For punching channel, angles, extrusions and flat stock up to 10 gauge
UNITTOOL
PUNCHING UNITS

Adjustable base units have 1 1/2" adjustment (1/4" 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.

Unitools 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.

SINGLE SPRING
Model LSS-6₁/₄F (Fixed Base)

<table>
<thead>
<tr>
<th>Model No.</th>
<th>LSS-6₁/₄F</th>
<th>LSS-6₁/₄A</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cat. No.</td>
<td></td>
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<tr>
<td>With Die # LPD-073A</td>
<td>LSS-6 ⅛ F-375</td>
<td>LSS-6 ⅛ A-375</td>
</tr>
<tr>
<td>With Die # LPD-073B</td>
<td>LSS-6 ⅛ F-500</td>
<td>LSS-6 ⅛ A-500</td>
</tr>
<tr>
<td>With Die Button LD-073  and Adapter LDA-078</td>
<td>LSS-6 ⅛ F-DA</td>
<td>LSS-6 ⅛ A-DA</td>
</tr>
</tbody>
</table>

Model LSS-6₁/₄A (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 ⅛ |
| 7 | ⅜ O.D. Pedestal Die LPD-073A  
   | For Punch Size up to .156 |
| 8 | ⅜ O.D. Pedestal Die LPD-073B  
   | For Punch Size up to .250 |
| 9 | ⅞ 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 |
**L-SERIES**  
(Light Duty) .125 Maximum Material Thickness

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

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

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

8. 3/16" O.D. Pedestal Die LPD-073A  
   For Punch Size up to .166

9. 1/4" O.D. Pedestal Die LPD-073B  
   For Punch Size up to .250

10. 3/8" 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

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**Unit Tool Punch & Die**
TRIPLE SPRING
Model LTS-7½F (Fixed Base)

Model LTS-7½A (Adjustable Base)

1. Punch (Only) LP-072
2. Head Nut LHN-072C
3. Lock Nut LLN-072D
4. Stripping Guide Assy. LSA-075-1
5. Stripper Spring LSS-075
6. Lifter Spring LLS-076
7. Holder 4L⅜
8. ⅜” O.D. Pedestal Die LPD-073A
   For Punch Size up to .156
9. ⅜” O.D. Pedestal Die LPD-073B
   For Punch Size up to .250
10. ¾” 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
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.

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

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

**Semi-Standard Units**

"Customerized" 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.

<table>
<thead>
<tr>
<th>DRAWING NO. 1</th>
<th>DRAWING NO. 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>B</td>
</tr>
<tr>
<td>PUNCH DIAMETER</td>
<td>PUNCH DIAMETER</td>
</tr>
<tr>
<td>MATERIAL THICKNESS</td>
<td>MATERIAL THICKNESS</td>
</tr>
</tbody>
</table>