**Tool Assignment by Station Range**

<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>(a) 6</td>
<td>(A) 12</td>
<td>(B) 16</td>
<td>(C) 4</td>
<td>(D) 2</td>
<td>(E) 4</td>
<td>(D) 2</td>
<td>Available</td>
</tr>
<tr>
<td>No. of Stations</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Round/Oblong</td>
<td>.500 Rnd. ONLY</td>
<td>.5&quot; &amp; Under</td>
<td>.501 to 1.250&quot;</td>
<td>1.251 to 2.00&quot;</td>
<td>2.001 to 3.500&quot;</td>
<td>3.501 to 4.500&quot;</td>
<td>2.001 to 3.500&quot;</td>
<td></td>
</tr>
<tr>
<td>Square</td>
<td>N/A</td>
<td>0.500&quot; Across Corners</td>
<td>1.250&quot; Across Corners</td>
<td>2.000&quot; Across Corners</td>
<td>3.500&quot; Across Corners</td>
<td>4.500&quot; Across Corners</td>
<td>3.500&quot; Across Corners</td>
<td></td>
</tr>
<tr>
<td>Rectangle</td>
<td>N/A</td>
<td>0.500&quot; Across Corners</td>
<td>1.250&quot; Across Corners</td>
<td>2.000&quot; Across Corners</td>
<td>3.500&quot; Across Corners</td>
<td>4.500&quot; Across Corners</td>
<td>3.500&quot; Across Corners</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>

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

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**Legend:**

- **C-17:** Station Number
- **Y:** Tool Range/Safety Zone

**Safety Zones:**

- X: +/- 0.984" (25mm)
- Y: +/- 0.197" (5mm) Outer Track
- Y: +/- 3.150" (80mm) Outer Track
- Y: +/- 1.575" (40mm) Middle Track
- Y: +/- 0.0" (Zero) Inner Track

**(US) Tonnage Limits:**

- 0.500" +/- 2.125" 0.945" Machine: V3046T - 33
- 1.250" +/- 2.559" 1.378" V3056T - 33
- 2.000" +/- 2.992" 1.811" Auto Index: 16.5
- 3.500" +/- 3.819" 2.638" Multi-Tool: 10
- 4.500" +/- 4.252" 3.070"

Cell Ready add +/- 0.563"

**Load Position:**

- X78.740 Y60.748 M30
- X78.740 Y72.047 M30

**Over Travel:**

- X = +/- 0.984" (25mm)
- Y = +/- 0.197" (5mm) Outer Track
- Y = +/- 3.150" (80mm) Outer Track
- Y = +/- 1.575" (40mm) Middle Track
- Y = +/- 0.0" (Zero) Inner Track

**Minimum size for part chute:** X1.18", Y3.15"

**Maximum size for part chute:** X7.87", Y3.94"

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

**M58 Opens the chute. M59 Closes the chute.**

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**Legend:**

- **C-17:** Station Number

**V3046T Turret Layout**