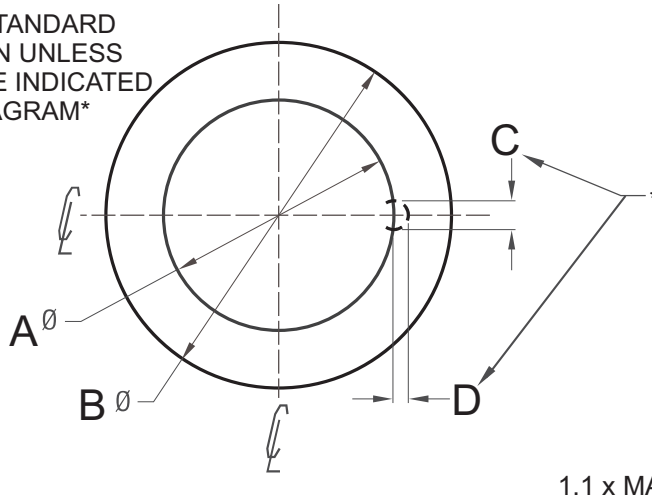
C _____

D _____

QUANTITY _____

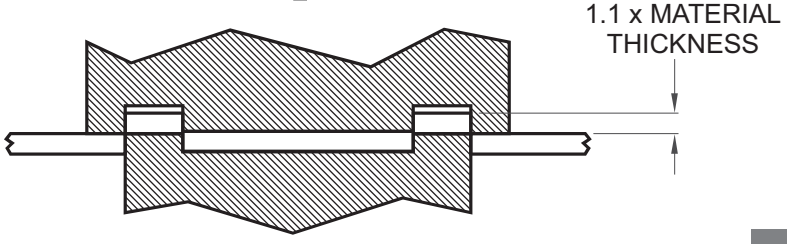
LOCATION- INDICATE ON DIAGRAM.

MATE STANDARD LOCATION UNLESS OTHERWISE INDICATED ON DIAGRAM



MATE STANDARD SIZE UNLESS OTHERWISE SPECIFIED

IF SPACING BETWEEN ADJACENT LIKE OR UNLIKE FORMS IS A CONSIDERATION, PLEASE SPECIFY OR SUBMIT PATTERN DRAWING



*FORM UP SHOWN IN DIAGRAM

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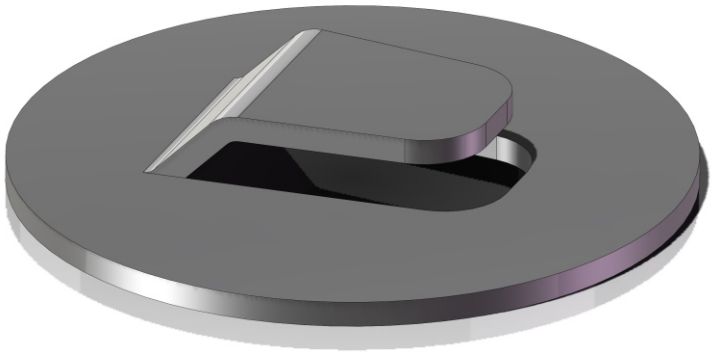
HPT HOLLAND PRECISION TOOLING

