

NOTCHING AND PUNCHING MACHINES





Notching machines

MRA - Manual pipe notchers

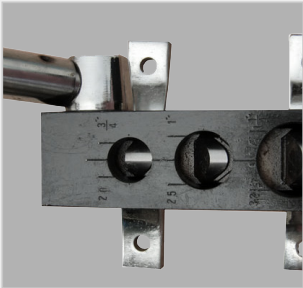
- ▶ For notching pipes up to 4.5 mm wall thickness
- ▶ Can be used both horizontally as well as vertically
- ▶ Low effort required due to large lever

Scope of delivery:
› knife set

Model	MRA 2	MRA 3
Art. no.	3772992	3772993
Technical data		
Pipe diameter	28 / 34 / 43 mm	50 / 61 mm
Wall thickness (aluminium)	4.5 mm	4.5 mm
Wandstärke (Kupfer)	4 mm	4 mm
Wandstärke (Messing)	4 mm	4 mm
Wall thickness (structural steel)	3 mm	3 mm
Wall thickness (stainless steel)	2 mm	2 mm
Dimensions (L x W x H) approx. with DPA	1060 x 160 x 80 mm	1090 x 160 x 105 mm
Weight approx.	8 kg	15 kg



MRA 2



Up to three different pipe diameters can be notched (MRA2)

Spare blade set	Art. no.
for MRA 2	3772996
for MRA 3	3772997

AKM 100 T - Manual notching machine

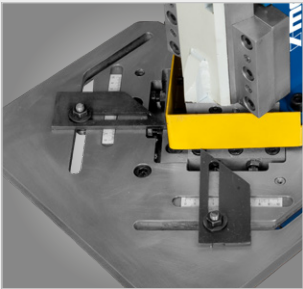
- ▶ Quick and easy right-angled notching with a burr-free cut and without bending the cut edges
- ▶ For punching out corners, shapes, etc.
- ▶ Robust construction made of high-quality grey cast iron
- ▶ Adjustable stops for efficient working (repeatability of the notching process)
- ▶ With scale on the lower cutting edge

Scope of delivery:
› Blade

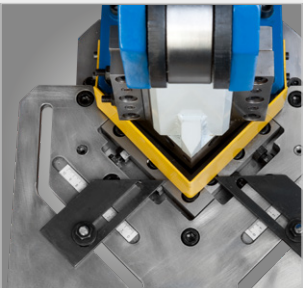
Model	AKM 100 T
Art. no.	3770512
Technical data	
Cutting capacity (400 N/mm ²)	3 mm
Cutting range (L x W)	100 x 100 mm
Cutting angle	90°
Work table (L x W)	380 x 280 mm
Stroke adjustment	30 mm
Dimensions (L x W x H) approx.	450 x 390 x 1020 mm
Weight approx.	90 kg



AKM 100 T
Manual notching machine



Robust steel construction



Scale setting

Accessory	Art. no.
Replacement blade AKM 100 T	3880701

AKM P - Pneumatic notching machines for quick and easy right-angled notching of sheet metal

- ▶ Stable design
- ▶ User-friendly and energy-saving thanks to pneumatic drive
- ▶ Solid table with recessed scales and T-slots for precise adjustment of the swivelling stops
- ▶ Plexiglas finger protection cover for an optimum view of the cutting edge
- ▶ Operation via foot pedal



AKM 131-3 P



AKM 151-3 P

Model	AKM 131-3 P	AKM 151-2 P
Art. no.	3834130	3834150

Technical data		
Cutting capacity 90° (400 N/mm²)	3 mm	2 mm
Cutting capacity 90° (600 N/mm²)	1.5 mm	1 mm
Cutting range (L x W)	130 x 130 mm	150 x 150 mm
Notch angle	90°	90°
Working pressure	8 bar	8 bar
Work table (L x W x H)	600 x 460 x 950 mm	600 x 460 x 950 mm
Dimensions (L x W x H) approx.	730 x 600 x 1260 mm	730 x 600 x 1260 mm
Weight approx.	188 kg	190 kg

Accessories AKM 131- 3 P		Art. no.
Measuring set, top AKM 131-3 P		3834901
Measuring set, bottom AKM 131-3 P		3834902

Accessories AKM 151- 2 P		Art. no.
Measuring set, top AKM 151-2 P		3834905
Measuring set, bottom AKM 151-2 P		3834906

Hydraulic notching machines

AKM H– For fast right-angled notching of sheet metal

- ▶ Cutting thickness up to 4 mm
- ▶ Operation via foot pedal
- ▶ Intuitive control panel and ergonomic design make handling easier
- ▶ Compact and space-saving, ideal for workshops with limited space
- ▶ User-friendly and energy-saving thanks to hydraulic drive



AKM 200-4 H



AKM 250-6 H

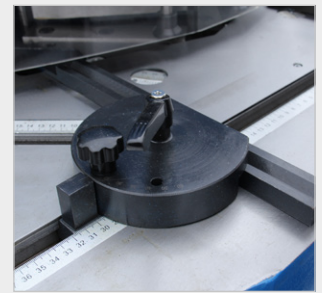
Model		AKM 200-4 H	AKM 250-6 H
Article no.		3830204	3830256
Cutting areas length x width	mm	197 x 197	250 x 250
Cutting capacity (400 N/mm ²)	mm	4	6
Cutting capacity (600N/mm ²) ⁽¹⁾	mm	2	3
Cutting angle	°	90	90
Number of strokes	/min	20	25
Work table length x width	mm	690 x 700	810 x 750
Worktable height	mm	950	952
Oil tank capacity	l	45	45
Working pressure	bar	120	200
Drive motor power	kW	3	4
Motor power ~50 Hz	V	400	400
Dimensions (L x W x H) approx.	mm	890x780x1170	950x780x1170
Weight approx.	kg	548	583

(1) Optional blade set required

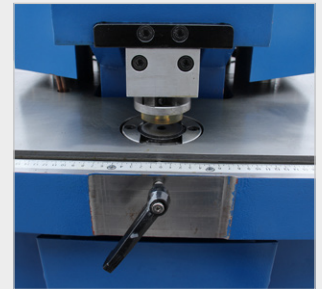
Spare blade set	Art. no.
AKM 200-4H	3839070
AKM 250-6H	3839075
Accessory	Art. no.
Hydraulic oil HLP 46 Precis 20l	3880041

AKM 200— 6 VP- Ausklinkmaschine mit Stanzstation für schnelles Notching with variable angle and for hole punching

- ▶ User-friendly and energy-saving thanks to hydraulic drive
- ▶ Solid table with recessed scales and T-slots for precise adjustment of the swivelling stops
- ▶ Heavy, stable construction
- ▶ Precise angle adjustment via two handwheels and angle display
- ▶ Standard blade set suitable for 6 mm steel and 3 mm stainless steel
- ▶ Transparent finger guard for an optimal view of the cutting edge
- ▶ Punching station with 12 tonnes of punching pressure at the rear
- ▶ Operation via pedal



Precise angle adjustment using stops and scales



Punching station at the rear



Model		AKM 200-6 VP
Art. no.		3837060
Technical data		
Cutting capacity 140°-65° (400N/mm²)	mm	6
Cutting capacity 140°-65° (600N/mm²)	mm	3
Cutting capacity 65°-30° (400N/mm²)	mm	3
Cutting capacity 65°-30° (600N/mm²)	mm	1.5
Cutting force max.	t	12
Cutting range (L x W)	mm	200 x 200
Cutting angle	°	30 – 140
Strokes	/min	15
Punching force	t	12
Maximum punch hole diameter ⁽¹⁾	mm	40
Work table (L x W x H)	mm	985 x 900 x 945
Drive motor power ~ 50 Hz	kW/V	4 / 400
Dimensions (L x W x H) approx.	mm	1065 x 900 x 1210
Weight approx.	kg	1020

(1) Material thickness 2.5 mm at 400N/mm²

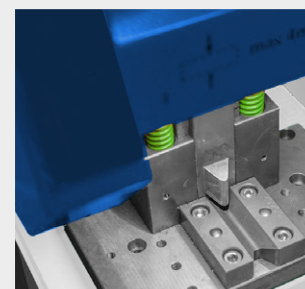
Accessory	Art. no.
Upper replacement blade set	3839060
Lower replacement blade set	3839061

