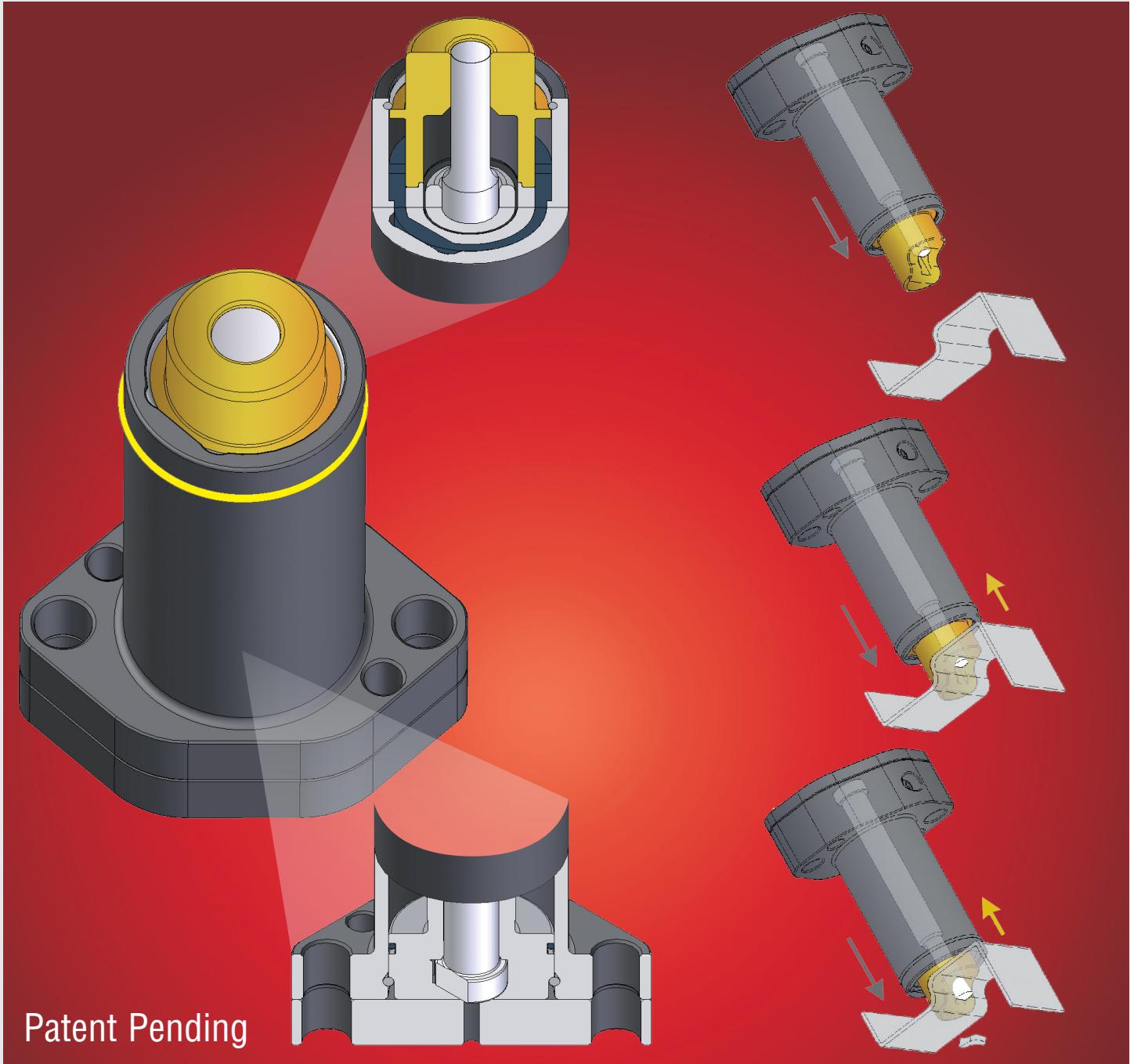


Nitrogen punching unit with removable and mouldable stripper



- STRIPPER HEAD REMOVABLE AND MOULDABLE
- EASY POSITIONING
- HIGH AND ADJUSTABLE HOLDING AND STRIPPING FORCE
- COMPACT DIMENSIONS
- SUITABLE FOR ISO 8020 SHOULDER STYLE PUNCH
- DOESN'T REQUIRE THE USE OF STANDARD RETAINER
- IDEAL FOR COMBINED USE WITH CAM UNIT

