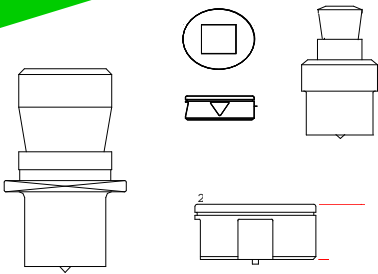
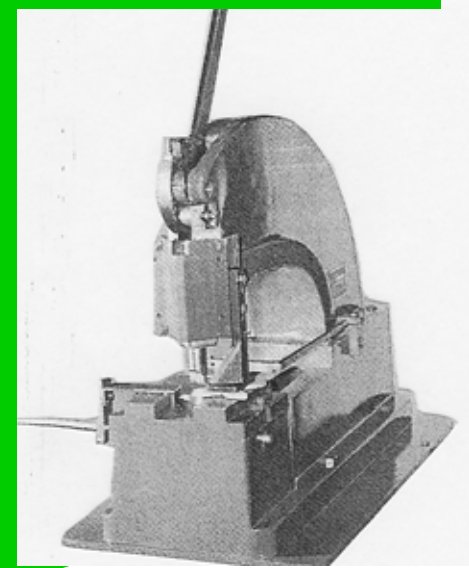
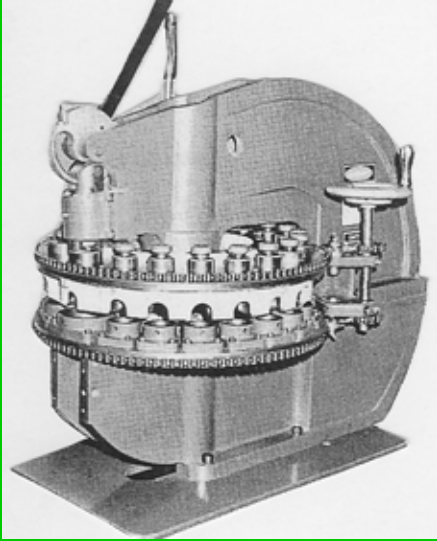
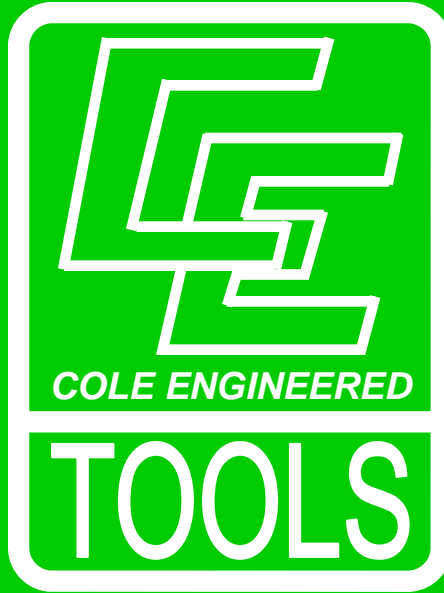


C.E. TOOLING

Section 4D



DI-ACRO

901 • 902/903 • 905 •
906 (212B)



TABLE OF CONTENTS

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C.E. Tooling started out in 1966 in Chicago as a tool & die shop. In the late 1970's, we directed our energies exclusively to the manufacturing of tooling for turret and duplicator presses. Presently, C.E. is the third largest independent turret press tooling supplier in the U.S. and is based in North Las Vegas, Nevada.

Through our use of the highest steel grades combined with manufacturing processes and procedures developed from over 30 years of producing punches and dies, our Quality and Value is unbeatable! We will continue to strive for excellence to continually earn the business of our current and future customers.



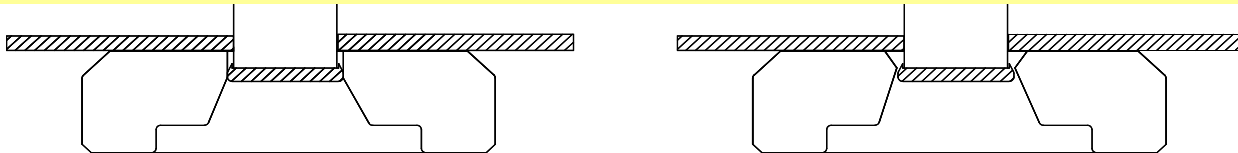


SLUG TRAP™ DIES

ELIMINATE SLUG PULLING WITH A SECOND TAPER ON THE DIE WHICH TRAPS THE SLUG PREVENTING IT FROM PULLING BACK UP.

Note: Taper shown in diagram is exaggerated to express feature.

Add "st" to catalog code after D-die part of code. Ex. Die= §§_D-st-* Set = §§-PD-st-* Replace: §§ with Tool Style Code
 Replace: _ with the tool Station Replace: * = s for shaped, or r for round




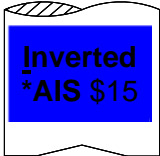

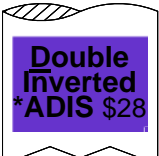
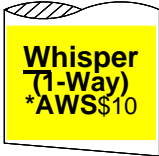
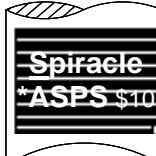

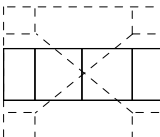
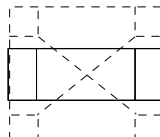

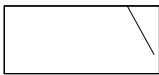
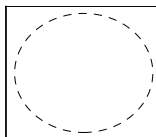

Improve tooling life of both punches and dies When a punch strikes a slug that has been pulled on to the top of sheet, great wear can be caused to the cutting edges of both the punch and die. The biggest cause of wear is when the punch comes down partially on a slug. It can side load the punch pushing the punch tip into the die wall. The next cause of wear is the fact that the die clearance is set for clearance for only 1 material thickness.