SHELF CLIP

☐ FORM UP ☐ FORM DOWN



GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

MACHINE TYPE _____

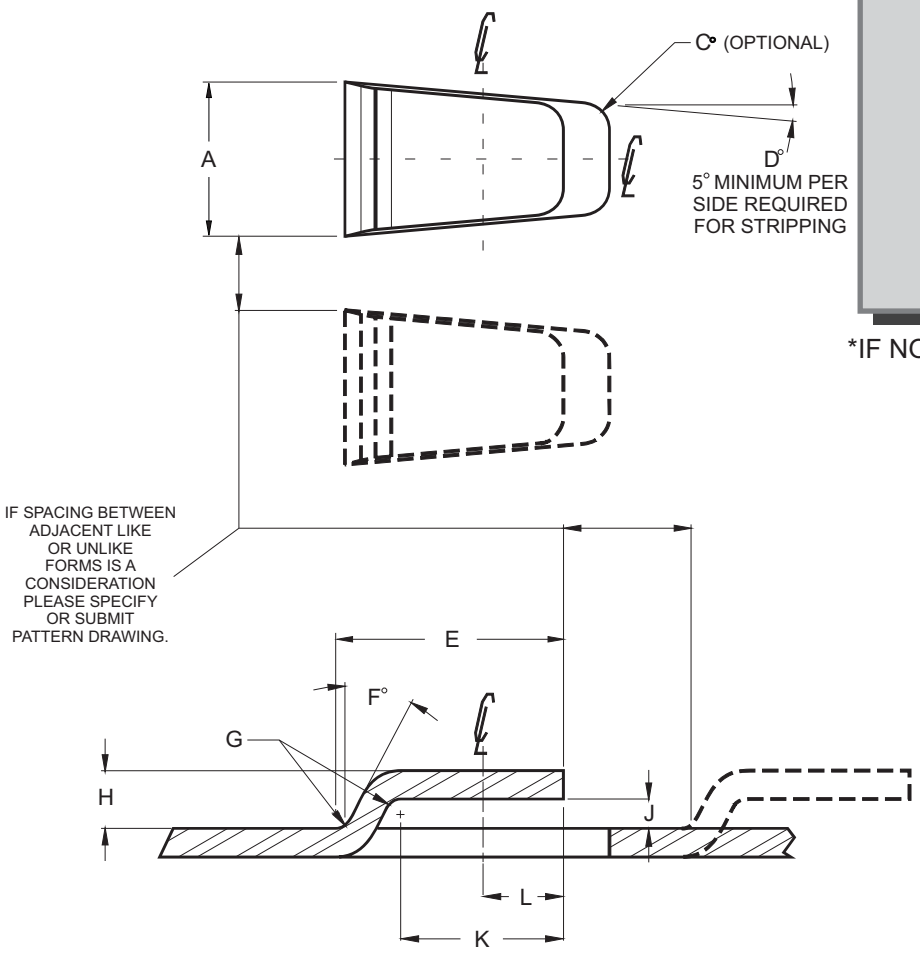
TOOLING STYLE _____

TOOL INFORMATION

A _____
C° _____
D _____
E _____
F _____
G _____
H _____
J _____
K _____
L* _____

*IF NOT SPECIFIED MATE WILL DETERMINE

FILL IN CRITICAL DIMS ONLY



MATE'S STANDARD RADIUS
-DIMENSION G- IS .03.

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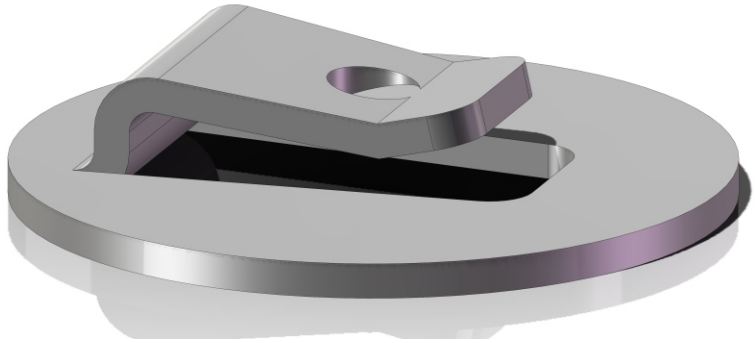
SNAP LOCK

☐ FORM UP ☐ FORM DOWN



GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

MACHINE TYPE _____

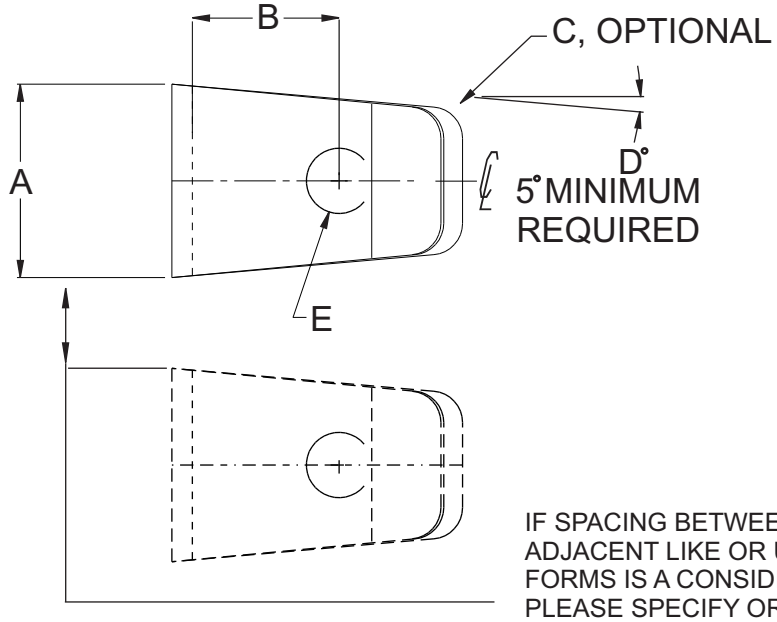
TOOLING STYLE _____

FILL IN CRITICAL DIMENSIONS ONLY

TOOL INFORMATION

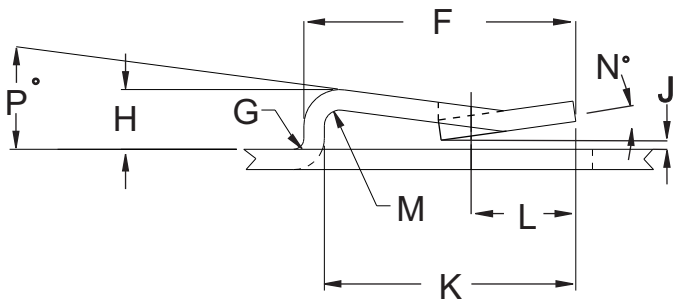
A _____
B _____
C° _____
D _____
E _____
F _____
G _____
H _____
J _____
K _____
L _____
M _____
N° _____
P° _____