PM 10 M - Motorised punching machine with Automatic mode 10t pressing force

- ▶ For precise and fast punching and cutting work thanks to powerful eccentric mechanism
- ▶ Two working modes selectable:
Automatic mode: The machine performs 30 cuts per minute and therefore saves time when processing workpieces with several identical punching cuts
Manual mode: The machine rotates when the foot switch is pressed
- ▶ Illuminated work area
- ▶ Storage option for punching and cutting tools in the substructure
- ▶ Recesses in the substructure for easy transport with a forklift truck
- ▶ Tools must be ordered separately depending on the application, not included in the scope of delivery

Model		PM 10 M
Art. no.		3818310

Technical data		
Punching force	t	10
Drive motor power ~50 Hz	kW/V	2.2 / 400
Dimensions (L x W x H) approx.	mm	680 x 430 x 1400
Weight approx.	kg	250



Illuminated work area



Storage option for punching and cutting tools in the substructure Recesses in the substructure for easy transport with a forklift truck

PM 16 H - Hydraulic punching machine for cutting, punching, deep drawing, levelling and embossing with 16 t pressing force

- ▶ Variable forward and return flow limitation through adjustable limit switches
- ▶ Use of a wide variety of tools possible thanks to the variable forward and return flow limitation
- ▶ Simple attachment of tools and devices to the worktable via M12 holes
- ▶ Interchangeable tables enable workpieces of different sizes to be processed
- ▶ Actuation of the lifting cylinder via foot switch
- ▶ Pressure adjustment via hydraulic valve
- ▶ Recess in the worktable for cutting waste
- ▶ Storage option for punching and cutting tools in the substructure
- ▶ Die holder not included in the scope of delivery

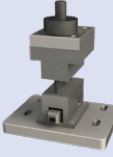
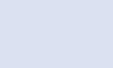
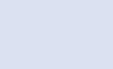
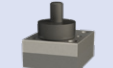
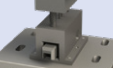
Model		PM 16 H
Art. no.		3818316

Technical data		
Punching force	t	16
Ø) in max. sheet thickness (400 N/mm ²)	mm	12 x 10
Ø max. x sheet thickness (steel 400 N/mm ²)	mm	30 x 4
Stroke distance max.	mm	70
Drive motor power ~50 Hz	kW/V	2.2/400
Dimensions (L x W x H) approx.	mm	800 x 450 x 1430
Weight approx.	kg	420





Model	Art. no.	PM 10 M Art no. 3818310	PM 16 H Art no. 3818316
 Wedge-shaped punching tool	3889100	●	●
 Wedge-shaped punching tool for corners	3889101	●	●
 Punching tool for notching pipes Ø26.9 mm / 3/4"	3889103	●	●
Punching tool for notching pipes Ø33.7mm / 1"	3889104	●	●
Punching tool for notching pipes Ø42.4mm / 1 1/4"	3889105	●	●
Punching tool for notching pipes Ø26.9 mm / 1 1/2"	3889106	●	●
 Punching tool for cutting flat steel max. 50 x 4 mm	3889107	●	●
 Punching tool for cutting bar steel max. Ø12mm - quality cut (specification of desired diameter required)	3889108	●	●
 Punching tool for cutting steel bars max. Ø12mm - Separating cut simultaneous cutting of several bars possible of several bars possible up to max. width 50 mm	3889109	●	●
 Punching tool for punching holes with Ø6mm in profiles up to max. 40 x 40 x 2 mm for hanging	3889110	●	●
 Punching tool for notching up to max. 100x100x3mm	3889111	●	●
 Punching tool for cutting angle steel up to max 35 x 35 x 3mm	3889112	●	●
 Punching tool for rounding off sheet metal corners R10 / 15 / 20 / 28 up to max. 5mm	3889113	●	●
 Holder for matrices	3889116		●

Model	Art. no.	PM 10 M Art no. 3818310	PM 16 H Art no. 3818316
 Punch and die set consisting of: Punch and die for Ø6.5mm Punch and die for Ø8.5mm Punch and die for Ø9.5mm Punch and die for Ø10.5mm Punch and die for Ø12.5mm Punch and die for Ø14.5mm Punch and die for Ø16.5mm Punch and die for Ø18.5mm	3889117		●
 Punch and die for Ø6.5mm	3889118		●
 Punch and die for Ø8.5mm	3889119		●
 Punch and die for Ø9.5mm	3889120		●
 Punch and die for Ø10.5mm	3889121		●
 Punch and die for Ø12.5mm	3889122		●
 Punch and die for Ø14.5mm	3889123		●
 Punch and die for Ø16.5mm	3889124		●
 Punch and die for Ø18.5mm	3889125		●
Top tool LG 85° H=66.6mm / R0.8 / L=415mm	388126000415		●
Upper tool LG 85° split H=66.6mm / R0.8 / L=805mm sect.	388126000F00		●
Multi-V die 85°/ W=60mm V=16/22/35/50mm / L=415mm	388206700415		●
Multi-V die 85°/ W=60mm V=16/22/35/50mm / L=835mm	388206700835		●
Multi-V die 85°/ B=60mm divided V=16/22/35/50mm / L=415mm sect.	388206700F00		●

Further accessories available on request

Grooving machine

NZM 20 - Grooving machine for the production of grooves up to 30x20mm

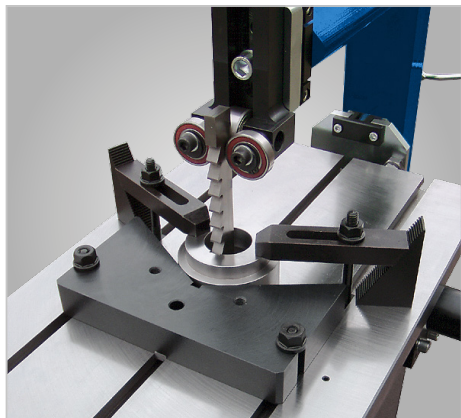
- ▶ Grooves are drawn in a vertical direction. This has advantages over grooving: Higher accuracy and better surface finish; higher cutting speed
- ▶ Quick and easy tool change
- ▶ No wandering of the clearing tool during machining thanks to three-sided ball bearing guide on the top of the cutter
- ▶ The vertical angle of the broach to the workpiece can be finely adjusted using a rotary wheel.
- ▶ Table feed is manual via large hand lever
- ▶ Extremely robust and low-maintenance design
- ▶ Tool arm can be tilted backwards for convenient workpiece changes
- ▶ Dividing plate with various angle divisions available as an accessory, enables precise and fast clamping and reclamping of workpieces



Scope of delivery:

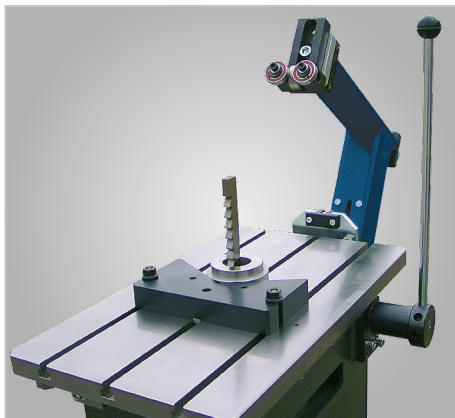
- > Two clamping prisms

Model		NZM 20
Article no.		3818420
Electrical data		
Workpiece height min.		Tooth spacing of the broach + 2 mm
Max. workpiece height	mm	90 / 170
Explanation Workpiece height max.		Broach with a width of 5–8 mm / 10–20 mm
Strokes per minute		54
Work table (L x W)	mm	400 x 680
Working height	mm	880
Groove depth max.	mm	30
Groove width max.	mm	20
Power drive motor ~ 50 Hz	kW/V	1.5 / 400
Dimensions (L x W x H) approx.	mm	520 x 1030 x 1200
Weight approx.	kg	330



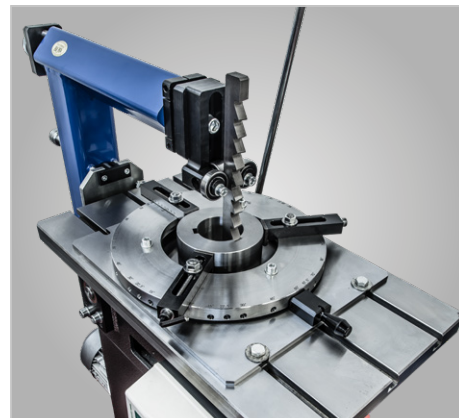
Stable broach guide

Broach is guided by three ball bearings and cannot move



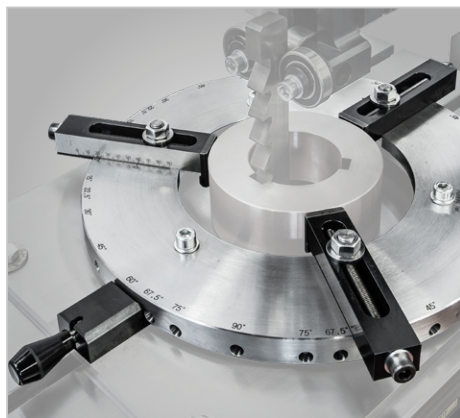
Tool arm

Can be tilted backwards by opening the clamping lever
For convenient workpiece and tool changes



Partial disc (optional accessory)

With different angle divisions
Precise and fast clamping and reclamping of workpieces



Partial disc (item no.: 3889201)

With different angle divisions
Enables precise and rapid clamping and reclamping of workpieces



Partial disc (item no.: 3889201)

With different angle divisions
Enables precise and rapid clamping and reclamping of workpieces

DESIRED GROOVE WIDTH (FITTING DIMENSION)
PLEASE SPECIFY WHEN ORDERING SO THAT THE ROOM NEEDLE
CAN BE GROUND TO THE APPROPRIATE SIZE!