Sheet Lubricant • CLM-50 oil base & PolyForm water base

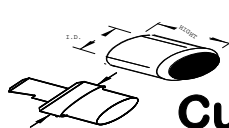
Reduce galling, increase tool edge life and improve stripping when used with standard tools, forming and cluster (gang) punching. To use, simply spray or wipe this premixed lubricant on every 3-6 sheets placed in the press. CLM-50 Formula may be mixed with kerosene to conserve or for easier sheet cleaning when plating is to be performed.

If your trying to keep away from oil base, our **Poly-Form™ is a water based soluble polymer** lubricant for CNC turret and high-speed punch presses. It's an excellent lubricant for soft nonferrous metals such as aluminum, copper & brass and will protect your nonferrous metals from oxidation including galvanized and tin-plate. **Clean to work with and doesn't stain skin or clothing or cause dermatitis.**

Punch End Shear Options

 <p>Roof Top *ARTS \$12</p>	 <p>Inverted *AIS \$15</p>	 <p>Concave *ACS \$28</p>	 <p>Double Inverted *ADIS \$28</p>	 <p>Whisper (1-Way) *AWS \$10</p>	 <p>Spiracle *ASPS \$10</p>
					
<p>Best all purpose shear for reducing tonnage requirement Nibbling must be performed at 75% of punch size to avoid side loading.</p>	<p>An all purpose shear. Ideal for nibbling.</p>	<p>An all purpose shear. Ideal for nibbling. Used over Inverted Shear when punching heavy plate.</p>	<p>Best Shear for slotting tools, 3" or longer in length.</p>	<p>Reduces tonnage requirements while reducing slug deformation. Requires a very Ridged Press.</p>	

FOR URETHANE STRIPPERS, GO TO PAGE 9.



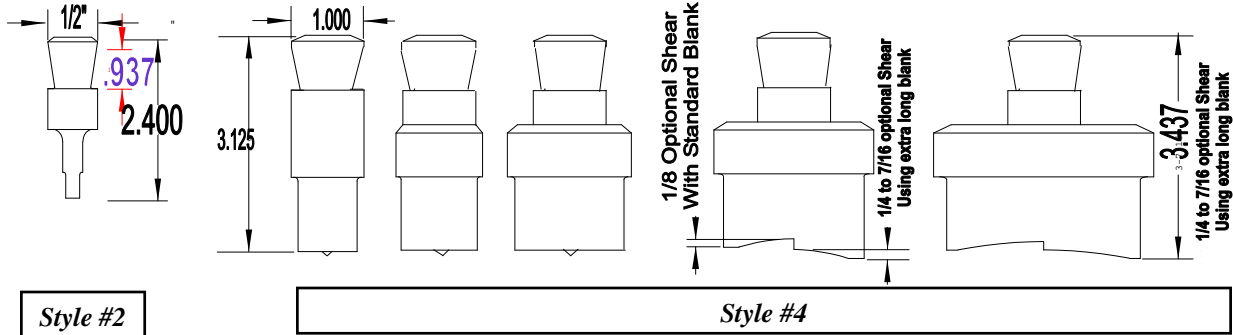
Cup Style Tube Style



Diacro 901 Style Tools

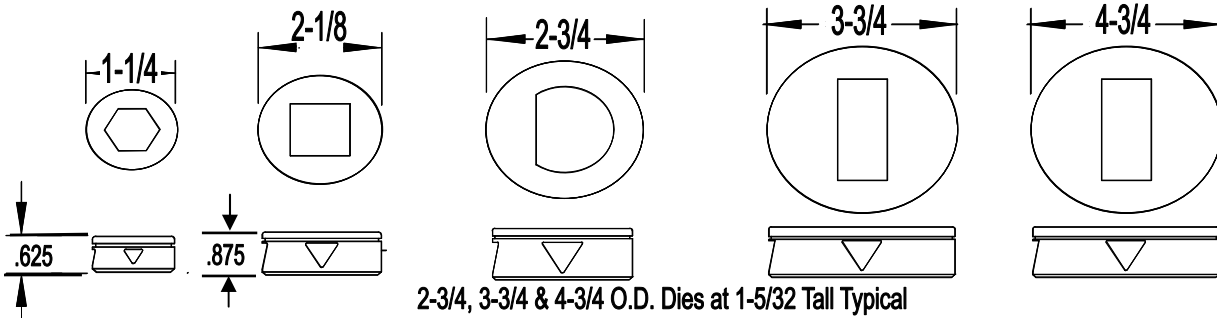
Although C.E. manufactures tools to be fully interchangeable for use in Di-Acro® equipment, there is no affiliation between Di-Acro Inc. and C.E. Tooling. Di-Acro® is a registered trade mark of Di-Acro Inc

Single Station Punch Press No. 1 & 2 and Similar Machines



Style #2

Style #4



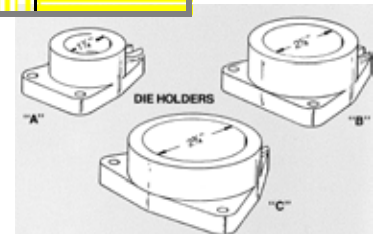
2-3/4, 3-3/4 & 4-3/4 O.D. Dies at 1-5/32 Tall Typical

PUNCHES
DIES

Station	RANGE - DIAGONALLY	ROUND	LIST PRICE	SHAPED (see note below)	LIST PRICE
2 No. 2	.093 - 500	912P-R			
A No. 4	.093 - 750	91AP-R			
B No. 4	.751 - 1.438	91BP-R			
C No. 4	1.439 - 2.000	91CP-R			
D No. 4	2.001 - 3.000	91DP-R			
E No. 4	3.001 - 4.000	91EP-RD			
A 1-1/4"	.093 - .762	91AD-R			
B 2-1/8"	.751 - 1.450	91BD-R			
C 2-3/4"	1.439 - 2.000	91CD-R			
D 3-3/4"	2.001 - 3.000	91DD-R			
E 4-3/4"	3.001 - 4.000	91ED-R			



Punches Larger Than .812 Diameter/Diagonal (Sta. B) or Greater Come With Criss-Cross Shear (Twin Shear) & Centerpoint.
 (4 ton punching requirement or greater)





Diacro 902/903 Style

Although C.E. manufactures tools to be fully interchangeable for use in Di-Acro[®] equipment there is no affiliation between Di-Acro Inc. and C.E. Tooling. Di-Acro[®] is a registered trade mark of Di-Acro Inc.