MATERIAL THICKNESS
OF MATING MATERIAL: _____



MATE'S STANDARD RADIUS
-DIMENSION G- IS .03

IF SPACING BETWEEN
ADJACENT LIKE OR UNLIKE
FORMS IS A CONSIDERATION,
PLEASE SPECIFY OR SUBMIT
PATTERN DRAWING



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HOLLAND PRECISION TOOLING

SPRING CLIP

☐ FORM UP ☐ FORM DOWN

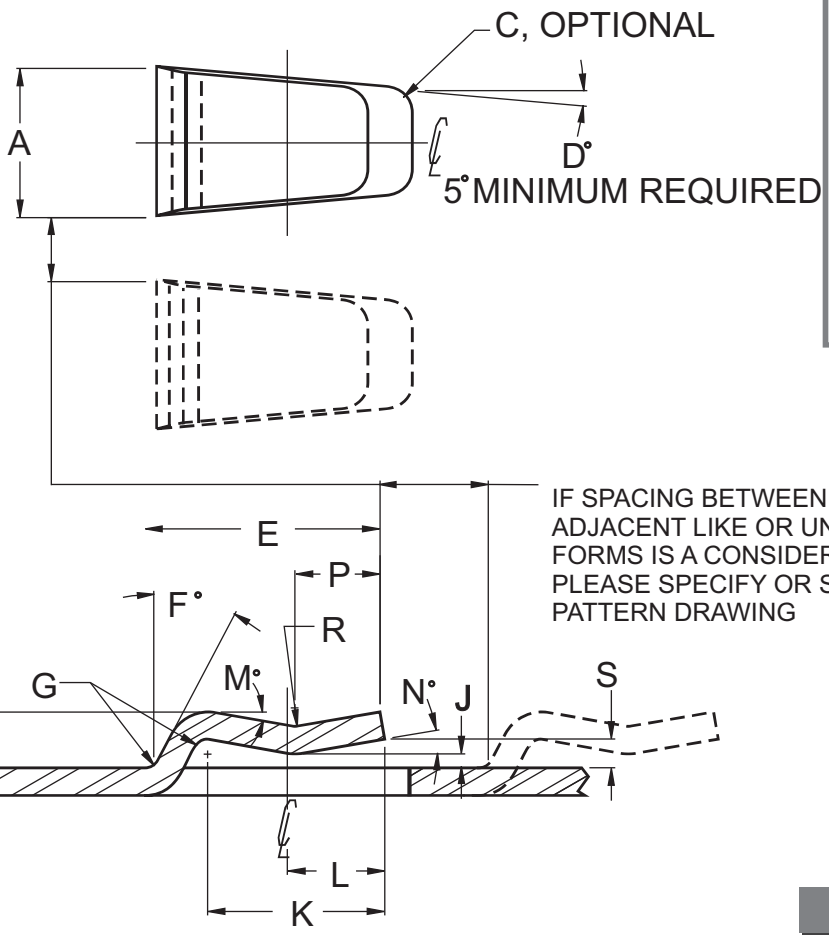
FILL IN CRITICAL DIMS ONLY

GENERAL INFORMATION

MATERIAL TYPE _____
MATERIAL THICKNESS _____
MACHINE TYPE _____
TOOLING STYLE _____

TOOL INFORMATION

A _____
C _____
D° _____
E _____
F° _____
F _____
H _____
J _____
K _____
L _____
M° _____
N° _____
P _____
R _____
S _____



MATE'S STANDARD RADIUS -DIMENSION G- IS .03.

IF SPACING BETWEEN ADJACENT LIKE OR UNLIKE FORMS IS A CONSIDERATION, PLEASE SPECIFY OR SUBMIT PATTERN DRAWING

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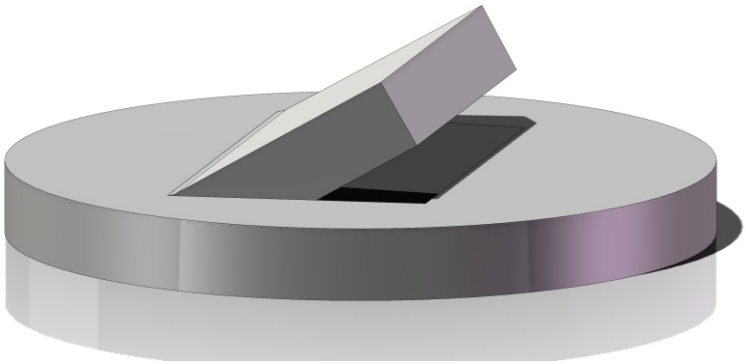
SPRING TAB

