

TOOLING FOR PUNCH PRESSES

THICK TURRET

Standard:

UNISTEEL

Premium Performance Steel

HIGH PRECISION TOOLS

UNISTAMP™
Always a Step Ahead



UNISTAMP™

Always a Step Ahead



ALWAYS INNOVATING TO BRING NEW TECHNOLOGIES TO OUR CUSTOMERS

For more than 35 years UNISTAMP has been the Leader in the Metal Fabricating Sector. Today our company has over 8000 square meters of manufacturing, warehousing and administration. UNISTAMP has representatives throughout the country and abroad. UNISTAMP is made of dedicated professionals who are always in search of technological developments to offer each day better productive solutions. Our technical and commercial team is always at your disposal!

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MATERIAL INFORMATION

UNISTEEL – PREMIUM PERFORMANCE STEEL

High Wear Resistance and Impact Toughness!

All Thick Turret punches are produced with Unisteel. The best performance option for the punch press process!

Test data control

Plate Material: 304 Stainless Steel

Thickness: 0.02" (0.5mm)

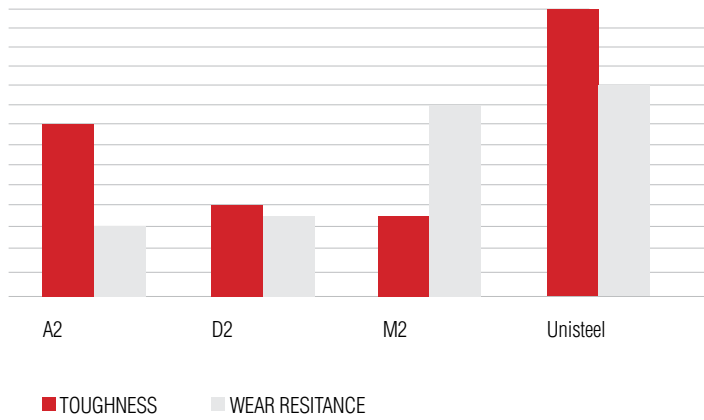
Shape: Rectangle

Dimension: 0.158"x1.181" (4x30 mm)

Result until first grind = 255,000 punches!



Properties Comparison



OPTIONS

UNITIN-CR (OPTIONAL)

A special proprietary coating to extend the life of the punch!

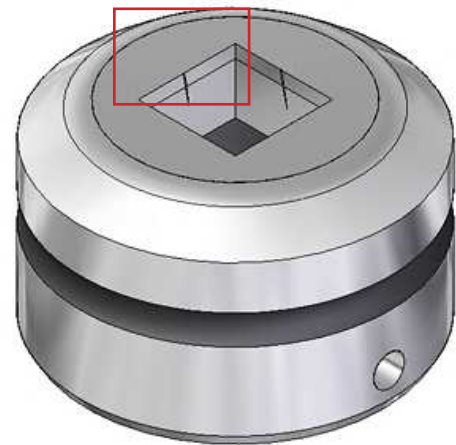
It is a PVD process (Physical Vapour Deposition). By applying a surface layer on the punch, besides generating high hardness and low friction, the following benefits are obtained:

- More durability cutting edge.
- Prevents adhesive wear
- Protect of abrasive wear
- Decreases friction



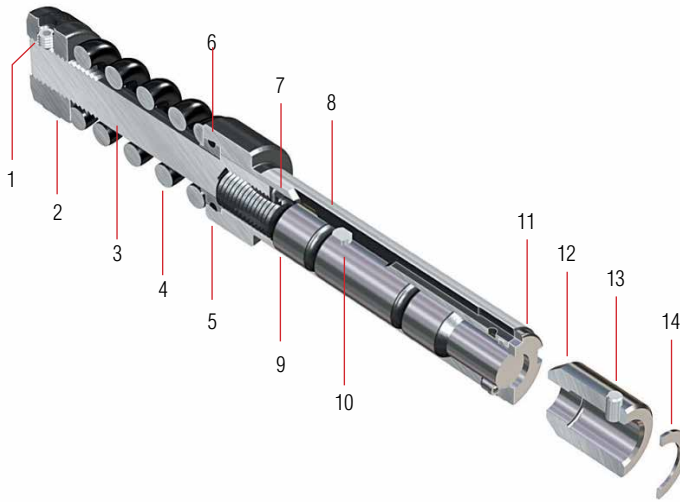
UNISLUG SLUG CONTROL (OPTIONAL)

UNISLUG is an “optional” system that UNISTAMP offers, whose purpose is to avoid return of the slug while punching, eliminating the risk of accumulating slug at the exit of die. So it's a solution for anyone who has this type of problem or that wants to avoid possible problems.



1/2" A STATION – MOD 90 THICK TURRET

Maximum Diagonal: 0.5" (12.7mm)



MOD 90

ITEM	CODE	DESCRIPTION
1	10902	Screw
2	9120A19	1/2" Mod 90 Thick Turret Punch Head
3	9120A12	1/2" Mod 90 Thick Turret Punch Driver
4	9120A05	1/2" Mod 90 Thick Turret Spring
4	9120A05CP	1/2" Mod 90 Thick Turret Heavy Duty Spring *
5	9120A28	1/2" Mod 90 Thick Turret O-Ring
6	9120A10	1/2" Mod 90 Thick Turret Spring Support
7	9120A21	1/2" Mod 90 Thick Turret Locking Ring
8	9120A04	1/2" Mod 90 Thick Turret Guide Round/Shape
9	9120A01D-UNISTEEL	1/2" Mod 90 Thick Turret UNISTEEL Punch Round
9	9120A01F-UNISTEEL	1/2" Mod 90 Thick Turret UNISTEEL Punch Shape
9	9120A01DU-UNISTEEL	1/2" Mod 90 Thick Turret UNISTEEL with UNITIN-CR Punch Round
9	9120A01FU-UNISTEEL	1/2" Mod 90 Thick Turret UNISTEEL with UNITIN-CR Punch Shape
10	9110A08	1/2" Thick Turret Dowel Pin to Punch
11	9120A03D	1/2" Mod 90 Thick Turret Stripper Round
11	9120A03F	1/2" Mod 90 Thick Turret Stripper Shape
12	9110A02D	1/2" Thick Turret Die Round
12	9110A02F	1/2" Thick Turret Die Shape
13	9110A07	1/2" Thick Turret Dowel Pin to Die
14	9110A40-0,5	1/2" Thick Turret Shim to Die - Thickness .020" (0.5mm)
14	9110A40-1,0	1/2" Thick Turret Shim to Die - Thickness .039" (1.0mm)
1-8	9120A0P	1/2" A Mod 90 Thick Turret Guide Assembly
1-8	9120A0PCP	1/2" A Mod 90 Thick Turret Heavy Duty Guide Assembly *

MOD 90 ABS

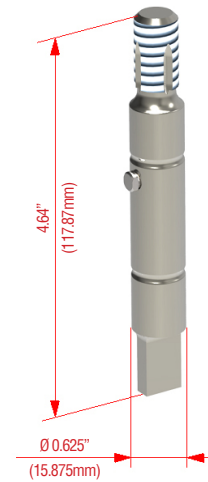
ITEM	CODE	DESCRIPTION
9	9120SA01D-UNISTEEL	1/2" Mod 90-ABS Thick Turret UNISTEEL Punch Round
9	9120SA01F-UNISTEEL	1/2" Mod 90-ABS Thick Turret UNISTEEL Punch Shape
9	9120SA01DU-UNISTEEL	1/2" Mod 90-ABS Thick T. UNISTEEL with UNITIN-CR Punch Round
9	9120SA01FU-UNISTEEL	1/2" Mod 90-ABS Thick T. UNISTEEL with UNITIN-CR Punch Shape

HEAVY DUTY HELICAL SPRING

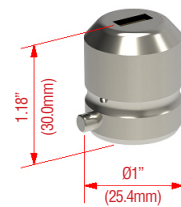
Available Station	Indicated for Punching Force (PF)	Units
1/2" A	9,348 lbs (4.67 tons) ≤ PF ≤ 14,264 lbs (7.13 tons)	US
	41,580 N (4.24 tonne) ≤ PF ≤ 63,449 N (6.47 tonne)	Metrics

PUNCH & DIE GRINDING

Grind Length: 0.236" (6.0mm)

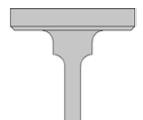


Grind Length: 0.079" (2.0mm)



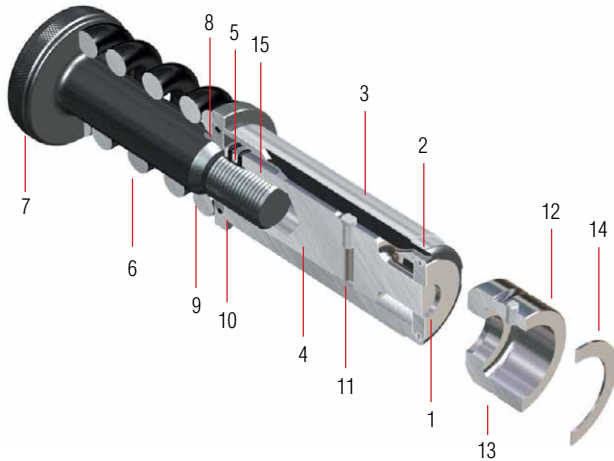
NOTE

Strong Profile
Standard for Round or Shape with
dimensions ≤ 0.018" (3.0mm)
Grind Length: 0.079" (2.0mm)



