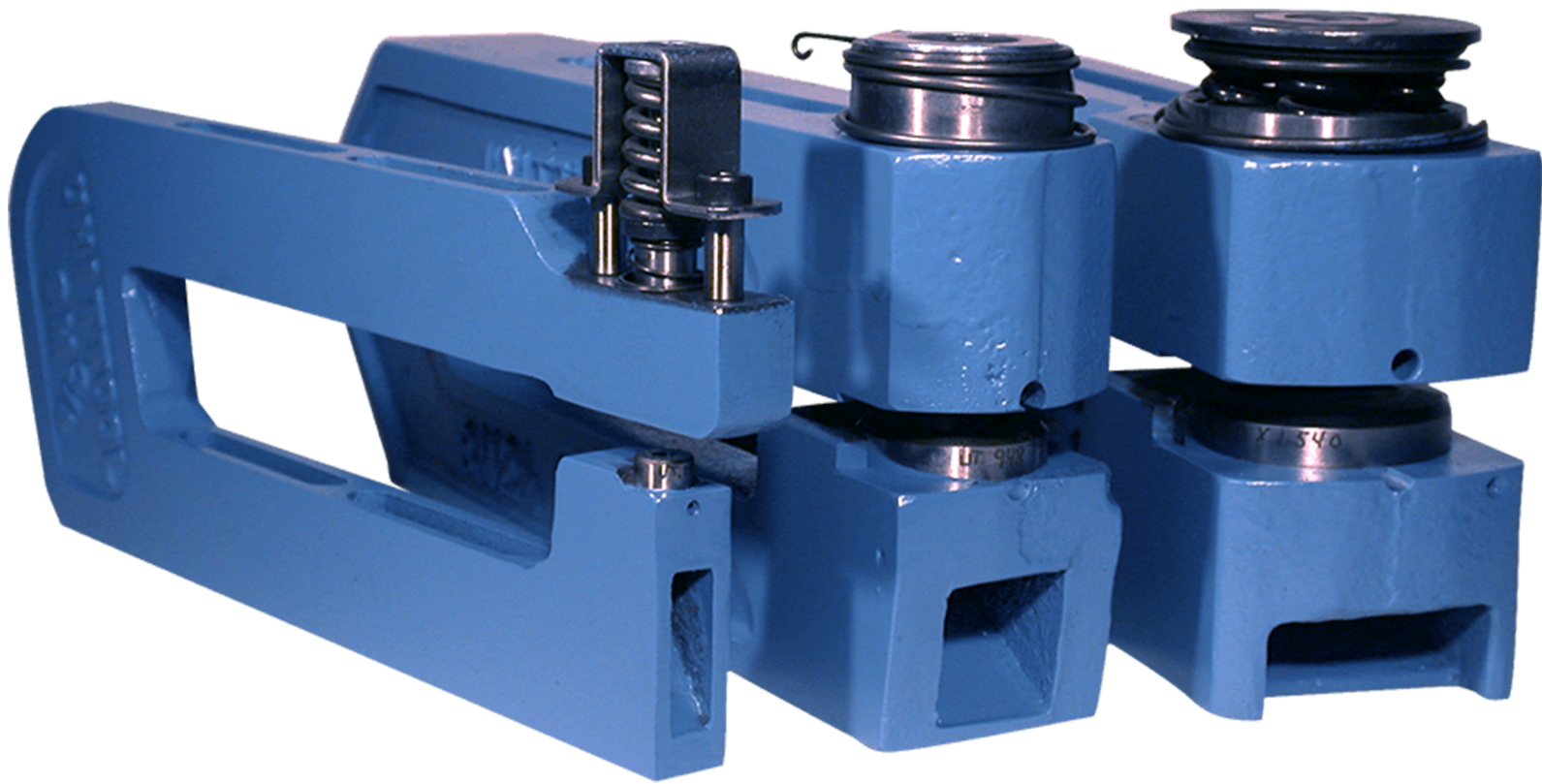


UNITTOOL

MEDIUM-DUTY PUNCHING UNITS



UNITTOOL PUNCH AND DIE COMPANY INC.

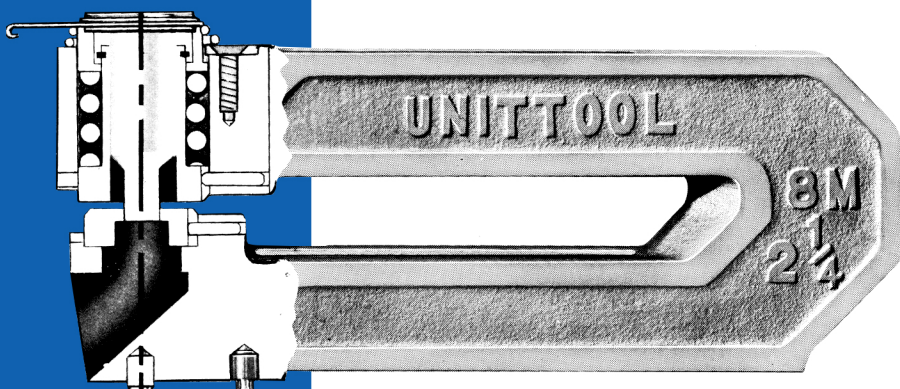
311 5th Street NW Clear Lake, WI 54005 | Phone: 1-716-873-8453 | Email: Info@Unittool.com

UNITTOOL "M" SERIES PUNCHING UNITS

UNITTOOL'S MEDIUM-DUTY SERIES PUNCHING UNITS are designed for use in press equipment with limited die space. Unittool and Unipunch brands have combined and merged product offerings.