☐ FORM UP ☐ FORM DOWN



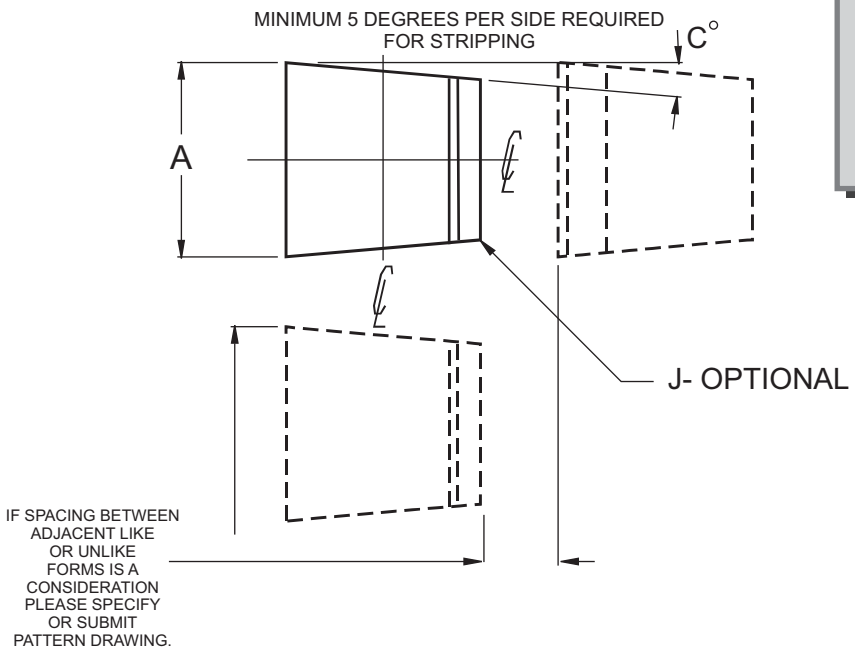
GENERAL INFORMATION

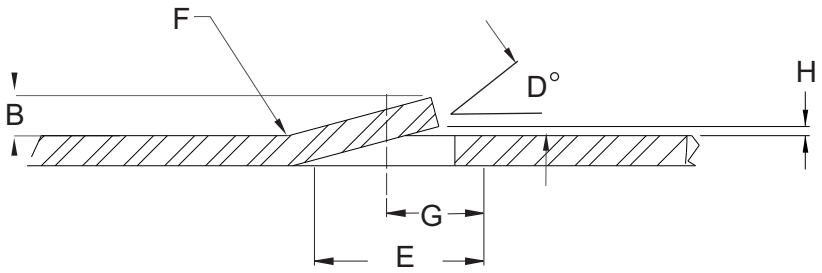
MATERIAL TYPE _____
MATERIAL THICKNESS _____
MACHINE TYPE _____
TOOLING STYLE _____

TOOL INFORMATION

A _____
B _____
C° _____
D° _____
E _____
F _____
G _____
H _____
J _____

FILL IN CRITICAL DIMS ONLY





MATE'S STANDARD RADIUS -DIMENSION F- IS .03

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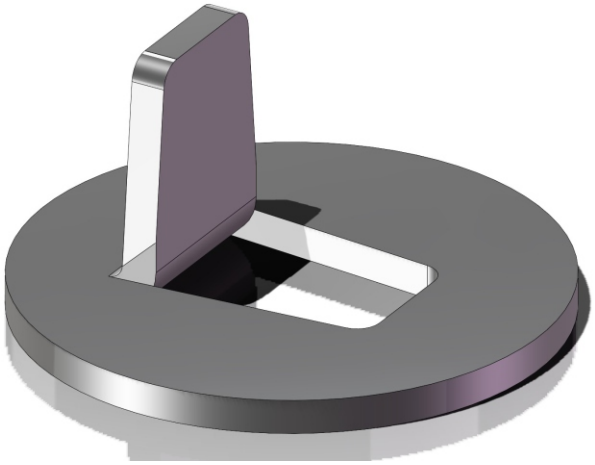
VERTICAL TAB