1-1/4" B STATION – MOD 90 THICK TURRET

Maximum Diagonal: 1.25" (31.75mm)



MOD 90

ITEM	CODE	DESCRIPTION
1	9120B03D	1-1/4" Mod 90 Thick Turret Stripper Round
1	9120B03F	1-1/4" Mod 90 Thick Turret Stripper Shape
2	9120B24	1-1/4" Mod 90 Thick Turret Spherical Pin
3	9120B04	1-1/4" Mod 90 Thick Turret Guide Round/Shape
4	9120B01D-UNISTEEL	1-1/4" Mod 90 Thick Turret UNISTEEL Punch Round
4	9120B01F-UNISTEEL	1-1/4" Mod 90 Thick Turret UNISTEEL Punch Shape
4	9120B01DU-UNISTEEL	1-1/4" Mod 90 Thick UNISTEEL with UNITIN-CR Punch Round
4	9120B01FU-UNISTEEL	1-1/4" Mod 90 Thick UNISTEEL with UNITIN-CR Punch Shape
5	9120B50	1-1/4" Mod 90 Thick Turret Retaining Ring
6	9110B05	1-1/4" Thick Turret Spring
6	9120B05CP	1-1/4" Thick Turret Heavy Duty Spring *
7	9120B12	1-1/4" Mod 90 Thick Turret Driver
8	9120B10	1-1/4" Mod 90 Thick Turret Spring Support
9	9120B28	1-1/4" Mod 90 Thick Turret O-Ring
10	9120B48	1-1/4" Mod 90 Thick Turret Nut
11	9110B08	1-1/4" Thick Turret Dowel Pin to Punch
12	9110B02D	1-1/4" Thick Turret Die Round
12	9110B02F	1-1/4" Thick Turret Die Shape
13	9110A07	1/2" Thick Turret Dowel Pin to Die
14	9110B40-0,5	1-1/4" Thick Turret Shim to Die - Thickness .020" (0.5mm)
14	9110B40-1,0	1-1/4" Thick Turret Shim to Die - Thickness .039" (1.0mm)
15	9120B23	1-1/4" Thick Turret Lock Pin
1-10	9120B0P	1-1/4" B Mod 90 Thick Turret Guide Assembly
1-10	9120B0PCP	1-1/4" B Mod 90 Thick Turret Heavy Duty Guide Assembly *

MOD 90 ABS

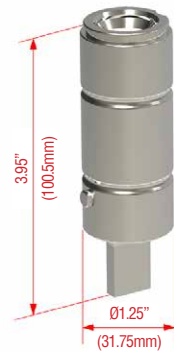
ITEM	CODE	DESCRIPTION
4	9120SB01D-UNISTEEL	1-1/4" Mod 90-ABS Thick Turret UNISTEEL Punch Round
4	9120SB01F-UNISTEEL	1-1/4" Mod 90-ABS Thick Turret UNISTEEL Punch Shape
4	9120SB01DU-UNISTEEL	1-1/4" Mod 90-ABS Thick UNISTEEL with UNITIN-CR Punch Round
4	9120SB01FU-UNISTEEL	1-1/4" Mod 90-ABS Thick UNISTEEL with UNITIN-CR Punch Shape

HEAVY DUTY HELICAL SPRING

Available Station	Indicated for Punching Force (PF)	Units
1-1/4" B	22,046 lbs (11.02 tons) ≤ PF ≤ 33,069 lbs (16.53 tons)	US
	98,066 N (10.00 tonne) ≤ PF ≤ 147,100 N (15.00 tonne)	Metrics

PUNCH & DIE GRINDING

Grind Length: 0.236" (6.0mm)

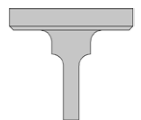


Grind Length: 0.079" (2.0mm)



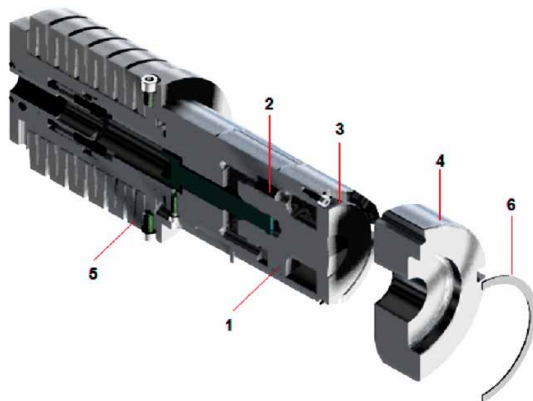
NOTE

Strong Profile
Standard for Round or Shape with
dimensions ≤ 0.018" (3.0mm)
Grind Length: 0.079" (2.0mm)



2" C STATION – MOD 90 THICK TURRET

Maximum Diagonal: 2.0" (50.8mm)



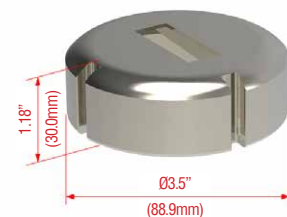
ITEM	CODE	DESCRIPTION
1	9120C01D-UNISTEEL	2" Mod 90 Thick Turret UNISTEEL Punch Round
1	9120C01F-UNISTEEL	2" Mod 90 Thick Turret UNISTEEL Punch Shape
1	9120C01DU-UNISTEEL	2" Mod 90 Thick Turret UNISTEEL with UNITIN-CR Punch Round
1	9120C01FU-UNISTEEL	2" Mod 90 Thick Turret UNISTEEL with UNITIN-CR Punch Shape
2	9120C08	2" Mod 90 Thick Turret Dowel Pin to Punch
3	9120C03D	2" Mod 90 Thick Turret Stripper Round
3	9120C03F	2" Mod 90 Thick Turret Stripper Shape
4	9110C02D	2" Thick Turret Die Round
4	9110C02F	2" Thick Turret Die Shape
5	9120C05	2" Mod 90 Thick Turret Spring
6	9110C40-0.5	2" Thick Turret Shim to Die - Thickness .020" (0.5mm)
6	9110C40-1.0	2" Thick Turret Shim to Die - Thickness .039" (1.0mm)
	9120C0P	2" C Mod 90 Thick Turret Guide Assembly

PUNCH & DIE GRINDING

Grind Length: 0.236" (6.0mm)

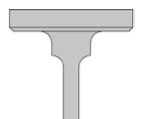


Grind Length: 0.079" (2.0mm)



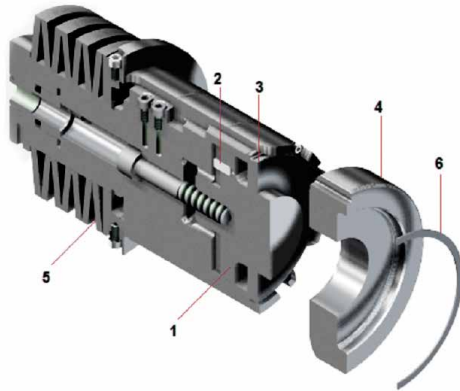
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



3-1/2" D STATION – MOD 90 THICK TURRET

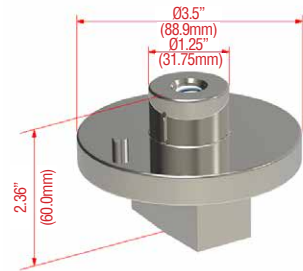
Maximum Diagonal: 3.5" (88.9mm)



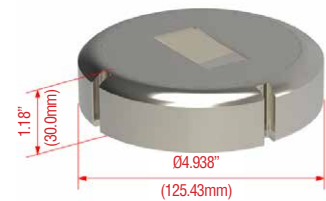
ITEM	CODE	DESCRIPTION
1	9120D01D-UNISTEEL	3-1/2" Mod 90 Thick Turret UNISTEEL Punch Round
1	9120D01F-UNISTEEL	3-1/2" Mod 90 Thick Turret UNISTEEL Punch Shape
1	9120D01DU-UNISTEEL	3-1/2" Mod 90 Thick UNISTEEL with UNITIN-CR Punch Round
1	9120D01FU-UNISTEEL	3-1/2" Mod 90 Thick UNISTEEL with UNITIN-CR Punch Shape
2	9120C08	3-1/2" Mod 90 Thick Turret Dowel Pin to Punch
3	9120D03D	3-1/2" Mod 90 Thick Turret Stripper Round
3	9120D03F	3-1/2" Mod 90 Thick Turret Stripper Shape
4	9110D02D	3-1/2" Thick Turret Die Round
4	9110D02F	3-1/2" Thick Turret Die Shape
5	9,16E+08	3-1/2" Mod 90 Thick Turret Spring
6	9110D40	3-1/2" Thick Turret Shim to Die - Thickness .020" (0.5mm)
6	9110D40	3-1/2" Thick Turret Shim to Die - Thickness .039" (1.0mm)
	9120D0P	3-1/2" C Mod 90 Thick Turret Guide Assembly

PUNCH & DIE GRINDING

Grind Length: 0.236" (6.0mm)

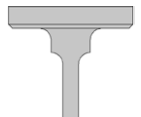


Grind Length: 0.079" (2.0mm)



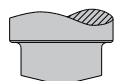
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