Accessory	Art. no.
Dividing plate for NZM 20	3889201
Broach width 5mm / tooth spacing 7mm	3889205
Broach width 6mm / tooth spacing 10mm	3889206
Broach width 8mm / tooth spacing 14mm	3889208
Broach width 10mm / tooth spacing 18mm	3889210
Broach width 12mm / tooth spacing 18mm	3889212
Broach width 14mm / tooth spacing 22mm	3889214
Broach width 16mm / tooth spacing 22mm	3889216
Broach width 18mm / tooth spacing 25mm	3889218
Broach width 20mm / tooth spacing 25mm	3889220

Hydraulic profile steel shears/hole punches

HPS – Combined hydraulic profile steel shears/hole punches with up to 5 processing stations and foot control

- ▶ Punching station, flat steel shears, angle steel shears, profile steel shears, from HPS 45S with notching station
- ▶ DS series with two working cylinders and two foot pedals for simultaneous operation with punching station and profile steel shears
- ▶ Stepless adjustment of the stroke
- ▶ Larger throat depth for punching station with 620 mm optional, available from HPS 55DS
- ▶ Heavy and stable welded construction
- ▶ With powerful hydraulic unit
- ▶ Two-cylinder machine with electric contact stop
- ▶ V-notch cutter, oversized punching device and larger projection for punching station available on request
- ▶ Comes standard with MUBEA mount for stamps no. 1, no. 2 and no. 3 as well as dies no. 30, no. 45 and no. 60, use of stamps and dies no. 4 and no. 80 optional (except HPS 40S)



HPS 40S

Electrical contact stop (ex works only)

for HPS 45S	3887150
for HPS 60S	3887151



Convince yourself of our capabilities and ask for individual advice!

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Technical data		HPS 40S	HPS 45S	HPS 60S	HPS 55DS	HPS 65DS	HPS 85DS	HPS 115DS	HPS 175DS
Art. no.		3819040	3819045	3819060	3819055	3819065	3819085	3819115	3819175
Punching station									
Punching force	t	40	45	60	55	65	85	115	175
Ø x sheet thickness max. ⁽²⁾	mm	Ø 20 x 15	Ø 22 x 15	Ø 28 x 15	Ø 20 x 20	Ø 26 x 20	Ø 33 x 20	Ø 34 x 26	Ø 40 x 32
Ø max. x sheet thickness ⁽²⁾	mm	Ø 30 x 10	Ø 38 x 8	Ø 38 x 11	Ø 40 x 10	Ø 57 x 10 ⁽³⁾	Ø 57 x 10 ⁽³⁾	Ø 55 x 16 ⁽³⁾	Ø 57 x 22 ⁽³⁾
Throat depth	mm	175	175	220	255 mm	305	355	355	625
Stroke	mm	50	50	55	60 mm	55	80	80	80
Stroke / min.	mm	20	20	25	25	25	25	25	22
Working height hole punch	mm	970	955	955	1030	1030	1080	1110	1130
Bar steel shears									
Round/square	mm	Ø 30 / 25	Ø 30 / 25	Ø 40 / 35	Ø 40 / 40	Ø 45 / 45	Ø 50 / 50	Ø 55 / 50	Ø 65 / 50
Angle steel shears									
90° cut	mm	80 x 80 x 8	100 x 100 x 10	120 x 120 x 12	120 x 120 x 12	120 x 120 x 12	150 x 150 x 15	150 x 150 x 15	200 x 200 x 15
45° cut	mm	50 x 50 x 6	70 x 70 x 6	80 x 80 x 8	70 x 70 x 10	70 x 70 x 10	80 x 80 x 8	80 x 80 x 10	80 x 80 x 10
Working height		1100	1140	1155	1130	1140	1200	1215	1130
Flat steel shears									
Material thickness max.	mm	200 x 13	200 x 15	200 x 20	200 x 20	300 x 20	380 x 20	380 x 25	380 x 30
Material size max.	mm	300 x 6	300 x 12	300 x 15	300 x 15	375 x 15	480 x 15	600 x 15	600 x 20
Blade length	mm	356	316	317	317	380	482	610	610
45° cut with angle profile max.	mm	80 x 80 x 10	80 x 80 x 10	80 x 80 x 10	80 x 80 x 15	100 x 100 x 15	120 x 120 x 15	120 x 120 x 15	120 x 120 x 15
Working height	mm	980	955	955	900	900	940	935	810
Notching station									
Material thickness max.	mm	-	8	10	10	10	13	13	16
Width	mm	-	35	42	45	45	52	60	60
Depth	mm	-	75	100	90	90	100	100	100
Motor power ~50 Hz	kW/V	3 / 400	4 / 400	4 / 400	5.5 / 400	5.5 / 400	7.5 / 400	11 / 400	11 / 400
Weight approx.	kg	580	1400	1440	1520	1600	2315	2920	6000
Dimensions (LxWxH) approx.	mm	1100 x 800 x 1520	1500 x 950 x 1680	1520 x 950 x 1780	1500 x 950 x 1880	1700 x 950 x 1880	1920 x 950 x 2040	2040 x 950 x 2180	2730 x 1150 x 2280
Optional equipment (see Seite 229)									
Projection of the punching station		-	-	-	620	620	620	620	-
U-I profile blade	mm	76 x 38	80 x 45	80 x 45	120 x 58	120 x 58	160 x 74	200 x 90	300 x 125
T-profile blade	mm	38 x 6	40 x 5	80 x 9	80 x 9	90 x 11	100 x 11	120 x 13	150 x 15
V-notching tools	mm	100 x 100 x 8	100 x 100 x 8	100 x 100 x 10	100 x 100 x 10	100 x 100 x 10	100 x 100 x 13	100 x 100 x 13	100 x 100 x 16

(2) Performance data based on material with tensile strength of 400 N/mm² (3) Oversized punching device option required



HPS 40S

Scope of delivery HPS 40S:

- › Punching station
- › Flat steel shears
- › Angle steel shears
- › Profile steel shears with round and square blades
- › Stamp holder with bayonet lock
- › MUBEA stamp holders No. 1, No. 2, No. 3
- › MUBEA die reduction system No. 30 and No. 45 (No. 60 is inserted directly into the punching saddle)
- › Punch and flat steel shears with adjustable stops
- › Hook wrench
- › Foot pedal
- › Hydraulic oil



HPS 45S

Scope of delivery HPS 45S/ HPS 60S:

- › Punching station
- › Flat steel shears
- › Angle steel shears
- › Profile steel shears with round and square blades
- › Notching station
- › Stamp holder with bayonet lock
- › MUBEA stamp holders No. 1, No. 2, No. 3
- › MUBEA die reduction system No. 30 and No. 45 (No. 60 is inserted directly into the punching saddle)
- › Punch, flat steel shears and notcher with adjustable stops
- › Hook wrench
- › Foot pedal
- › Hydraulic oil



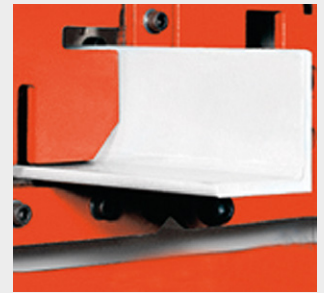
HPS 55DS

Scope of delivery HPS 55DS / HPS 65DS / HPS 85DS / HPS 115DS / HPS 175DS:

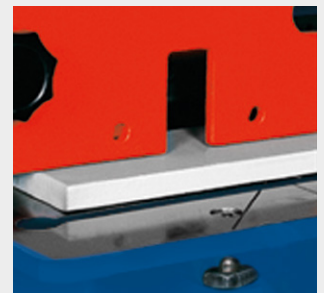
- › Punching station
- › Flat steel shears
- › Angle steel shears
- › Profile steel shears with round and square blades
- › Notching station
- › LED workplace lighting
- › Electrical contact stop
- › Stamp holder with bayonet lock
- › MUBEA stamp holders No. 1 / 2 / 3
- › MUBEA die reductions No. 30/45 (No. 60 is inserted directly into the punching saddle)
- › Punch with adjustable stop with scale, flat steel shears and notcher with adjustable stops
- › Hook wrench
- › 2 working cylinders and 2 foot pedals
- › Hydraulic oil



Punching station



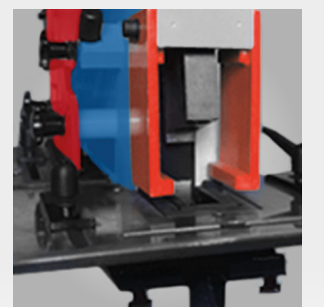
Angle steel shears



Flat steel shears



Bar steel shears / Round steel blade



Notching station (from HPS 45S)

Drilling

Deburring

Laser cutting

Circular saws

Roller conveyors

Metal-cutting band saws

Cutting

Presses

Notching & punching

Bending

Metal grinding

Hydraulic profile steel shears/hole punches



HPS 115DS



HPS 175DS



Electrical contact stop (standard from HPS 55DS)



Work light (standard from HPS 55DS)



Various profile steel blades, punching saddles, special punches and dies available on request.

Scope of delivery HPS 55DS / HPS 65DS / HPS 85DS / HPS 115DS / HPS 175DS:

- › Punching station
- › Flat steel shears
- › Angle steel shears
- › Profile steel shears with round and square blades
- › Notching station
- › LED workplace lighting
- › Electrical contact stop
- › Stamp holder with bayonet lock
- › MUBE stamp holders No. 1 / 2 / 3
- › MUBE die reductions No. 30/45 (No. 60 is inserted directly into the punching saddle)
- › Punch with adjustable stop with scale, flat steel shears and notcher with adjustable stops
- › Hook wrench
- › 2 working cylinders and 2 foot pedals
- › Hydraulic oil

Accessories for hydraulic profile steel shears

Spare blade set for flat steel station	Art. no.
For HPS 40S/ 40S	3887010
for HPS 60S	3887011
For HPS 55DS/ 55DS	3887012
for HPS 85DS	3887013
for HPS 115DS	3887014
for HPS 175DS	3887015

Spare blade set for angle steel station	
For HPS 40S/ 40S	3887020
for HPS 60S	3887021
For HPS 55DS/ 55DS	3887022
for HPS 85DS	3887023
for HPS 115DS	3887024
for HPS 175DS	3887025

Spare blade set for steel bar station	
For HPS 40S/ 40S	3887026
for HPS 60S	3887027
For HPS 55DS/ 55DS	3887028
for HPS 85DS	3887029
for HPS 115DS	3887030
for HPS 175DS	3887031

Replacement blade set for notching station	
for HPS 45S	3887040
for HPS 60S	3887041
For HPS 55DS/ 55DS	3887042
for HPS 85DS	3887043
for HPS 115DS	3887044
for HPS 175DS	3887045

Oversized punching device (suitable for all standard HPS models)	
for HPS 45S	3887160
for HPS 60S	3887161
for HPS 55DS	3887162
for HPS 65DS	3887163
for HPS 85 DS	3887164
for HPS 115DS	3887165
for HPS 175DS	3887166

Blade set for IPN profiles	Art. no.
For HPS 40S/ 40S	3887050
for HPS 60S	3887051
For HPS 55DS/ 55DS	3887052
for HPS 85DS	3887053
for HPS 115DS	3887054
for HPS 175DS	3887055

Measuring set for UPN profiles	
For HPS 40S/ 40S	3887060
for HPS 60S	3887061
For HPS 55DS/ 55DS	3887062
for HPS 85DS	3887063
for HPS 115DS	3887064
for HPS 175DS	3887065

Measuring set for T-profiles	
For HPS 40S/ 40S	3887070
for HPS 60S	3887071
For HPS 55DS/ 55DS	3887072
for HPS 85DS	3887073
for HPS 115DS	3887074
for HPS 175DS	3887075

Holder and table V-knife set 100 x 100 mm (for notching station)	
for HPS 45S	
for HPS 60S	3887131
for HPS 55DS	3887132
for HPS 65DS	3887133
for HPS 85 DS	3887134
for HPS 115DS	3887135
for HPS 175DS	3887136

V-shaped replacement knife set 100 x 100 mm	
for HPS 45S	3887080
for HPS 60S	3887081
For HPS 55DS/ 55DS	3887082
for HPS 85DS	3887083
for HPS 115DS	3887084
for HPS 175DS	3887085

Electrical contact stop (ex works only)	
for HPS 45S	3887150
for HPS 60S	3887151

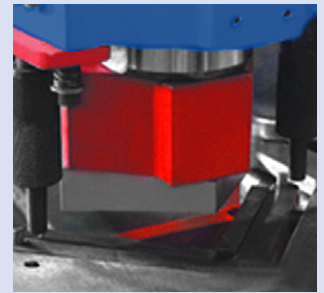
Folding device	Art. no.
100 x 12 mm for HPS 45S	3887090
110 x 12 mm for HPS 60S	3887091
250 x 15 mm for HPS 55DS / 65DS	3887092
500 x 3 mm for HPS 55DS / 65DS	3887093
250 x 20 mm for HPS 85DS	3887094
500 x 3 mm for HPS 85DS	3887095
250 x 22 mm for HPS 115DS	3887096
500 x 3 mm for HPS 115DS	3887097
250 x 25 mm for HPS 175DS	3887098
700 x 4 mm for HPS 175DS	3887099

Punching saddle for U-profile	
For HPS 40S/ 40S	3887105
for HPS 60S	3887106
For HPS 55DS/ 55DS	3887107
for HPS 85DS	3887108
for HPS 115DS	3887109
for HPS 175DS	3887110

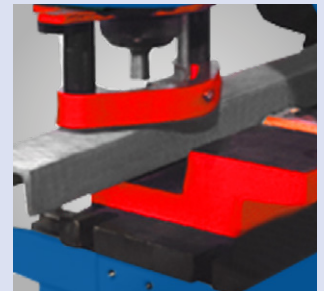
620 mm projection for punching station (only possible ex works)	
for HPS 55DS	3887120
for HPS 65DS	3887121
for HPS 85DS	3887122
for HPS 115DS	3887123

Stamp and die holders (suitable for all standard HPS models)	
Stamp supplement No. 1 ⁽¹⁾	3889002
Stamp reduction No. 1 ⁽¹⁾	3889003
Stamp holder no. 2	3889005
Stamp holder no. 3	3889006
Die reduction 60-30	3889000
Die reduction 60-45	3889001

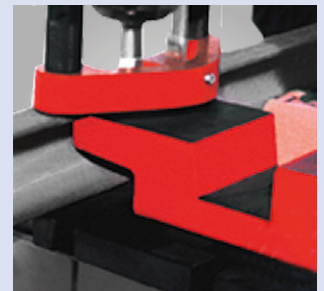
(1) Stamp supplement no. 1, stamp reduction no. 1 and stamp mount no. 2 are required for the use of stamp no. 1.



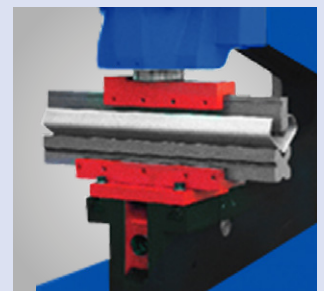
Optional V-notching blade available from HPS 45S upwards



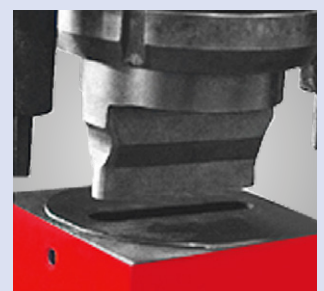
Optional punching saddle for U-profiles



Optional punching saddle for angle iron



Optional bending device for flat steel (available from HPS 45S upwards)



Optional punching device for large diameters

Hydraulic hole punching

HLS - Hydraulic hole punches with foot operation

- ▶ For punching sheet metal, flat and U-shaped steel
- ▶ Heavy and stable welded construction
- ▶ Punching table with scale and stops
- ▶ Particularly large projection of 625 mm
- ▶ Time-saving, stepless stroke adjustment
- ▶ With powerful hydraulic unit
- ▶ Stepless adjustment of the stroke
- ▶ Punch saddle with second mount for machining UPN profiles
- ▶ Comes standard with MUBEA mount for punch no. 1, no. 2 and no. 3 as well as die no. 30, no. 45 and no. 60; use of punch and die no. 4 and no. 80 is optional.