☐ FORM UP ☐ FORM DOWN



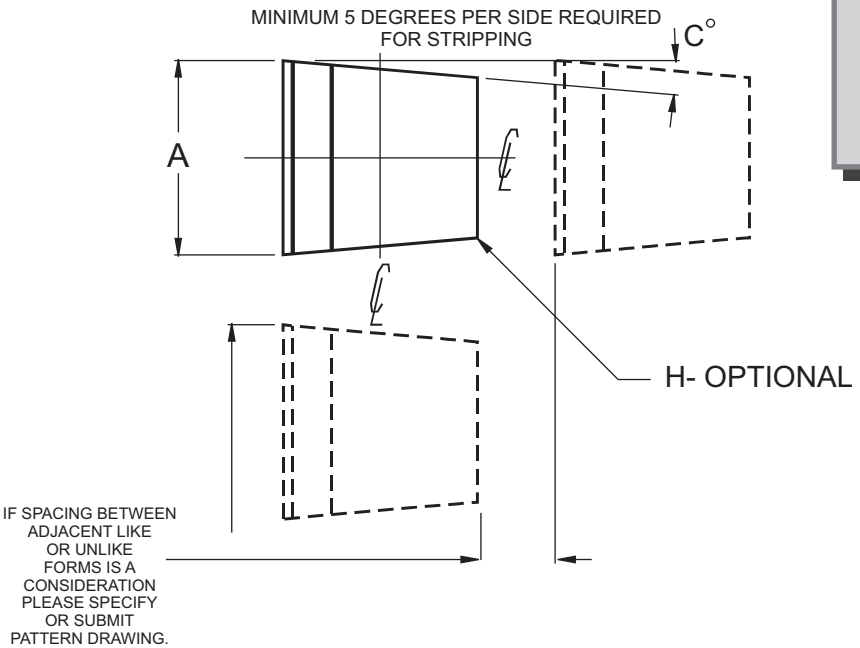
FILL IN CRITICAL DIMS ONLY

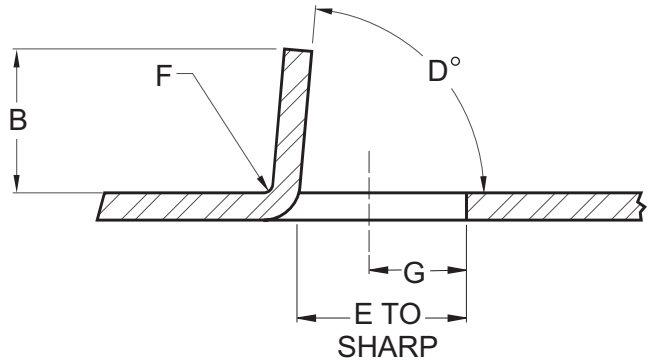
GENERAL INFORMATION

MATERIAL TYPE _____
MATERIAL THICKNESS _____
MACHINE TYPE _____
TOOLING STYLE _____

TOOL INFORMATION

A _____
B _____
C° _____
D° _____
E _____
F _____
G _____
H _____





MATES STANDARD RADIUS
-DIMENSION F- IS .03

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HOLLAND PRECISION TOOLING

KNOCKOUT SINGLE DIAMETER

☐ FORM UP ☐ FORM DOWN

MATE STANDARDS

TAB LOCATION		
A Ø	E QUANTITY	LOCATION LOWER UPPER
.000-.313 (0,00-7,95)	1 TAB IN UPPER ONLY	
.314-1.374 (7,97-34,90)	1 TAB IN UPPER AND LOWER ASSEMBLY	
1.375 TO MAX (34,93) TO MAX	2 TABS IN UPPER & LOWER AT 180 °	

TAB SIZE		
MATERIAL THICKNESS	C	D
.020-.045(0,51-1,14)	.060(1,52)	.030(0,76)
.046-.070(1,16-1,78)	.090(2,29)	.050(1.27)
.071-.097(1,80-2,46)	.120(3,05)	.060(1,52)
.098-.127(2,49-3,23)	.180(4,57)	.090(2,29)
.128-.179(3,25-4,55)	.250(6,35)	.125(3,18)

GENERAL INFORMATION

MATERIAL TYPE _____

MATERIAL THICKNESS _____

MACHINE TYPE _____

TOOLING STYLE _____

TOOL INFORMATION

AØ _____

IF NOT MATE STANDARD TAB SIZE:

C _____

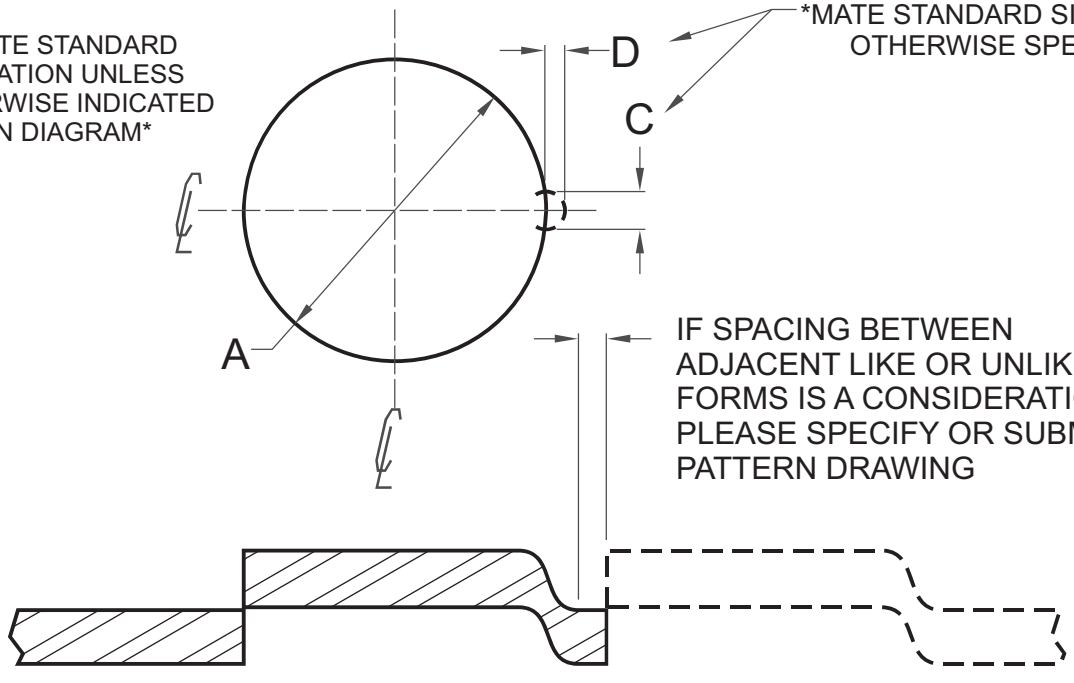
D _____

QUANTITY _____

LOCATION- INDICATE ON DIAGRAM.

MATE STANDARD LOCATION UNLESS OTHERWISE INDICATED ON DIAGRAM

MATE STANDARD SIZE UNLESS OTHERWISE SPECIFIED



IF SPACING BETWEEN ADJACENT LIKE OR UNLIKE FORMS IS A CONSIDERATION, PLEASE SPECIFY OR SUBMIT PATTERN DRAWING

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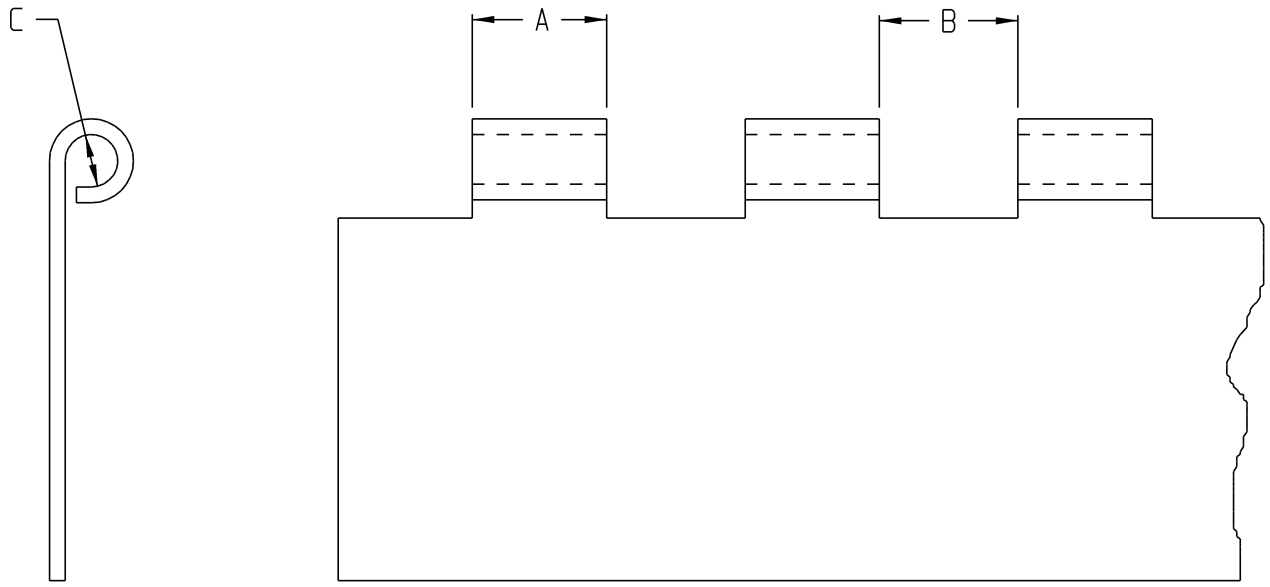
MATE PRECISION TOOLING

DWN:	DATE:	
APP:	DATE:	
MFG:	DATE:	
		SCALE: NONE

ORIGINAL: ☐

HINGE FORM DATA SHEET

HOLLAND PRECISION TOOLING



KNUCKLE LENGTH "A" _____

KNUCKLE SPACE B" _____

KNUCKLE I.D. "C" _____

MAT'L TYPE _____

MAT'L THICKNESS "T" _____

MACHINE TYPE _____

TOOLING STATION & STYLE _____

DIMENSIONS FILLED IN BY _____

APPROVED BY _____

TO ASSURE AN ACCURATE FORMED RESULT THE MATERIAL THICKNESS MUST BE SPECIFIED AS AN ACTUAL MEASURED VALUE, NOT A GAUGE SPECIFICATION.

THE KNUCKLE I.D. "C" EQUALS THE PIN DIAMETER PLUS THE DESIRED CLEARANCE.

PLEASE SUBMIT A PART DRAWING IF AVAILABLE.

