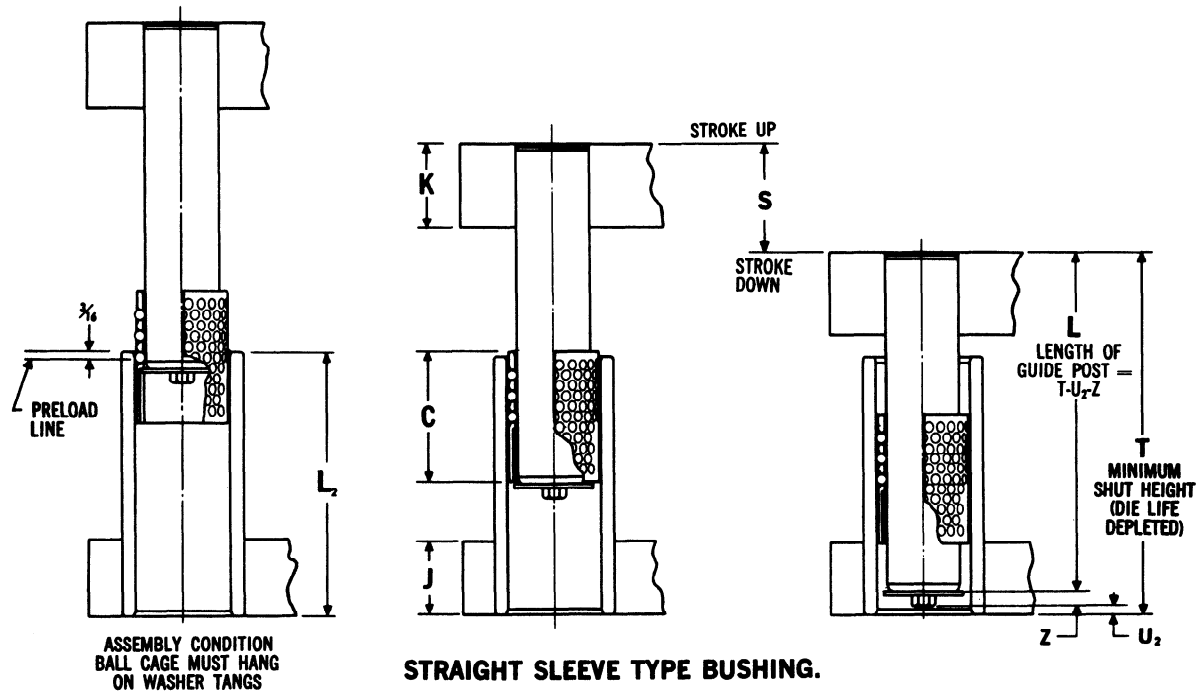
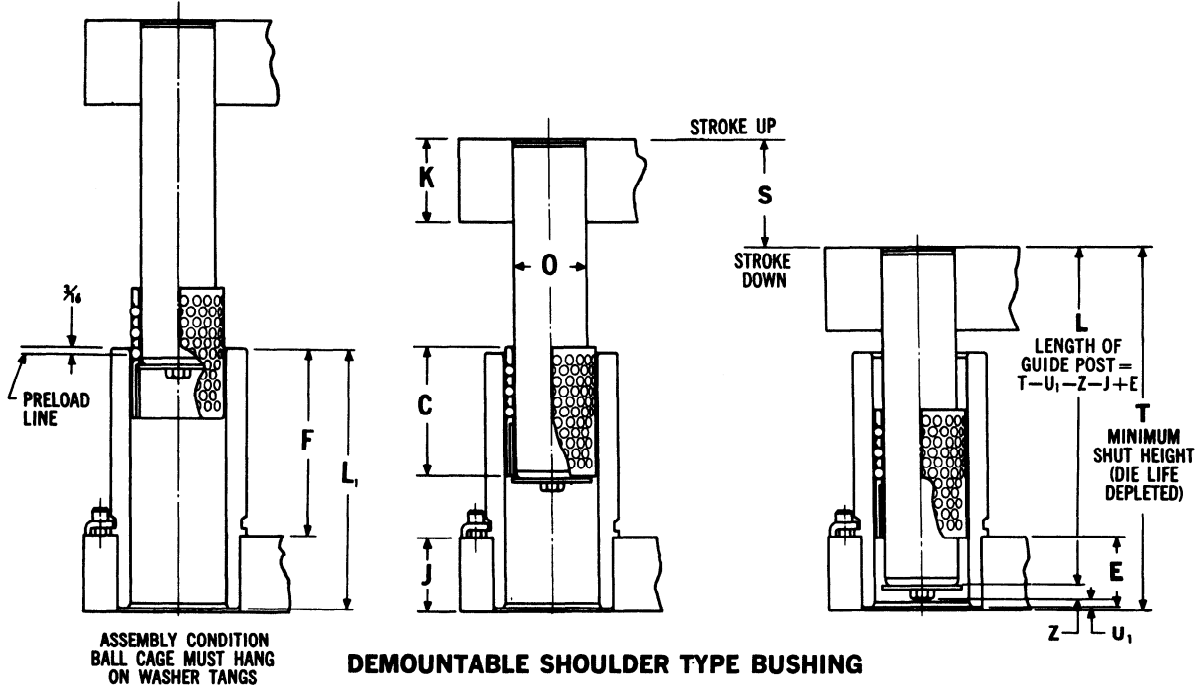




DATA FOR FINDING GUIDE POST LENGTH

TYPE I — FULL PRE-LOAD THROUGHOUT STROKE



NOTE: If calculated guide post length is not listed on page 5:

1. Select next longer length and cut off to required length, or:
2. Select shorter length and recess post in punchholder to obtain correct L dimension.

Press fit length should always be equal to or greater than the diameter of the guide post, if possible.

NOTE: On Type I Assemblies, a die set designed for a particular stroke may be used in any press of lesser stroke, but never in any press where the stroke is greater than originally chosen.

Caution: Be sure bushing does not strike punch holder at minimum shutheight. If this condition exists, use shorter bushing and corresponding ball cage.