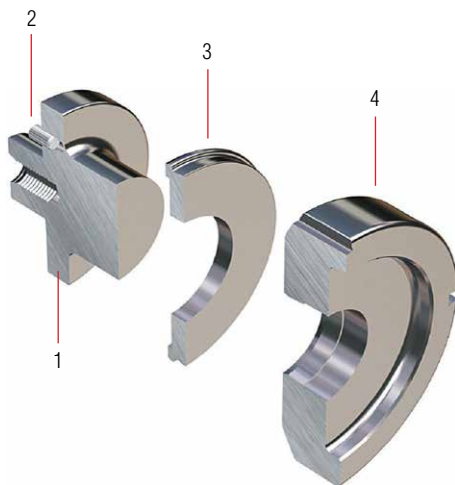
STANDARD

Rooftop



4-1/2" E STATION – MOD 90 THICK TURRET

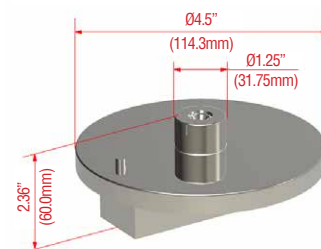
Maximum Diagonal: 4.5" (114.3mm)



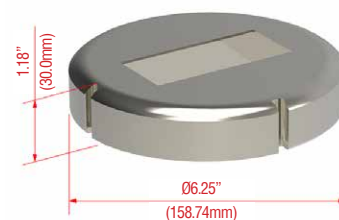
ITEM	CODE	DESCRIPTION
1	9120E01D	4-1/2" Mod 90 Thick Turret Punch Round
1	9120E01F	4-1/2" Mod 90 Thick Turret Punch Shape
1	9120E01DU	4-1/2" Mod 90 Thick Turret UNITIN-CR Punch Round
1	9120E01FU	4-1/2" Mod 90 Thick Turret UNITIN-CR Punch Shape
2	9120C08	2" Mod 90 Thick Turret Dowel Pin to Punch
3	9120E03D	4-1/2" Mod 90 Thick Turret Stripper Round
3	9120E03F	4-1/2" Mod 90 Thick Turret Stripper Shape
4	9110E02D	4-1/2" Thick Turret Die Round
4	9110E02F	4-1/2" Thick Turret Die Shape
	9110E40-0,5	4-1/2" Thick Turret Shim to Die - Thickness .020" (0.5mm)
	9110E40-1,0	4-1/2" Thick Turret Shim to Die - Thickness .039" (1.0mm)

PUNCH & DIE GRINDING

Grind Length: 0.236" (6.0mm)

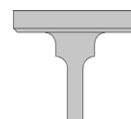


Grind Length: 0.079" (2.0mm)



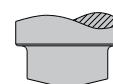
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



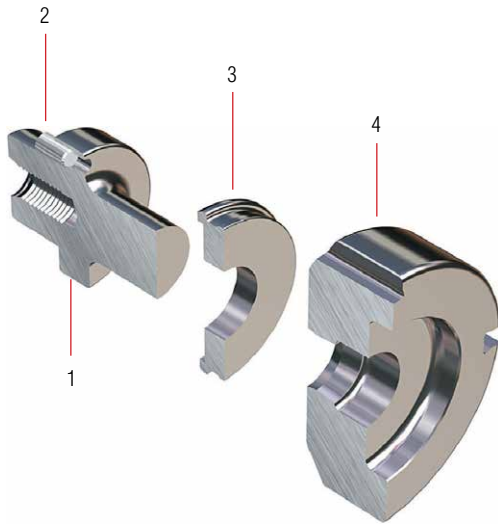
STANDARD

Rooftop



6" F STATION – MOD 90 THICK TURRET

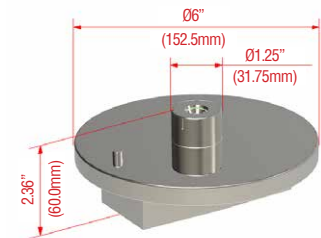
Maximum Diagonal: 6.0" (152.4mm)



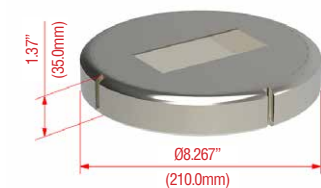
ITEM	CODE	DESCRIPTION
1	9120F01D-UNISTEEL	6" Mod 90 Thick Turret UNISTEEL Punch Round
1	9120F01F-UNISTEEL	6" Mod 90 Thick Turret UNISTEEL Punch Shape
1	9120F01DU-UNISTEEL	6" Mod 90 Thick Turret UNISTEEL with UNITIN-CR Punch Round
1	9120F01FU-UNISTEEL	6" Mod 90 Thick Turret UNISTEEL with UNITIN-CR Punch Shape
3	9120F03D	6" Mod 90 Thick Turret Stripper Round
3	9120F03F	6" Mod 90 Thick Turret Stripper Shape
4	9110F02D	6" Thick Turret Die Round
4	9110F02F	6" Thick Turret Die Shape
	9110F40-0,5	6" Thick Turret Shim to Die - Thickness .020" (0.5mm)
	9110F40-1,0	6" Thick Turret Shim to Die - Thickness .039" (1.0mm)

PUNCH & DIE GRINDING

Grind Length: 0.236" (6.0mm)

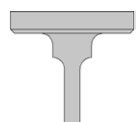


Grind Length: 0.079" (2.0mm)



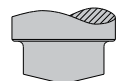
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



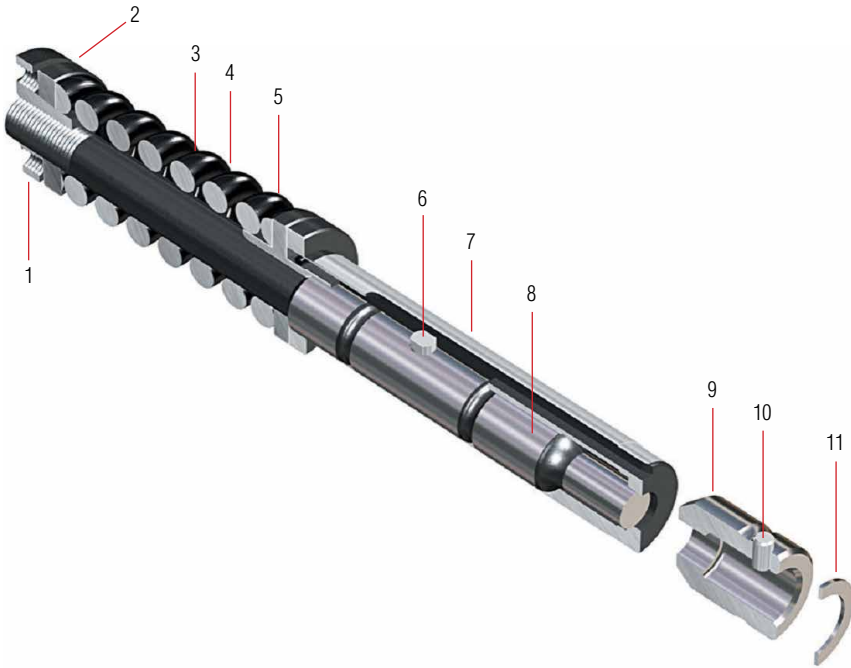
STANDARD

Rooftop



1/2" A STATION – OLD STYLE THICK TURRET

Maximum Diagonal: 0.5" (12.7mm)



OLD STYLE

ITEM	CODE	DESCRIPTION
1	9110A09	1/2" Old Style Thick Turret Punch Head
2	9110A19	1/2" Old Style Thick Turret Lock Nut
3	9110A05	1/2" Old Style Thick Turret Spring
4	9110A10	1/2" Old Style Thick Turret Spring Support
5	9110A28	1/2" Old Style Thick Turret O-Ring
6	9110A08	1/2" Thick Turret Dowel Pin to Punch
7	9110A04D	1/2" Old Style Thick Turret Guide Round
7	9110A04F	1/2" Old Style Thick Turret Guide Shape
8	9110A01D-UNISTEEL	1/2" Old Style Thick Turret UNISTEEL Punch Round
8	9110A01F-UNISTEEL	1/2" Old Style Thick Turret UNISTEEL Punch Shape
8	9110A01DU-UNISTEEL	1/2" Old Style Thick Turret UNISTEEL with UNITIN-CR Punch Round
8	9110A01FU-UNISTEEL	1/2" Old Style Thick Turret UNISTEEL with UNITIN-CR Punch Shape
9	9110A02D	1/2" Thick Turret Die Round
9	9110A02F	1/2" Thick Turret Die Shape
10	9110A07	1/2" Thick Turret Dowel Pin to Die
11	9110A40-0,5	1/2" Thick Turret Shim to Die - Thickness .020" (0.5mm)
11	9110A40-1,0	1/2" Thick Turret Shim to Die - Thickness .039" (1.0mm)
1-5	9110A0P	1/2" A Mod 90 Thick Turret Guide Assembly

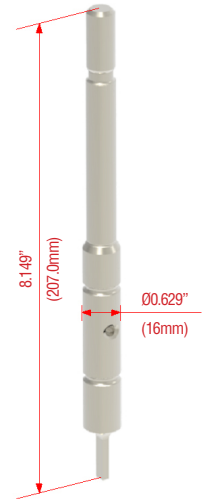
OLD STYLE ABS

ITEM	CODE	DESCRIPTION
7	9110SA04D	1/2" Old Style-ABS Thick Turret Guide Round
7	9110SA04F	1/2" Old Style-ABS Thick Turret Guide Shape
8	9110SA01D-UNISTEEL	1/2" Old Style-ABS Thick Turret UNISTEEL Punch Round
8	9110SA01F-UNISTEEL	1/2" Old Style-ABS Thick Turret UNISTEEL Punch Shape
8	9110SA01DU-UNISTEEL	1/2" Old Style-ABS Thick UNISTEEL with UNITIN-CR Punch Round
8	9110SA01FU-UNISTEEL	1/2" Old Style -ABS Thick UNISTEEL with UNITIN-CR Punch Shape

Be attention: This assembly doesn't use stripper.
The guide has profile of punch. Necessary a guide for each punch.

