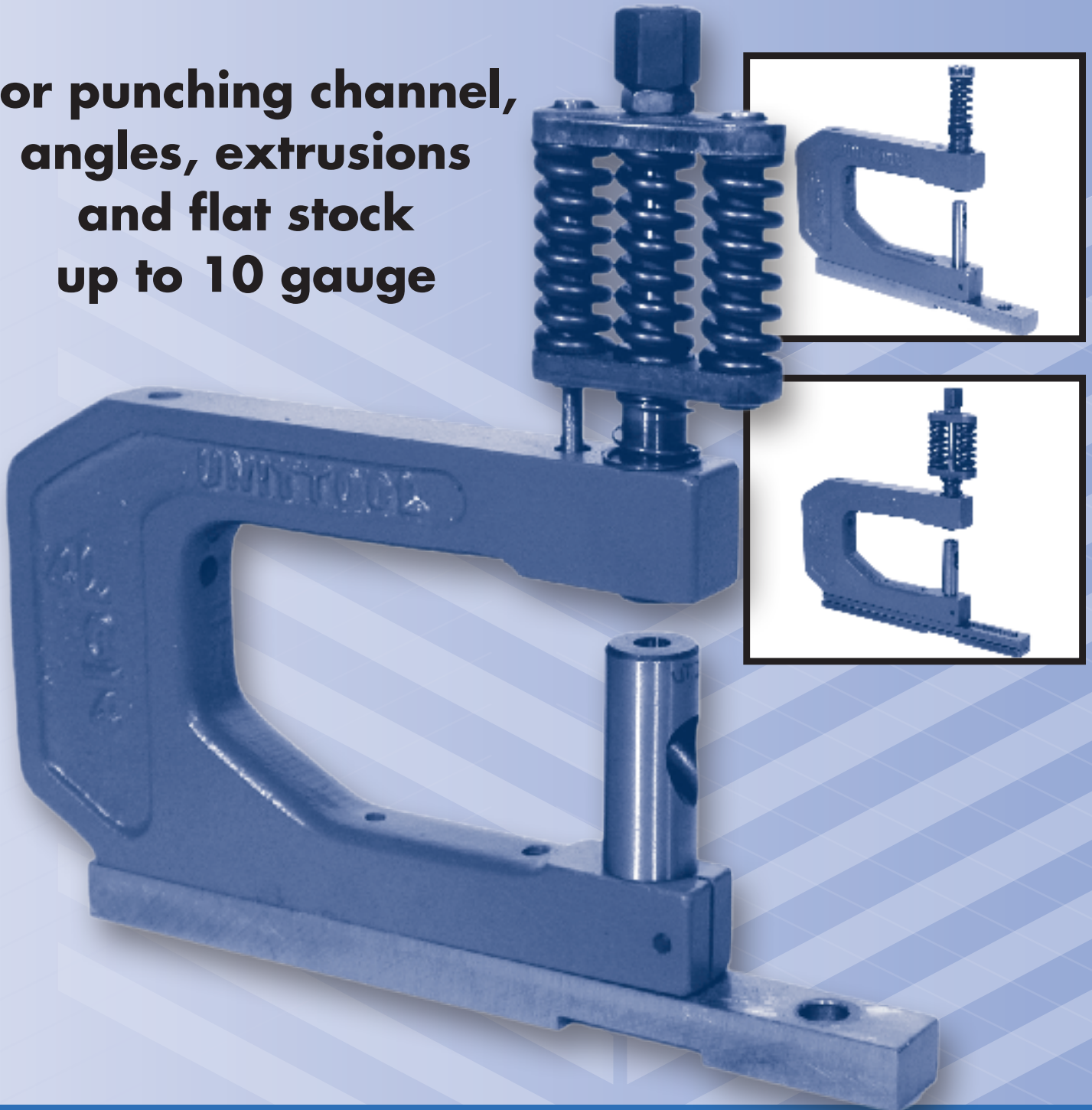


UNITTOOL

LIGHT-DUTY PUNCHING UNITS

**For punching channel,
angles, extrusions
and flat stock
up to 10 gauge**



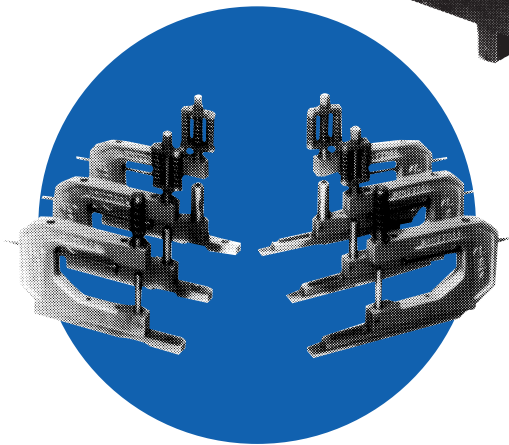
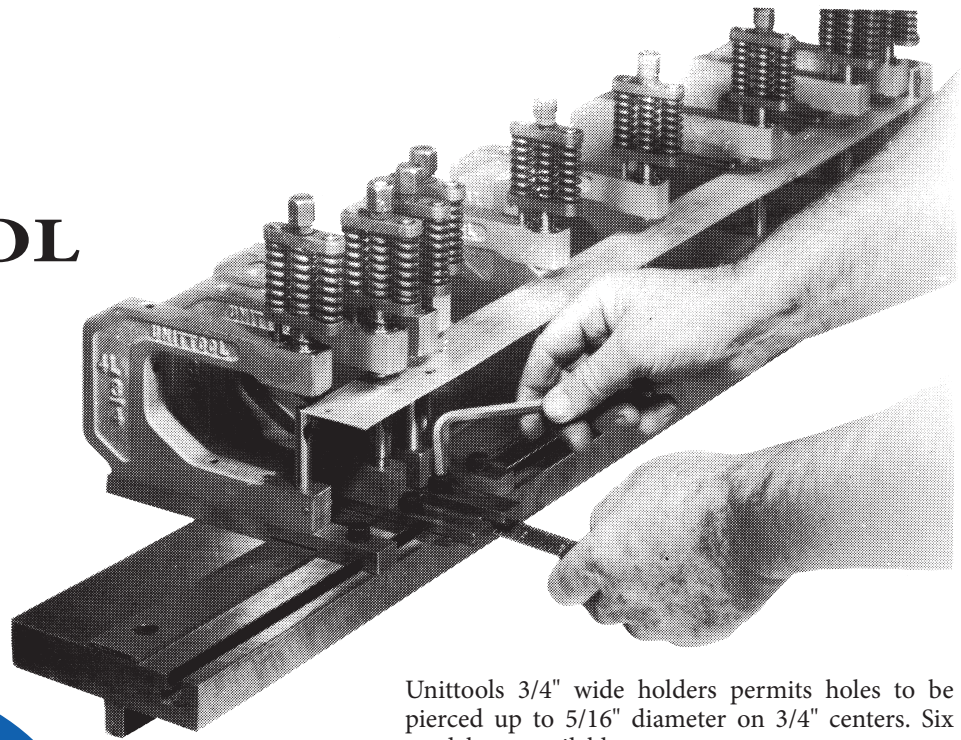
UNITTOOL PUNCH & DIE COMPANY INC.

