



C.E. TOOLING



Section

4

Tooling Booklet



**Murata WIEDEMANN • BEHRENS
112 • 114 • 212 • Nova • Marathon**



STANDARD SHAPES

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

114, 112, 212, 906 & 903 Wiedemann /Di-Acro
Looking Down On
 Face of Punch Looking Down on Face of Die

112& 114 B -C
A-H
903 A-C
112& 114 D-L

Looking Down Ot Top of DIE
 Holder is keyed 2plc allowing 0 & 90° indexing

28XX & 36/37tc

Chassis Maker A, B 1,2,3

EXPEDITING SERVICES

1FDS Place your order by 1 PM PST,
Order Ships The Next Work Day,
Add 25% to order cost.
2FDS • Place your order by 3 PM PST,
Order Ships In 1-2 Work Days, Add 10% to
order cost.

EXTRA PINS or KEYS

45° Increments			Other Than 45° Inc.	
STA.	PUNCH	DIE	PUNCH	DIE
A-C	\$9	\$9	\$15	\$14
D	\$14	\$140	\$20	\$20
E-F	\$14	\$14	\$20	\$20
G-H	\$30	\$30	\$50	\$50
J-L	\$45	\$45	\$65	\$65

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 Manufactures ordering diagrams may differ from C.E.'s!

WORK HOLDER PARTS

Call to request pricing sheet for your
machine model.

OPTIONAL PUNCH SHEARS

SHEARS Should be Considered for All DIAGONAL DIMENSIONS Over

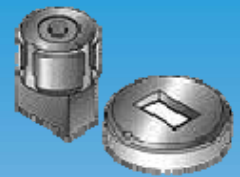
Roof Top Best all purpose shear for reducing tonnage	Inverted *AIS \$15 An all purpose	Concave *ACS An all purpose shear. Ideal for	Double Inverted Best Shear for slotting	Whisp Reduces tonnage requirements while reducing	Spiracle *ASPS Ideal for rounds or squares < 1.18 30,m.
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Page 2



112W Style Tools

For: BEHRENS, WIEDEMANN, and DI-ACRO Machines with 112 Turrets
BELOW PRICES ARE FOR WIDTHS OF .093 (2.36MM) AND ABOVE



Sta. &	Shape	PUNCH 5/16-18 thread	Part#	Type	Price	Die	Part#	Type	Price
B .093-1.000	ROUND		2WBP-r	Standard			2WBD-r 2WBDst-r	Standard Slug Trap™	
	SHAPE		2WBP-s	Standard			2WBD-s 2WBDst-s	Standard Slug Trap™	
C 1.001-1.500	ROUND		2WCP-r	Standard			2WCD-r 2WCDst-r	Standard Slug Trap™	
	SHAPE		2WCP-s	Standard			2WCD-s 2WCDst-s	Standard Slug Trap™	
D 1.501-2.000 Standard & Auto Index	ROUND		2WDP-r	Standard			2WDD-r 2WDDst-r	Standard Slug Trap™	
	SHAPE		2WDP-s	Standard			2WDD-s 2WDDst-s	Standard Slug Trap™	
E 2.001-2.500	ROUND		2WEP-r	Standard			2WED-r 2WEDst-r	Standard Slug Trap™	
	SHAPE		2WEP-s	Standard			2WED-s 2WEDst-s	Standard Slug Trap™	
F 2.501-3.125 Standard & Auto Index	ROUND		2WFP-r	Standard			2WFD-r 2WFDst-r	Standard Slug Trap™	
	SHAPE		2WFP-s	Standard			2WFD-s 2WFDst-s	Standard Slug Trap™	
G 3.126-3.500	ROUND		2WGP-r	Standard			2WGD-r 2WGDst-r	Standard Slug Trap™	
	SHAPE		2WGP-s	Standard			2WGD-s 2WGDst-s	Standard Slug Trap™	
H 3.501-4.125 Behrens Only	ROUND		2WHP-r	Standard			2WHD-r 2WHDst-r	Standard Slug Trap™	
	SHAPE		2WHP-s	Standard			2WHD-s 2WHDst-s	Standard Slug Trap™	

