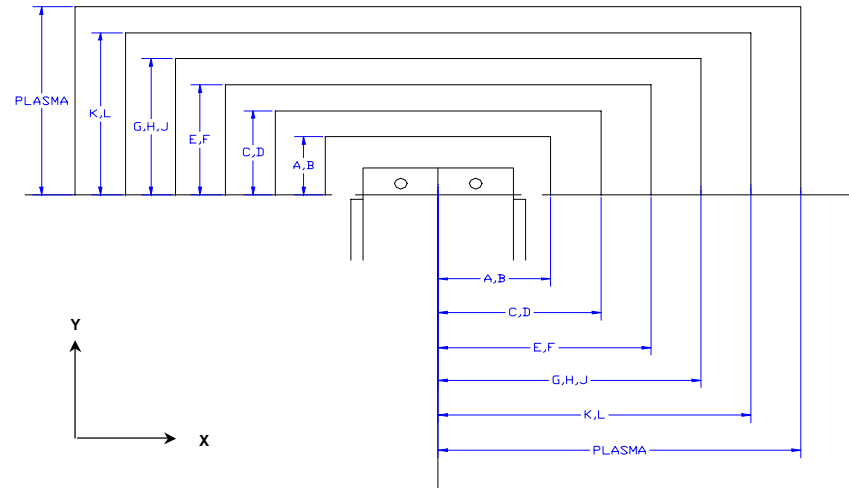
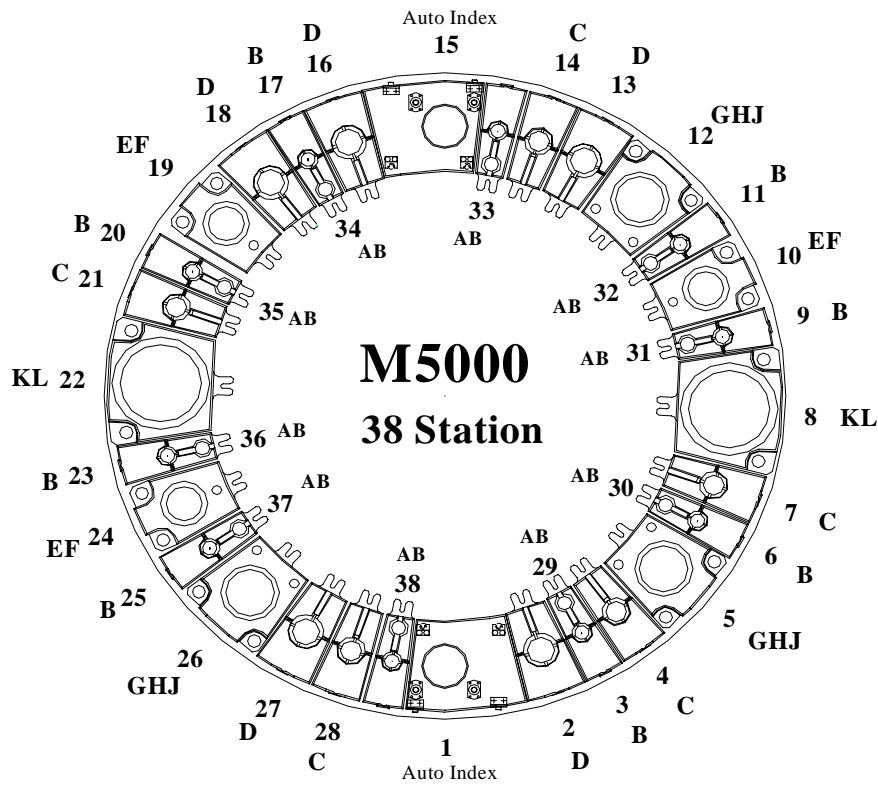


Tool Assignment by Station Range

Tooling Style: 114

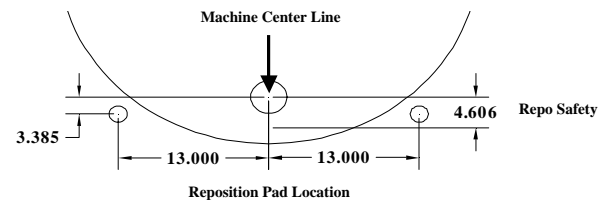
Max Station Range	AB	B	C	D	EF		GHJ				Auto Index	
Act. Station Range					E	F	G	H (114)	J (114)	K (114)	L (114)	D
No. of Stations	10	8	5	5	1	2	1	1	1	1	1	2
Round/Obround	1.000" & Under	1.000" & Under	Over 1.000" to 1.500"	Over 1.500" to 2.00"	Over 2.000" to 2.500"	Over 2.500" to 3.000"	Over 3.000" to 3.500"	Over 3.500" to 4.125"	Over 4.125" to 4.750"	Over 4.750" to 5.500"	Over 5.500" to 6.000"	Over 1.500" to 2.00"
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 1.875"	Over 1.875" to 2.250"	Over 2.250" to 2.750"	Over 2.750" to 3.125"	Over 3.125" to 3.625"	Over 3.625" to 4.000"	Over .875" to 1.250"
Rectangle	N/A	0.875" Max Across Corners	1.219" 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	5.125" Max Across Corners	5.625" Max Across Corners	1.750" Max Across Corners
Punch Holder O.D.	2.250"	2.250"	3.125"	3.375"	4.563"	4.563"	5.938"	5.938"	5.938"	6.750"	6.750"	3.375"
Die Holder I.D.	1.563"	1.563"	2.250"	2.750"	3.500"	4.000"	4.500"	5.250"	6.000"	7.000"	7.500"	2.750"



Safety Zones:	X	Y	(US) Tonnage Limits:	
AB	+/-2.756"	1.575"	Machine - M5000	45
CD	+/-3.307"	2.126"	Machine - V5058	50
EF	+/-3.898"	2.717"	Auto Index:	16.5
GHJ	+/-4.606"	3.425"	Vari-Tool:	N/A
KL	+/-5.000"	3.819"		
PLASMA	+/-6.810"	5.550"		
Laser (Contact)	+/-3.346"	1.575"		
Laser (Non-Con)	+/-4.331"	2.559"		

Cell Ready add +/- .563" to X

Load Position: X72.047 Y60.039 M30 (M5000) Throat depth: 63.898" (1623mm)
 X98.425 Y60.039 M30 (V5058) Throat depth: 63.898" (1623mm)
 Over Travel: X = +/- 0.984" (25mm)
 Y = + 0.987" (25mm M5000) +1.772" (45mm V5058)
 Y = - 2.756" (70mm) Dist. between inner & outer track (Outer track)
 Y = - 0 (Zero) Inner track



Magnum 5000 Turret Layout