### Motorum Series Tool Assignment by Station Range

#### Spring Style Tooling

<table>
<thead>
<tr>
<th>Max Station Range</th>
<th>1/2&quot; Round Only</th>
<th>1/2&quot;</th>
<th>1 1/4&quot;</th>
<th>2.00&quot;</th>
<th>3 1/2&quot;</th>
<th>4 1/2&quot;</th>
<th>Auto Index</th>
<th>Multi-Tool</th>
</tr>
</thead>
<tbody>
<tr>
<td>Act. Station Range</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>No. of Stations</td>
<td>6</td>
<td>12</td>
<td>16</td>
<td>4</td>
<td>2</td>
<td>2</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Round/Obround</td>
<td>.5&quot; &amp; Under</td>
<td>.501&quot; to 1.250&quot;</td>
<td>1.251&quot; to 2.00&quot;</td>
<td>2.001&quot; to 3.500&quot;</td>
<td>3.501&quot; to 4.500&quot;</td>
<td>2.001&quot; to 3.500&quot;</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Square</td>
<td>N/A</td>
<td>0.500&quot; Across Corners</td>
<td>2.000&quot; Across Corners</td>
<td>4.500&quot; Across Corners</td>
<td>3.500&quot; Across Corners</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Rectangle</td>
<td>N/A</td>
<td>0.500&quot; Across Corners</td>
<td>2.000&quot; Across Corners</td>
<td>4.500&quot; Across Corners</td>
<td>3.500&quot; Across Corners</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Punch Holder O.D.</td>
<td>1.019&quot;</td>
<td>1.019&quot;</td>
<td>1.883&quot;</td>
<td>2.750&quot;</td>
<td>4.374&quot;</td>
<td>5.250&quot;</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Die Holder I.D.</td>
<td>1.000&quot;</td>
<td>1.000&quot;</td>
<td>1.875&quot;</td>
<td>3.500&quot;</td>
<td>4.938&quot;</td>
<td>6.250&quot;</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

#### Notes:
- The Auto Index stations can be either 1.250", 2.000", 3.500", or Multi-Tool, depending on customer requirements.

#### Machine Center Line

**Load Position:**
- X98.425 Y60.748 M30 (M2548T)
- X98.425 Y72.756 M30 (M2558T)

**Over Travel:**
- X = +/- 0.984" (25mm)
- Y = +/- 0.197" (5mm) Outer Track
- Y = +/- 3.159" (80mm) Outer Track
- Y = +/- 1.575" (40mm) Middle Track
- Y = 0.0" (Zero) Inner Track

**Safety Zones:**
- X | Y (US) Tonnage Limits:
  - 0.500" | +/- 2.125" | 0.945" Machine: 27
  - 1.250" | +/- 2.559" | 1.378" Auto Index: 16.5
  - 2.000" | +/- 2.992" | 1.811"
  - 3.500" | +/- 3.819" | 2.638" M-2548T & M-2558T
  - 4.500" | +/- 4.252" | 3.070" M-2548T

**Cell Ready add +/- 0.563"**

**T29 is reserved for separating parts for the unload chute.**

**Minimum size for part chute:**
- X1.18", Y3.15" M58 Opens the chute. M59 Closes the chute
- X7.87", Y3.94" Maximum size for part chute

**M2558-T 46 Ranges**

**P66 PSD-D0179-31 8/31/2007**