Go to page 6 for
Urethane
Strippers





114W STYLE TOOLING

FOR MURATA WIEDEMANN AND BEHRENS STYLE PUNCHING MACHINES
BELOW PRICES ARE FOR WIDTHS OF .093 (2.36MM) AND ABOVE

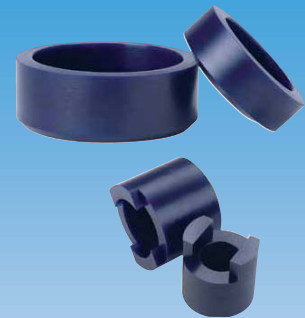
Sta. & Range	Shape	A2/D2 Tool Steel Option: M2 HSS 1 1/2-13 threads	Part#	Price	Die A2/D2 Steel	Part#	Description Of Die Land	Price
A .093-	ROUND	 .5625	4WAP-r		 1.5625 dia	4WAD-r 4WADst-r	Standard Slug Trap™	
B .093 - 1.000	ROUND	 1.0625 OD	4WBP-r		 1.5625 dia 1.125 thick	4WBD-r 4WBDst-r	Standard Slug Trap™	
	SHAPE	Shapes k 0 & 90	4WBP-s			4WBD-s 4WBDst-s	Standard Slug Trap™	
C 1.001-1.500	ROUND	 1.3125 OD	4WCP-r		 2.250 2.250 dia. 1.125 thick	4WCD-r 4WCDst-r	Standard Slug Trap™	
	SHAPE	Shapes k 0 & 90	4WCP-s			4WCD-s 4WCDst-s	Standard Slug Trap™	
D 1.501-2.000 Auto Index may be style 112 See Page 5	ROUND	 1.750 OD	4WDP-r		 2.750 2.750 dia 1.125 thick	4WDD-r 4WDDst-r	Standard Slug Trap™	
	SHAPE	Shapes k- 0&90 Squares k- 0&45	4WDP-s			4WDD-s 4WDDst-s	Standard Slug Trap™	
E 2.001-2.500	ROUND	 2.500 OD	4WEP-r		 3.500 3.500 dia. 1.125 thick	4WED-r 4WEDst-r	Standard Slug Trap™	
	SHAPE		4WEP-s			4WED-s 4WEDst-s	Standard Slug Trap™	
F 2.501-3.000 See Page 4 for Auto Index	ROUND	Shapes keyed @ 0 & 90	4WFP-r		 4.000 4.000 dia	4WFD-r 4WFDst-r	Standard Slug Trap™	
	SHAPE	Squares keyed 0&45	4WFP-s			4WFD-s 4WFDst-s	Standard Slug Trap™	
G 3.001-3.500	ROUND	 4.125 OD	4WGP-r		 4.500 4.500 dia 1.125 thick	4WGD-r 4WGDst-r	Standard Slug Trap™	
	SHAPE		4WGP-s			4WGD-s 4WGDst-s	Standard Slug Trap™	
H 3.501-4.125	ROUND	Shapes keyed @ 0 & 90	4WHP-r		 5.250 5.250 dia 1.125 thick	4WHD-r 4WHDst-r	Standard Slug Trap™	
	SHAPE	Squares keyed @ 0 & 45	4WHP-s			4WHD-s 4WHDst-s	Standard Slug Trap™	
J 4.126-4.750	ROUND	 5.375 OD	4WJP-r		 6.000 6.000 dia 1.125 thick	4WJD-r 4WJDst-r	Standard Semi-HSS	
	SHAPE	1/2 KEY	4WJP-s			4WJD-s 4WJDst-s	Standard Semi-HSS	
K 4.751-5.500	ROUND	 5.31	4WKP-r		 6.500 6.500 dia 1.125 thick	4WKD-r 4WKDst-r	Standard Semi-HSS	
	SHAPE		4WKP-s			4WKD-s 4WKDst-s	Standard Semi-HSS	
L 5.001-6.000	ROUND	Shapes keyed @ 0 & 90	4WLP-r		 7.500 7.500 dia 1.125 thick	4WLD-r 4WLDst-r	Standard Semi-HSS	
	SHAPE	Squares keyed @ 0 & 45	4WLP-s			4WLD-s 4WLDst-s	Standard Semi-HSS	

Charges for extra keys, or shapes on angles Page 2

URETHANE STRIPPERS

Murata Wiedemann:W20-W30-W45 Series, Centrum-Quantum
-Magnum-Motorum-Vectrum Std Shore Hardness Sta.A-F=90, G-L=95