HLS 65S

Please order
to be processed
Specify material type!



Various optional punching
tools on request

Scope of delivery:

- › Stamp holder with bayonet lock
- › MUBEA stamp holders No. 1 / 2 / 3
- › MUBEA die reduction system No. 30 and No. 45 (No. 60 is inserted directly into the punching saddle)
- › Stop with scale
- › Work light
- › Foot pedal
- › Hook wrench
- › Hydraulic oil

Convince yourself of our
capabilities and ask for
individual advice!

+49 95196555-504
beratung@metallkraft.de



Model	HLS 65S	HLS 85S	HLS 115S	HLS 175S
Art. no.	3818065	3818085	3818115	3818175
Technical data				
Punching force	65 t	85 t	115 t	175 t
Ø x sheet thickness max. ⁽²⁾	Ø 26 x 20 mm	Ø 33 x 20 mm	Ø 34 x 26 mm	Ø 40 x 32 mm
Ø max. x sheet thickness ⁽²⁾	Ø 57 x 10 ⁽³⁾ mm	Ø 57 x 12 ⁽³⁾ mm	Ø 55 x 16 ⁽³⁾ mm	Ø 57 x 22 ⁽³⁾ mm
Outreach	625 mm	625 mm	625 mm	625 mm
Stroke	55 mm	80 mm	80 mm	80 mm
Stroke / min.	22	21	21	21
Working height hole punch	950 mm	950 mm	950 mm	950 mm
Motor power ~50 Hz	5.5 kW / 400 V	7.5 kW / 400 V	11 kW / 400 V	11 kW / 400 V
Dimensions (L x W x H) approx.	1600 x 900 x 1800 mm	1850 x 950 x 1920 mm	2000 x 950 x 1970 mm	2700 x 1120 x 2160 mm
Weight approx.	2440 kg	3270 kg	3760 kg	5270 kg
Optional				
Sheet metal bending max.	500 x 3 mm	500 x 3 mm	700 x 3 mm	700 x 4 mm

(2) Performance data based on material with tensile strength 400 N/mm² (3) Option for oversized punching device required

MUBEA stamp and die system

- ▶ The desired hole diameter corresponds to the punch diameter.
- ▶ The diameter of the die depends on the material thickness.

Cutting game for round holes, rectangles and squares

Material thickness	mm	0 – 3.9	4 – 8.9	9 – 13.9	14 – 18.9	19 – 24
Cutting play	mm	0.2	0.7	1.2	1.7	2.2

Example: Stamp diameter 15 mm and material thickness 10 mm → Die diameter 16.2

Cutting clearance for slotted hole

Material thickness	mm	0 – 5.9	6 – 14
Cutting play	mm	0.3	1.0

Example: Stamp 10 x 25 mm and material thickness 10 mm → Die 11 x 26 mm

Round stamp no. 1

Ød)	Art. no.
3.0 mm	388933.0
3.5 mm	388933.5
4.0 mm	388934.0
4.5 mm	388934.5
5.0 mm	388935.0
5.5 mm	388935.5
6.0 mm	388936.0
6.5 mm	388936.5
7.0 mm	388937.0

Ød)	Art. no.
7.5 mm	388937.5
8.0 mm	388938.0
8.5 mm	388938.5
9.0 mm	388939.0
9.5 mm	388939.5
10.0 mm	3889310.0
10.5 mm	3889310.5
11.0 mm	3889311.0
11.5 mm	3889311.5

Ød)	Art. no.
12.0 mm	3889312.0
12.5 mm	3889312.5
13.0 mm	3889313.0
13.5 mm	3889313.5
14.0 mm	3889314.0
14.5 mm	3889314.5
15.0 mm	3889315.0



Round stamp no. 2

Ød)	Art. no.
14.0 mm	3889314.0-2
15.0 mm	3889315.0-2
15.5 mm	3889315.5
16.0 mm	3889316.0
16.5 mm	3889316.5
17.0 mm	3889317.0
17.5 mm	3889317.5
18.0 mm	3889318.0
18.5 mm	3889318.5
19.0 mm	3889319.0
19.5 mm	3889319.5

Ød)	Art. no.
20.0 mm	3889320.0
20.5 mm	3889320.5
21.0 mm	3889321.0
21.5 mm	3889321.5
22.0 mm	3889322.0
22.5 mm	3889322.5
23.0 mm	3889323.0
23.5 mm	3889323.5
24.0 mm	3889324.0
24.5 mm	3889324.5
25.0 mm	3889325.0

Ød)	Art. no.
25.5 mm	3889325.5
26.0 mm	3889326.0
26.5 mm	3889326.5
27.0 mm	3889327.0
27.5 mm	3889327.5
28.0 mm	3889328.0
28.5 mm	3889328.5
29.0 mm	3889329.0
29.5 mm	3889329.5
30.0 mm	3889330.0



Round stamp no. 3

Ød)	Art. no.
30.5 mm	3889330.5
31.0 mm	3889331.0
32.0 mm	3889332.0
33.0 mm	3889333.0

Ød)	Art. no.
34.0 mm	3889334.0
35.0 mm	3889335.0
36.0 mm	3889336.0
37.0 mm	3889337.0

Ød)	Art. no.
38.0 mm	3889338.0
39.0 mm	3889339.0
40.0 mm	3889340.0



Round stamp no. 4 ⁽¹⁾

Ød)	Art. no.
41.0 mm	3889341.0
42.0 mm	3889342.0
43.0 mm	3889343.0
44.0 mm	3889344.0

Ød)	Art. no.
45.0 mm	3889345.0
46.0 mm	3889346.0
47.0 mm	3889347.0
48.0 mm	3889348.0

Ød)	Art. no.
49.0 mm	3889349.0
50.0 mm	3889350.0



Round stamp no. 30

Ød)	Art. no.
3.2 mm	388933.2
3.7 mm	388933.7
4.2 mm	388934.2
4.7 mm	388934.7
5.2 mm	388935.2
5.7 mm	388935.7
6.2 mm	388936.2
6.7 mm	388936.7
7.2 mm	388937.2

Ød)	Art. no.
7.7 mm	388937.7
8.2 mm	388938.2
8.7 mm	388938.7
9.2 mm	388939.2
9.7 mm	388939.7
10.2 mm	3889310.2
10.7 mm	3889310.7
11.2 mm	3889311.2
11.7 mm	3889311.7

Ød)	Art. no.
12.2 mm	3889312.2
12.7 mm	3889312.7
13.2 mm	3889313.2
13.7 mm	3889313.7
14.2 mm	3889314.2
14.7 mm	3889314.7
15.2 mm	3889315.2
15.7 mm	3889315.7

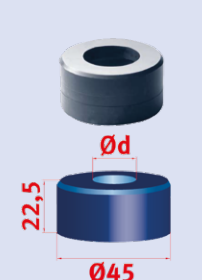


Round stamp no. 45

Ød)	Art. no.
14.7 mm	3889314.7-45
15.2 mm	3889315.2-45
15.7 mm	3889315.7-45
16.2 mm	3889316.2
16.7 mm	3889316.7
17.2 mm	3889317.2
17.7 mm	3889317.7
18.2 mm	3889318.2
18.7 mm	3889318.7
19.2 mm	3889319.2
19.7 mm	3889319.7
20.2 mm	3889320.2
20.7 mm	3889320.7

Ød)	Art. no.
21.2 mm	3889321.2
21.7 mm	3889321.7
22.2 mm	3889322.2
22.7 mm	3889322.7
23.2 mm	3889323.2
23.7 mm	3889323.7
24.2 mm	3889324.2
24.7 mm	3889324.7
25.2 mm	3889325.2
25.7 mm	3889325.7
26.2 mm	3889326.2
26.7 mm	3889326.7
27.2 mm	3889327.2

Ød)	Art. no.
27.7 mm	3889327.7
28.2 mm	3889328.2
28.7 mm	3889328.7
29.2 mm	3889329.2
29.7 mm	3889329.7
30.2 mm	3889330.2
30.7 mm	3889330.7
31.2 mm	3889331.2
31.7 mm	3889331.7
32.2 mm	3889332.2
32.7 mm	3889332.7



The punches and dies are not suitable for working with stainless steel. Tools for stainless steel can be supplied on request.