20 Norris St. Buffalo, New York 14207 | Phone: 1-716-873-8453 | Fax: (USA Only) 1-800-25Punch (257-8624)
Email: Info@Unittool.com

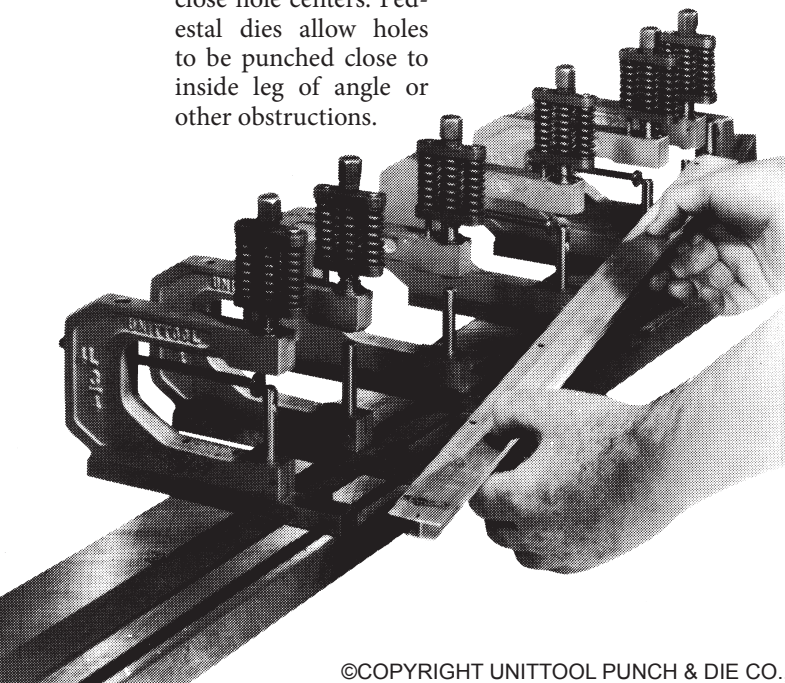
UNITTOOL

PUNCHING UNITS

Adjustable base units have 1 1/2" adjustment (3/4" each side of center-line) for punching staggered hole patterns.