TABLE OF CONTENTS

MODEL M-3/4	PG 3
MODEL M-1	PG 4
MODEL M-1 1/4	PG 5
MODEL M-1 3/4	PG 6
MODEL M-2 1/4	PG 7
MODEL M-2 1/2	PG 8
MODEL M-3	PG 9
MODEL M-5	PG 10

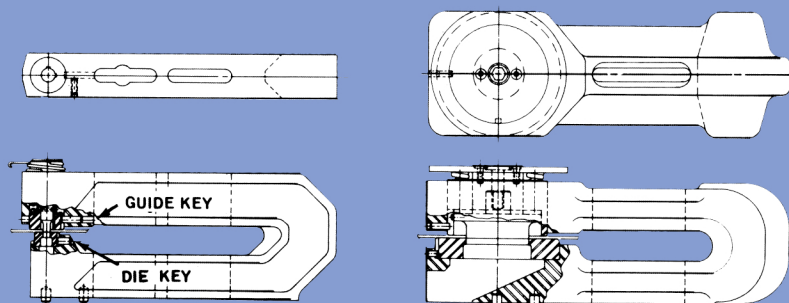


5-1/2" SHUT HEIGHT

Punch size range — .093 to 5.00 dia.

2-19/32" DIE HEIGHT

Capacity up to 10 gauge mild steel

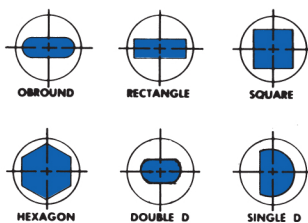


KEYING ARRANGEMENT
FOR MODELS M1 1/4, M1 3/4,
M2 1/4, M2 1/2, M3 & M4

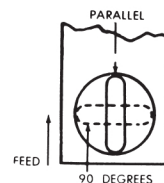
KEYING ARRANGEMENT
FOR MODELS M5 & M8

SHAPED HOLE PUNCHING DATA

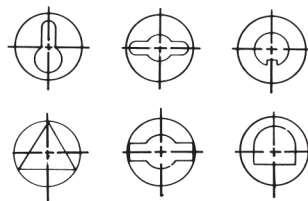
Standard Shapes



Standard shapes are keyed for both parallel and 90 degree position to the center line of the holder.



Semi standard and special shapes



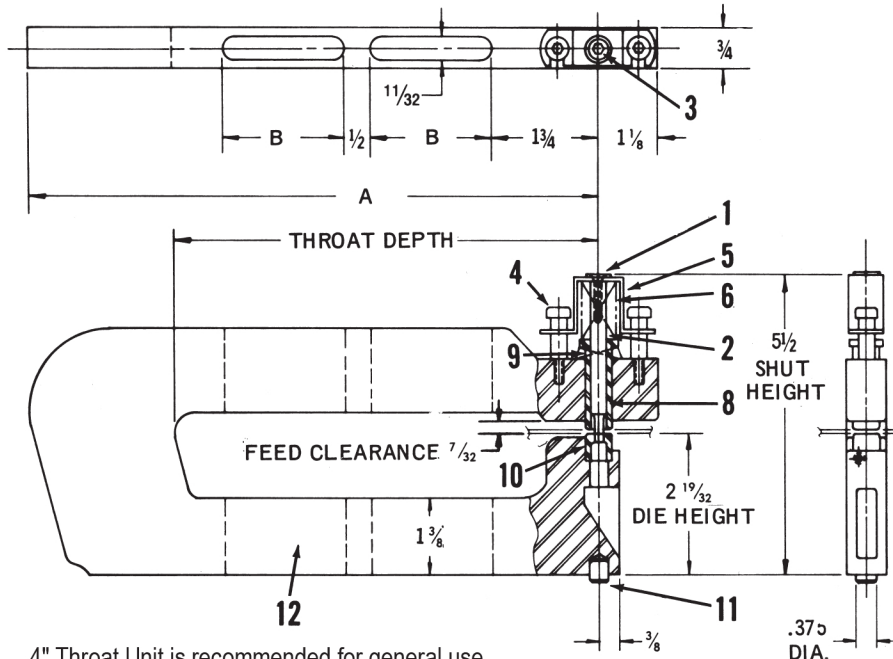
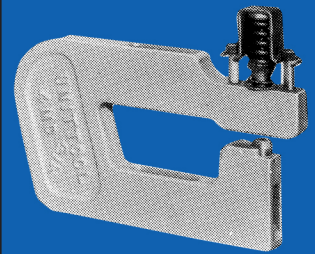
SEND SKETCH
FOR PRICE QUOTATION

MODEL M-3/4"

5 1/2" SHUT
HEIGHT

2 19/32" DIE
HEIGHT

CAT. NO.	THROAT DEPTH	HOLDER WIDTH	LENGTH A	LENGTH B	LENGTH C
4M-3/4	4 1/2	3/4	7 1/8	2 3/4	—
8M-3/4	8 1/2	3/4	11 1/8	2 3/4	—

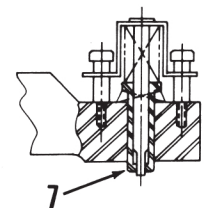


4" Throat Unit is recommended for general use.

8" Throat Unit should be used only where extra throat depth is required.

ALTERNATE ASSEMBLY
FOR HOLE SIZE
.125 AND UNDER

—Furnished with Closed Guide
and Long Punch Tip.



