## Tool Assignment by Station Range

### Tooling Style: 114

<table>
<thead>
<tr>
<th>Max Station Range</th>
<th>A</th>
<th>B</th>
<th>CD</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>G</th>
<th>VariTool Auto Index</th>
</tr>
</thead>
<tbody>
<tr>
<td>Max Station Range</td>
<td>No. of Stations</td>
<td>0</td>
<td>12</td>
<td>4</td>
<td>1</td>
<td>1</td>
<td>1</td>
<td>0</td>
</tr>
<tr>
<td>Round/Obround</td>
<td>.5&quot; &amp; Under</td>
<td>1&quot; &amp; Under</td>
<td>Over 1&quot; to 1.500&quot;</td>
<td>Over 1-1.5&quot; to 2.00&quot;</td>
<td>Over 2.00&quot; to 2.500&quot;</td>
<td>Over 2.50&quot; to 3.00&quot;</td>
<td>Over 3.00&quot; to 3.500&quot;</td>
<td>3.00&quot; Max. Diagonal</td>
</tr>
<tr>
<td>Square</td>
<td>N/A</td>
<td>.625&quot; &amp; Under</td>
<td>Over .625&quot; to .875&quot;</td>
<td>Over .875&quot; to 1.250&quot;</td>
<td>Over 1.250&quot; to 1.625&quot;</td>
<td>Over 1.625&quot; to 2.00&quot;</td>
<td>Over 2.00&quot; to 2.250&quot;</td>
<td>4.562&quot;</td>
</tr>
<tr>
<td>Rectangle</td>
<td>N/A</td>
<td>1.000&quot; Max Across Corners</td>
<td>1.500&quot; Max Across Corners</td>
<td>2.000&quot; Max Across Corners</td>
<td>2.500&quot; Max Across Corners</td>
<td>3.000&quot; Max Across Corners</td>
<td>3.500&quot; Max Across Corners</td>
<td>4.172&quot;</td>
</tr>
<tr>
<td>Punch Holder O. D.</td>
<td>2.250&quot;</td>
<td>2.250&quot;</td>
<td>3.125&quot;</td>
<td>3.375&quot;</td>
<td>4.562&quot;</td>
<td>4.562&quot;</td>
<td>5.938&quot;</td>
<td>4.172&quot;</td>
</tr>
<tr>
<td>Die Holder I. D.</td>
<td>1.562&quot;</td>
<td>1.562&quot;</td>
<td>2.250&quot;</td>
<td>2.750&quot;</td>
<td>3.500&quot;</td>
<td>4.000&quot;</td>
<td>4.500&quot;</td>
<td>4.000&quot;</td>
</tr>
</tbody>
</table>

### Motorum 2044TC
22 Stations

**Load Position:**
- X = +/- 0.787" (20mm)
- Y = +/- 1.968" (50mm)
- Y = +/- 0.197" (5mm)

**Over Travel:**
- X = +/- 1.968" (50mm)

**Throat Depth:** 51.181" (1300mm)

**With Stubby Work Holders you gain 9.843" in material capacity.**
(250mm)

Part #: P63-23001-10

**Machine Center Line**

**Reposition Pad Location**

**Safety Zones:**
- AB: +/- 2.756" 1.575" Machine: 22
- CD: +/- 3.307" 2.126" Auto Index: 16.5
- EF: +/- 3.898" 2.717" Vari-Tool: 5
- G: +/- 4.606" 3.425"