For #12 & #18 turret hand punching machines. Some machines were offered with options on tool styles. These models are **VT19P, VT19S, 18-18N/C, VT-19N/C, VT36 N/C, VT36S stylus & 18E.** Round tools are always Non-Keyed Style 902. Shapes can be 902 (non-keyed) or 903 (keyed). **If there is any doubt** on which style to use for shapes, **ALWAYS** order **keyed 903.** **VT36 & VT19** models can also use 112 style tools. Models **VT36N/C & VT36S** use 903 keyed. For model #18 with manual turret, use Style #902. For models without a turret, use Style #901.

Sta. & Range	Shape	Punch	Price	C.E. Cat. Code	Die	C.E. Cat. Code	Price
A .093-.750 (max. Diagonal)	Round 902			92AP-R		92ADR	
	Shape 902 no-key			92AP-S		92AD-S	
	Shape 903 Keyed			93AP-S		93AD-S	
B .751-1.433 (max. Diagonal) W/Twin (Criss-Cross) Shear & C/P	Round 902			92BP-R		92BD-R	
	Shape 902 no-key			92BP-S		92BD-S	
	Shape 903 Keyed			93BP-S		93BD-S	
C 1.439-2" (max. Diagonal) W/Twin (Criss-Cross) Shear &	Round 902			92CP-R		92CD-R	
	Shape 902 no-key			92CP-S		92CD-S	
	Shape 903 Keyed			93CP-S		93CD-S	

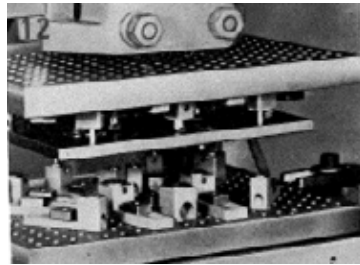
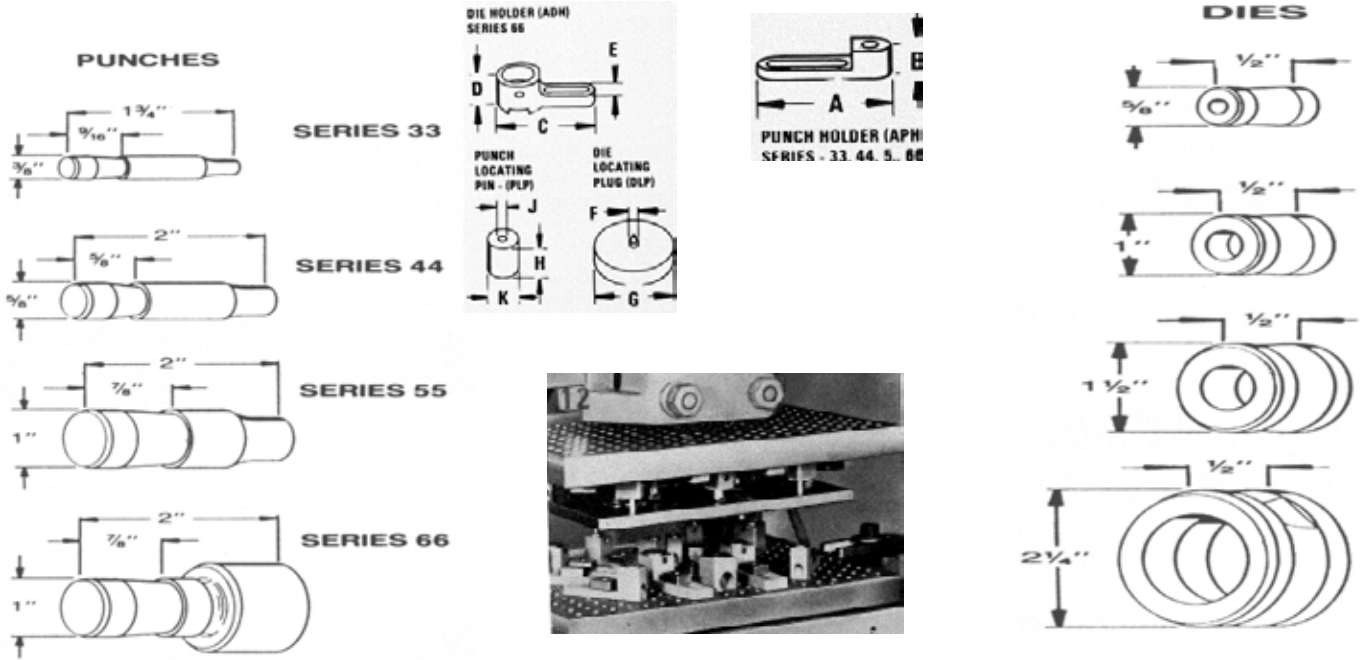
Note: Always take into consideration the diagonal measurement of shapes such as square, rectangle, hexagon, etc. when trying to determine proper station for punch and die! Diagonal charts can be found on pages 10-11 for your use for standard rectangle, square and hexagon sizes.