MAXIMUM PUNCH SIZE .3125 – MAXIMUM MATERIAL THICKNESS – 10 GAUGE MILD STEEL

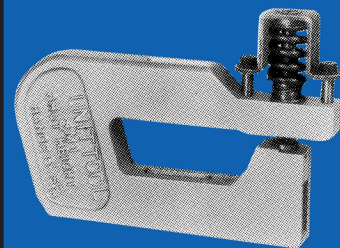
ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.	ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.
1	Punch Head	MPH-077	9	Lifter Spring	MLS-076
2	Punch (for size .125 and under) – Long Tip for Closed Guide.	MP-072-1	10	Die	MD-073
2	Punch (for size over .125) Stub Tip for Open Guide	MP-072-2	11	Pilot Pin	PP-1000
	Punch & Head Ass'y (for size .125 and under)	MPA-072-1A	12	1 Holder - 4" Throat	4M3/4C
	Punch & Head Ass'y for size over .125	MPA-072-2A		1 Holder - 8" Throat	8M3/4C
3	Flat Head Socket Screw	10-32x1" F.H.S.S.	MINIMUM RECOMENDED DIE CLEARANCE .006		
4	Stripper Bolts	MSB-078			
5	Retainer Cup	MR-079			
6	Stripper Spring	MSS-075			
7	Stripper Guide (Closed -Specify Punch Tip Size (Do not use Stub Tip Punches in Closed Guide)	MG-074-1			
8	Stripper Guide (Open)	MG-074-2			

MODEL M-1"

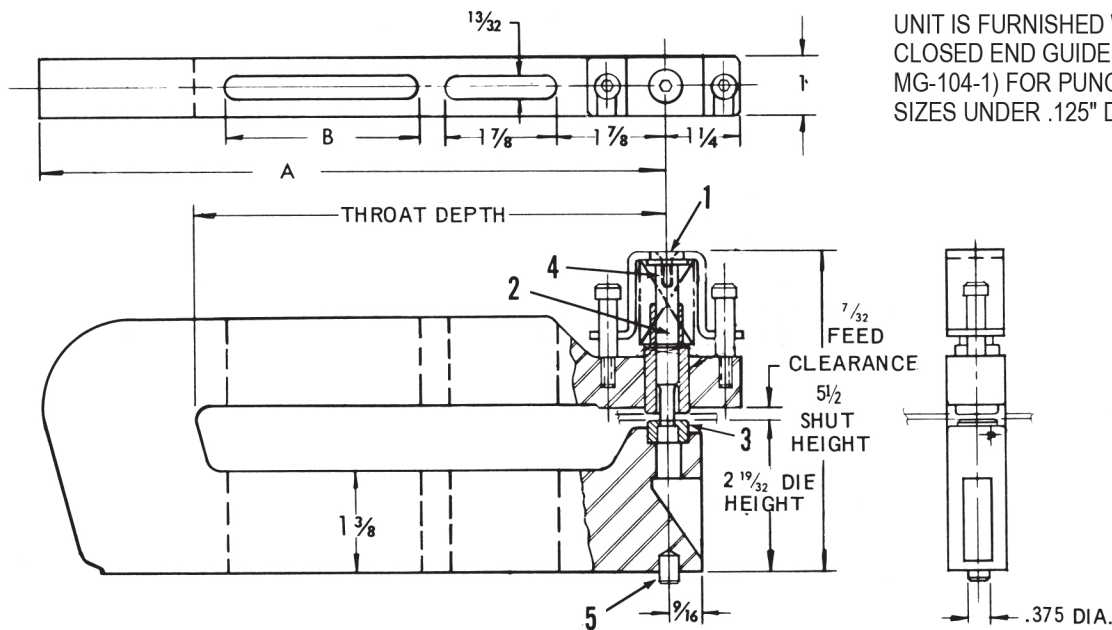
5 1/2" SHUT HEIGHT

2 19/32" DIE HEIGHT

CAT. NO.	THROAT DEPTH	HOLDER WIDTH	LENGTH A	LENGTH B
4M-1	4 1/2	1	7 1/8	—
8M-1	8 1/2	1	11 1/8	3 1/2



THE UNIT IS FOR ROUND HOLE PUNCHING ONLY.



UNIT IS FURNISHED WITH
CLOSED END GUIDE (Part No.
MG-104-1) FOR PUNCH TIP
SIZES UNDER .125" DIAMETER.

MAXIMUM PUNCH SIZE .375 – MAXIMUM MATERIAL THICKNESS – 10 GAUGE MILD STEEL

ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.
1	Punch Head	MPH-107
2	Punch & Head Assy.	MPA-102A
	Punch Only	MP-122
3	Die	MD103
4	Flat Head Socket Screw	91203
5	Pilot Pin	PP-1000

MINIMUM RECOMENDED
DIE CLEARANCE .006

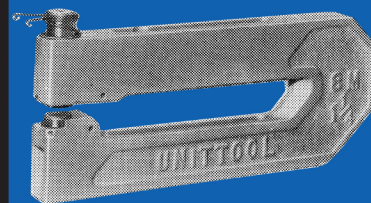
*Complete unit is not available.
Contact us for replacement components
or a comparable unit.*

MODEL M-1 1/4"