STYLE 112 (ID/OD/HEIGHT)	Part#	\$Price	STYLE 114 (ID/OD/HEIGHT)	Part#	\$Price
"B" STA. .99 X 2" X 1.9	*AUS2WB		"A" Sta. .54X1¼X1.7	*AU4WA1	
"C" STA. 1.49X2½"X 2.15	*AUS2WC		"A"Sta. 1"X1.8X1¾Magnum	*AU4WA2	
"D" STA. 1.98"X 3"X1½	*AUS2WD		"X-B".84X1.33X1.9 .4X.08slot	*AU4WX	
"D" Ribbed for slotting tool	*AUS2WDst		"B" 1.06 X 1.8 X 1.73/2.42	*AU4WB	
"D" 1"=25mmSQ 95shore	*AUS2WDsq		"C" 1.75 X 2½ X 2.15	*AU4WC	
Auto Inde 95Shore			"D" 2" X 2¾ X 2.12	*AU4WD	
"D" Auto-Index 1.94/2.8/1.6	*AUS2Wai		"D" Ribbed for Slotting Tool	*A4WDst	
"D" Auto-Index 1" /2mm SQ	*AU2WDsq		"D" Ribbed for 1"/25m SQ	*AU4WDsq	
"E" C=C2.8 3.08X4.2X1.5	*AUS2WE		"E/F" STA. 3" X 3¾ X 2.12	*AU4WEF	
"E" Ribbed for slotting tool	*AUS2WEst		"E/F"Ribbed for slotting tool	*AU4WEFst	
F C=3.3 3.08 X 4.2 X1.5	*AUS2WF		"F" Ribbed for 2" / 50m sq	*AU4WFsq	
"F" Ribbed for slotting tool	*AU2WFst		"G/H/J" 4.37 X 5" X 2.15	*AU4WGHJ	
"F" Ribbed for 2"/50m SQ	*AU2WFsq		"G/H/J"Ribbed for slotting	*AU4WGHJst	
"G" 3.48 X 4.75 X 1.5	*AU2WG		"G/H/J" Ribbed for 2"/50m	*AU4W GHJsq	
"G" Slotting Tool	*AUS2WGst		"K/L" STA. MAGNUM	*AUS34	
			"K/L"Standard & slotting	*AU4WK/L	



Di-Acro: QCT-20 & CAP 1000 B&C 112/212		
"B" 1.12X2.01X1.9 n/ear	*AUS51	
"C" 1.6X2.25X1.9 n/ear	*AUS52	
"D" E-5 2.13X2.67X1.93	*AUS53	
"E" E-6. 3.22X4"X1.93	*AUS54	
"F" E7 3.5 X4"X1.93	*AUS55	
EAR TYPE: WIEDEMANN RA41P/S15/A15 DI-ACRO: 15TON/20NC/VT36/VT19/3620 *212 only BEHRENS: 22TON/PANTOGRAPH/NC1518 NC2532/NC2524/25		
"B" E-1 ½id X 1¼ X 1"	*AUS41	
"B" E-1 ¾id X 1¼ X 1"	*AUS42	
"C" E-4 1id X1½X1.18	*AUS43	

WIEDEMANN:NC25/S25/RA25/RA425/25TON *212 only		
"B" Sta. E-2 .5"/1.5/1.18	*AUS56	
"C" Sta. E-4 1"/1.5/1.18	*AUS57	
"B" Sta. E-3 1"X2"X1.18	*AUS58	
* "D" STA. E-5 ___/___/1.28	*AUS44	
* "E" STA. E-6 2.83/3.15/1.28	*AUS45	
* "F" STA. E-7 2.83/3.15/1.28	*AUS46	

NCT³ Turret Automated Tapping

Reduce your cost per hole to below \$.01 each Tap up to 180 holes a minute. (Depending on ram speed) Pitch insert change in minutes. Roll form taps. No minimum distance between tapped holes
Pre-Pierce Hole is required prior to tapping. Tapping tool and Oil Tank is loaded into turret. The "ready punch height will need to be calibrated prior to tapping and the clamp safety zone will need to be set. Oil Housing rests on the backside of the turret and is held in place by two magnets. The tapping unit and oil housing are connected together by supplied hoses. (With Finnpower machines, the tank surrounds the B sta. Yet still allows the station to be used.

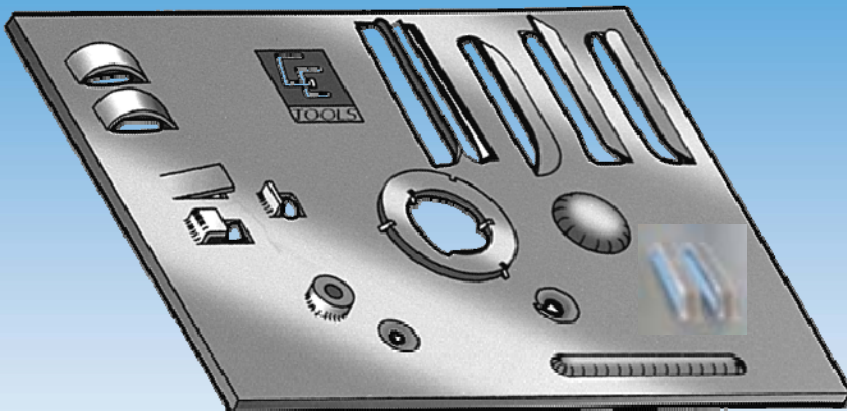


Max. Material Thickness is determined by Pitch. Speed is up to 200 SPM on 1" Centers.