Shapes Angled Other Than 0-90°

Punch	Die
<i>Due to pin orientation on the punch holder, keying of the punch can only be 0°-90°. A separate punch for non-0/90 orientation must be ordered.</i>	<i>Additional Pin Locations can be provided at an additional cost.</i>

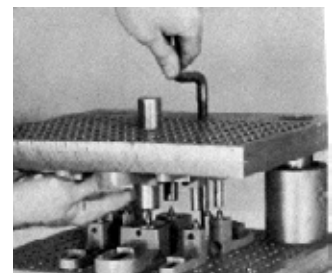
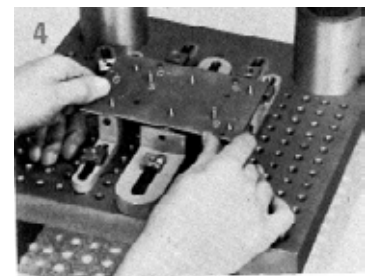
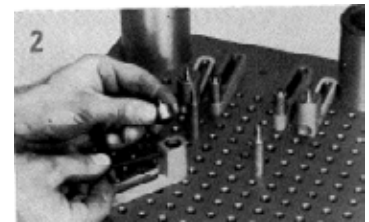


Diacro 905 Style Tools



PUNCHES
DIES

STA. O.D.	RANGE - (DIAGONAL)	ROUND	PRICE	SHAPED (see note below)	PRICE
Series 33	.093 - .375	95-33-P-r	\$21.25	95-33-P-S	\$47.10
Series 44	.375 - .625	95-44-P-r	\$29.45	95-44-P-s	\$59.25
Series 55	.626 - 1.000	95-55-P-r	\$41.20	95-55-P-s	\$88.30
Series 66	1.001 - 1.750	95-66-P-r	\$111.85	95-66-P-s	\$155.15
Series 33	.093 - .375	95-33-D-r	\$21.25	95-33-D-s	\$56.55
Series 44	.375 - .625	95-44-D-r	\$30.00	95-44-D-s	\$70.65
Series 55	.626 - 1.000	95-55-D-r	\$56.50	95-55-D-s	\$94.15
Series 66	1.001 - 1.750	95-66-D-r	\$103.60	95-66-D-s	\$141.25



Note: Always take into consideration the diagonal measurement of shapes such as square, rectangle, hexagon, etc. when trying to determine proper station for punch and die! Diagonal charts can be found on pages 10-11 for your use for standard rectangle, square and hexagon sizes.



Diacro 906=212B Style Tools

FOR: BEHRENS, WIEDEMANN, AND DI-ACRO MACHINES WITH 212 TURRETS
 BELOW PRICES ARE FOR WIDTHS OF .093 (2.36MM) AND ABOVE

Sta. & Range	Shape	Mfg. with A2 Tool Steel 5/16-18 threads	C.E. Cat. Code	REF. MATE® CODE	Punch Price	Die A2 Steel S7 Avail.	C.E. Cat. Code	REF. MATE® CODE	Die Price
B 0.093-1.000	ROUND		2BBP-r	PO2BOA			2BBD-r	DO2BOA	
	SHAPE		2BBP-s	PO2B_A			2BBD-s	DO2B_A	
C 1.001-1.500	ROUND		2BCP-r	PO2COA			2BCD-r	DO2COA	
	SHAPE		2BCP-s	PO2C_A			2BCD-s	DO2C_A	
D 1.501-2.000	ROUND		2BDP-r	PO2DOA			2BDD-r	DO2DOA	
	SHAPE		2BDP-s	PO2C_A			2BDD-s	DO2C_A	
E 2.001-2.500	ROUND		2BEP-r	PO2EOA			2BED-r	DO2EOA	
	SHAPE		2BEP-s	PO2E_A			2BED-s	DO2E_A	
F* 2.501-3.125	ROUND		2BFP-r	PO2FOA			2BFD-r	DO2FOA	
	SHAPE		2BFP-s	PO2F_A			2BFD-s	DO2F_A	
G 3.126-3.500	ROUND		2BGP-r	PO2G0A			2BGD-r	DO2G0A	
	SHAPE		2BGP-s	PO2G_A			2BGD-s	DO2G_A	
H 3.501-4.125 Behrens Only	ROUND		2BHP-r	PO2HOA			2BHD-r	DO2HOA	
	SHAPE		2BHP-s	PO2H_A			2BHD-s	DO2H_A	

*112- F sta. Used for Auto Index Station on most Behrens machines

For material over 10 gauge, solid dies for Sta. B & C are recommended for Rectangle & Square Shapes.
Semi-High Speed Steel sta.B or C Punches +25% Shapes, +50% Rounds • S7 Shock Proof Steel Dies, +25%
 Add 50% to die cost. • S7 Shock Proof Steel available in Dies. Add 25%

Ejector holes are placed in punch tip sizes larger than .270"/6.86mm

Bag of 50 Each Slug Ejector .078 Code *AEJ-R2 • .250" Code *AEJ-R7

Shape @ Angles other than 0-90°				
15 Increments		Other than 15 Inc		
ST.	PUNCH	DIE	PUNCH	DIE
A-C				
D				
E-F				
G-H				

EXTRA PINS OR KEYS				
45° Increments			Other than 45° Inc	
STA.	PUNCH	DIE	PUNCH	DIE
A-C				
D-H				

Note: Always take into consideration the diagonal measurement of shapes such as square, rectangle, hexagon, etc. when trying to determine proper station for punch and die! Diagonal charts can be found on pages 10-11 for your use for standard rectangle, square and hexagon sizes.