(1) Cannot be used with standard HPS/HLS scope of delivery – special accessory 'oversized punching device' required

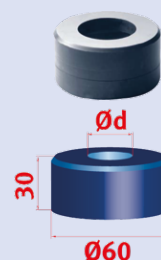
Accessories for hydraulic hole punches

Round stamp no. 60

(Ød)	Art. no.
32.2 mm	3889332.2-60
32.7 mm	3889332.7-60
33.2 mm	3889333.2
33.7 mm	3889333.7
34.2 mm	3889334.2
34.7 mm	3889334.7
35.2 mm	3889335.2

(Ød)	Art. no.
35.7 mm	3889335.7
36.2 mm	3889336.2
36.7 mm	3889336.7
37.2 mm	3889337.2
37.7 mm	3889337.7
38.2 mm	3889338.2
38.7 mm	3889338.7

(Ød)	Art. no.
39.2 mm	3889339.2
39.7 mm	3889339.7
40.2 mm	3889340.2
40.7 mm	3889340.7
41.2 mm	3889341.2
41.7 mm	3889341.7
42.2 mm	3889342.2

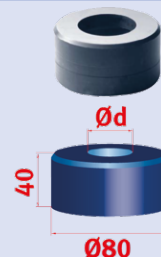


Round stamp no. 80*

(Ød)	Art. no.
42.2 mm	3889342.2-80
42.7 mm	3889342.7
43.2 mm	3889343.2
43.7 mm	3889343.7
44.2 mm	3889344.2
44.7 mm	3889344.7
45.2 mm	3889345.2

(Ød)	Art. no.
45.7 mm	3889345.7
46.2 mm	3889346.2
46.7 mm	3889346.7
47.2 mm	3889347.2
47.7 mm	3889347.7
48.2 mm	3889348.2
48.7 mm	3889348.7

(Ød)	Art. no.
49.2 mm	3889349.2
49.7 mm	3889349.7
50.2 mm	3889350.2
50.7 mm	3889350.7
51.2 mm	3889351.2



Long hole punch No. 2

(w x l)	Art. no.
5.0 x 10.0 mm	388945.0X10.0
5.0 x 13.0 mm	388945.0X13.0
5.0 x 15.0 mm	388945.0X15.0
5.0 x 20.0 mm	388945.0X20.0
5.0 x 25.0 mm	388945.0X25.0
5.5 x 11.0 mm	388945.5X11.0
5.5 x 15.0 mm	388945.5X15.0
5.5 x 20.0 mm	388945.5X20.0
5.5 x 25.0 mm	388945.5X25.0
6.5 x 13.0 mm	388946.5X13.0
6.5 x 20.0 mm	388946.5X20.0
6.5 x 25.0 mm	388946.5X25.0
6.5 x 30.0 mm	388946.5X30.0
7.0 x 15.0 mm	388947.0X15.0
7.0 x 20.0 mm	388947.0X20.0
7.0 x 25.0 mm	388947.0X30.0
7.0 x 30.0 mm	388947.0X30.0
8.0 x 13.0 mm	388948.0X13.0
8.0 x 20.0 mm	388948.0X20.0
8.0 x 25.0 mm	388948.0X25.0
8.0 x 30.0 mm	388948.0X30.0

(w x l)	Art. no.
9.0 x 13.0 mm	388949.0X13.0
9.0 x 18.0 mm	388949.0X18.0
9.0 x 20.0 mm	388949.0X20.0
9.0 x 25.0 mm	388949.0X25.0
9.0 x 30.0 mm	388949.0X30.0
9.5 x 20.0 mm	388949.5X20.0
9.5 x 25.0 mm	388949.5X25.0
9.5 x 30.0 mm	388949.5X30.0
10.0 x 20.0 mm	3889410.0X20.0
10.5 x 15.0 mm	3889410.5X15.0
10.5 x 21.0 mm	3889410.5X21.0
10.5 x 25.0 mm	3889410.5X25.0
10.5 x 30.0 mm	3889410.5X30.0
11.0 x 20.0 mm	3889411.0X20.0
11.0 x 25.0 mm	3889411.0X25.0
11.0 x 30.0 mm	3889411.0X30.0
12.0 x 20.0 mm	3889412.0X20.0
12.0 x 25.0 mm	3889412.0X25.0
12.0 x 30.0 mm	3889412.0X30.0
13.0 x 20.0 mm	3889413.0X20.0
13.0 x 25.0 mm	3889413.0X25.0

(w x l)	Art. no.
13.0 x 30.0 mm	3889413.0X30.0
13.5 x 20.0 mm	3889413.5X20.0
13.5 x 25.0 mm	3889413.5X25.0
13.5 x 30.0 mm	3889413.5X30.0
14.0 x 20.0 mm	3889414.0X20.0
14.0 x 25.0 mm	3889414.0X25.0
14.0 x 30.0 mm	3889414.0X30.0
16.0 x 25.0 mm	3889416.0X25.0
16.0 x 30.0 mm	3889416.0X30.0
17.5 x 25.0 mm	3889417.5X25.0
17.5 x 30.0 mm	3889417.5X30.0
18.0 x 30.0 mm	3889418.0X30.0
19.0 x 25.0 mm	3889419.0X25.0
19.0 x 30.0 mm	3889419.0X30.0
20.5 x 30.0 mm	3889420.5X30.0
22.5 x 30.0 mm	3889422.5X30.0
25.5 x 30.0 mm	3889425.5X30.0



Long hole punch No. 3

(w x l)	Art. no.
9.0 x 40.0 mm	388949.0X40.0
11.0 x 35.0 mm	3889411.0X35.0
11.0 x 40.0 mm	3889411.0X40.0
13.5 x 35.0 mm	3889413.5X35.0
13.5 x 40.0 mm	3889413.5X40.0
14.0 x 35.0 mm	3889414.0X35.0
14.0 x 40.0 mm	3889414.0X40.0
16.0 x 35.0 mm	3889416.0X35.0

(w x l)	Art. no.
16.0 x 40.0 mm	3889416.0X40.0
17.5 x 35.0 mm	3889417.5X35.0
17.5 x 40.0 mm	3889417.5X40.0
19.0 x 35.0 mm	3889419.0X35.0
19.0 x 40.0 mm	3889419.0X40.0
20.5 x 35.0 mm	3889420.5X35.0
20.5 x 40.0 mm	3889420.5X40.0
22.5 x 35.0 mm	3889422.5X35.0

(w x l)	Art. no.
22.5 x 40.0 mm	3889422.5X40.0
24.0 x 40.0 mm	3889424.0X40.0
25.5 x 40.0 mm	3889425.5X40.0
26.0 x 40.0 mm	3889426.0X40.0
27.0 x 40.0 mm	3889427.0X40.0



Long hole punch No. 4 ⁽¹⁾

(w x l)	Art. no.
11.0 x 45.0 mm	3889411.0X45.0
11.0 x 50.0 mm	3889411.0X50.0
13.5 x 50.0 mm	3889413.5X50.0
17.5 x 50.0 mm	3889417.5X50.0
20.5 x 50.0 mm	3889420.5X50.0

(w x l)	Art. no.
22.5 x 50.0 mm	3889422.5X50.0
24.0 x 50.0 mm	3889424.0X50.0
25.5 x 50.0 mm	3889425.5X50.0
26.0 x 50.0 mm	3889426.0X50.0
27.0 x 50.0 mm	3889427.0X50.0



Punch and die holders	Art. no.	Oversized punching device
<i>(suitable for all standard HPS/ HPS models)</i>		<i>(suitable for all standard HPS/ HPS models)</i>
Stamp supplement No. 1	3889002	for HPS 45S 3887160
Round stamp no. 1	3889003	for HPS 60S 3887161
Stamp holder no. 2	3889005	for HPS 55DS 3887162
Stamp holder no. 3	3889006	for HPS 65DS 3887163
Die reduction 60-30	3889000	for HPS 85 DS 3887164
Die reduction 60-45	3889001	for HPS 115DS 3887165
		for HPS 175DS 3887166

(requires use of stamp no. 4 and die no. 80)

The punches and dies are not suitable for working with stainless steel. Tools for stainless steel can be supplied on request.