PUNCH & DIE GRINDING

Grind Length: 0.079" (2.0mm)

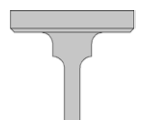


Grind Length: 0.079" (2.0mm)



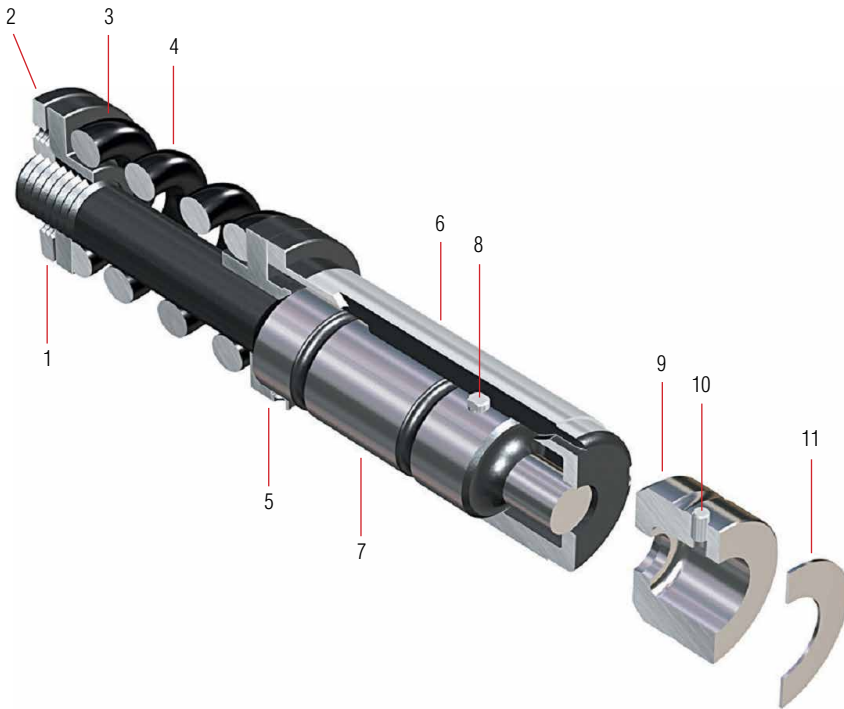
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



1-1/4" B STATION – OLD STYLE THICK TURRET

Maximum Diagonal: 1.25" (31.75mm)



OLD STYLE

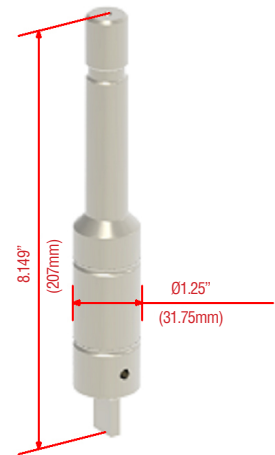
ITEM	CODE	DESCRIPTION
1	9110B09	1-1/4" Old Style Thick Turret Punch Head
2	9110B19	1-1/4" Old Style Thick Turret Lock Nut
3	9110B05	1-1/4" Thick Turret Spring
4	9110B10	1-1/4" Old Style Thick Turret Spring Support
5	10883	Screw
6	9110B04D	1-1/4" Old Style Thick Turret Guide Round
6	9110B04F	1-1/4" Old Style Thick Turret Guide Shape
7	9110B01D-UNISTEEL	1-1/4" Old Style Thick Turret UNISTEEL Punch Round
7	9110B01F-UNISTEEL	1-1/4" Old Style Thick Turret UNISTEEL Punch Shape
7	9110B01DU-UNISTEEL	1-1/4" Old Style Thick T. UNISTEEL with UNITIN-CR Punch Round
7	9110B01FU-UNISTEEL	1-1/4" Old Style Thick T. UNISTEEL with UNITIN-CR Punch Shape
8	9110B08	1-1/4" Thick Turret Dowel Pin to Punch
9	9110B02D	1-1/4" Thick Turret Die Round
9	9110B02F	1-1/4" Thick Turret Die Shape
10	9110A07	1/2" Thick Turret Dowel Pin to Die
11	9110B40-0.5	1-1/4" Thick Turret Shim to Die - Thickness .020" (0.5mm)
11	9110B40-1.0	1-1/4" Thick Turret Shim to Die - Thickness .039" (1.0mm)
1-5	9110B0P	1-1/4" B Old Style Thick Turret Guide Assembly

OLD STYLE ABS

ITEM	CODE	DESCRIPTION
6	9110SB04D	1-1/4" Old Style -ABS Thick Turret Guide Round
6	9110SB04F	1-1/4" Old Style -ABS Thick Turret Guide Shape
7	9110SB01D-UNISTEEL	1-1/4" Old Style-ABS Thick Turret UNISTEEL Punch Round
7	9110SB01F-UNISTEEL	1-1/4" Old Style-ABS Thick Turret UNISTEEL Punch Shape
7	9110SB01DU-UNISTEEL	1-1/4" Old Style -ABS Thick UNISTEEL UNITIN-CR Punch Round
7	9110SB01FU-UNISTEEL	1-1/4" Old Style-ABS Thick UNISTEEL with UNITIN-CR Punch Shape

PUNCH & DIE GRINDING

Grind Length: 0.079" (2.0mm)

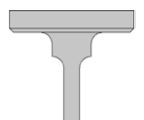


Grind Length: 0.079" (2.0mm)



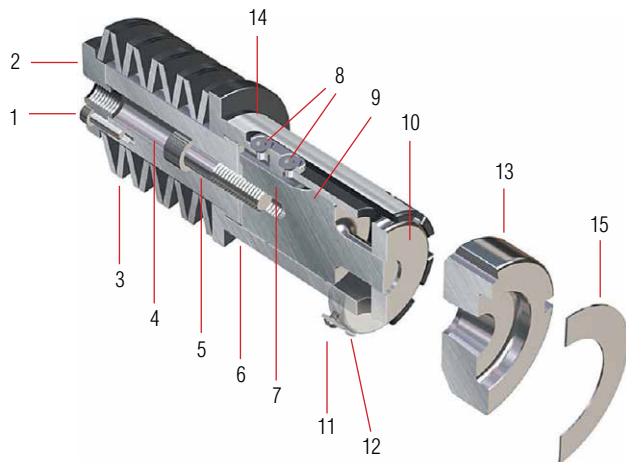
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



2" C STATION – OLD STYLE THICK TURRET

Maximum Diagonal: 2.0" (50.8mm)



OLD STYLE

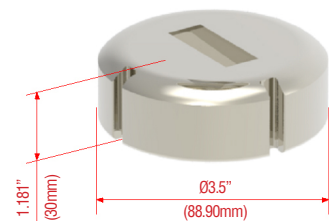
ITEM	CODE	DESCRIPTION
1	10725	Screw
2	9110C09	2" Old Style Thick Turret Punch Head
3	9110C05	2" Old Style Thick Turret Spring
4	9110C17	2" Old Style Thick Turret Retainer
5	10769	Screw
6	9110C04	2" Old Style Thick Turret Guide Round/Shape
7	9110C14	2" Old Style Thick Turret Keying for Guide
8	9110C25	Screw
9	9110C01D-UNISTEEL	2" Old Style Thick Turret UNISTEEL Punch Round
9	9110C01F-UNISTEEL	2" Old Style Thick Turret UNISTEEL Punch Shape
9	9110C01DU-UNISTEEL	2" Old Style Thick Turret UNISTEEL with UNITIN-CR Punch Round
9	9110C01FU-UNISTEEL	2" Old Style Thick Turret UNISTEEL with UNITIN-CR Punch Shape
10	9110C03D	2" Old Style Thick Turret Stripper Round
10	9110C03F	2" Old Style Thick Turret Stripper Shape
11	9110D26	Screw
12	9110D20	2" Old Style Thick Turret Lock to Stripper
13	9110C02D	2" Thick Turret Die Round
13	9110C02F	2" Thick Turret Die Shape
14	9110C39	2" Old Style Thick Turret Shim to Punch - Thickness (0.5 or 1.0mm)
15	9110C40-0,5	2" Thick Turret Shim to Die - Thickness .020" (0.5mm)
15	9110C40-1,0	2" Thick Turret Shim to Die - Thickness .039" (1.0mm)
1-8	9110C0P	2" C Old Style Thick Turret Guide Assembly

PUNCH & DIE GRINDING

Grind Length: 0.079" (2.0mm)



Grind Length: 0.079" (2.0mm)

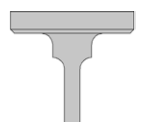


OLD STYLE ABS

ITEM	CODE	DESCRIPTION
9	9110SC01D-UNISTEEL	2" Old Style-ABS Thick Turret UNISTEEL Punch Round
9	9110SC01F-UNISTEEL	2" Old Style-ABS Thick Turret UNISTEEL Punch Shape
9	9110SC01DU-UNISTEEL	2" Old Style-ABS Thick T. UNISTEEL with UNITIN-CR Punch Round
9	9110SC01FU-UNISTEEL	2" Old Style-ABS Thick T. UNISTEEL with UNITIN-CR Punch Shape