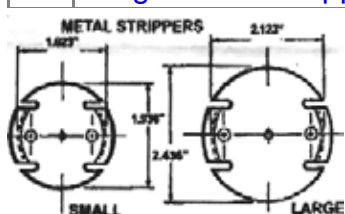
Punch Strippers

901 Style Tools

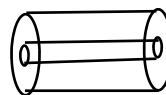
Punch Flange	Stripper I.D.	Stripper O.D.	Stripper Height	Stripper CAT.CODE	Stripper PRICE
1.000"	.99"	2"	1.9"	*AUSO2-281	
1.245"	1.24"	2.5"	2.15"	*AUSO2-282	
1.495"	1.49"	2.5"	2.15"	*AUS03-283	
1.745"	1.75"	2.5"	2.15"	*AUS23-284	
1.995"	2"	2.75"	2.12"	*AUS24-285	
2.995"	3"	3.75"	2.12"	*ASU29-286	

902/903 Style Tools

Sta.	Max. Range	DESCRIPTION OF URETHANE & PUNCH TIP RANGE	I.D.	O.D.	Height +/- .02	CAT.CODE	PRICE
A	.25"	Tube Style: Tip Sizes fitting within .250 circle	.25"	.5	.83	*A93Utub.25	
A	.50"	Tube Style: Tip Sizes fitting within .251 -.5"	.5"	1."	.83"	*A93Utub.50	
A	.75"	Tube Style: Tip Sizes fitting within .5-.75" circle	.75"	1.25	.83"	*A93Utub.75	
A	.75	Cup Style: Fitted Stripping Grabs on Punch Tip as well as 4 pin locations on 903 holders	.75	1.5	1.25	*AUS93A	
B/C	1.5		.75	2.0	1.25	*AUS93B	
MOLDED URETHANE STRIPPER Urethane is poured onto punch end						*A93U-Mold	
A	"Small" Metal Strippers 1.94" OD					*A0601403042	
B/C	"Large" Metal Strippers 2.44" OD					*A0601403042	



	903-PUNCH Holder *A93PH	902-PUNCH Holder *A92PH	DIE HOLDER *A92_PH *A93_PH	Die Lock Dawgs
Sta. A	*A06615071709	*A0601501038	*A0601502045	*A0661502053
Sta. B	*A0661501710	*A0601501039	*A0601502046	*A0661502054
Sta. C			*A0601502047	*A0661502055



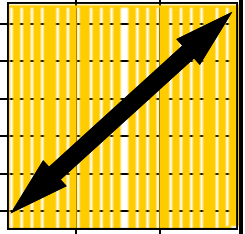
Tube Style

STYLE 212 (906 Di-Acro)

Sta. Description	ID/OD/HEIGHT	CODE	PRICE
"B" STA. (E1)	.5/ 1.25/ 1"	*AUS41	
"B" STA. (E1)	.75/ 1.25/ 1"	*AUS42	
"C" STA. (E4)	1"/ 1.5/ 1.18"	*AUS43	
"D" STA. (E5)	1.75/ 2.08/ 1.25"	*AUS44	
"E" STA. (E6)	2.85/ 3.18/ 1.25	*AUS45	
"F" STA. (E7)	2.85/3.18/1.25	*AUS46	

