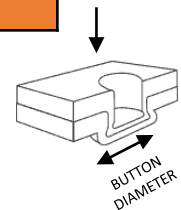




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DIE & THICKNESS ADJUSTMENT REQUIRED FOR 2 LAYERS OF GALVANIZED SHEET METAL

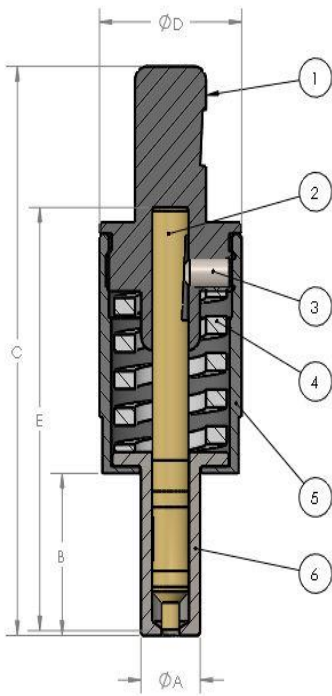
THICKNESS (ONE LAYER)	DIE ASSEMBLY REQUIRED	BUTTON DIAMETER
0,0635"	20040AS	0.300"
0,0575"	20040AS	0.295"
0,0516"	20038AS	0.292"
0,0456"	20038AS	0.287"
0,0396"	20036AS	0.285"
0,0366"	20036AS	0.285"
0,0336"	20034AS	0.275"
0,0306"	20034AS	0.275"
0,0276"	20032AS	0.272"
0,0261"	20032AS	0.270"
0,0231"	20032AS	0.270"
0,0209"	20032AS	0.265"
0,0194"	20032AS	0.260"
0,0179"	20032AS	0.255"
0,0160"	20030AS	0.250"
0,0125"	20030AS	0.245"



FOR A SUITABLE LOCK, VERIFY THE MEASURE OF THE BUTTON DIAMETER & PROPERLY ADJUST THE MACHINE WHEN CHANGING TO DIFFERENT THICKNESSES



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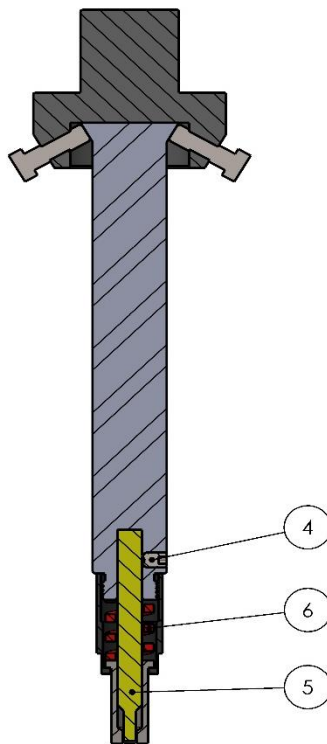
- | | | |
|----|--------------------------|-------------------|
| 1. | <i>PUNCH HOLDER</i> | : 6-303 |
| 2. | <i>CLINCHING PUNCH</i> | : See chart below |
| 3. | <i>LOCKING SET SCREW</i> | : ¼-28 x 3/8 |
| 4. | <i>STRIPPER SPRING</i> | : 32066 |
| 5. | <i>SPRING HOLDER</i> | : 6-310 |
| 6. | <i>STRIPPER</i> | : 6-305 |

Clinching punch	Punch assembly	Thickness range	A	B	C	D	E
20882 /2798	20882AS	27-32G	0.6250"	0.4375"	4.0375"	1.5000"	2,75"
20884 /6624	20884AS	27-32G	0.6250"	1.4375"	5.0375"	1.5000"	3,75"
20886 /6636	20886AS	12-26G	0.6250"	1.4375"	5.0375"	1.5000"	3,75"

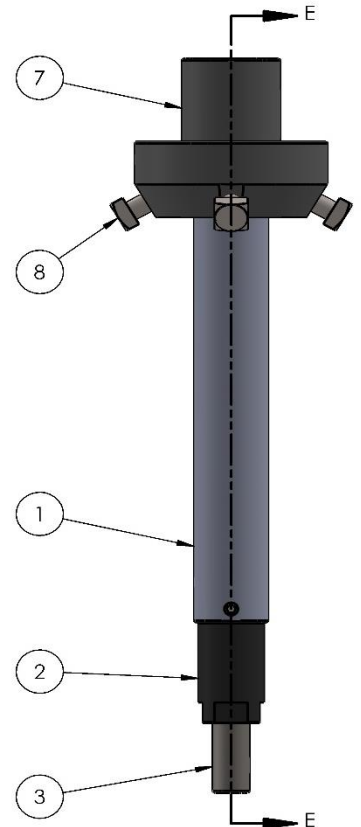


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ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	6-302.1	NARROW SHANK, 10"	1
2	6-310.1	SPRING HOLDER	1
3	22068	SPRING 3/4" X 3/8" X 1", GOLD (T)	1
4	6-305.1	CROWN STRIPPER, Ø 3/4	1
5	20618	CLINCHING PUNCH, 3.5" LG.	1
6	4000-007	Setscrew 1/4-28 x 3/8" LG.	1
7	6-301	H600 TOOLING ADAPTER	1
8	22052	Square head bolt, 5/16-18 x 1" LG.	3

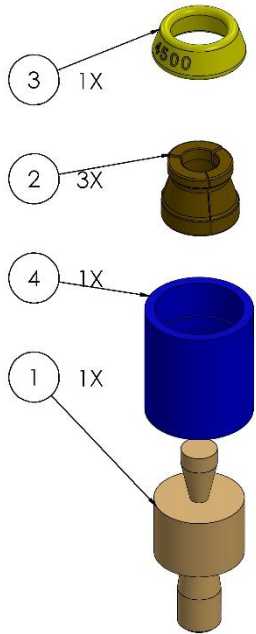


COUPE E-E
ECHELLE 1 : 2





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- 1. DIE BODY : See chart Below
 - 2. CLINCHING BLADES : 20254/3471
 - 3. ELASTOMER : 20262/4500
 - 4. PROTECTIVE SLEEVE : See chart Below
- Die assembly includes all parts above.
Choose sleeve color depending of the thickness*

Standard Gauge	Die assembly required	# on the die	Sleeve #
14	20040AS	4037	6-304.5
15	20040AS	4037	6-304.5
16	20040AS	4037	6-304.5
17	20040AS	4037	6-304.5
18	20038AS	3977	6-304.4
19	20038AS	3977	6-304.4
20	20036AS	3969	6-304.3
21	20036AS	3969	6-304.3
22	20034AS	3961	6-304.2
23	20034AS	3961	6-304.2
24	20032AS	3954	6-304.1
25	20032AS	3954	6-304.1
26	20032AS	3954	6-304.1
27	20032AS	3954	6-304.1
28	20032AS	3954	6-304.1
29	20032AS	3954	6-304.1
30	20030AS	3947	6-304.0
31	20030AS	3947	6-304.0