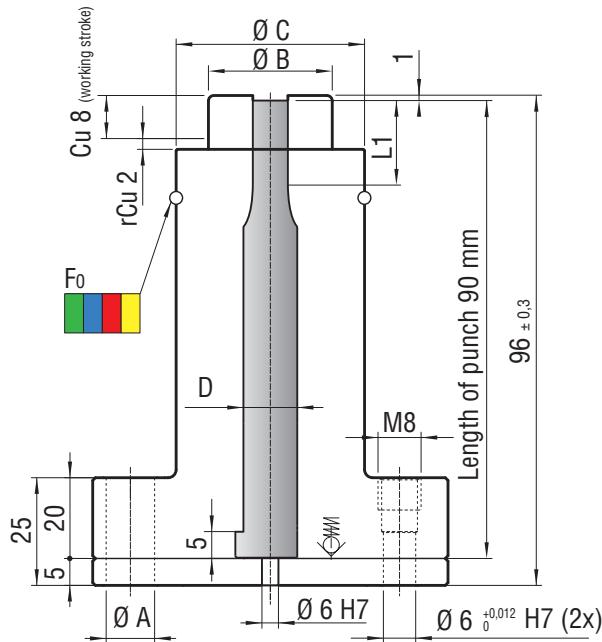


Nitrogen punching unit with removable and mouldable stripper

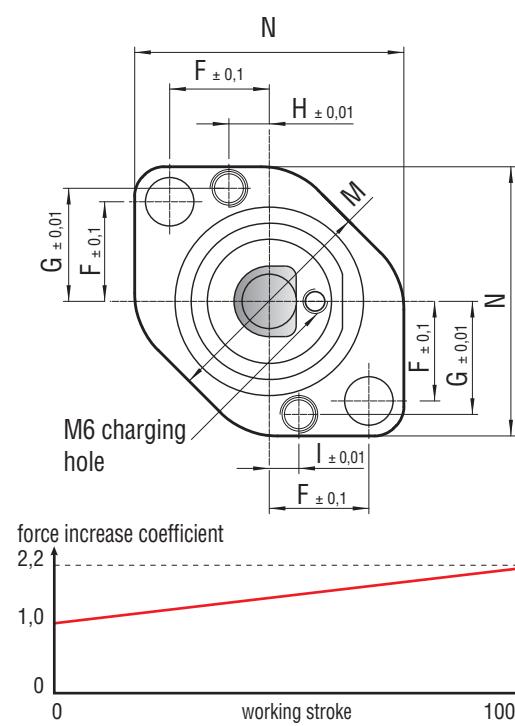


90 mm shoulder style punch length

Short stripper head



Long stripper head



Nitrogen punching unit code	D ISO 8020	B	C	Cu	rCu*	A	F	G	H	I	M	N	L1	S**	F_o daN ±5% (25 bar at 20°C)	F_o daN ±5% (50 bar at 20°C)	F_o daN ±5% (75 bar at 20°C)	F_o daN ±5% (100 bar at 20°C)
short and long stripper	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	cm²	GR	BU	RD	YW
3L P01A (GR/BU ...)	10	23	35	8	2	9 (2x)	19	22	7	5	42	55	≥ 19	5,05	125	255	380	505
3L P02A (GR/BU ...)	13	29	43	8	2	9 (2x)	24	27	7	5	50	65	≥ 19	6,95	175	350	520	695
3L P03A (GR/BU ...)	16	29	43	8	2	9 (2x)	24	27	7	5	50	65	≥ 19	6,95	175	350	520	695
3L P04A (GR/BU ...)	20	40	58	8	2	11 (2x)	28	32,5	13	11	64	78	≥ 19	11,6	290	580	870	1160
3L P05A (GR/BU ...)	25	40	58	8	2	11 (2x)	28	32,5	13	11	64	78	≥ 25	11,6	290	580	870	1160
3L P06A (GR/BU ...)	32	48	67	8	2	13 (2x)	31	37	14	12	74	85	≥ 25	13,85	345	695	1040	1390
3L P07A (GR/BU ...)	40	60	81	8	2	13 (2x)	36	42,5	21	19	90	96	≥ 25	18,85	470	940	1410	1880