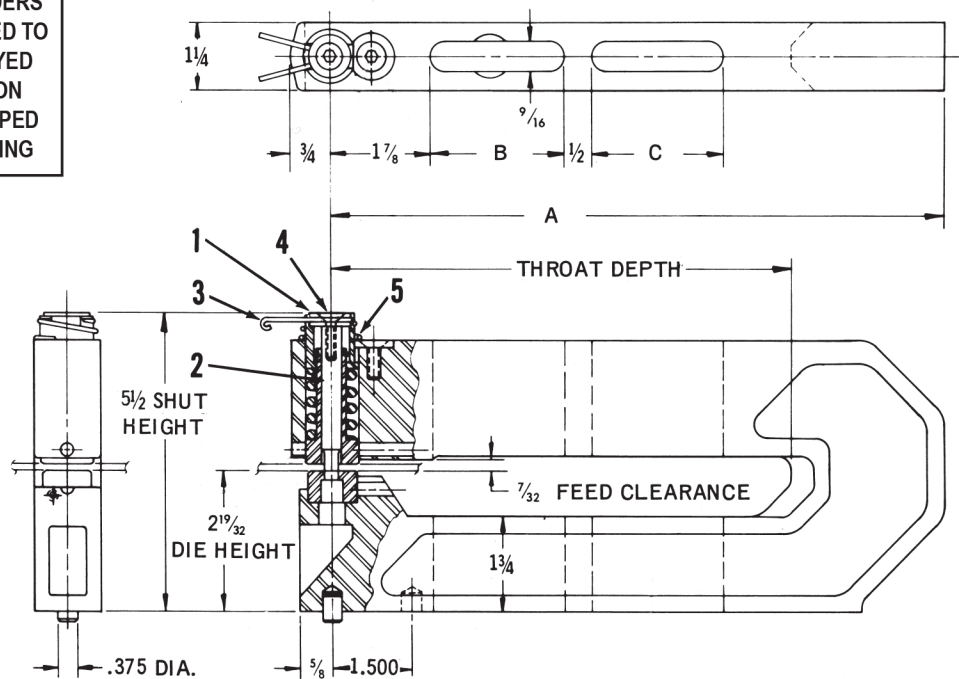
5 1/2" SHUT
HEIGHT

2 19/32" DIE
HEIGHT

CAT. NO.	THROAT DEPTH	HOLDER WIDTH	LENGTH A	LENGTH B	LENGTH C
4M-1 1/4	4 5/8	1 1/4	7 7/8	1 7/8	—
8M-1 1/4	8 5/8	1 1/4	11 7/8	5 7/8	—
12M-1 1/4	12 5/8	1 1/4	15 7/8	5 7/8	3 1/2



ROUND HOLDERS
ARE MACHINED TO
ACCEPT KEYED
CONVERSION
KIT FOR SHAPED
HOLE PIERCING



MAXIMUM PUNCH SIZE .375" – MAXIMUM MATERIAL THICKNESS – 10 GAUGE MILD STEEL

ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.
1	Punch Head	MPH-127
2	Punch (Round)	MP-122
	Round Punch & Head Ass'y.	MPA-122A
	Punch (Shaped)	MP-122K
	Shaped Punch & Head Ass'y.	MPA-122K
3	Punch Retainer	MPR-128
4	Flat Head Socket Screw	10-32x1" F.H.S.S.
5	Lifter Spring	MLS-126

**MINIMUM RECOMENDED
DIE CLEARANCE .006**

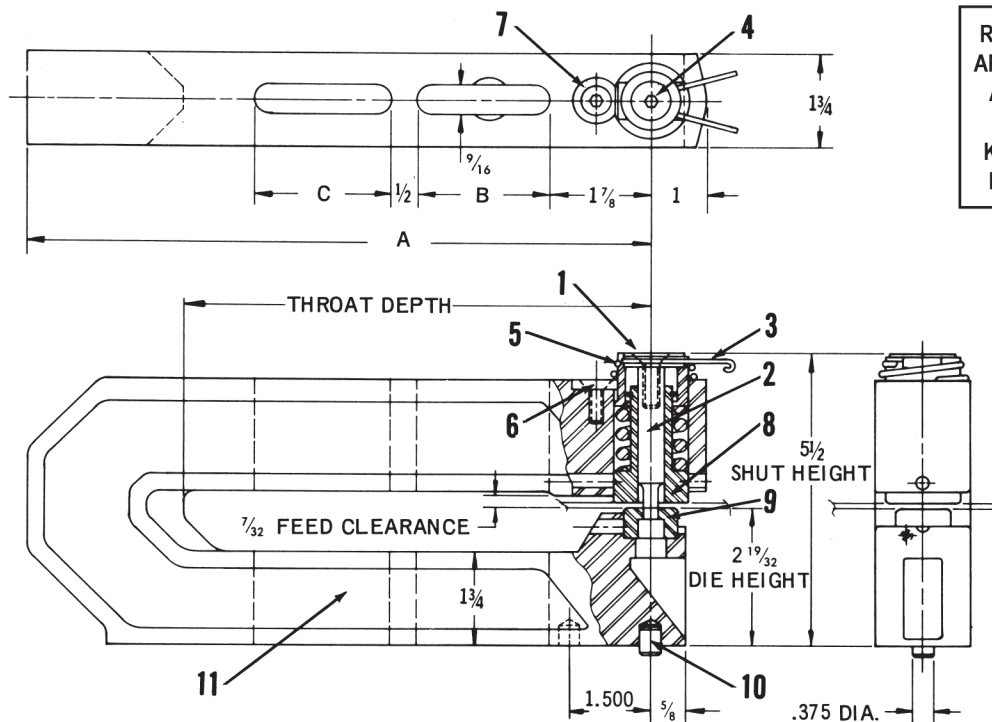
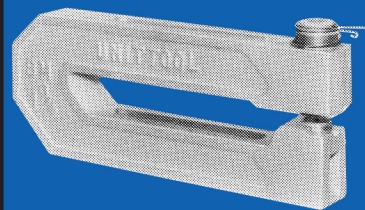
*Complete unit is not available.
Contact us for replacement components
or a comparable unit.*