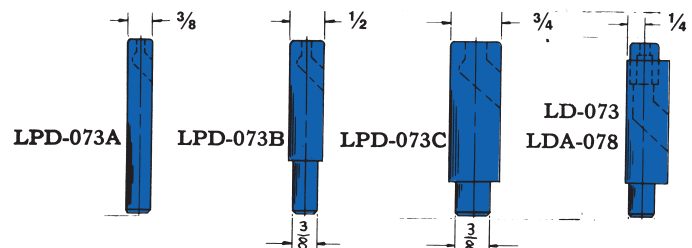
Small extrusions are readily punched on close hole centers. Pedestal dies allow holes to be punched close to inside leg of angle or other obstructions.



Unittools 3/4" wide holders permits holes to be pierced up to 5/16" diameter on 3/4" centers. Six models are available.

The Single Spring – 6-1/4" shut height units are recommended where maximum shut height is not great enough to accommodate the features available in the double and triple spring – 7-1/2" shut unit heights. **The Double Spring** – 7-1/2" shut height unit is recommended for most applications for piercing up to a 5/16" diameter hole in 12 gauge material. **The Triple Spring** – 7-1/2" shut height unit offers still greater stripping forces and is recommended for the "tough" applications – where the units are stacked up against one another. This unit will pierce up to 5/16" diameter hole in 10 gauge material. The adjustable punch head offered on these double and triple spring units provides greater cost savings by increasing punch life. The punch assembly can be adjusted to "new length" after sharpening.

Several different dies are available. Selection of most suitable die for the application can have an economical advantage. Still greater savings can be realized by "shimming up" the die after excessive sharpening. This feature also permits a constant die height that eliminates material distortion resulting from punching with irregular die heights. The split bore feature provided in the pedestal at die section of the holder permits easy removal of die. This feature allows the die bore to be self adjusting in event of excessive wear.



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3/4"

HOLDER WIDTH

6 1/4" SHUT HEIGHT

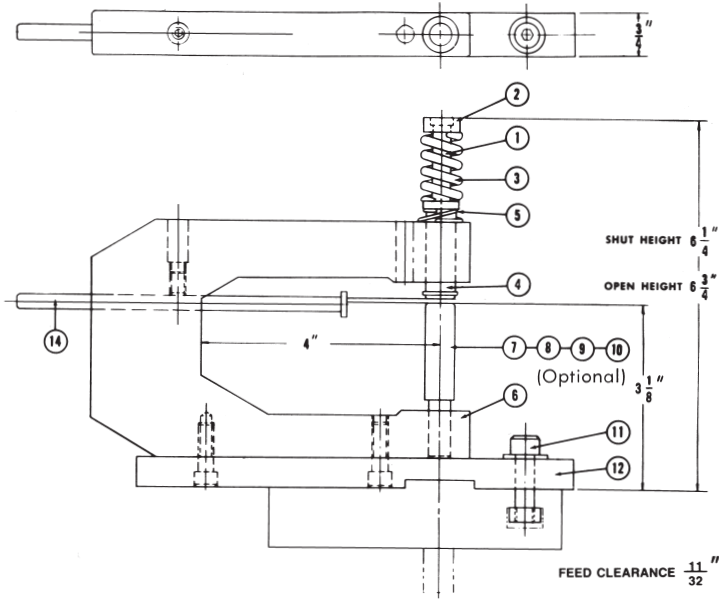
3 1/8" DIE HEIGHT

L-SERIES

(Light Duty)