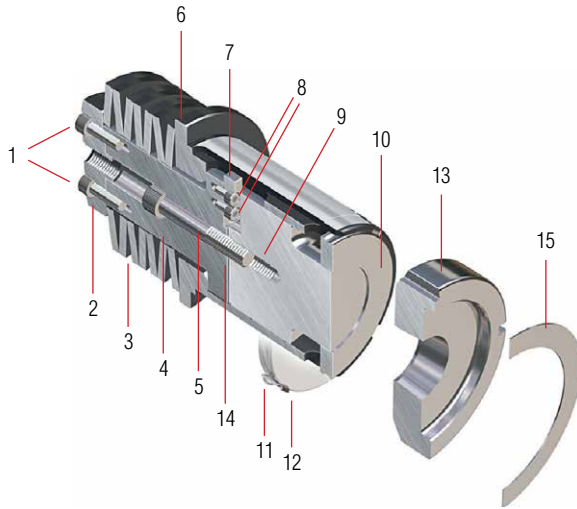
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



3-1/2" D STATION – OLD STYLE THICK TURRET

Maximum Diagonal: 3.5" (88.9mm)



OLD STYLE

ITEM	CODE	DESCRIPTION
1	10736	Screw
2	9110D09	3-1/2" Old Style Thick Turret Punch Head
3	9110D05	3-1/2" Old Style Thick Turret Spring
4	9110D17	3-1/2" Old Style Thick Turret Retainer
5	10771	Screw
6	9110D04	3-1/2" Old Style Thick Turret Guide Round/Shape
7	9110D16	3-1/2" Old Style Thick Turret Keying for Guide
8	10713	Screw
9	9110D01D-UNISTEEL	3-1/2" Old Style Thick Turret UNISTEEL Punch Round
9	9110D01F-UNISTEEL	3-1/2" Old Style Thick Turret UNISTEEL Punch Shape
9	9110D01DU-UNISTEEL	3-1/2" Old Style Thick T. UNISTEEL with UNITIN-CR Punch Round
9	9110D01FU-UNISTEEL	3-1/2" Old Style Thick T. UNISTEEL with UNITIN-CR Punch Shape
10	9110D03D	3-1/2" Old Style Thick Turret Stripper Round
10	9110D03F	3-1/2" Old Style Thick Turret Stripper Shape
11	9110D26	Screw
12	9110D20	3-1/2" Old Style Thick Turret Lock to Stripper
13	9110D02D	3-1/2" Thick Turret Die Round
13	9110D02F	3-1/2" Thick Turret Die Shape
14	9110D39	3-1/2" Old Style Thick T. Shim to Punch - Thickness (0.5 or 1.0mm)
15	9110D40-0,5	3-1/2" Thick Turret Shim to Die - Thickness .020" (0.5mm)
15	9110D40-1,0	3-1/2" Thick Turret Shim to Die - Thickness .039" (1.0mm)
1-8	9110D0P	3-1/2" C Old Style Thick Turret Guide Assembly

OLD STYLE ABS

ITEM	CODE	DESCRIPTION
9	9110SC01D-UNISTEEL	2" Old Style-ABS Thick Turret UNISTEEL Punch Round
9	9110SC01F-UNISTEEL	2" Old Style-ABS Thick Turret UNISTEEL Punch Shape
9	9110SC01DU-UNISTEEL	2" Old Style-ABS Thick T. UNISTEEL with UNITIN-CR Punch Round
9	9110SC01FU-UNISTEEL	2" Old Style-ABS Thick T. UNISTEEL with UNITIN-CR Punch Shape

PUNCH & DIE GRINDING

Grind Length: 0.079" (2.0mm)

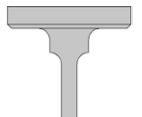


Grind Length: 0.079" (2.0mm)



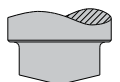
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



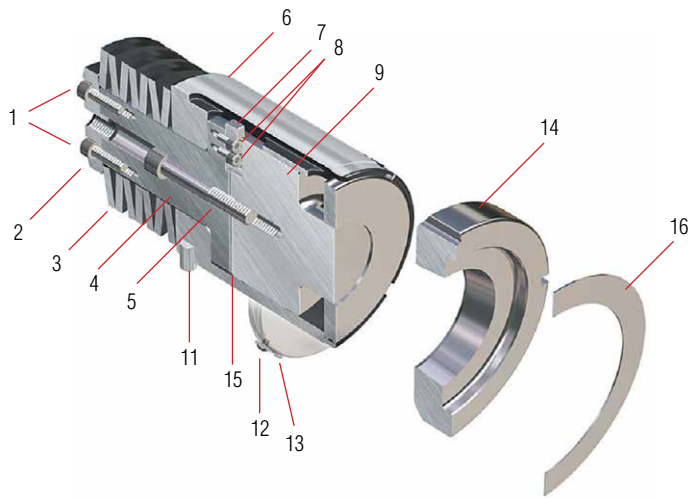
STANDARD

Rooftop



4-1/2" E STATION – OLD STYLE THICK TURRET

Maximum Diagonal: 4.5" (114,3mm)



OLD STYLE

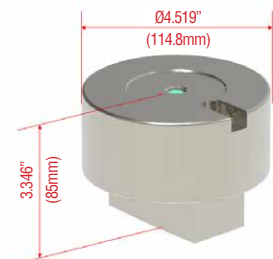
ITEM	CODE	DESCRIPTION
1	10736	Screw
2	9110E09	4-1/2" Old Style Thick Turret Punch Head
3	9110D05	3-1/2" Old Style Thick Turret Spring
4	9110E17	4-1/2" Old Style Thick Turret Retainer
5	10771	Screw
6	9110E04	4-1/2" Old Style Thick Turret Guide Round/Shape
7	9110D16	3-1/2" Old Style Thick Turret Keying for Guide
8	10713	Screw
9	9110E01D-UNISTEEL	4-1/2" Old Style Thick Turret UNISTEEL Punch Round
9	9110E01F-UNISTEEL	4-1/2" Old Style Thick Turret UNISTEEL Punch Shape
9	9110E01DU-UNISTEEL	4-1/2" Old Style Thick T. UNISTEEL with UNITIN-CR Punch Round
9	9110E01FU-UNISTEEL	4-1/2" Old Style Thick T. UNISTEEL with UNITIN-CR Punch Shape
10	9110E03D	4-1/2" Old Style Thick Turret Stripper Round
10	9110E03F	4-1/2" Old Style Thick Turret Stripper Shape
11	9110E27	4-1/2" Old Style Thick Turret Pin Support
12	9110D26	Screw
13	9110D20	3-1/2" Old Style Thick Turret Lock to Stripper
13	9110E02D	4-1/2" Thick Turret Die Round
14	9110E02F	4-1/2" Thick Turret Die Shape
15	9110E39	4-1/2" Old Style Thick T. Shim to Punch - Thickness (0.5 or 1.0mm)
16	9110E40	4-1/2" Thick Turret Shim to Die - Thickness .020" (0.5mm)
16	9110E40	4-1/2" Thick Turret Shim to Die - Thickness .039" (1.0mm)
1-8	9110E0P	4-1/2" C Old Style Thick Turret Guide Assembly

OLD STYLE ABS

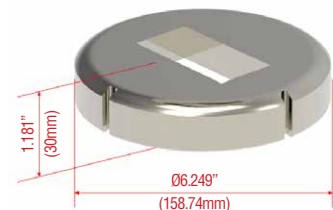
ITEM	CODE	DESCRIPTION
9	9110SE01D-UNISTEEL	4-1/2" Old Style-ABS Thick Turret UNISTEEL Punch Round
9	9110SE01F-UNISTEEL	4-1/2" Old Style-ABS Thick Turret UNISTEEL Punch Shape
9	9110SE01DU-UNISTEEL	4-1/2" Old Style-ABS Thick UNISTEEL with UNITIN-CR Punch Round
9	9110SE01FU-UNISTEEL	4-1/2" Old Style-ABS Thick UNISTEEL with UNITIN-CR Punch Shape

PUNCH & DIE GRINDING

Grind Length: 0.079" (2.0mm)

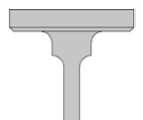


Grind Length: 0.079" (2.0mm)



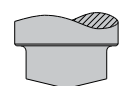
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



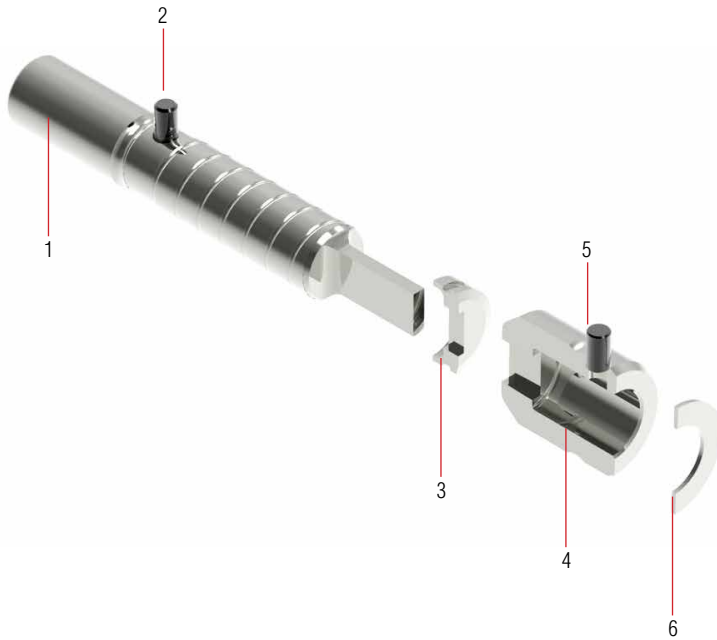
STANDARD

Rooftop



1/2" A STATION – MOD ULTRA THICK TURRET

Maximum Diagonal: 0.5" (12.7mm)