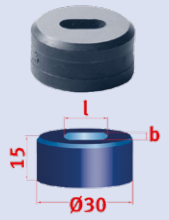
(1) Cannot be used with standard HPS/HLS scope of delivery – special accessory 'oversized punching device' required

Slotted hole die no. 30

(w x l)	Art. no.
5.3 x 10.3 mm	388945.3X10.3
5.3 x 13.3 mm	388945.3X13.3
5.3 x 15.3 mm	388945.3X15.3
5.8 x 11.3 mm	388945.8X11.3
5.8 x 15.3 mm	388945.8X15.3
6.0 x 11.0 mm	388946.0X11.0
6.0 x 16.0 mm	388946.0X16.0
6.5 x 12.0 mm	388946.5X12.0

(w x l)	Art. no.
6.5 x 16.0 mm	388946.5X16.0
6.8 x 13.3 mm	388946.8X13.3
7.3 x 15.3 mm	388947.3X15.3
7.5 x 14.0 mm	388947.5X14.0
8.0 x 16.0 mm	388948.0X16.0
8.3 x 13.3 mm	388948.3X13.3
9.0 x 14.0 mm	388949.0X14.0
9.3 x 13.3 mm	388949.3X13.3

(w x l)	Art. no.
10.0 x 14.0 mm	3889410.0X14.0
10.8 x 15.3 mm	3889410.8X15.3
11.5 x 16.0 mm	3889411.5X16.0

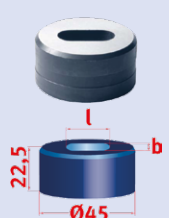


Slotted hole die no. 45

(w x l)	Art. no.
5.3 x 20.3 mm	388945.3X20.3
5.3 x 25.3 mm	388945.3X25.3
5.8 x 20.3 mm	388945.8X20.3
5.8 x 25.3 mm	388945.8X25.3
6.0 x 21.0 mm	388946.0X21.0
6.0 x 26.0 mm	388946.0X26.0
6.5 x 21.0 mm	388946.5X21.0
6.5 x 26.0 mm	388946.5X26.0
6.8 x 20.3 mm	388946.8X20.3
6.8 x 25.3 mm	388946.8X25.3
6.8 x 30.3 mm	388946.8X30.3
7.3 x 20.3 mm	388947.3X20.3
7.3 x 25.3 mm	388947.3X25.3
7.3 x 30.3 mm	388947.3X30.3
7.5 x 21.0 mm	388947.5X21.0
7.5 x 26.0 mm	388947.5X26.0
7.5 x 31.0 mm	388947.5X31.0
8.0 x 21.0 mm	388948.0X21.0
8.0 x 26.0 mm	388948.0X26.0
8.0 x 31.0 mm	388948.0X31.0
8.3 x 20.3 mm	388948.3X20.3
8.3 x 25.3 mm	388948.3X25.3
8.3 x 30.3 mm	388948.3X30.3
9.0 x 21.0 mm	388949.0X21.0
9.0 x 26.0 mm	388949.0X26.0
9.0 x 31.0 mm	388949.0X31.0
9.3 x 18.3 mm	388949.3X18.3
9.3 x 20.3 mm	388949.3X20.3
9.3 x 25.3 mm	388949.3X25.3
9.3 x 30.3 mm	388949.3X30.3
9.8 x 20.3 mm	388949.8X20.3
9.8 x 25.3 mm	388949.8X25.3
9.8 x 30.3 mm	388949.8X30.3

(w x l)	Art. no.
10.0 x 19.0 mm	3889410.0X19.0
10.0 x 21.0 mm	3889410.0X21.0
10.0 x 26.0 mm	3889410.0X26.0
10.0 x 31.0 mm	3889410.0X31.0
10.5 x 21.0 mm	3889410.5X21.0
10.5 x 26.0 mm	3889410.5X26.0
10.5 x 31.0 mm	3889410.5X31.0
10.8 x 21.3 mm	3889410.8X21.3
10.8 x 25.3 mm	3889410.8X25.3
10.8 x 30.3 mm	3889410.8X30.3
11.3 x 20.3 mm	3889411.3X20.3
11.3 x 25.3 mm	3889411.3X25.3
11.3 x 30.3 mm	3889411.3X30.3
11.5 x 22.0 mm	3889411.5X22.0
11.5 x 26.0 mm	3889411.5X26.0
11.5 x 31.0 mm	3889411.5X31.0
12.0 x 21.0 mm	3889412.0X21.0
12.0 x 26.0 mm	3889412.0X26.0
12.0 x 31.0 mm	3889412.0X31.0
12.3 x 20.3 mm	3889412.3X20.3
12.3 x 25.3 mm	3889412.3X25.3
12.3 x 30.3 mm	3889412.3X30.3
13.0 x 21.0 mm	3889413.0X21.0
13.0 x 26.0 mm	3889413.0X26.0
13.0 x 31.0 mm	3889413.0X31.0
13.3 x 20.3 mm	3889413.3X20.3
13.3 x 25.3 mm	3889413.3X25.3
13.3 x 30.3 mm	3889413.3X30.3
13.8 x 20.3 mm	3889413.8X20.3
13.8 x 25.3 mm	3889413.8X25.3
13.8 x 30.3 mm	3889413.8X30.3
14.0 x 21.0 mm	3889414.0X21.0
14.0 x 26.0 mm	3889414.0X26.0

(w x l)	Art. no.
14.0 x 31.0 mm	3889414.0X31.0
14.3 x 20.3 mm	3889414.3X20.3
14.3 x 25.3 mm	3889414.3X25.3
14.3 x 30.3 mm	3889414.3X30.3
14.5 x 21.0 mm	3889414.5X21.0
14.5 x 26.0 mm	3889414.5X26.0
14.5 x 31.0 mm	3889414.5X31.0
15.0 x 21.0 mm	3889415.0X21.0
15.0 x 26.0 mm	3889415.0X26.0
15.0 x 31.0 mm	3889415.0X31.0
16.3 x 25.3 mm	3889416.3X25.3
16.3 x 30.3 mm	3889416.3X30.3
17.0 x 26.0 mm	3889417.0X26.0
17.0 x 31.0 mm	3889417.0X31.0
17.8 x 25.3 mm	3889417.8X25.3
17.8 x 30.3 mm	3889417.8X30.3
18.5 x 26.0 mm	3889418.5X26.0
18.5 x 31.0 mm	3889418.5X31.0
19.3 x 25.3 mm	3889419.3X25.3
19.3 x 30.3 mm	3889419.3X30.3
20.0 x 26.0 mm	3889420.0X26.0
20.0 x 31.0 mm	3889420.0X31.0
20.8 x 30.3 mm	3889420.8X30.3
21.5 x 31.0 mm	3889421.5X31.0
22.8 x 30.3 mm	3889422.8X30.3
23.5 x 31.0 mm	3889423.5X31.0
25.8 x 30.3 mm	3889425.8X30.3
26.5 x 31.0 mm	3889426.5X31.0

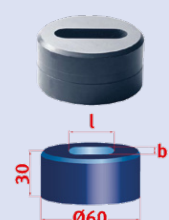


Slotted hole die no. 60

(w x l)	Art. no.
9.3 x 40.3 mm	388949.3X40.3
10.0 x 41.0 mm	3889410.0X41.0
11.3 x 40.3 mm	3889411.3X40.3
12.0 x 41.0 mm	3889412.0X41.0
13.8 x 35.3 mm	3889413.8X35.3
13.8 x 40.3 mm	3889413.8X40.3
14.3 x 35.3 mm	3889414.3X35.3
14.3 x 40.3 mm	3889414.3X40.3
14.5 x 36.0 mm	3889414.5X36.0
14.5 x 41.0 mm	3889414.5X41.0
15.0 x 36.0 mm	3889415.0X36.0
15.0 x 41.0 mm	3889415.0X41.0
16.3 x 35.3 mm	3889416.3X35.3
16.3 x 40.3 mm	3889416.3X40.3

(w x l)	Art. no.
17.0 x 36.0 mm	3889417.0X36.0
17.0 x 41.0 mm	3889417.0X41.0
17.8 x 35.3 mm	3889417.8X35.3
17.8 x 40.3 mm	3889417.8X40.3
18.5 x 36.0 mm	3889418.5X36.0
18.5 x 41.0 mm	3889418.5X41.0
19.3 x 35.3 mm	3889419.3X35.3
19.3 x 40.3 mm	3889419.3X40.3
20.0 x 36.0 mm	3889420.0X36.0
20.0 x 41.0 mm	3889420.0X41.0
20.8 x 35.3 mm	3889420.8X35.3
20.8 x 40.3 mm	3889420.8X40.3
21.5 x 36.0 mm	3889421.5X36.0
21.5 x 41.0 mm	3889421.5X41.0