Diagonals of Common Square & Rectangles

	0.125	0.156	0.187	0.218	0.250	0.281	0.312	0.343	0.375	0.406	0.437	0.469	0.500			
.125	0.177	0.200	0.225	0.252	0.280	0.308	0.337	0.366	0.395	0.425	0.455	0.485	0.515			
.156	0.200	0.221	0.244	0.269	0.295	0.322	0.349	0.378	0.406	0.435	0.465	0.494	0.524			
.187	0.225	0.244	0.265	0.288	0.313	0.338	0.364	0.391	0.419	0.447	0.476	0.505	0.534			
.218	0.252	0.269	0.288	0.309	0.332	0.356	0.381	0.407	0.434	0.461	0.489	0.517	0.546			
.250	0.280	0.295	0.313	0.332	0.354	0.376	0.400	0.425	0.451	0.477	0.504	0.531	0.559			
.281	0.308	0.322	0.338	0.356	0.376	0.398	0.420	0.444	0.469	0.494	0.520	0.547	0.574			
.312	0.337	0.349	0.364	0.381	0.400	0.420	0.442	0.465	0.488	0.513	0.538	0.563	0.590			
.343	0.366	0.378	0.391	0.407	0.425	0.444	0.465	0.486	0.509	0.532	0.556	0.581	0.607			
.375	0.395	0.406	0.419	0.434	0.451	0.469	0.488	0.509	0.530	0.553	0.576	0.600	0.624			
.406	0.425	0.435	0.447	0.461	0.477	0.494	0.513	0.532	0.553	0.575	0.597	0.620	0.644			
.437	0.455	0.465	0.476	0.489	0.504	0.520	0.538	0.556	0.576	0.597	0.619	0.641	0.664			
.469	0.485	0.494	0.505	0.517	0.531	0.547	0.563	0.581	0.600	0.620	0.641	0.663	0.685			
.500	0.515	0.524	0.534	0.546	0.559	0.574	0.590	0.607	0.625	0.644	0.664	0.685	0.707			
	0.531	0.562	0.593	0.625	0.656	0.687	0.718	0.750	0.781	0.812	0.843	0.875	0.906	0.937	0.968	1.000
.125	0.546	0.576	0.607	0.657	0.668	0.699	0.730	0.760	0.791	0.822	0.853	0.884	0.915	0.946	0.977	1.008
.156	0.554	0.584	0.614	0.644	0.675	0.705	0.736	0.766	0.797	0.827	0.858	0.889	0.920	0.950	0.981	1.012
.187	0.563	0.593	0.623	0.653	0.683	0.713	0.743	0.773	0.803	0.834	0.864	0.895	0.925	0.956	0.987	1.017
.218	0.575	0.604	0.633	0.662	0.692	0.722	0.751	0.781	0.811	0.841	0.872	0.902	0.932	0.963	0.993	1.024
.250	0.587	0.616	0.644	0.673	0.702	0.732	0.761	0.791	0.820	0.850	0.880	0.910	0.940	0.970	1.000	1.031
.281	0.601	0.629	0.657	0.685	0.714	0.743	0.772	0.801	0.830	0.860	0.889	0.919	0.949	0.979	1.009	1.039
.312	0.616	0.643	0.671	0.699	0.727	0.755	0.784	0.813	0.841	0.871	0.900	0.929	0.959	0.988	1.018	1.048
.343	0.633	0.659	0.686	0.713	0.741	0.769	0.797	0.825	0.854	0.882	0.911	0.940	0.969	0.999	1.028	1.057
.375	0.650	0.676	0.702	0.729	0.756	0.783	0.811	0.839	0.867	0.895	0.923	0.952	0.981	1.010	1.039	1.068
.406	0.669	0.694	0.719	0.745	0.772	0.799	0.826	0.853	0.881	0.909	0.936	0.965	0.993	1.022	1.051	1.079
.437	0.688	0.713	0.738	0.763	0.789	0.815	0.841	0.868	0.895	0.923	0.950	0.978	1.006	1.035	1.063	1.092
.469	0.709	0.732	0.757	0.781	0.806	0.832	0.858	0.884	0.911	0.938	0.965	0.993	1.020	1.048	1.076	1.104
.500	0.730	0.753	0.776	0.800	0.825	0.850	0.876	0.901	0.928	0.954	0.981	1.008	1.035	1.063	1.090	1.118
	0.531	0.562	0.593	0.625	0.656	0.687	0.718	0.750	0.781	0.812	0.843	0.875	0.906	0.937	0.968	1.000
.531	0.751	0.774	0.797	0.820	0.844	0.869	0.894	0.919	0.945	0.971	0.997	1.024	1.051	1.078	1.105	1.132
.562	0.774	0.796	0.818	0.841	0.864	0.888	0.913	0.938	0.963	0.988	1.014	1.040	1.067	1.093	1.120	1.147
.593	0.797	0.818	0.840	0.862	0.885	0.908	0.932	0.957	0.981	1.006	1.032	1.057	1.083	1.110	1.136	1.163
.625	0.820	0.841	0.862	0.884	0.906	0.929	0.953	0.976	1.001	1.025	1.050	1.075	1.101	1.127	1.153	1.179
.656	0.844	0.864	0.885	0.906	0.928	0.950	0.973	0.997	1.020	1.044	1.069	1.094	1.119	1.144	1.170	1.196
.687	0.869	0.888	0.908	0.929	0.950	0.972	0.995	1.017	1.041	1.064	1.088	1.113	1.138	1.163	1.188	1.214
.718	0.894	0.913	0.932	0.953	0.973	0.995	1.016	1.039	1.062	1.085	1.108	1.132	1.157	1.181	1.206	1.232
.750	0.919	0.938	0.957	0.976	0.997	1.017	1.039	1.061	1.083	1.106	1.129	1.152	1.176	1.201	1.225	1.250
.781	0.945	0.963	0.981	1.001	1.020	1.041	1.062	1.083	1.105	1.127	1.150	1.173	1.197	1.220	1.245	1.269
.812	0.971	0.988	1.006	1.025	1.044	1.064	1.085	1.106	1.127	1.149	1.171	1.194	1.217	1.241	1.264	1.288
.843	0.997	1.014	1.032	1.050	1.069	1.088	1.108	1.129	1.150	1.171	1.193	1.216	1.238	1.261	1.285	1.308
.875	1.024	1.040	1.057	1.075	1.094	1.113	1.132	1.152	1.173	1.194	1.216	1.237	1.260	1.282	1.305	1.329
.906	1.051	1.067	1.083	1.101	1.119	1.138	1.157	1.176	1.197	1.217	1.238	1.260	1.282	1.304	1.327	1.350
.937	1.078	1.093	1.110	1.127	1.144	1.163	1.181	1.201	1.220	1.241	1.261	1.282	1.304	1.326	1.348	1.371
.968	1.105	1.120	1.136	1.153	1.170	1.188	1.206	1.225	1.245	1.264	1.285	1.305	1.327	1.348	1.370	1.392
1.000	1.132	1.147	1.163	1.179	1.196	1.214	1.232	1.250	1.269	1.288	1.308	1.329	1.350	1.371	1.392	1.414



	1.031	1.062	1.093	1.125	1.156	1.187	1.218	1.250	1.281	1.312	1.343	1.375	1.406	1.437	1.468	1.500
.125	1.039	1.070	1.101	1.132	1.163	1.194	1.225	1.256	1.287	1.318	1.350	1.381	1.412	1.443	1.474	1.505
.156	1.043	1.074	1.105	1.136	1.167	1.198	1.229	1.297	1.291	1.322	1.353	1.384	1.415	1.446	1.477	1.508
.187	1.048	1.079	1.110	1.149	1.171	1.202	1.233	1.264	1.295	1.326	1.357	1.388	1.419	1.450	1.479	1.512
.218	1.054	1.085	1.115	1.146	1.177	1.208	1.238	1.269	1.300	1.331	1.361	1.392	1.423	1.454	1.485	1.516
.250	1.061	1.092	1.122	1.152	1.183	1.214	1.244	1.275	1.305	1.336	1.367	1.398	1.428	1.459	1.490	1.521
.281	1.069	1.099	1.129	1.160	1.190	1.220	1.251	1.281	1.312	1.342	1.373	1.403	1.434	1.465	1.495	1.526
.312	1.078	1.108	1.138	1.168	1.198	1.228	1.285	1.288	1.319	1.349	1.380	1.410	1.441	1.471	1.502	1.532
.343	1.087	1.117	1.146	1.176	1.206	1.236	1.266	1.296	1.327	1.357	1.387	1.417	1.448	1.478	1.508	1.539
.375	1.097	1.127	1.156	1.186	1.216	1.245	1.275	1.305	1.335	1.365	1.395	1.425	1.455	1.486	1.516	1.546
.406	1.108	1.138	1.180	1.196	1.226	1.255	1.285	1.314	1.344	1.374	1.404	1.434	1.464	1.494	1.524	1.554
.437	1.120	1.149	1.178	1.207	1.236	1.266	1.295	1.324	1.354	1.384	1.413	1.443	1.473	1.503	1.533	1.563
.469	1.131	1.161	1.190	1.219	1.248	1.277	1.306	1.335	1.364	1.394	1.423	1.453	1.482	1.512	1.542	1.572
.500	1.146	1.174	1.203	1.231	1.260	1.288	1.317	1.346	1.375	1.405	1.434	1.463	1.492	1.522	1.552	1.581