MODEL M-13/4"

5 1/2" SHUT HEIGHT

2 19/32" DIE HEIGHT

CAT. NO.	THROAT DEPTH	HOLDER WIDTH	LENGTH A	LENGTH B	LENGTH C
4M-1 3/4	4 5/8	1 3/4	7 7/8	1 7/8	—
8M-1 3/4	8 5/8	1 3/4	11 7/8	5 7/8	—
12M-1 3/4	12 5/8	1 3/4	15 7/8	5 7/8	5 7/8
18M-1 3/4	18 5/8	1 3/4	21 7/8	5 7/8	3 1/2
24M-1 3/4	24 5/8	1 3/4	27 3/8	5 7/8	5 7/8



ROUND HOLDERS
ARE MACHINED TO
ACCEPT KEYED
CONVERSION
KIT FOR SHAPED
HOLE PIERCING

MAXIMUM PUNCH SIZE .500" – MAXIMUM MATERIAL THICKNESS – 10 GAUGE MILD STEEL

ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.	ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.
1	Punch Head	MPH-177	11	2 Holder – 4" Throat	4M1 3/4C
2	Punch (Round)	MP-172		2 Holder – 8" Throat	8M1 3/4C
	Round Punch & Head Ass'y	MPA-172A		2 Holder – 12" Throat	12M1 3/4C
	Punch (Shaped)	MP-172K		2 Holder – 18" Throat	18M1 3/4C
	Shaped Punch & Head Ass'y	MPA-172K	12	Guide or Die Key	GK-100
3	Punch Retainer	MPR-178	13	Shaped Hole Conversion Kit	MCK-175
4	Flat Head Socket Screw	5/16-24x1" F.H.S.S.		1 includes Lifter Spring	
5	Lifter Spring	MLS-176		2 includes Pilot Pin & Guide Retainer	
6	Button Head Screw	1/4-20x5/8 B.H.S.			
7	Guide Retainer	MGR-300			
8	1 Guide Ass'y. (not keyed)	MG-174			
	1 Guide Ass'y. (keyed)	MG-174K			
9	Die (Round)	MD-173			
	Die (Shaped)	MD-173K			
10	Pilot Pin (Round)	PP-1000			
	Pilot Pin (Keyed)	PP-1000K			

MINIMUM RECOMENDED
DIE CLEARANCE .006

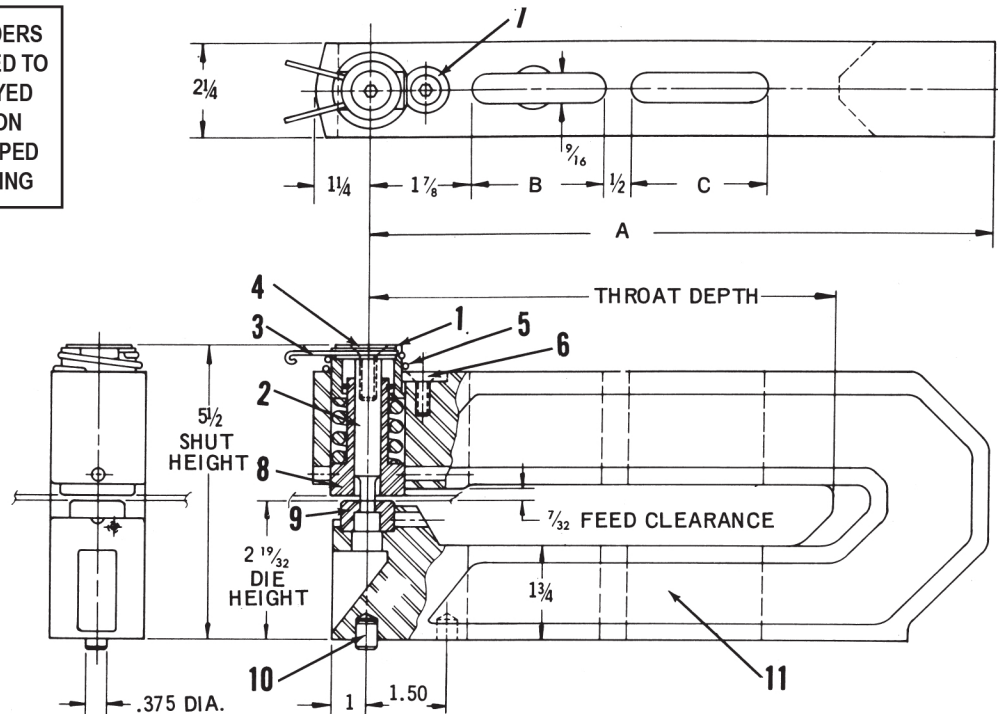
MODEL M-2 1/4"

5 1/2" SHUT HEIGHT

2 19/32" DIE HEIGHT

CAT. NO.	THROAT DEPTH	HOLDER WIDTH	LENGTH A	LENGTH B	LENGTH C
4M-2 1/4	4 5/8	2 1/4	7 7/8	1 7/8	-
8M-2 1/4	8 5/8	2 1/4	11 7/8	5 7/8	-
12M-2 1/4	12 5/8	2 1/4	15 7/8	5 7/8	3 1/2
18M-2 1/4	18 5/8	2 1/4	21 7/8	5 7/8	5 7/8
24M-2 1/4	24 5/8	2 1/4	27 3/8	5 7/8	5 7/8

