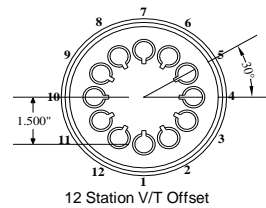
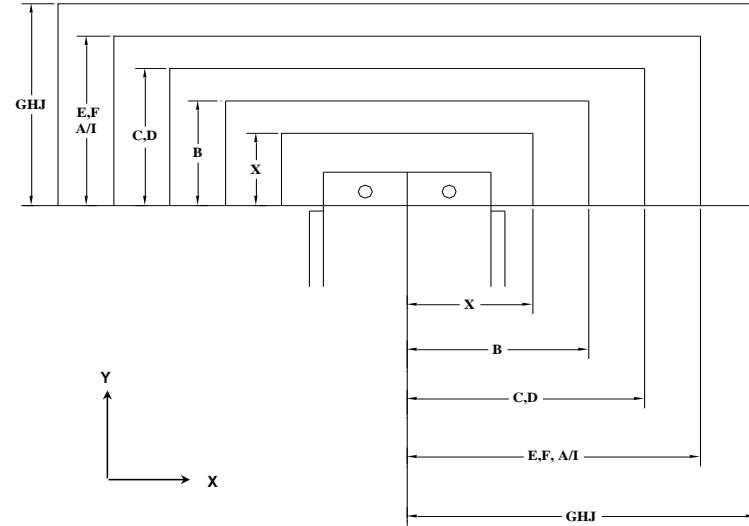
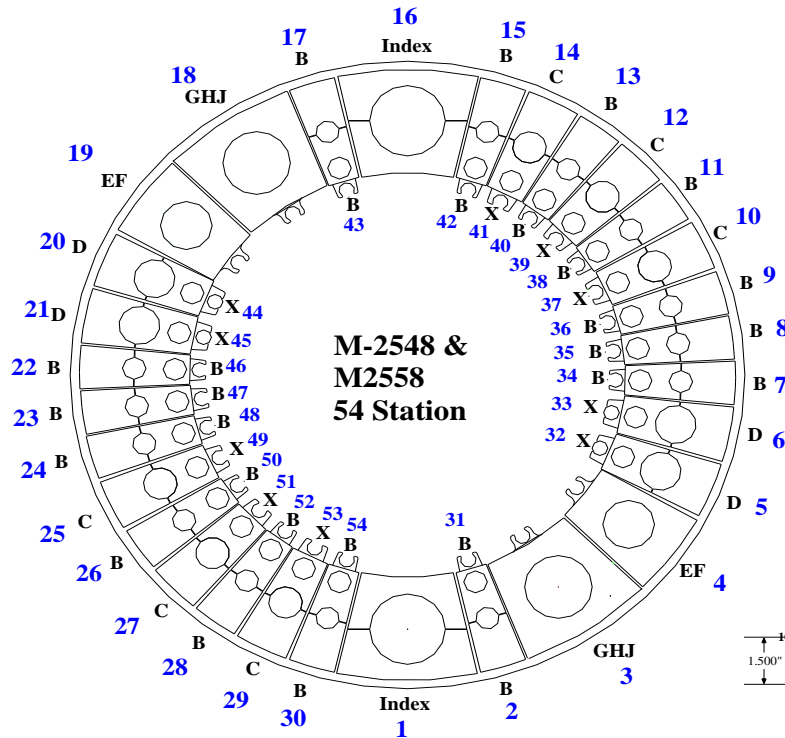


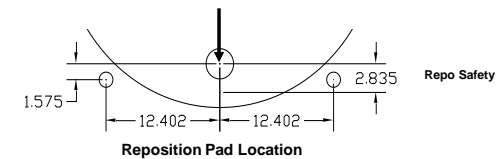
| Max Station Range Act. Station Range | X | B | C | D | EF | | GHJ | | | VariTool Auto Index | |
|---|----------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------|----------------------------------|
| | | | | | E | F | G | H (114) | J (114) | A/I, V/T Ready | VARITOOL |
| No. of Stations | 10 | 28 | 6 | 4 | 1 | 1 | 1 | 1 | 0 | 2 | 0 |
| Round/Obround | 0.500" & Under | 1.000" & Under | Over 1.000" to 1.500" | Over 1.500" to 2.00" | Over 2.000" to 2.500" | Over 2.500" to 3.000" | Over 3.000" to 3.500" | Over 3.500" to 4.125" | Over 4.125" to 4.750" | 3.00" Max. Diameter | 12 Station 1/2" Maximum Diameter |
| Square | N/A | 0.625" & Under | Over 0.625" to 0.875" | Over .875" to 1.250" | Over 1.250" to 1.625" | Over 1.625" to 2.00" | Over 2.000" to 2.250" | Over 2.250" to 2.750" | Over 2.750" to 3.125" | | |
| Rectangle | N/A | 1.000" Max Across Corners | 1.500" Max Across Corners | 1.750" Max Across Corners | 2.250" Max Across Corners | 2.625" Max Across Corners | 3.125" Max Across Corners | 3.875" Max Across Corners | 4.437" Max Across Corners | | |
| Punch Holder O.D. | 1.692" | 2.250" | 3.125" | 3.375" | 4.562" | 4.562" | 5.938" | 5.938" | 5.938" | 4.172" | 4.172" |
| Die Holder I.D. | 1.562" | 1.562" | 2.250" | 2.750" | 3.500" | 4.000" | 4.500" | 5.250" | 6.000" | 4.000" | N/A |



| Safety Zones: | X | Y | (US) Tonnage Limits: |
|--------------------------|-----------|--------|----------------------|
| X | +/-2.480" | 1.299" | Machine: 27.5 |
| B | +/-2.756" | 1.575" | Auto Index: 16.5 |
| CD | +/-3.307" | 2.126" | Vari-Tool: 5 |
| EF | +/-3.898" | 2.717" | |
| GHJ | +/-4.606" | 3.425" | |
| Cell Ready add +/- .563" | | | |

T38 is reserved for separating parts for the unload chute.
 Maximum size for part chute : X7.87", Y3.94"
 Minimum size for part chute : X1.18", Y3.15"

Machine Center Line



Load Position: X98.425 Y60.039 M30 (M2548)
 X98.425 Y72.047 M30 (M2558)

Throat Depth: 52.756" (1340mm)
 Throat Depth: 63.779" (1620mm)

Travel Range: Minimum Maximum
 X -0.984 99.409
 Y 0.000 62.991 (Inner Track M2548)
 Y -2.756 60.236 (Outer Track M2548)
 Y 0.000 74.999 (Inner Track M2558)
 Y -2.756 72.244 (Outer Track M2558)