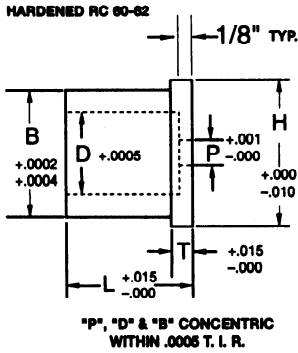
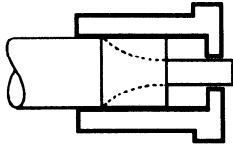




PIVOT PUNCH CORPORATION / SELECTIVE SERIES
TWO-STEP STRIPPER GUIDES



STEEL	SHAPE	SHANK GUIDE	BODY DIAMETER		HEAD		HOLE SIZE	L - OVERALL LENGTH						ROUND HOLE ORDER ACS			
			B	H	T	D		5/8	15/16	1-7/32	1-1/4	1-1/2	1-3/4	MIN.	P	MAX.	
			DIAMETER		THICKNESS												
A	()	S	3/8	1/2	3/16	3/16	37-62								.050		.109
A	()	S	1/2	5/8	3/16	1/4		50-93							.050		.125
A	()	S	5/8	3/4	3/16	5/16		62-93							.062		.172
A	()	S	5/8	3/4	3/16	3/8		62A-93							.093		.218
A	()	S	7/8	1	3/16	1/2			87-121						.125		.297
A	()	S	1	1-1/8	3/16	5/8				100-125					.203		.375
A	()	S	1-1/8	1-1/4	3/16	3/4					112-150				.281		.500
A	()	S	1-1/4	1-3/8	3/16	7/8					125-150	125-175			.370		.595
A	()	S	1-3/8	1-1/2	3/16	1					137-150	137-175			.468		.687

HOW TO ORDER STEEL SHAPE PUNCH BODY DIA. OVERALL LENGTH "P" "W"
A F S 87 - 121 X .420 X .250

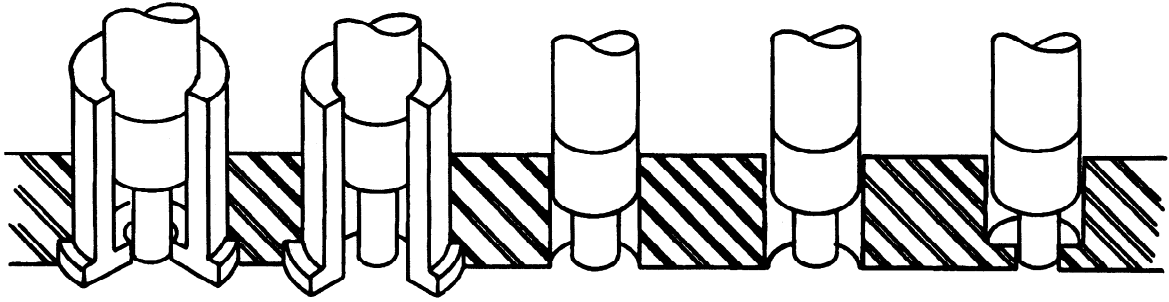
WHEN ORDERING WHIPSLEEVE PUNCHES:

1. Use shortest possible point length for added strength on critical punches.
2. Use largest practical size shank in relation to point diameter.
3. Use maximum punch and die clearance wherever possible.
4. Consider hardness as well as thickness of material to be punched in relation to point diameter. (In most cases, the XS punch will penetrate thickness as much as twice the diameter of the punch, — replacing many drilling operations.)
5. Provide depth stop so that punches cannot be set too deep.
6. Provide taper on die sections or die buttons all the way through.
7. Provide taper slug clearance in die shoe.

WHEN GUIDING IN STRIPPER BUSHING:

Make certain the whipsleeve is an easy slip-fit in the guide bushing. When guiding in the stripper itself use 4140 steel or equivalent, hardness approx. 300 Brinell, heat treated before machining. Be sure whipsleeve is engaged in guide before punch contacts material.

Pivot Punches are supplied without guides. Use "PG" Stripper Guide Bushings, Standard Drill Bushings, or the type of guide that will give the punch the proper support for the particular application. Examples are shown below:



"PG" TWO-STEP STRIPPER GUIDE
Guide on shank Clearance on point

STRIPPER GUIDE
Guide on shank

PUNCH GUIDED IN STRIPPER

CLEARANCE HOLE IN STRIPPER
No guide

COUNTER BORED HOLE IN STRIPPER
No guide