.250 Maximum Punch Diameter

.125 Maximum Material Thickness



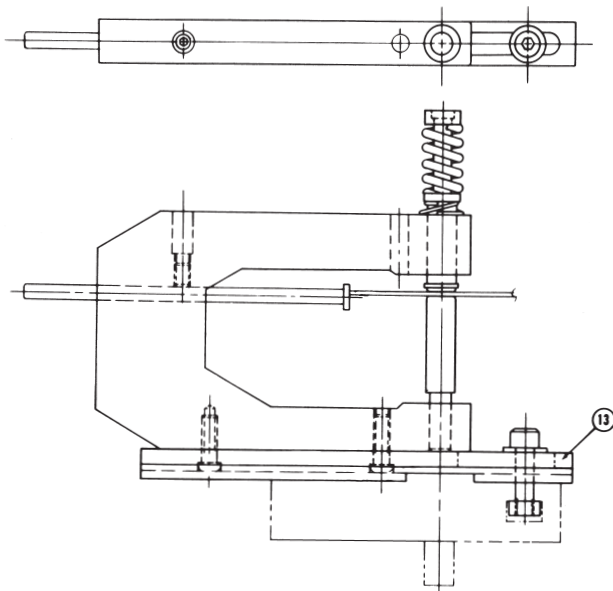
SINGLE SPRING

Model LSS-6 1/4 F (Fixed Base)

Model No.

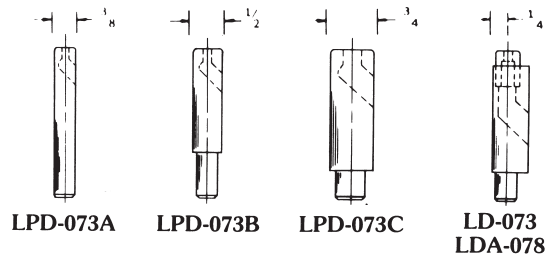
	LSS-6 1/4 F	LSS-6 1/4 A
Cat. No.		
With Die # LPD-073A	LSS-6 1/4 F-375	LSS-6 1/4 A-375
With Die # LPD-073B	LSS-6 1/4 F-500	LSS-6 1/4 A-500
With Die Button LD-073 and Adapter LDA-078	LSS-6 1/4 F-DA	LSS-6 1/4 A-DA

Cat. No.



Model LSS-6 1/4 A (Adjustable Base)

Pedestal Dies



- 1 Punch (Only) LP-072E
- 2 Punch Head LPH-077
- 1 & 2 Punch & Head Assy. LPA-077A
- 3 Stripper Spring LSS-075A
- 4 Guide (Open) LG-074A



Specify Punch Tip Size

- 5 Lifter Spring LLS-076
- 6 Holder HL 3/4
- 7 3/8" O.D. Pedestal Die LPD-073A
For Punch Size up to .156

- 8 1/2" O.D. Pedestal Die LPD-073B
For Punch Size up to .250
- 9 3/4" O.D. Pedestal Die LPD-073C
For Punch Size up to .312
- 10 Die Button LD-073 Max. Hole Size — .250
Die Adapter LDA-078
- 11 Nut, Bolt & Washer Set NB-100
- 12 Fixed Adapter with Screws LFA-079
- 13 Adjustable Adapter with Screws LAA-079
- 14 Gauge Rod GR-100
Furnished with 20% of Holders Ordered

3/4"

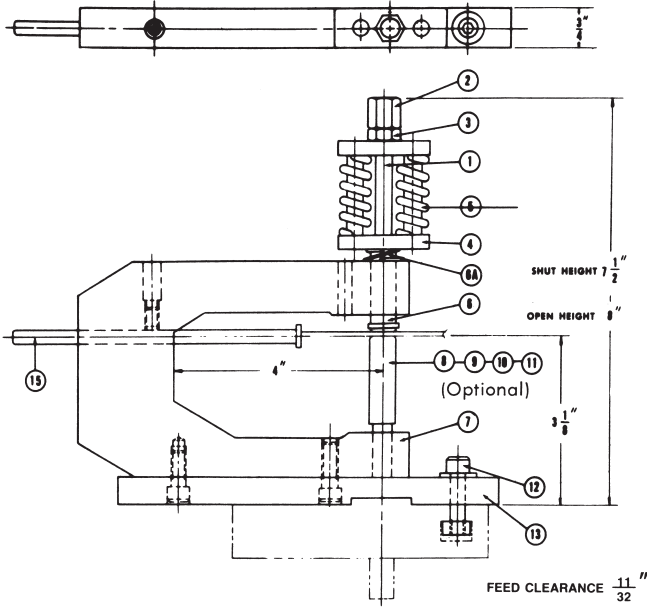
HOLDER WIDTH

7 1/2" SHUT HEIGHT

3 1/8" DIE HEIGHT

L-SERIES (Light Duty)