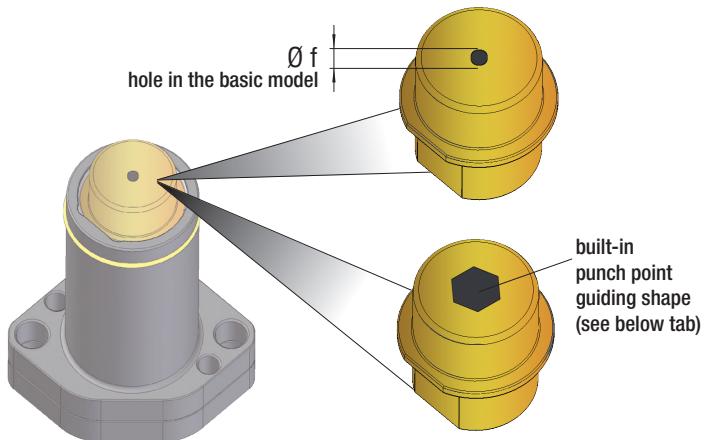
All sizes in mm.

Special Springs

* rCu reserve of stroke

** S piston working size

Nitrogen punching unit with removable and mouldable stripper



The stripper head can also be supplied separately from the nitrogen punching unit. It can be supplied with or without (basic model) punch point guiding shape built-in.

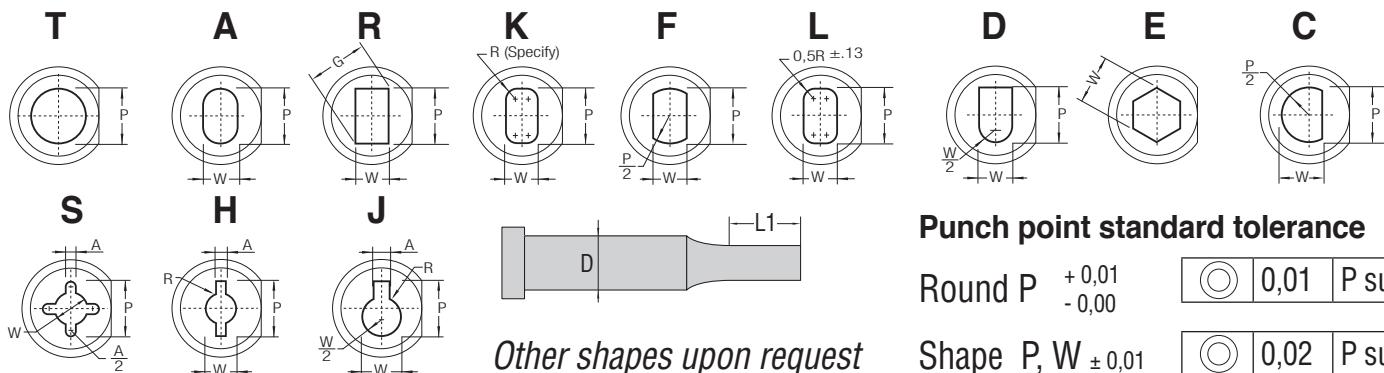


Geometry size and tolerance of the built-in punch guiding shape is always referred to the nominal punch size.



Radial clearance between punch and punch point guiding hole is max. 0,1 mm.

Reference to nitrogen punching unit code	\varnothing punch mm	Short model stripper head punch length = 90 mm code	$\varnothing f$ mm	Long model stripper head punch length = 90 mm code	$\varnothing f$ mm
3L P01A	10	42 S 01	1,5	42 S 02	1,5
3L P02A	13	42 S 03	3	42 S 04	3
3L P03A	16	42 S 03	3	42 S 04	3
3L P04A	20	42 S 07	3	42 S 08	3
3L P05A	25	42 S 07	3	42 S 08	3
3L P06A	32	42 S 11	3	42 S 12	3
3L P07A	40	42 S 13	3	42 S 14	3



Punch point standard tolerance

Round P $+0,01$
 $-0,00$ 0,01 P su D

Shape P, W $\pm 0,01$ 0,02 P su D



The punch is not included!

How to order only the nitrogen unit

Example: 5 3L P04 YW

5

Quantity

3L P04A

Nitrogen unit code

YW

Initial stripping force

How to order the nitrogen punching unit with punch point guiding shape built-in the stripper head Example: 5 3L P04 YW 42 S 08 A P=.. W=..

