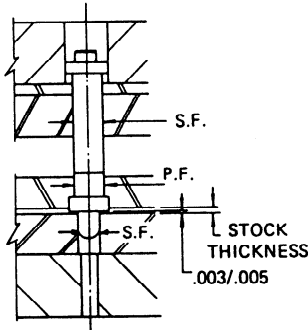




T.R. JONES MACHINE COMPANY, INC.

T.R. JONES DIE ACCESSORIES

SUB-LINER PINS



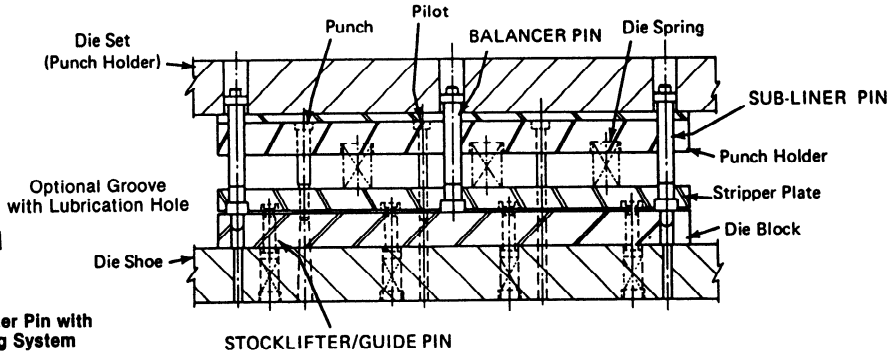
Sub-liner Pins provide exact alignment of the punch holder, spring stripper, and die block. As the die is closing the bullet nose pilot end of the Sub-liner enters a precision slip fit hole in the die block. Since the Sub-liner is pressed into the spring stripper, and is a precision slip fit with the punch holder, accurate alignment is accomplished. Flats on shoulder to prevent turning when screw is removed are optional. Sub-liner Pins now available with special lubricating hole system designed to your specifications.

ADVANTAGES

1. Eliminates need for stripper bolts and are commonly used to support die spring.
2. Assures parallel alignment of stripper plate and die block when shoulder of Sub-liner extends .003/.005 less than stock thickness. (Shoulder will bottom on die block if there is any deflection in stripper plate, especially when stock is started through the die).
3. Aligns delicate and close fitting punches with stripper plate.
4. All critical diameters machined to $\pm .0002$ and concentric to $\pm .0002$ T.I.R.
5. Shoulder thickness machined to $\pm .001$, length machined to $\pm .002$.
6. Made of SAE-06 tool steel and heat treated to 58-61 Rockwell "C".
7. Available in standard sizes at greater a cost savings.



New Sub-Liner Pin with Lubricating System

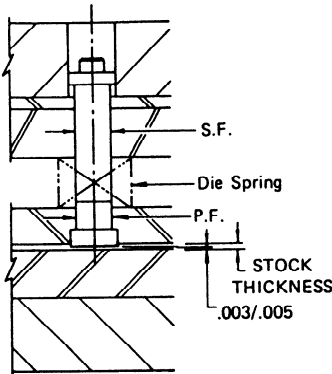


BALANCER PINS

Balancer Pins provide exact alignment of the punch holder and the spring stripper plate. Flats on shoulder to prevent turning when screw is removed are optional.

ADVANTAGES

1. Eliminates need for stripper bolts and are commonly used to support die springs.
2. Used in conjunction with Sub-liner Pins to balance spring stripping action.
3. Rugged construction assures minimum amount of deflection.
4. Used for excellent stripper alignment when Sub-liners are not required.
5. Constructed of SAE-06 tool steel and heat treated to 58-61 Rockwell "C".
6. Precision machined to $\pm .0002$ T.I.R. on concentricity and $\pm .0002$ on all critical diameters.
7. Shoulder thickness machined to $\pm .001$, length machined to $\pm .002$.
8. Available in standard sizes at greater cost savings.



HOW MANY PINS ARE REQUIRED?

1. For maximum alignment and parallelism a minimum of 4 Sub-liner Pins should be used for each spring stripper section in the die. This will minimize stripper deflection.
2. For precision alignment only, 2 Sub-liner Pins and the required number of Balancers are used to produce the correct stripping action for each spring stripper section of the die.
3. For precision alignment of the stripper and punch holder only, Balancers are recommended. The correct number to be used depends on the die and stripping characteristics. Usually 4-6 Balancers for each stripper section are used.

SPECIAL PINS

Special pins for any purpose are our specialty — Send prints with English or Metric dimensions for quotation.

CAD LIBRARY

A complete CAD library of all T.R. Jones pins is available as DWG or DXF files upon request.