ROUND HOLDERS ARE MACHINED TO ACCEPT KEYED CONVERSION KIT FOR SHAPED HOLE PIERCING



MAXIMUM PUNCH SIZE – 1.000" – MAXIMUM MATERIAL THICKNESS – 10 GAUGE MILD STEEL

ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.	ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.
1	Punch Head	MPH-227	11	2 Holder 4" Throat	4M2 1/4C
2	Punch (Round)	MP-222		2 Holder 8" Throat	8M2 1/4C
	Round Punch & Head Ass'y	MPA-222A		2 Holder 12" Throat	12M2 1/4C
	Punch (Shaped)	MP-222K		2 Holder 18" Throat	18M2 1/4C
	Shaped Punch & Head Ass'y	MPA-222K	12	Guide or Die Key	GK-100
3	Punch Retainer	MPR-228	13	Shaped Hole Conversion Kit	MCK-225
4	Flat Head Socket Screw	1/2-20x1" F.H.S.S.		1 includes Lifter Spring	
5	Lifter Spring	MLS-226		2 includes Pilot Pin & Guide Retainer	
6	Button Head Screw	1/4-20x5/8 B.H.S.			
7	Guide Retainer	MGR-300			
8	1 Guide Ass'y. (not keyed)	MG-224			
	1 Guide Ass'y. (keyed)	MG-224K			
9	Die-(Round)	MD-223			
	Die-(Shaped)	MD-223K			
10	Pilot Pin (Round)	PP-1000			
	Pilot Pin (Diamond)	PP-1000K			

MINIMUM RECOMENDED
DIE CLEARANCE .006

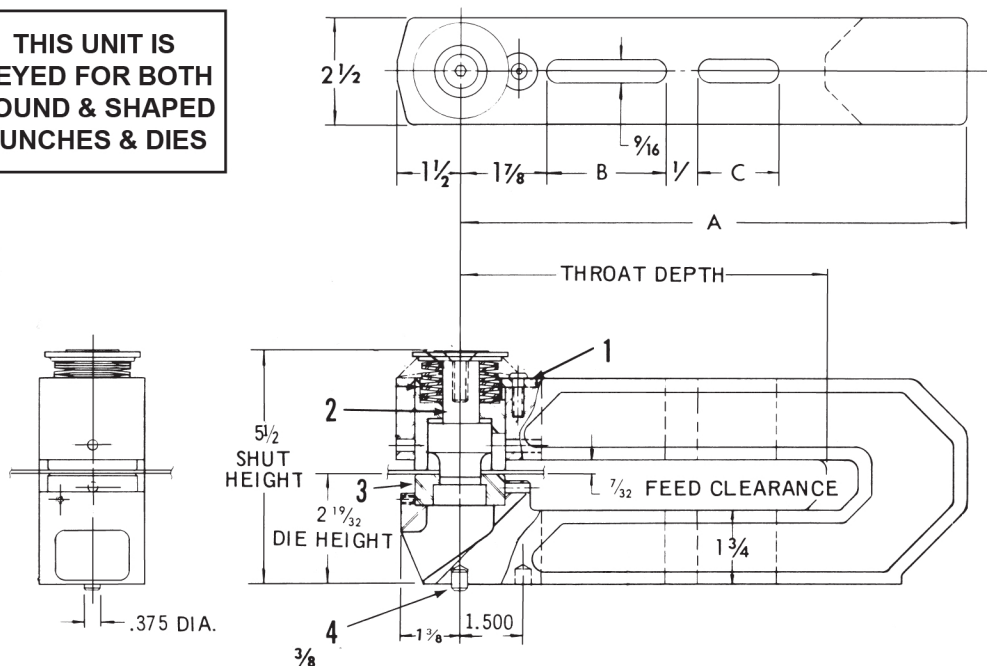
MODEL M-2¹/₂"

5¹/₂" SHUT
HEIGHT

2¹⁹/₃₂" DIE
HEIGHT

CAT. NO.	THROAT DEPTH	HOLDER WIDTH	LENGTH A	LENGTH B	LENGTH C
4M-2 ¹ / ₂	4 ⁵ / ₈	2 ¹ / ₂	7 ⁷ / ₈	1 ⁷ / ₈	—
8M-2 ¹ / ₂	8 ⁵ / ₈	2 ¹ / ₂	11 ⁷ / ₈	5 ⁷ / ₈	—
12M-2 ¹ / ₂	12 ⁵ / ₈	2 ¹ / ₂	15 ⁷ / ₈	5 ⁷ / ₈	3 ¹ / ₂
18M-2 ¹ / ₂	18 ⁵ / ₈	2 ¹ / ₂	21 ⁷ / ₈	5 ⁷ / ₈	5 ⁷ / ₈
24M-2 ¹ / ₂	24 ¹ / ₈	2 ¹ / ₂	27 ³ / ₈	5 ⁷ / ₈	5 ⁷ / ₈

THIS UNIT IS
KEYED FOR BOTH
ROUND & SHAPED
PUNCHES & DIES



MAXIMUM PUNCH SIZE 1.500" – MAXIMUM MATERIAL THICKNESS – 10 GAUGE MILD STEEL

ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.
1	Guide (Retainer)	MGR-300
2	Punch (Round)	MP-252
	Punch (Shaped)	MP-252K
3	Die (Round)	MD-253
	Die (Shaped)	MD-253K
4	Pilot Pin (Round)	PP-1000
	Pilot Pin (Shaped)	PP-1000K