5	3L P04A	YW	42 S 08	A	P =... W =...
Quantity	Nitrogen unit code	Initial stripping force	Stripper head model	Form of punch point guiding built-in	Nominal sizes of punch point in mm

How to order only the stripper head with punch point guiding built-in Example: 5 42 S 08 A P=... W=...

5	42 S 08	A	P =... W =...
Quantity	Stripper head model	Form of punch point guiding built-in	Nominal sizes of punch point in mm

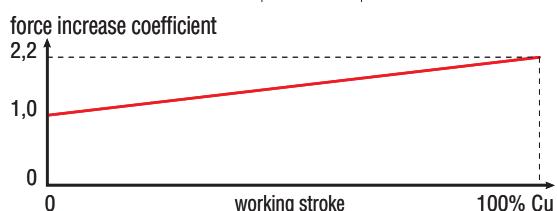
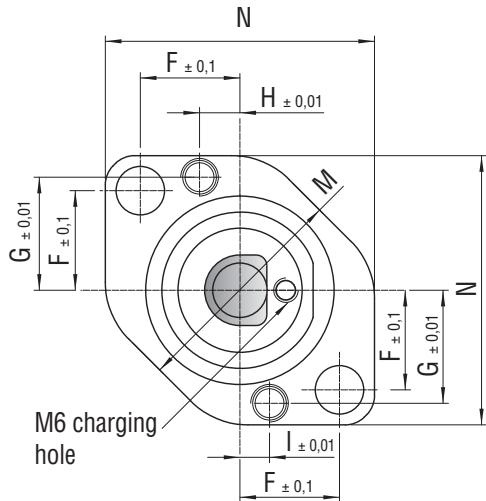
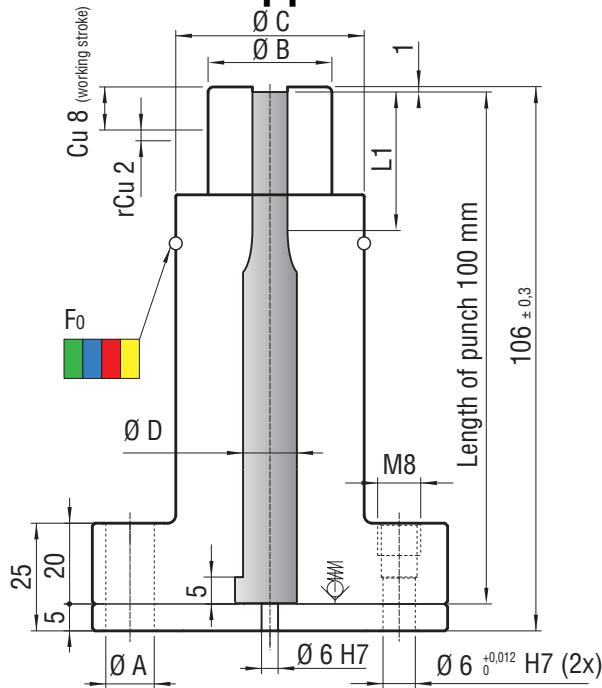
How to order only the stripper head without punch point guiding shape built-in (basic model) Example: 5 42 S 08

5	42 S 08
Quantity	Stripper head model

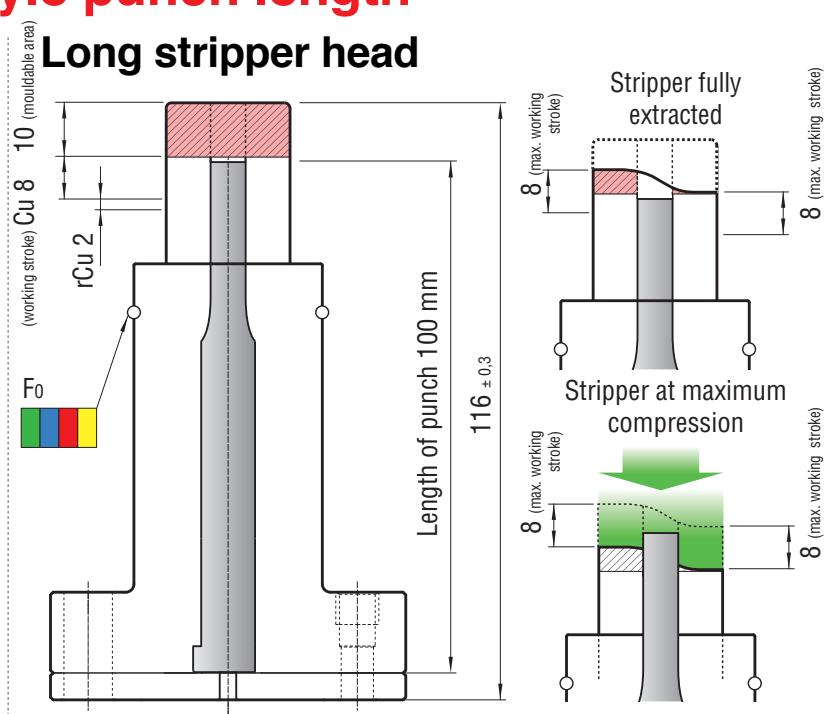
Nitrogen punching unit with removable and mouldable stripper 100 mm shoulder style punch length