	1.031	1.062	1.093	1.125	1.156	1.187	1.218	1.250	1.281	1.312	1.343	1.375	1.406	1.437	1.468	1.500
.531	1.160	1.188	1.216	1.244	1.272	1.301	1.329	1.358	1.387	1.416	1.445	1.476	1.503	1.533	1.562	1.591
.562	1.175	1.202	1.230	1.258	1.286	1.314	1.342	1.371	1.399	1.428	1.457	1.486	1.515	1.544	1.573	1.602
.593	1.190	1.217	1.244	1.272	1.300	1.328	1.356	1.384	1.412	1.441	1.472	1.498	1.526	1.555	1.584	1.613
.625	1.206	1.233	1.260	1.287	1.314	1.342	1.370	1.398	1.426	1.454	1.482	1.510	1.539	1.568	1.596	1.625
.656	1.222	1.249	1.275	1.302	1.329	1.357	1.384	1.412	1.440	1.467	1.495	1.524	1.552	1.580	1.609	1.637
.687	1.239	1.266	1.292	1.318	1.345	1.372	1.399	1.427	1.454	1.482	1.509	1.537	1.565	1.593	1.622	1.650
.718	1.257	1.283	1.309	1.335	1.361	1.388	1.415	1.442	1.469	1.496	1.524	1.552	1.579	1.607	1.635	1.663
.750	1.275	1.301	1.326	1.352	1.378	1.405	1.431	1.458	1.485	1.512	1.539	1.566	1.594	1.621	1.649	1.677
.781	1.294	1.319	1.344	1.370	1.395	1.421	1.448	1.474	1.500	1.527	1.554	1.581	1.609	1.636	1.664	1.691
.812	1.313	1.338	1.363	1.388	1.413	1.439	1.465	1.491	1.517	1.544	1.570	1.597	1.624	1.651	1.679	1.706
.843	1.332	1.357	1.381	1.406	1.431	1.454	1.482	1.508	1.534	1.560	1.587	1.613	1.640	1.667	1.694	1.721
.875	1.352	1.376	1.401	1.425	1.450	1.472	1.500	1.526	1.552	1.577	1.604	1.630	1.656	1.683	1.710	1.737
.906	1.391	1.415	1.438	1.462	1.486	1.511	1.535	1.560	1.585	1.611	1.636	1.662	1.688	1.714	1.740	1.767
.937	1.394	1.417	1.441	1.464	1.489	1.513	1.538	1.563	1.588	1.613	1.638	1.664	1.690	1.690	1.742	1.769
.968	1.415	1.438	1.461	1.485	1.523	1.533	1.557	1.581	1.606	1.631	1.657	1.682	1.708	1.733	1.759	1.786
1.000	1.436	1.459	1.482	1.505	1.529	1.553	1.577	1.601	1.625	1.650	1.675	1.700	1.726	1.751	1.777	1.803

	1.031	1.062	1.093	1.125	1.156	1.187	1.218	1.250	1.281	1.312	1.343	1.375	1.406	1.437	1.468	1.500
1.031	1.458	1.481	1.503	1.526	1.549	1.573	1.596	1.620	1.645	1.669	1.694	1.719	1.744	1.769	1.795	1.820
1.062	1.481	1.503	1.525	1.547	1.568	1.593	1.617	1.641	1.664	1.689	1.713	1.739	1.763	1.788	1.813	1.838
1.093	1.503	1.525	1.547	1.569	1.592	1.614	1.638	1.661	1.687	1.709	1.733	1.759	1.781	1.806	1.831	1.856
1.125	1.526	1.547	1.569	1.591	1.613	1.636	1.659	1.682	1.705	1.729	1.753	1.778	1.801	1.825	1.848	1.875
1.156	1.549	1.568	1.592	1.613	1.635	1.657	1.680	1.702	1.726	1.749	1.773	1.797	1.821	1.845	1.869	1.894
1.187	1.573	1.593	1.614	1.636	1.657	1.679	1.703	1.724	1.747	1.770	1.793	1.817	1.841	1.865	1.889	1.913
1.218	1.596	1.617	1.638	1.659	1.680	1.702	1.724	1.746	1.768	1.791	1.814	1.837	1.861	1.885	1.909	1.933
1.250	1.620	1.641	1.661	1.682	1.703	1.724	1.746	1.768	1.790	1.812	1.834	1.857	1.879	1.902	1.926	1.949
1.281	1.645	1.664	1.685	1.705	1.726	1.747	1.768	1.790	1.812	1.834	1.857	1.879	1.902	1.926	1.949	1.973
1.312	1.669	1.689	1.709	1.729	1.749	1.770	1.791	1.813	1.834	1.856	1.878	1.901	1.922	1.947	1.968	1.993
1.343	1.694	1.713	1.733	1.753	1.773	1.793	1.814	1.835	1.857	1.878	1.900	1.923	1.945	1.968	1.991	2.014
1.375	1.719	1.739	1.759	1.778	1.797	1.817	1.837	1.858	1.879	1.901	1.923	1.945	1.967	1.989	2.012	2.035
1.406	1.744	1.763	1.787	1.801	1.821	1.841	1.861	1.882	1.902	1.924	1.945	1.967	1.989	2.010	2.033	2.056
1.437	1.769	1.788	1.806	1.825	1.845	1.865	1.885	1.905	1.926	1.947	1.968	1.989	2.010	2.033	2.054	2.078
1.468	1.795	1.813	1.831	1.848	1.869	1.889	1.909	1.929	1.949	1.968	1.991	2.012	2.033	2.054	2.077	2.099
1.500	1.820	1.838	1.856	1.875	1.894	1.913	1.933	1.953	1.973	1.993	2.014	2.035	2.056	2.078	2.099	2.121