(w x l)	Art. no.
22.8 x 35.3 mm	3889422.8X35.3
22.8 x 40.3 mm	3889422.8X40.3
23.5 x 36.0 mm	3889423.5X36.0
23.5 x 41.0 mm	3889423.5X41.0
24.3 x 40.3 mm	3889424.3X40.3
25.0 x 41.0 mm	3889425.0X41.0
26.3 x 40.3 mm	3889426.3X40.3
26.5 x 41.0 mm	3889426.5X41.0
27.0 x 41.0 mm	3889427.0X41.0
27.3 x 40.3 mm	3889427.3X40.3
28.0 x 41.0 mm	3889428.0X41.0

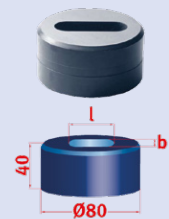


Slotted hole die no. 80 ⁽¹⁾

(w x l)	Art. no.
11.3 x 45.3 mm	3889411.3X45.3
11.3 x 50.3 mm	3889411.3X50.3
12.0 x 46.0 mm	3889412.0X46.0
12.0 x 51.0 mm	3889412.0X51.0
13.8 x 50.3 mm	3889413.8X50.3
14.5 x 51.0 mm	3889414.5X51.0
17.8 x 50.3 mm	3889417.8X50.3
18.5 x 51.0 mm	3889418.5X51.0

(w x l)	Art. no.
20.8 x 50.3 mm	3889420.8X50.3
21.5 x 51.0 mm	3889421.5X51.0
22.8 x 50.3 mm	3889422.8X50.3
23.5 x 51.0 mm	3889423.5X51.0
24.3 x 50.3 mm	3889424.3X50.3
25.0 x 51.0 mm	3889425.0X51.0
25.8 x 50.3 mm	3889425.8X50.3
26.3 x 50.3 mm	3889426.3X50.3

(w x l)	Art. no.
26.5 x 51.0 mm	3889426.5X51.0
27.0 x 51.0 mm	3889427.0X51.0
27.3 x 50.3 mm	3889427.3X50.3
28.0 x 51.0 mm	3889428.0X51.0

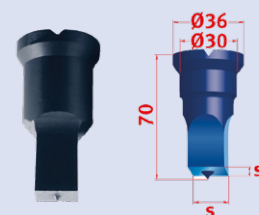


The punches and dies are not suitable for working with stainless steel. Tools for stainless steel can be supplied on request.
 (1) Cannot be used with standard HPS/HLS scope of delivery – special accessory 'oversized punching device' required

Accessories for hydraulic hole punches

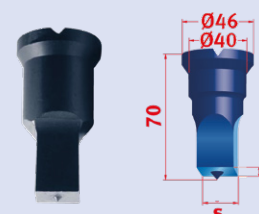
Long hole punch No. 2

(s)	Art. no.	(s)	Art. no.	(s)	Art. no.
4.0 mm	388954.0	11.0 mm	3889511.0	18.0 mm	3889518.0
5.0 mm	388955.0	12.0 mm	3889512.0	19.0 mm	3889519.0
6.0 mm	388956.0	13.0 mm	3889513.0	20.0 mm	3889520.0
7.0 mm	388957.0	14.0 mm	3889514.0		
8.0 mm	388958.0	15.0 mm	3889515.0		
9.0 mm	388959.0	16.0 mm	3889516.0		
10.0 mm	3889510.0	17.0 mm	3889517.0		



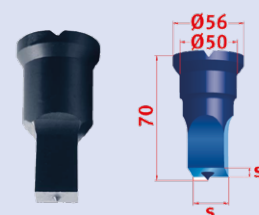
Long hole punch No. 3

(s)	Art. no.	(s)	Art. no.	(s)	Art. no.
21.0 mm	3889521.0	25.0 mm	3889525.0	28.0 mm	3889528.0
22.0 mm	3889522.0	25.5 mm	3889525.5		
23.0 mm	3889523.0	26.0 mm	3889526.0		
23.5 mm	3889523.5	26.5 mm	3889526.5		
24.0 mm	3889524.0	27.0 mm	3889527.0		
24.5 mm	3889524.5	27.5 mm	3889527.5		



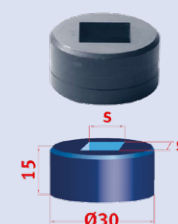
Square stamp No. 4 ⁽¹⁾

(s)	Art. no.	(s)	Art. no.	(s)	Art. no.
28.5 mm	3889528.5	31.5 mm	3889531.5	34.5 mm	3889534.5
29.0 mm	3889529.0	32.0 mm	3889532.0	35.0 mm	3889535.0
29.5 mm	3889529.5	32.5 mm	3889532.5		
30.0 mm	3889530.0	33.0 mm	3889533.0		
30.5 mm	3889530.5	33.5 mm	3889533.5		
31.0 mm	3889531.0	34.0 mm	3889534.0		



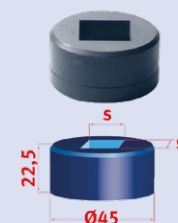
Square die No. 30

(s)	Art. no.	(s)	Art. no.	(s)	Art. no.
4.2 mm	388964.2	7.2 mm	388967.2	10.2 mm	3889610.2
4.7 mm	388964.7	7.7 mm	388967.7	10.7 mm	3889610.7
5.2 mm	388965.2	8.2 mm	388968.2	11.2 mm	3889611.2
5.7 mm	388965.7	8.7 mm	388968.7		
6.2 mm	388966.2	9.2 mm	388969.2		
6.7 mm	388966.7	9.7 mm	388969.7		



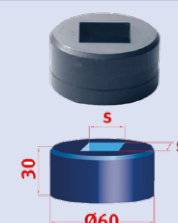
Square die No. 45

(s)	Art. no.	(s)	Art. no.	(s)	Art. no.
11.7 mm	3889611.7	16.2 mm	3889616.2	20.7 mm	3889620.7
12.2 mm	3889612.2	16.7 mm	3889616.7	21.2 mm	3889621.2
12.7 mm	3889612.7	17.2 mm	3889617.2	21.7 mm	3889621.7
13.2 mm	3889613.2	17.7 mm	3889617.7	22.2 mm	3889622.2
13.7 mm	3889613.7	18.2 mm	3889618.2	22.7 mm	3889622.7
14.2 mm	3889614.2	18.7 mm	3889618.7	23.2 mm	3889623.2
14.7 mm	3889614.7	19.2 mm	3889619.2		
15.2 mm	3889615.2	19.7 mm	3889619.7		
15.7 mm	3889615.7	20.2 mm	3889620.2		



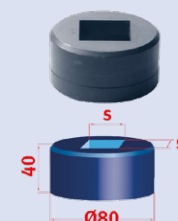
Square die No. 60

(s)	Art. no.	(s)	Art. no.	(s)	Art. no.
23.2 mm	3889623.2-60	26.2 mm	3889626.2	29.2 mm	3889629.2
23.7 mm	3889623.7	26.7 mm	3889626.7		
24.2 mm	3889624.2	27.2 mm	3889627.2		
24.7 mm	3889624.7	27.7 mm	3889627.7		
25.2 mm	3889625.2	28.2 mm	3889628.2		
25.7 mm	3889625.7	28.7 mm	3889628.7		



Square die no. 80 ⁽¹⁾

(s)	Art. no.	(s)	Art. no.	(s)	Art. no.
28.7 mm	3889628.7-80	31.7 mm	3889631.7	34.7 mm	3889634.7
29.2 mm	3889629.2-80	32.2 mm	3889632.2	35.2 mm	3889635.2
29.7 mm	3889629.7	32.7 mm	3889632.7	35.7 mm	3889635.7
30.2 mm	3889630.2	33.2 mm	3889633.2		
30.7 mm	3889630.7	33.7 mm	3889633.7		
31.2 mm	3889631.2	34.2 mm	3889634.2		



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⁽¹⁾ Cannot be used with standard HPS/HLS scope of delivery – special accessory 'oversized punching device' required

Intermediate sizes
and special shapes on
request (3889399)



We would be happy to advise you on any questions you may have about dies and stamps, such as:

- ▶ Which punch goes with which die?
- ▶ What size do I need for my area of application?
- ▶ Which material can I punch?

Prices are available on
request! Contact:
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