MINIMUM RECOMENDED
DIE CLEARANCE .006

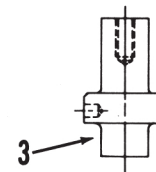
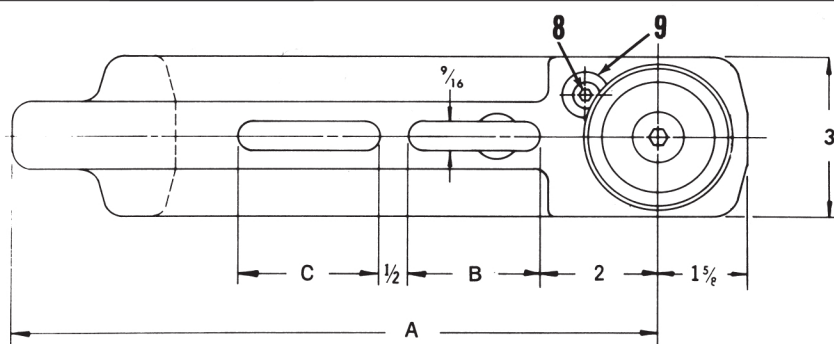
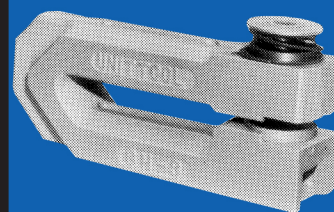
*Complete unit is not available.
Contact us for replacement components
or a comparable unit.*

MODEL M-3"

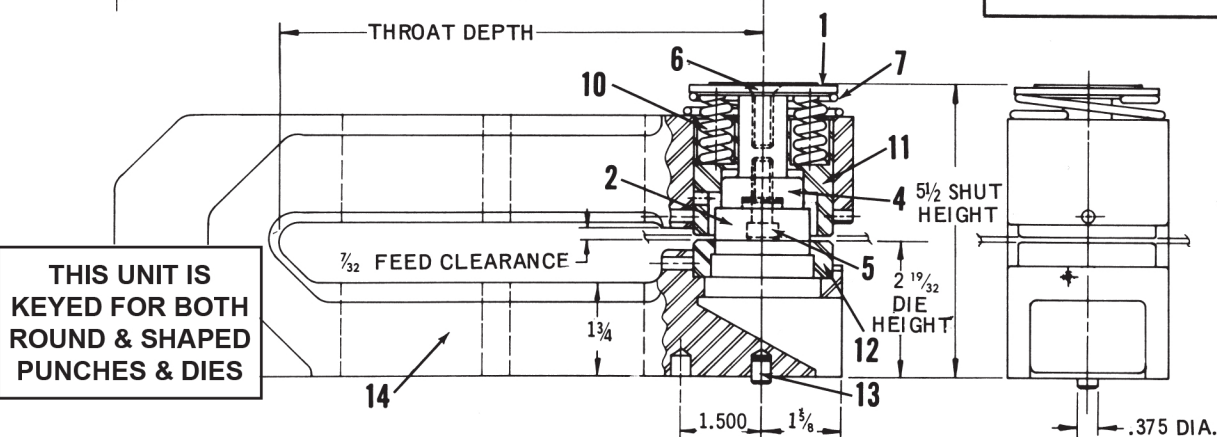
5 1/2" SHUT
HEIGHT

2 19/32" DIE
HEIGHT

CAT. NO.	THROAT DEPTH	HOLDER WIDTH	LENGTH A	LENGTH B	LENGTH C
4M-3	4 5/8	3	7 7/8	1 7/8	—
8M-3	8 5/8	3	11 7/8	5 7/8	—
12M-3	12 5/8	3	15 7/8	5 7/8	3 1/2
18M-3	18 5/8	3	21 7/8	5 7/8	5 7/8
24M-3	24 5/8	3	27 3/8	5 7/8	5 7/8



ALTERNATE FOR PUNCH
TIP UNDER 1.125" DIA.



MAXIMUM PUNCH SIZE – 2.000" – MAXIMUM MATERIAL THICKNESS – 10 GAUGE MILD STEEL

ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.	ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.
1	Punch Head	MPH-307	13	Pilot Pin (Round)	PP-1000
2	Punch (Round) 1.125 Dia. & over	MP-302		Pilot Pin (Diamond)	PP-1000K
3	Punch (Round) under 1.125 Dia.	MP-302-1	14	1 Holder 4" Throat	4M3CK
	Punch (Shaped)	MP-302-K		1 Holder 8" Throat	8M3CK
4	Punch Driver	MPD-308		1 Holder 12" Throat	12M3CK
5	Socket Head Cap Screw	3/8-24x1 1/4 S.H.C.S.		1 Holder 18" Throat	18M3CK
6	Flat Head Machine Screw	3/8-24x1 F.H.M.S.		1 Includes Round Pilot Pin, Diamond Pilot Pin Guide Key, Die Key & Guide Retainer	
7	Lifter Spring	MLS-306			
8	Button Head Screw	1/4-20x5/8 B.H.S.			
9	Guide Retainer	MGR-300			
10	Stripper Spring (6 req.)	MSS-305			
11	Guide (keyed)	MG-304K			
12	Die (Round)	HD-303			
	Die (Shaped)	HD-303K			