.312 Maximum Punch Diameter
.125 Maximum Material Thickness



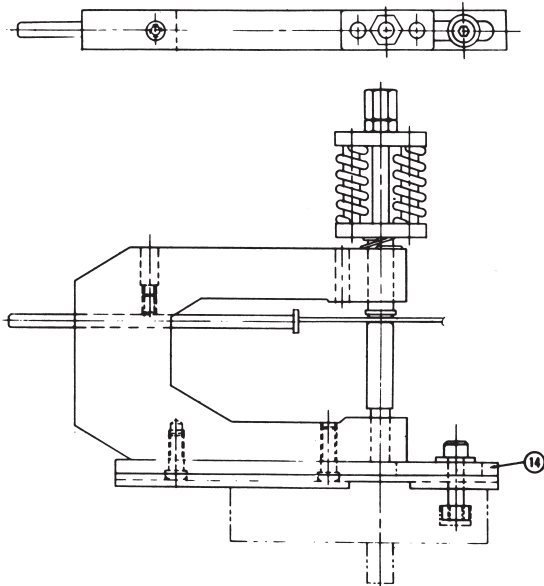
DOUBLE SPRING Model LDS-7 1/2 F (Fixed Base)

Model No.

Complete Unit	LDS-7 1/2 F	LDS-7 1/2 A
---------------	-------------	-------------

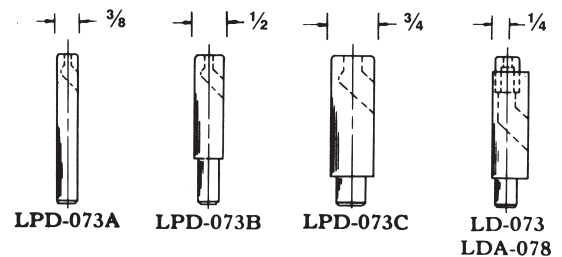
Cat. No.

With Die # LPD-073A	LDS-7 1/2 F-375	LDS-7 1/2 A-375
With Die # LPD-073B	LDS-7 1/2 F-500	LDS-7 1/2 A-500
With Die # LPD-073C	LDS-7 1/2 F-750	LDS-7 1/2 A-750
With Die Button LD-073 and Adapter LDA-078	LDS-7 1/2 F-DA	LDS-7 1/2 A-DA



Model LDS-7 1/2 A (Adjustable Base)

Pedestal Dies



- 1 Punch (Only) LP-072
- 2 Head Nut LHN-072C
- 3 Lock Nut LLN-072D
- 4 Spring Assy. LSA-075
- 5 Stripper Spring LSS-075
- 6 Guide (Open) LG-074

Guide (Closed) LG-074-1

Specify Punch Tip Size →

- 6A Lifter Spring LLS-076
- 7 Holder 4L 3/4

- 8 3/8" O.D. Pedestal Die LPD-073A
For Punch Size up to .156
- 9 1/2" O.D. Pedestal Die LPD-073B
For Punch Size up to .250
- 10 3/4" O.D. Pedestal Die LPD-073C
For Punch Size up to .312
- 11 Die Button LD-073 Max. Hole Size — .250
Die Adapter LDA-078
- 12 Nut, Bolt & Washer Set NB-100
- 13 Fixed Adapter with Screws LFA-079
- 14 Adjustable Adapter with Screws LAA-079
- 15 Gauge Rod GR-100
Furnished with 20% of Holders Ordered

3/4"

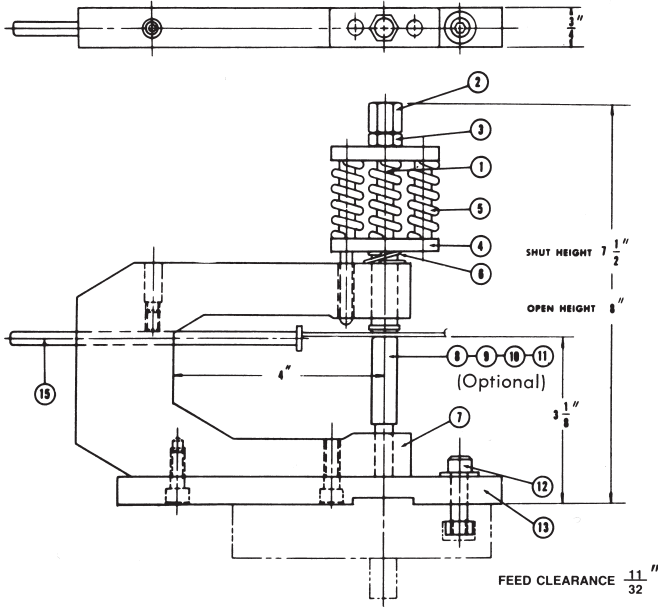
HOLDER WIDTH

7 1/2" SHUT HEIGHT

3 1/8" DIE HEIGHT

L-SERIES (Light Duty)