Hexagon-Size	0.250	0.281	0.312	0.343	0.375	0.406	0.437	0.468	0.500	0.531	0.562	0.593	0.625			
Diagonal	0.289	0.325	0.361	0.397	0.433	0.469	0.505	0.541	0.577	0.613	0.649	0.686	0.722	He		
Hexagon-Size	0.656	0.687	0.718	0.750	0.781	0.812	0.843	0.875	0.906	0.937	0.968	1.000	1.031			
Diagonal	0.758	0.794	0.830	0.866	0.902	0.938	0.974	1.010	1.046	1.082	1.118	1.155	1.191			
Hexagon-Size	1.062	1.094	1.125	1.156	1.187	1.218	1.250	1.281	1.312	1.343	1.375	1.406	1.437			
Diagonal	1.227	1.263	1.299	1.335	1.371	1.407	1.443	1.479	1.516	1.552	1.588	1.624	0.722			
Hexagon-Size	1.468	1.500	1.531	1.562	1.593	1.625	1.656	1.687	1.750	1.812	1.875	1.937	2.000			
Diagonal	1.606	1.732	1.768	1.804	1.840	1.876	1.912	1.949	2.021	2.093	2.155	2.217	2.280			

ADDITIONAL COSTS FOR NON-STANDARD OPTIONS



RADIUS OR 45° CHAMFERS + \$.00 per corner

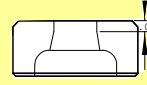
	PUNCHES	Corners 1-3 X #	4 (all)
Lengths under 1.625 and any size Radius or Chamfer, add		# X \$10.00	\$10.00
Lengths over 1.625 & .032 maximum Radius or Chamfer, add		# X \$10.00	\$30.00
Lengths over 1.625 and Radius or Chamfer over .032 (.8mm), add		# X \$15.00	\$40.00
Add On To All <u>DIES</u> any size Radius or Chamfer		# X \$10.00	\$10.00

No Extra Charge for STRIPPERS or GUIDES When Ordered With Set

Add 25% to set price for **Clearance** of .003(.08mm) & under.

Add 50% to die price for **Solid Dies**.

For Widths or Diameters Under .093 (2.36mm) Add 30% to set price.
 For Widths or Diameters Under .062 (1.57mm) Add 50% to set price.
 For Widths or Diameters Under .046 (1.2mm) Add 100% to set price.



.09 land, then 1.5° relief

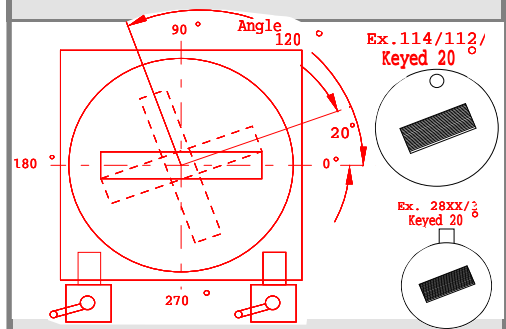
Included in add on cost: Dies are produced with a .090 land then a 1.5° relief is given to prevent multiple slugs from stacking causing excessive pressure on punch. Further, punches can be produced with Stubby Punch Design at no additional charge. A Stubby Punch has it's tip (diameter or width) first ground to a size of .187 then a tip is ground to requested size for a length of .225 + thickness to be punched. (If fitted strippers are used, + .125 to tip grind length and use strippers .187 or greater in diameter or width.)

STANDARD KEYING

10 Standard Shapes plus Rounds. (RT Rectangles • SQ=Square • OB=Oround • SD=Single-D • DD=Double-D
 LD=Long-D • EQ=Equilateral • OC=Octagon • HX=Hexagon • QD-Quad-D Add \$10 per set to standard price for LD & EQ

LOOKING AT FACE OF PUNCH	LOOKING AT TOP OF DIE

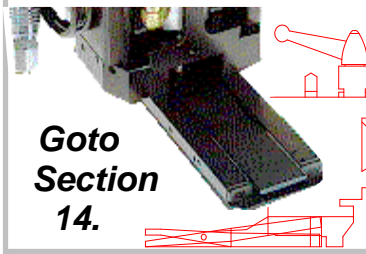
Shapes on Angles or Extra



Visualize location **key** of tool as it would load into turret. Start with length of shape horizontal Length points to 0°
Rotate shape, not location key.
 A sketch accompanying your order ensures keying as required! Note: Other Manufacturers ordering diagrams may differ from C.E.'s!

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Call to request pricing sheet for your machine model.
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Goto Section 14.

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10 STANDARD SHAPES

Reference Index Page 4.3 for Deliveries

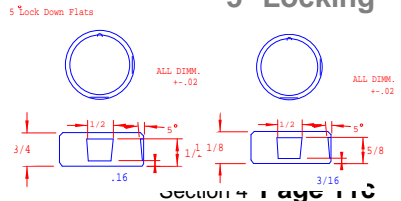
RECTANGLE • SQUARE • OROUND • SINGLE-D
 DOUBLE-D • QUAD-D • HEXAGON • OCTAGON
 ADD \$10 PER SET FOR: LONG-D & EQUILATERAL

EXPEDITING SERVICES

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2FDS • Place your order by 3 PM PST, Order Ships In 1-2 Work Days, Add 10% to order cost.

5° Locking

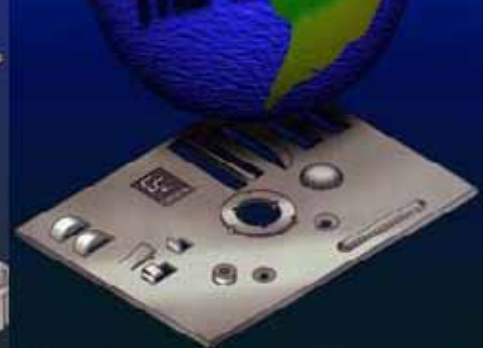


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