**MINIMUM RECOMENDED
DIE CLEARANCE .006**

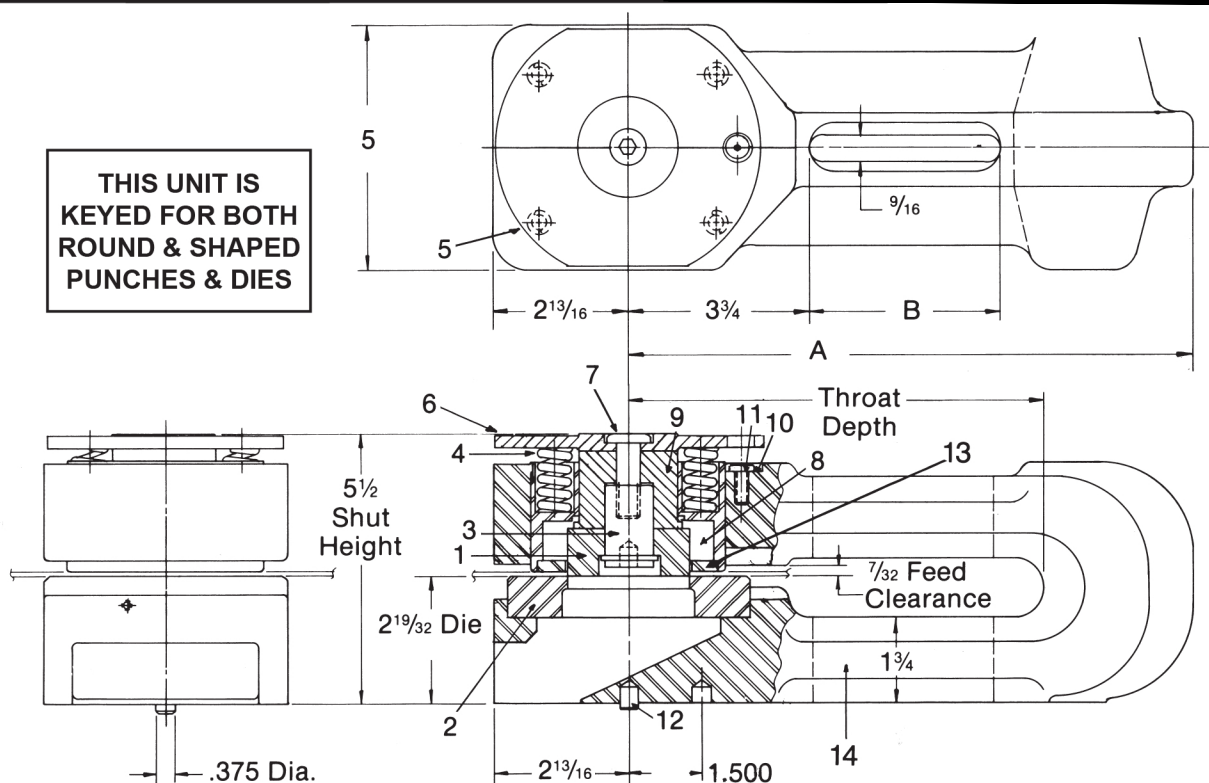
MODEL M-5"

5 1/2" SHUT
HEIGHT

2 19/32" DIE
HEIGHT

CAT. NO.	THROAT DEPTH	HOLDER WIDTH	LENGTH A	LENGTH B
10M-5	10 5/8	5	14 1/2	6
14M-5	14 5/8	5	18 1/2	11
18M-5	18 5/8	5	22 1/2	14
24M-5	24 5/8	5	27 1/8	14

THIS UNIT IS
KEYED FOR BOTH
ROUND & SHAPED
PUNCHES & DIES



MAXIMUM PUNCH SIZE – 3.500" – MAXIMUM MATERIAL THICKNESS – 10 GAUGE

ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.	ITEM NO.	PART LIST DESCRIPTION	CATALOG NO.
1	Punch Tip (Round) over 1 9/16" to 2 1/4" Dia.	MP-502B	11	Button Head Screw	1/4-20x5/8 B.H.S.
	Punch Tip (Round) over 2 1/4" to 2 7/8" Dia.	MP-502C	12	Pilot Pin (Round)	PP-1000
	Punch Tip (Round) over 2 7/8" to 3 1/2" Dia.	MP-502D	13	Pilot Pin (Shaped)	PP-1000K
	Punch (Shaped) up to 1 1/2" Dimension	UMP-502AK	14	Stripper Plate	MSP-509
	Punch (Shaped) over 1 1/2" to 2 1/2" Dimension	UMP-502CK	15	1 Holder 10" Throat	10M5-CK
	Punch (Shaped) over 2 1/2" to 3 1/2" Dimension	UMP-502DK		1 Holder 14" Throat	14M5-CK
2	Die (Round)	HD-603		1 Holder 18" Throat	18M5-CK
	Die (Shaped)	HD-603K		Guide or Die Key	GK-500
3	Punch Tip Retainer	PR-500		1 Includes Round Pilot Pin, Diamond Pilot Pin Guide Key, Die Key & Guide Retainer	
4	Stripper Spring (12 req.)	MSS-305			
5	Lifter Spring (4 req.)	MLS-506			
6	Punch Plate	MPP-507			
7	Button Head Screw	1/2-13x2			
8	Guide (Keyed)	MG-504K			
9	Punch Driver	MPD-508			
10	Guide (Retainer)	MGR-300			

MINIMUM RECOMENDED
DIE CLEARANCE .008