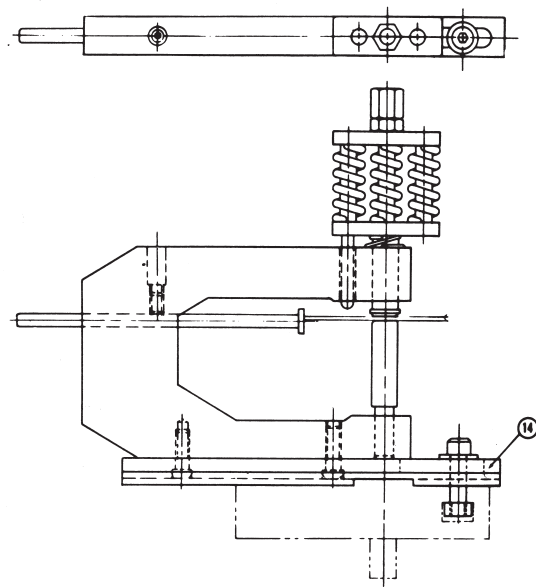
.312 Maximum Punch Diameter
10 Ga. Maximum Material Thickness



TRIPLE SPRING Model LTS-7 1/2 F (Fixed Base)

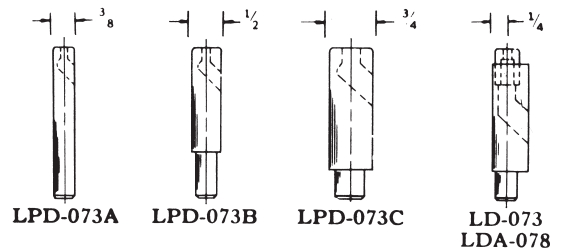
Model No.

Complete Unit	Model No.	
	LTS-7 1/2 F	LTS-7 1/2 A
	Cat. No.	
With Die # LPD-073A	LTS-7 1/2 F-375	LTS-7 1/2 A-375
With Die # LPD-073B	LTS-7 1/2 F-500	LTS-7 1/2 A-500
With Die # LPD-073C	LTS-7 1/2 F-750	LTS-7 1/2 A-750
With Die Button LD-073 and Adapter LDA-078	LTS-7 1/2 F-DA	LTS-7 1/2 A-DA



Model LTS-7 1/2 A (Adjustable Base)

Pedestal Dies

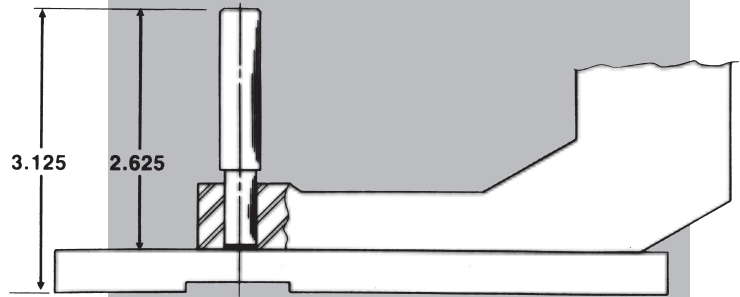
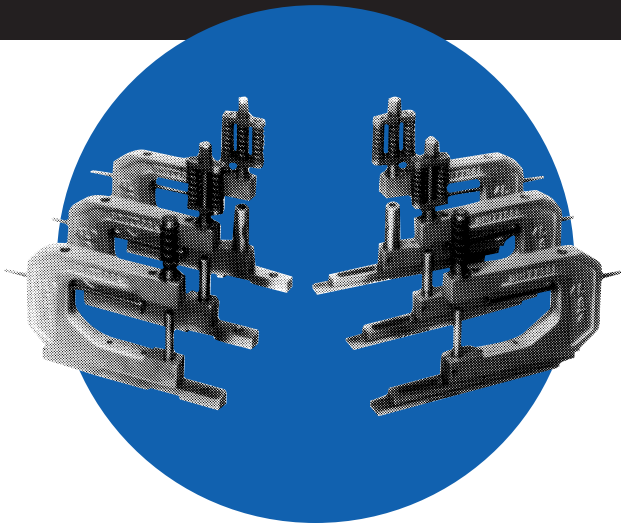