MATE PRECISION TOOLING

HPT HOLLAND PRECISION TOOLING

Your Name: _____

Telephone# _____

Company: _____

Mate Roller Solution - Offset Tool

ROLLING OFFSET

OFFSET WHEEL PARAMETERS

MATERIAL RANGE OF EACH TOOL

.032” - .060” (0.8mm – 1.5mm) for Stainless Steel

.032” - .079” (0.8mm – 2.0m m) for Mild Steel

.032” - .098” (0.8mm – 2.5mm) for Aluminum

MINIMUM RADIUS

1.000" (25.4mm)

Maximum height for all machines is .188" (4.7mm)

Multiple passes required to get heights .156" (4mm) or greater

BASIC REQUIREMENTS TO RUN TOOL

Programmable ram

GENERAL INFORMATION

*Never run material thicker than what it was designed for

*If the customer is changing only material thickness from the original order, they only need an upper wheel assembly

*Relief cannot be put on this tool

*Minimum distance from the edge of the form is 1" (25.4mm)

*To get a form down Offset, turn the tool or wheels 180°

* Rib wheel assemblies are interchangeable with the Rolling Offset tool

*The tool is ABS compatible

SPECIAL INFORMATION MACHINES

Finn-Power

7.8 or higher, the tool will work

7.7, will work if PLC software version is 75.11 or higher

7.6 or less, the tool will not work

AMADA

04P-c is okay for straight lines only

04P-c will not work for machines that end in "8"

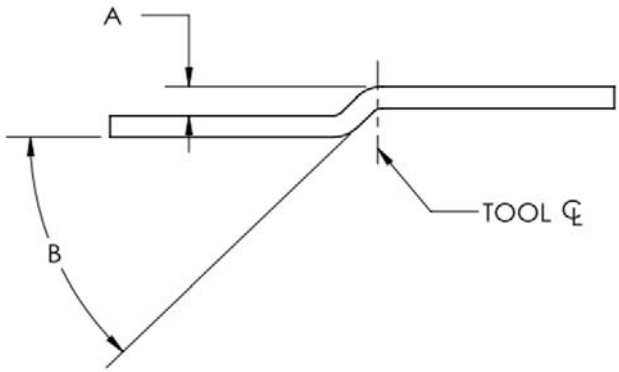
18p control is okay

EM, AC, ACIES machines are okay

Questions, Changes, Comments Here:

A = .062"(1.5mm), B = 45° - Stock Size

A = .125" (3.2mm), B = 45° - Stock Size



Information Needed

Machine Model: _____

[Example: Amada Vipros]

Material Type _____

[Example: Aluminum]

Material Thickness: _____

[Example 0.060" or 1.6mm)

Height "A": _____

[0.188 (4.70mm) max]

Angle "B": _____

[45 std, 30 min, 60 max]

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Your Name: _____

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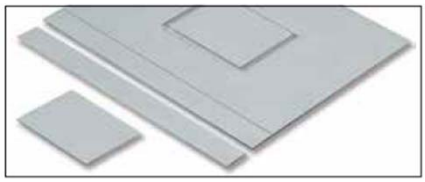
Mate Roller Solution - Pincher Tool



ROLLING PINCHER

PINCHER WHEEL PARAMETERS

MATERIAL RANGE OF EACH TOOL

.032" - .060" (0.8mm – 1.5mm) for Stainless Steel

.032" - .079" (0.8mm – 2.0m m) for Mild Steel

.032" - .098" (0.8mm – 2.5mm) for Aluminum

MINIMUM RADIUS

20" (500mm)

BASIC REQUIREMENTS TO RUN TOOL

Programmable ram

GENERAL INFORMATION

*Stock chisel point angle is 60°

*Relief cannot be put on this tool

*Minimum distance from the edge of the form is 1" (25.4mm)

*The tool is ABS compatible

SPECIAL INFORMATION MACHINES

Finn-Power

7.8 or higher, the tool will work

7.7, will work if PLC software version is 75.11 or higher

7.6 or less, the tool will not work

AMADA

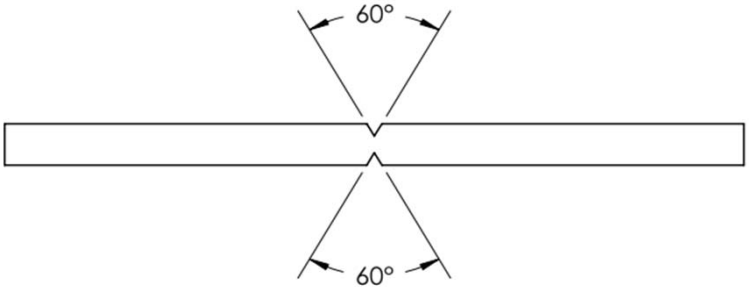
04P-c is okay for straight lines only

04P-c will not work for machines that end in "8"

18p control is okay

EM, AC, ACIES machines are okay

Questions, Changes, Comments Here:



Information Needed

Machine Model: _____

[Example: Amada Vipros]

Material Type _____

[Example: Aluminum]

Material Thickness: _____

[Example 0.060" or 1.6mm)

Pincher Angle: _____

[60 degrees is standard]

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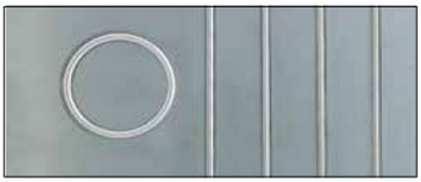
Mate Roller Solution - Rib Tool



ROLLING RIB

RIB WHEEL PARAMETERS

MATERIAL RANGE OF EACH TOOL

Minimum Thickness - .032" (0.8mm)

Maximum Thickness- .060" (1.5mm) for Stainless Steel

Maximum Thickness - .079" (2.0mm) for Mild Steel

Maximum Thickness -.098" (2.5mm) for Aluminum

MINIMUM RADIUS

.590" (15mm) on material up to .060" (1.5mm)

.787" (20mm) on material greater than .060" (1.5mm)

Maximum height for all machines is .188" (4.7mm)

Multiple passes required to get heights .156" (4mm) or greater

BASIC REQUIREMENTS TO RUN TOOL

Programmable ram

GENERAL INFORMATION

*Never run material thicker than what it was designed for

*If the customer is changing only material thickness from the original order, they only need an upper wheel assembly

*Relief cannot be put on this tool

*Minimum distance from the edge of the form is 1" (25.4mm)

* A form down rib is possible - Check with engineering
Form up and form-down ribs are not interchangeable

* Rib wheel assemblies are interchangeable with the Rolling Offset tool

*The tool is ABS compatible

SPECIAL INFORMATION MACHINES

Finn-Power

7.8 or higher, the tool will work

7.7, will work if PLC software version is 75.11 or higher

7.6 or less, the tool will not work

AMADA

04P-c is okay for straight lines only

04P-c will not work for machines that end in "8"

18p control is okay

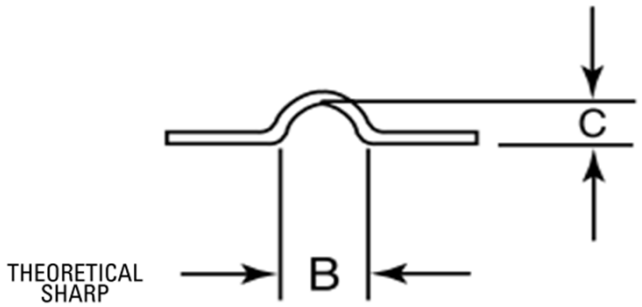
EM, AC, ACIES machines are okay

Questions, Changes, Comments Here:

B = .187", C = .094" (2.4mm) Stock Size

B = .250", C = .125" (3.2mm) Stock Size

Maximum B dimension is .500" (12.7mm)



Information Needed

Machine Model: _____

[Example: Amada Vipros]

Material Type _____

[Example: Aluminum]

Material Thickness: _____

[Example 0.060" or 1.6mm)

Height "C" _____

Width "B": _____

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MATE PRECISION TOOLING

HPT HOLLAND PRECISION TOOLING

Your Name: _____

Telephone# _____

Company: _____

Mate Roller Solution - Shear Tool

SHEAR WHEEL PARAMETERS

MATERIAL RANGE OF EACH TOOL

.030” - .060” (0.8mm – 1.5mm) for Stainless Steel
.030” - .079” (0.8mm – 2.0m m) for Mild Steel
.030” - .098” (0.8mm – 2.5mm) for Aluminum
.020" .029" (0.5 - 0.7mm) = non-stock ETO

MINIMUM RADIUS

1.77” – 3.94” (45 - 100mm)

BASIC REQUIREMENTS TO RUN TOOL

Programmable ram
Station alignment

GENERAL INFORMATION

*Never run material thicker than what it was designed for
*Thinner material can be run but there may be a slight curl at the sheared edge
*Relief cannot be put on this tool
*Minimum distance from the edge of the form is 1" (25.4mm)
*Tool must start the cut on the edge or middle of the sheet or on the edge of a hole
*The tool cannot start off the edge of the sheet or run through a hole (tool may force the sheet from the clamps)
*The tool is not sharpenable
*The tool is ABS compatible

SPECIAL INFORMATION MACHINES

Finn-Power

7.8 or higher, the tool will work
7.7, will work if PLC software version is 75.11 or higher
7.6 or less, the tool will not work

AMADA

04P-c is okay for straight lines only
04P-c will not work for machines that end in "8"
18p control is okay
EM, AC, ACIES machines are okay

Questions, Changes, Comments Here:

Information Needed

Machine Model: _____
[Example: Amada Vipros]

Material Type _____
[Example: Aluminum]

Material Thickness: _____
[Example 0.060" or 1.6mm)

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