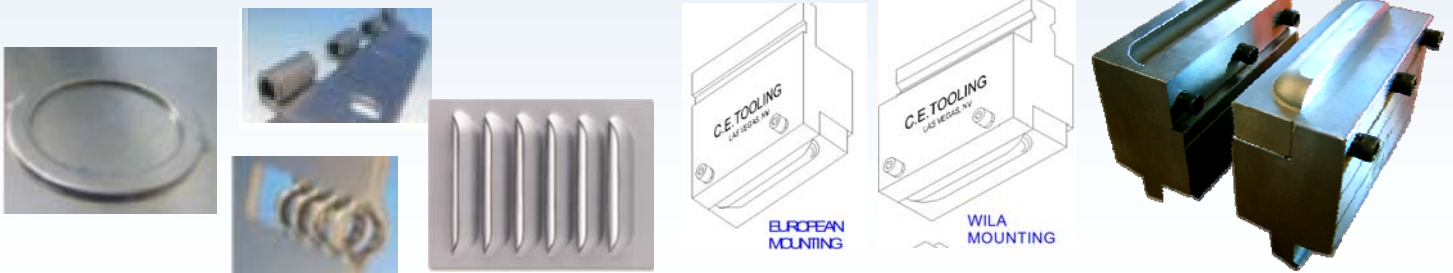


SPECIAL APPLICATION FORMING TOOLS

HIGHER PRODUCTIVITY THROUGH SUPERIOR ENGINEERING



9 Sizes of Stocked Press

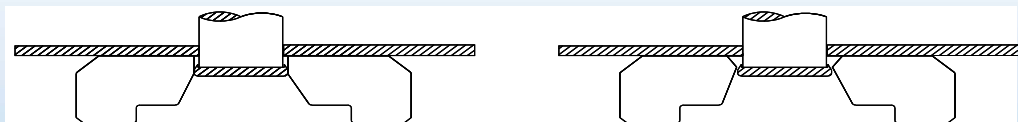


SLUG TRAP™ DIES

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



GROUND SYMBOL

Standard=1/2"Ø +\$50 for non standard Longest horizontal line=3/8 length



DOWN Sta. B Punch & Die **UP** Sta. D Punch & Die
DOWN Sta. B Punch & Die **UP** Sta. D Punch & Die

Sheet Lubricant CLM-50 oil 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.

Slug Ejector are placed in punch tip sizes >.27"/6.86mm

Bag of 50 .078 Code*AEJ-R2

Bag of .250 " Code *AEJ-R7

**FABRICATING TOOLS
and Accessories for most
Punching, Bending and
Shearing Equipment**



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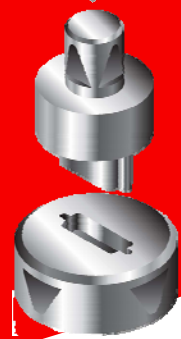
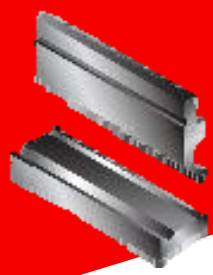
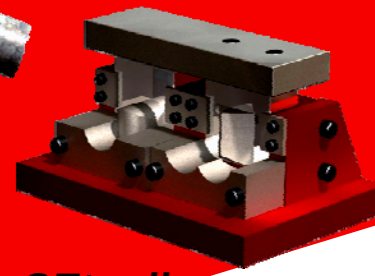
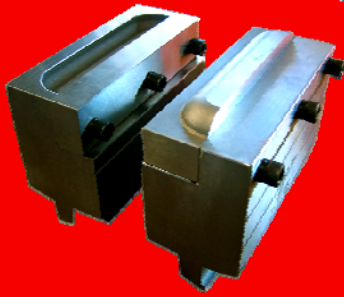
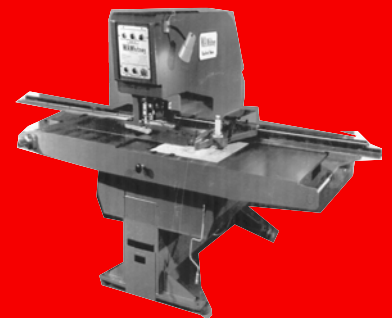


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