- 1 Punch (Only) LP-072
- 2 Head Nut LHN-072C
- 3 Lock Nut LLN-072D
- 4 Stripping Guide Assy. LSA-075-1
Specify Punch Tip Size → |←
- 5 Stripper Spring LSS-075
- 6 Lifter Spring LLS-076
- 7 Holder 4L 3/4
- 8 3/8" O.D. Pedestal Die LPD-073A
For Punch Size up to .156



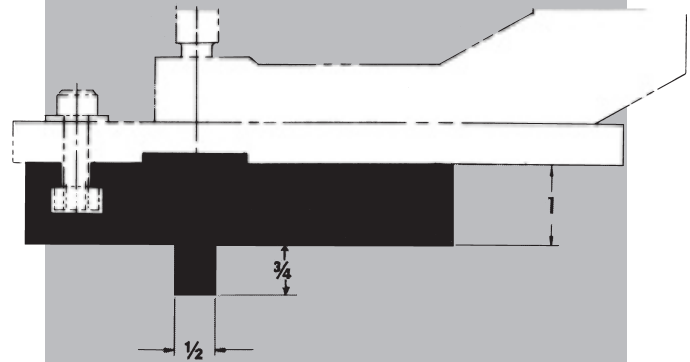
- 9 1/2" O.D. Pedestal Die LPD-073B
For Punch Size up to .250
- 10 3/4" O.D. Pedestal Die LPD-073C
For Punch Size up to .312
- 11 Die Button LD-073 Max. Hole Size — .250
Die Adapter LDA-078
- 12 Nut, Bolt & Washer Set NB-100
- 13 Fixed Adapter with Screws LFA-079
- 14 Adjustable Adapter with Screws LAA-079
- 15 Gauge Rod GR-100
Furnished with 20% of Holders Ordered

UNITTOOL ACCESSORIES



**DIE SHIMS
CAT NO. DS-100**

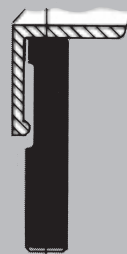
Die shims can be used with the $\frac{3}{8}$ " O.D. and the $\frac{1}{2}$ " O.D. pedestal dies to bring the die up to "new" length after excessive sharpening. A constant die height eliminates material distortion resulting from irregular die heights.



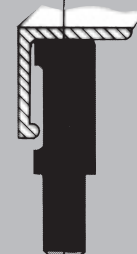
**BED RAIL
CAT. NO. BR-100**

This rail is used for mounting all "L" Series Units. Available in any required length.

Weight Per Ft. = 18 lbs.

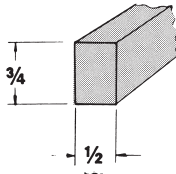


**$\frac{3}{8}$ " O.D. BULB
CLEARANCE DIE
CAT. NO.
LPD-073-ABC**

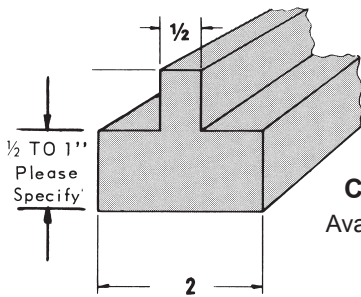


**$\frac{1}{2}$ " O.D. BULB
CLEARANCE DIE
CAT. NO.
LPD-073-BBC**

**RAM FILLER BAR
CAT. NO. RPB-100**



This bar is necessary to fill in key slot on bottom of press brake ram to provide a level surface. Available in any length.

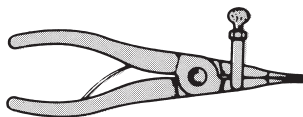
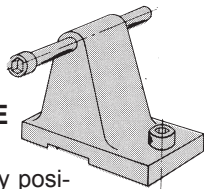


**RAM PLATE
CAT. NO. RP-100**

Available in any length.

