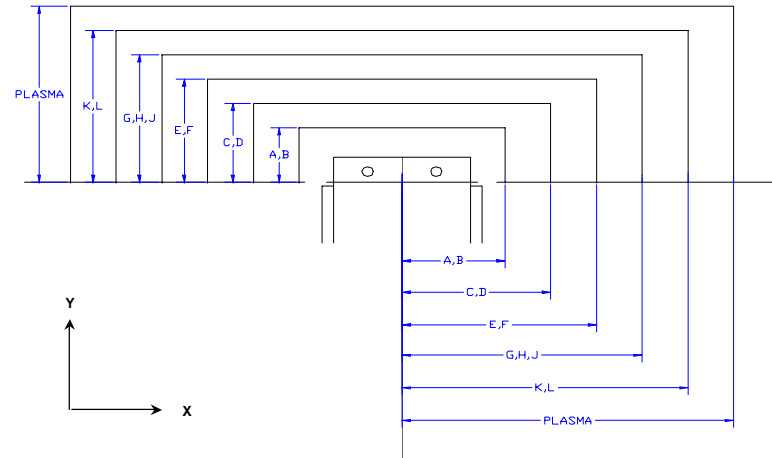
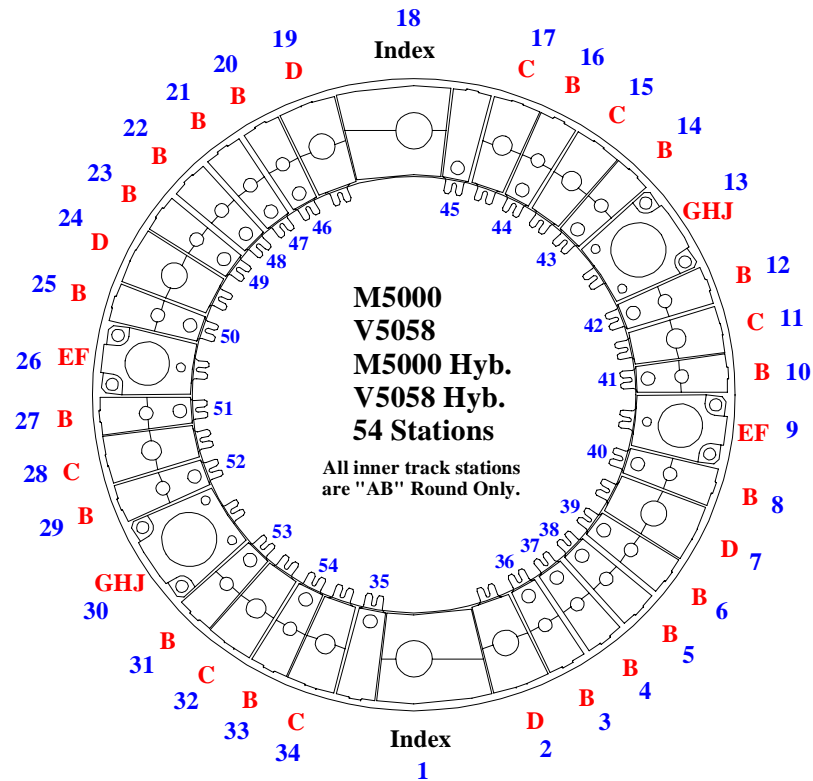


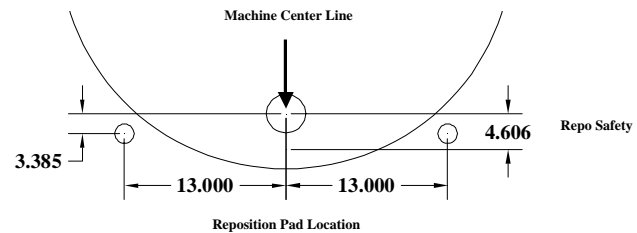
| Max Station Range  | AB             | B                         | C                         | D                         | EF                        |                           | GHJ                       |                           |                           |                           |                           | Auto Index                |
|--------------------|----------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|---------------------------|
| Act. Station Range |                |                           |                           |                           | E                         | F                         | G                         | H (114)                   | J (114)                   | K (114)                   | L (114)                   | D                         |
| No. of Stations    | 20             | 18                        | 6                         | 4                         | 1                         | 1                         | 1                         | 1                         | 0                         | N/A                       | N/A                       | 2                         |
| Round/Oround       | 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

The customer must specify the range of stations 13 and 30, when placing the order.



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