ITEM	CODE	DESCRIPTION
1	9175A01D-UNISTEEL	1/2" Mod Ultra Thick Turret UNISTEEL Punch Round
1	9175A01F-UNISTEEL	1/2" Mod Ultra Thick Turret UNISTEEL Punch Shape
1	9175A01DU-UNISTEEL	1/2" Mod Ultra Thick T. UNISTEEL with UNITIN-CR Punch Round
1	9175A01FU-UNISTEEL	1/2" Mod Ultra Thick T. UNISTEEL with UNITIN-CR Punch Shape
2	9175A08	1/2" Thick Turret Dowel Pin to Punch
3	9175A03D	1/2" Mod Ultra Thick Turret Stripper Round
3	9175A03F	1/2" Mod Ultra Thick Turret Stripper Shape
4	9110A02D	1/2" Thick Turret Die Round
4	9110A02F	1/2" Thick Turret Die Shape
5	9110A07	1/2" Thick Turret Dowel Pin to Die
6	9110A40-0,5	1/2" Thick Turret Shim to Die - Thickness .020" (0.5mm)
6	9110A40-1,0	1/2" Thick Turret Shim to Die - Thickness .039" (1.0mm)

PUNCH & DIE GRINDING

Grind Length: 0.236" (6.0mm)

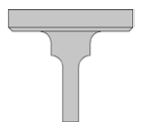


Grind Length: 0.079" (2.0mm)



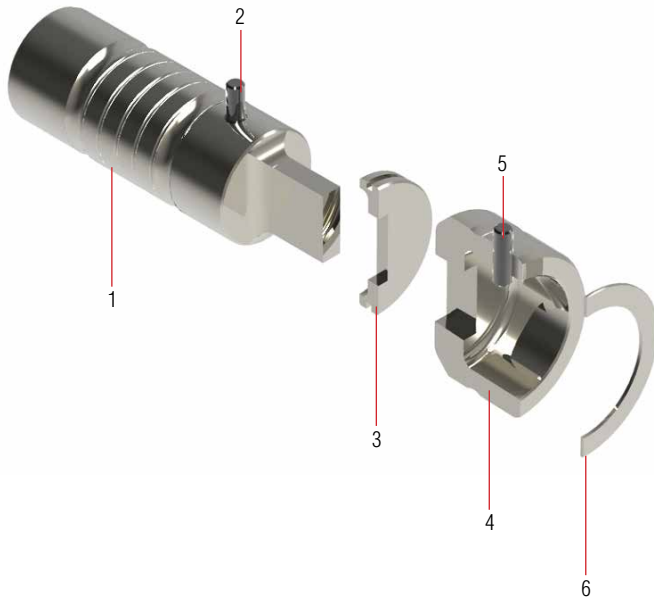
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



1-1/4" B STATION – MOD ULTRA THICK TURRET

Maximum Diagonal: 1.25" (31.75mm)



ITEM	CODE	DESCRIPTION
1	9175B01D-UNISTEEL	1-1/4" Mod Ultra Thick Turret UNISTEEL Punch Round
1	9175B01F-UNISTEEL	1-1/4" Mod Ultra Thick Turret UNISTEEL Punch Shape
1	9175B01DU-UNISTEEL	1-1/4" Mod Ultra Thick T. UNISTEEL with UNITIN-CR Punch Round
1	9175B01FU-UNISTEEL	1-1/4" Mod Ultra Thick T. UNISTEEL with UNITIN-CR Punch Shape
2	9175B08	1-1/4" Thick Turret Dowel Pin to Punch
3	9175B03D	1-1/4" Mod Ultra Thick Turret Stripper Round
3	9175B03F	1-1/4" Mod Ultra Thick Turret Stripper Shape
4	9110B02D	1-1/4" Thick Turret Die Round
4	9110B02F	1-1/4" Thick Turret Die Shape
5	9110B07	1-1/4" Thick Turret Dowel Pin to Die
6	9110B40	1-1/4" Thick Turret Shim to Die - Thickness .020" (0.5mm)
6	9110B40	1-1/4" Thick Turret Shim to Die - Thickness .039" (1.0mm)

PUNCH & DIE GRINDING

Grind Length: 0.236" (6.0mm)

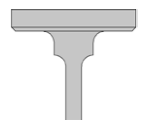


Grind Length: 0.079" (2.0mm)



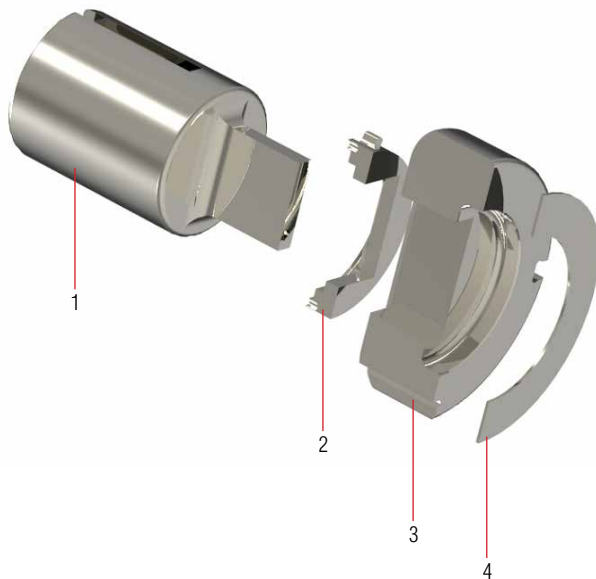
NOTE

Strong Profile
 Standard for Round or Shape with
 dimensions $\leq 0.018"$ (3.0mm)
 Grind Length: 0.079" (2.0mm)



2" C STATION – MOD ULTRA THICK TURRET

Maximum Diagonal: 2.0" (50.8mm)



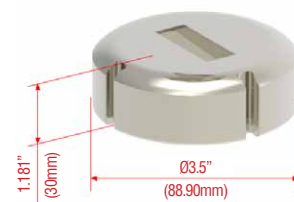
ITEM	CODE	DESCRIPTION
1	9110C01D-UNISTEEL	2" Old Style Thick Turret UNISTEEL Punch Round
1	9110C01F-UNISTEEL	2" Old Style Thick Turret UNISTEEL Punch Shape
1	9110C01DU-UNISTEEL	2" Old Style Thick Turret UNISTEEL with UNITIN-CR Punch Round
1	9110C01FU-UNISTEEL	2" Old Style Thick Turret UNISTEEL with UNITIN-CR Punch Shape
2	9175C03D	2" Mod Ultra Thick Turret Stripper Round
2	9175C03F	2" Mod Ultra Thick Turret Stripper Shape
3	9110C02D	2" Thick Turret Die Round
3	9110C02F	2" Thick Turret Die Shape
4	9110C40-0.5	2" Thick Turret Shim to Die - Thickness .020" (0.5mm)
4	9110C40-1.0	2" Thick Turret Shim to Die - Thickness .039" (1.0mm)

PUNCH & DIE GRINDING

Grind Leight: 0.079" (2.0mm)

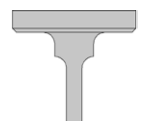


Grind Leight: 0.079" (2.0mm)



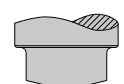
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



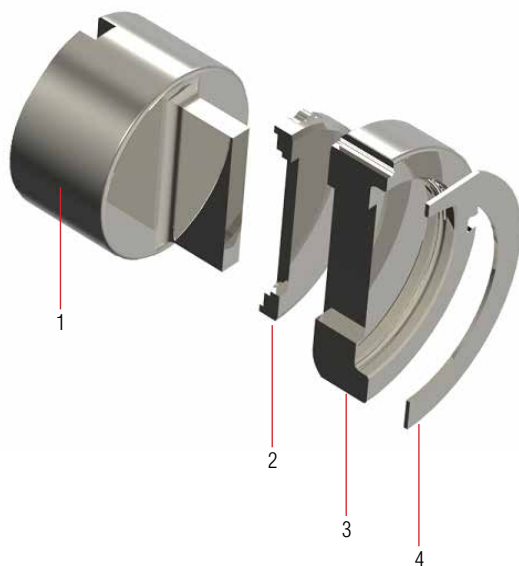
STANDARD

Rooftop



3-1/2" D STATION – MOD ULTRA THICK TURRET

Maximum Diagonal: 3.5" (88.9mm)



ITEM	CODE	DESCRIPTION
1	9110D01D-UNISTEEL	3-1/2" Old Style Thick Turret UNISTEEL Punch Round
1	9110D01F-UNISTEEL	3-1/2" Old Style Thick Turret UNISTEEL Punch Shape
1	9110D01DU-UNISTEEL	3-1/2" Old Style Thick T. UNISTEEL with UNITIN-CR Punch Round
1	9110D01FU-UNISTEEL	3-1/2" Old Style Thick T. UNISTEEL with UNITIN-CR Punch Shape
2	9175D03D	3-1/2" Mod Ultra Thick Turret Stripper Round
2	9175D03F	3-1/2" Mod Ultra Thick Turret Stripper Shape
3	9110D02D	3-1/2" Thick Turret Die Round
3	9110D02F	3-1/2" Thick Turret Die Shape
4	9110D40	3-1/2" Thick Turret Shim to Die - Thickness .020" (0.5mm)
4	9110D40	3-1/2" Thick Turret Shim to Die - Thickness .039" (1.0mm)