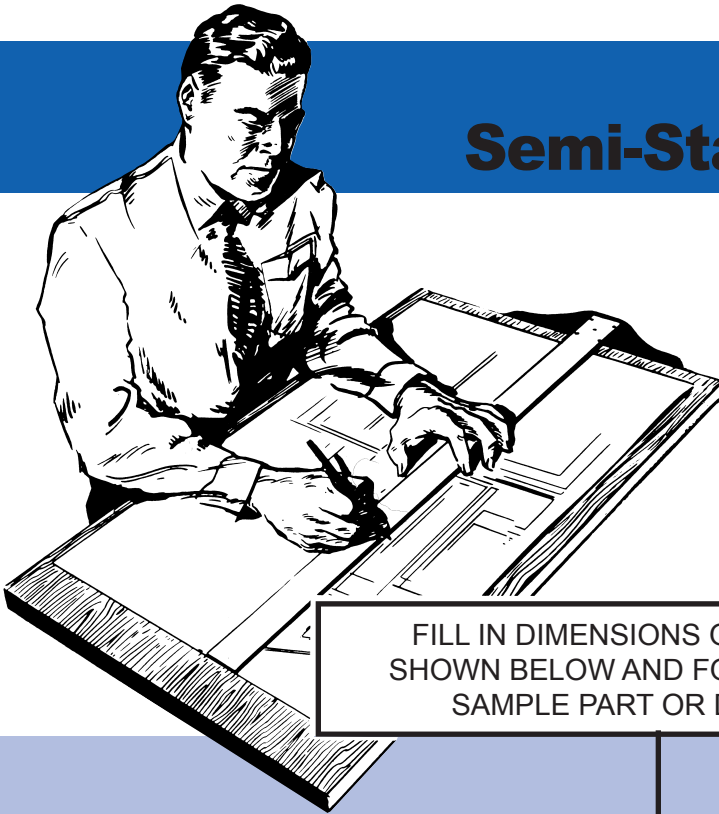
**END-STOP-ADJUSTABLE
CAT. NO. WS-100**

The end stop can be located at any position on the bed rail. Fine adjustment can be made with the adjustment screw.



**SNAP RING PLIERS
CAT. NO. SNP-100**

Semi-Standard Units

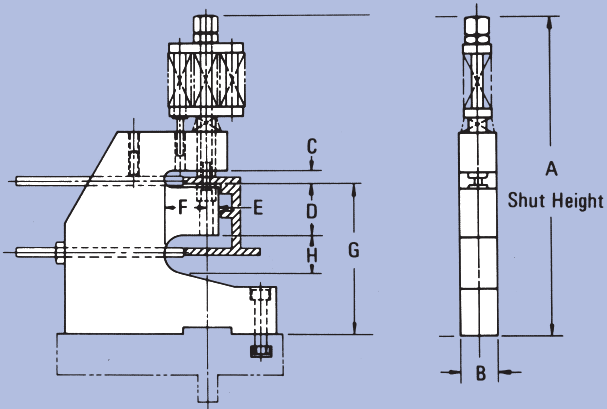


“Customized” units can be designed at reasonable costs, to fulfill a special need. Our free engineering department will be happy to furnish a quotation.

FILL IN DIMENSIONS ON DRAWING SHOWN BELOW AND FORWARD WITH SAMPLE PART OR DRAWING.

TEAR ON LINE

TO REMOVE -



DRAWING NO. 1



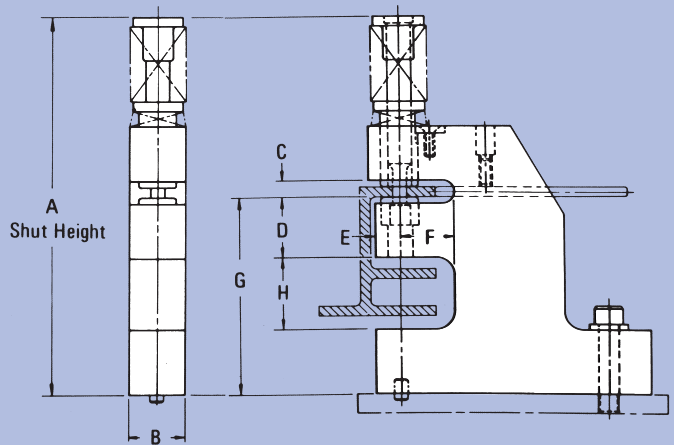
PUNCH DIAMETER



MATERIAL THICKNESS

--	--	--	--	--	--	--	--	--

A B C D E F G H



DRAWING NO. 2



PUNCH DIAMETER



MATERIAL THICKNESS

--	--	--	--	--	--	--	--	--

A B C D E F G H