PUNCH & DIE GRINDING

Grind Length: 0.079" (2.0mm)

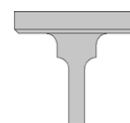


Grind Length: 0.079" (2.0mm)



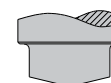
NOTE

Strong Profile
Standard for Round or Shape with
dimensions $\leq 0.018"$ (3.0mm)
Grind Length: 0.079" (2.0mm)



STANDARD

Rooftop



ADAPTER



ITEM	CODE	DESCRIPTION
1	9110BA01	Punch & Guide Ass'y Adapter Thick 1-1/4" to 1/2" Station
2	9110BA02	Die Adapter Thick 1-1/4" to 1/2" Station
3	9110DB01	Punch & Guide Ass'y Adapter Thick 3-1/2" to 1-1/4" Station
4	9110DB02	Die Adapter Thick 3-1/2" to 1-1/4" Station
5	9110DC01	Punch & Guide Ass'y Adapter Thick 3-1/2" to 2" Station

EXAMPLES TO SELECT AND IDENTIFY ABS TOOLS

Punch Mod 90 – ABS (B station)



There are ABS options in Mod 90 only "A" and "B" stations



EXAMPLES TO SELECT AND IDENTIFY ABS TOOLS

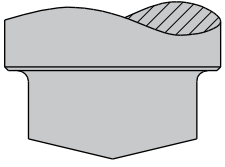
Punch OLD STYLE – ABS (B station)



Be attention – A and B station Guides for Old Style ABS, aren't the same "Old Style Standard" (without ABS)

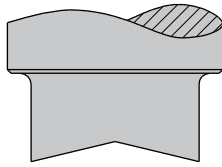
SHEAR CONFIGURATION / STANDARD SHAPES

SHEAR OPTIONS



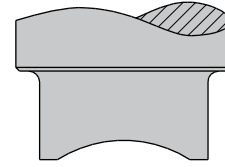
Rooftop

Standard for Stations D, E, F. A good option for reduce the cutting force and noise.



Inverted Rooftop

Better shear for Nibbling



Concave

Best Shear for Nibbling

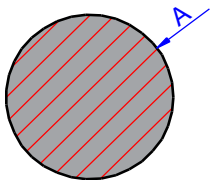
LIMITATION

Not good for nibbling. It is necessary to have 75% of point length engaged to avoid excessive side load.

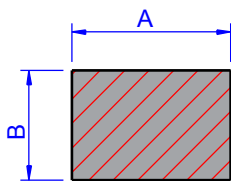
Most likely breakage will occur because of stresses at sharp points.

Not good for high tonnages, because of inverted stresses

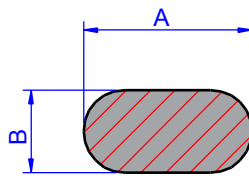
STANDARD SHAPES



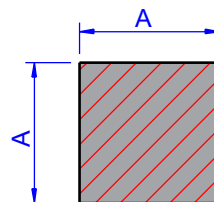
Round



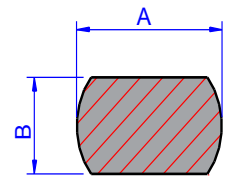
Rectangle



Obround



Square



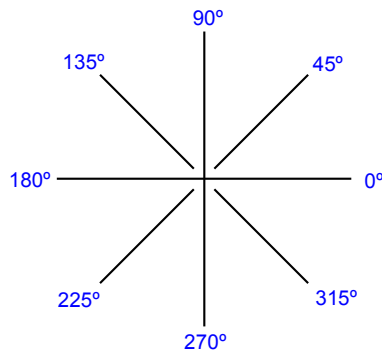
Double-D

PIN OR KEY DIE POSITION

Die Station	Type	Standard	Square Shape
A	Pin	0°	0°
B	Pin	0°	0°
C	Key	0° and 270°	0° and 315°
D	Key	0° and 270°	0° and 315°
E	Key	0° and 270°	0° and 315°
F	Key	0° and 270°	0° and 315°

When ordering shapes at non-standard, Use the diagrams below

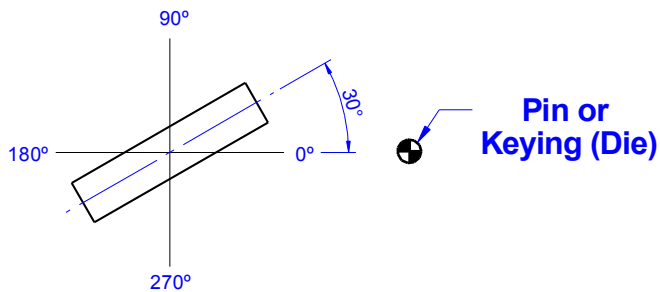
Unistamp Tool's keying diagram



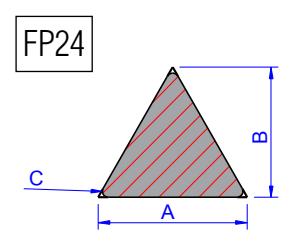
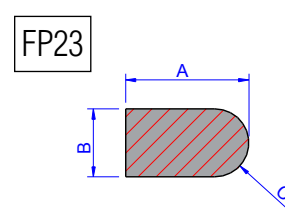
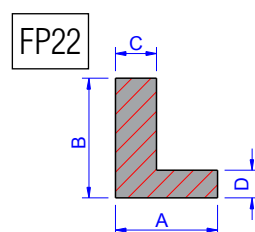
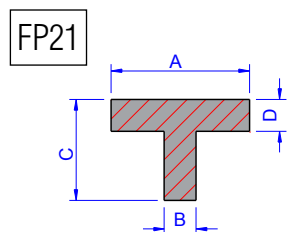
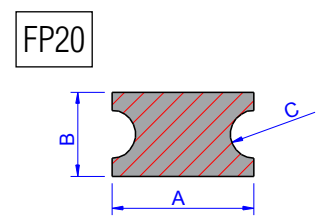
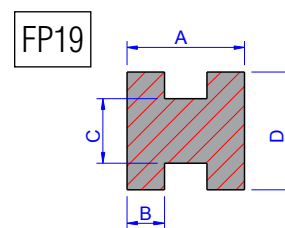
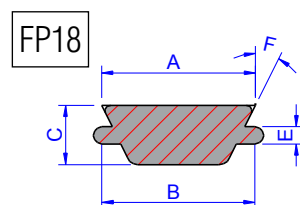
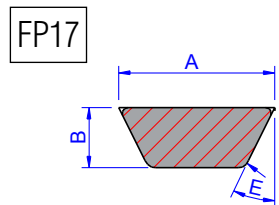
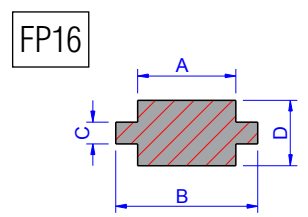
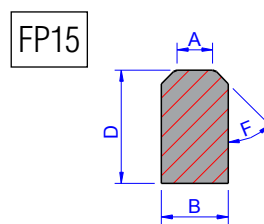
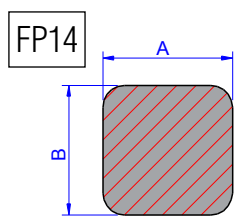
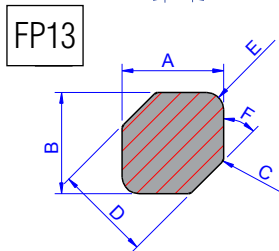
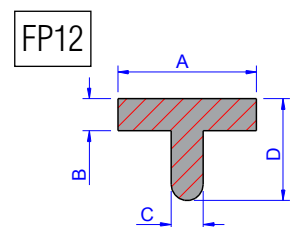
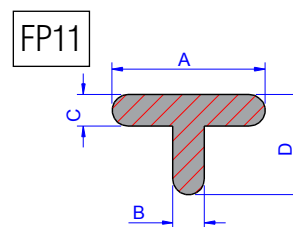
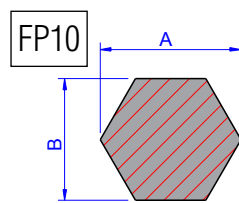
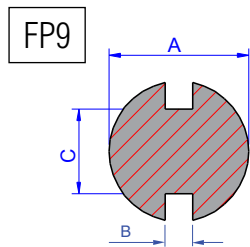
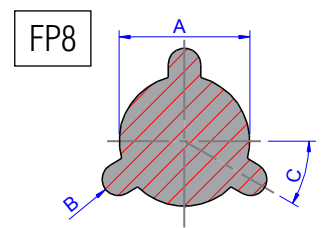
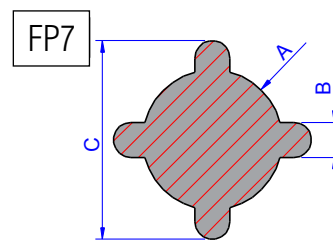
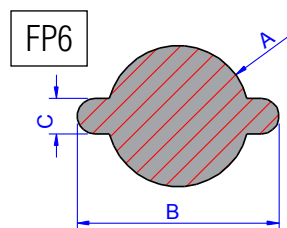
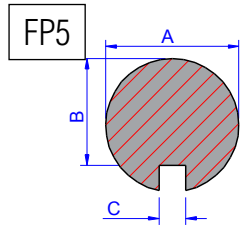
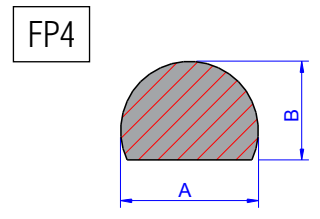
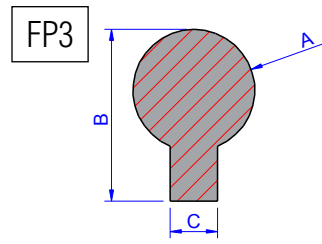
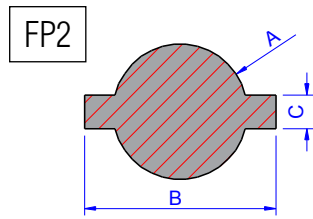
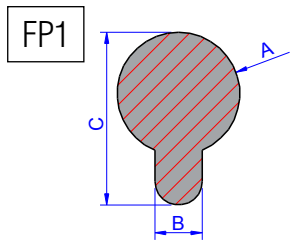
Die View

Example

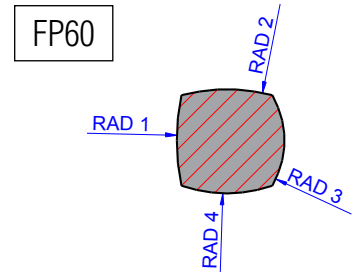
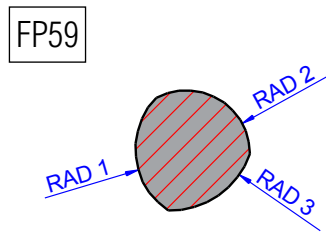
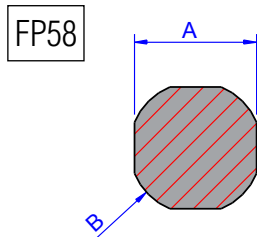
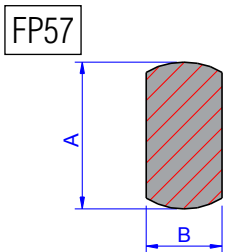
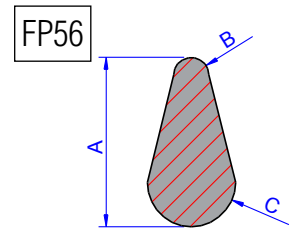
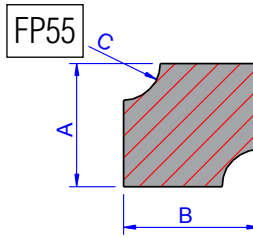
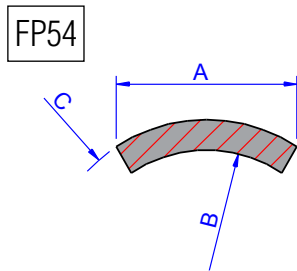
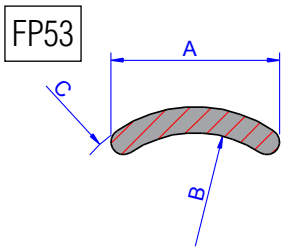
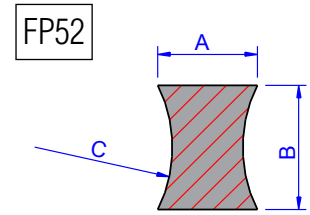
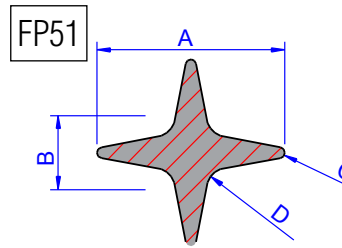
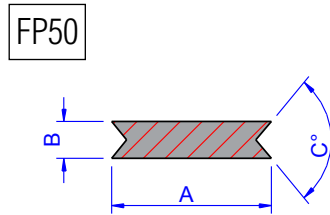
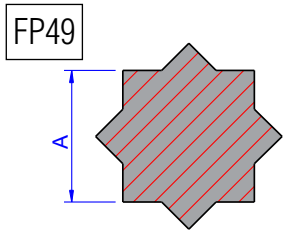
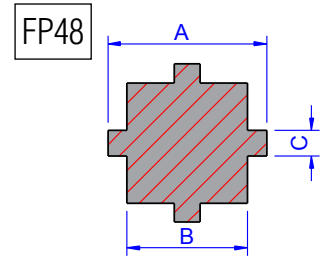
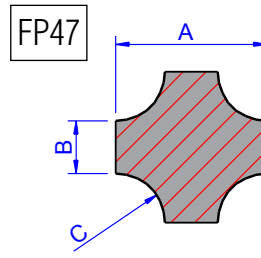
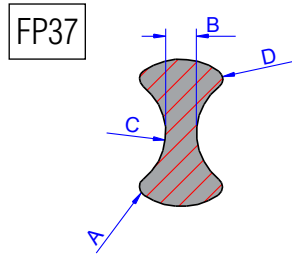
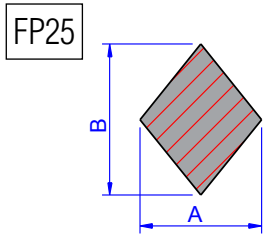
Shape at 30°



SPECIAL SHAPES



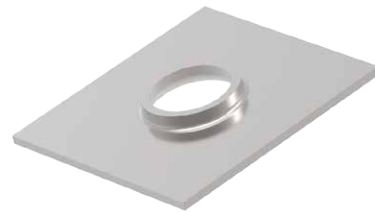
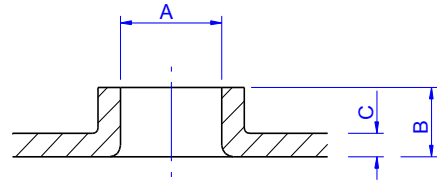
SPECIAL SHAPES



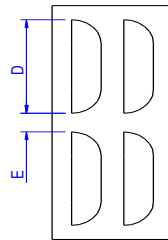
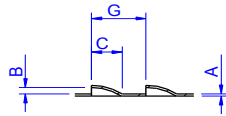
Multiple profiles
Multiple shapes



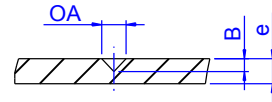
Extrusion (Form-Up)



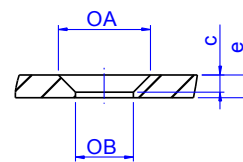
Louvers (Form-Up)



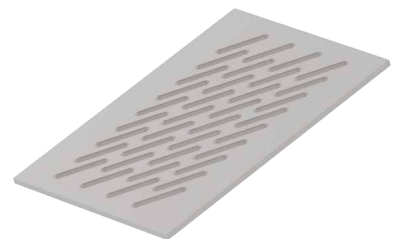
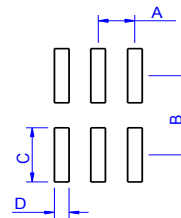
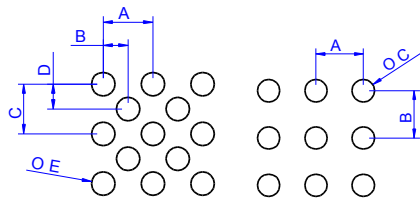
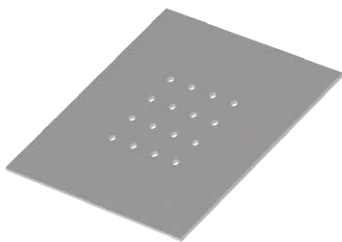
Mark



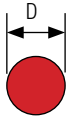
Countersink



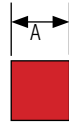
Cluster Tool



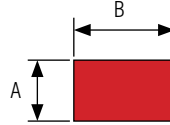
DIAGONAL DEFINITION



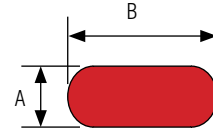
Diag = D



Diag = A x 1.4142



Diag = $\sqrt{A^2 + B^2}$

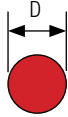


Diag = B

How to choose correct station considering diagonal size?

Situation 1


ROUND HOLE Ø3/8" (0.375")

For round, should to use:  Diag = D
Diagonal = 0.375"

Station A (1/2")

Situation 2

SQUARE SHAPE 7/8" (0.875")

For round, should to use:  Diag = A x 1.4142
Diag = 0.875" x 1.4142 = 1.237"

Diagonal = 1.237"

Station B (1 1/4")

CUTTING FORCE


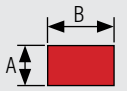

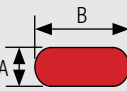
$$Cf = P \cdot t \cdot \tau$$

Cf = Cutting force
P = Shape perimeter
t = Plate thickness
 τ = Shear Stress

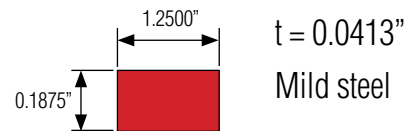
Shear Stress

Aluminium	≈21,320 psi (*)	≈147 MPa (*)
Mild steel	≈56,564 psi (*)	≈390 MPa (*)
Stainless steel	≈84,121 psi (*)	≈580 MPa (*)

Shape perimeter

	$P = D \cdot 3.1416$		$P = 2 \times (A+B)$
	$P = D \cdot 3.1416$		$P = 2 \times (B-A) + (A \times 3.1416)$

Situation 1



$$P = 2 \times (A + B)$$

$$P = 2 \times (0.1875 + 1.2500)$$

$$P = 2.875"$$

$$Cf = 2.875 \times 0.0413 \times 56,564$$

$$Cf = 6,716 \text{ lbs}$$





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