Short stripper head



Long stripper head



! The short stripper head is recommended for flat piercing. Any moulded contour of the stripper head will cause a lost of working stroke.

! The long stripper head is recommended for piercing where it is required a moulded contour of the stripper. The mouldable area of the stripper is 10 mm long and shall be machined by the user.

IMPORTANT

The maximum working stroke of the stripper head is always **8 mm**. The maximum working stroke of the stripper head shall be always calculated from the first point of contact of the stripper with the working area of the sheet.

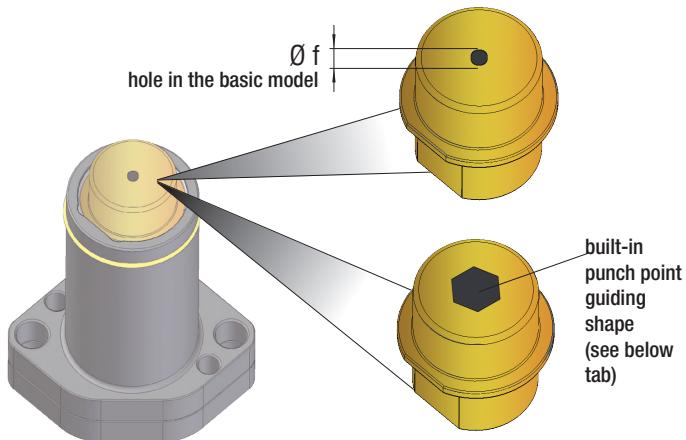
! Special Springs' nitrogen punching unit with removable and mouldable stripper head is designed to fit ISO 8020 shoulder style punch standard.

! The supply of the nitrogen punching unit stripper head always includes the punch guiding shape built-in the stripper, if not otherwise required. A bottom hardened counter plate is included. See how to order examples.

Nitrogen punching unit code	D ISO 8020	B	C	Cu	rCu*	A	F	G	H	I	M	N	L1	S**	F ₀ daN ±5% (25 bar at 20° C)	F ₀ daN ±5% (50 bar at 20° C)	F ₀ daN ±5% (75 bar at 20° C)	F ₀ daN ±5% (100 bar at 20° C)
short and long stripper	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	cm ²	GR	BU	RD	YW
3L P01A (GR/BU ...)	10	23	35	8	2	9 (2x)	19	22	7	5	42	55	≥ 25	5,05	125	255	380	505
3L P02A (GR/BU ...)	13	29	43	8	2	9 (2x)	24	27	7	5	50	65	≥ 25	6,95	175	350	520	695
3L P03A (GR/BU ...)	16	29	43	8	2	9 (2x)	24	27	7	5	50	65	≥ 25	6,95	175	350	520	695
3L P04A (GR/BU ...)	20	40	58	8	2	11 (2x)	28	32,5	13	11	64	78	≥ 25	11,6	290	580	870	1160
3L P05A (GR/BU ...)	25	40	58	8	2	11 (2x)	28	32,5	13	11	64	78	≥ 25	11,6	290	580	870	1160
3L P06A (GR/BU ...)	32	48	67	8	2	13 (2x)	31	37	14	12	74	85	≥ 30	13,85	345	695	1040	1390
3L P07A (GR/BU ...)	40	60	81	8	2	13 (2x)	36	42,5	21	19	90	96	≥ 30	18,85	470	940	1410	1880

All sizes in mm.

Nitrogen punching unit with removable and mouldable stripper



The stripper head can also be supplied separately from the nitrogen punching unit. It can be supplied with or without (basic model) punch point guiding shape built-in.

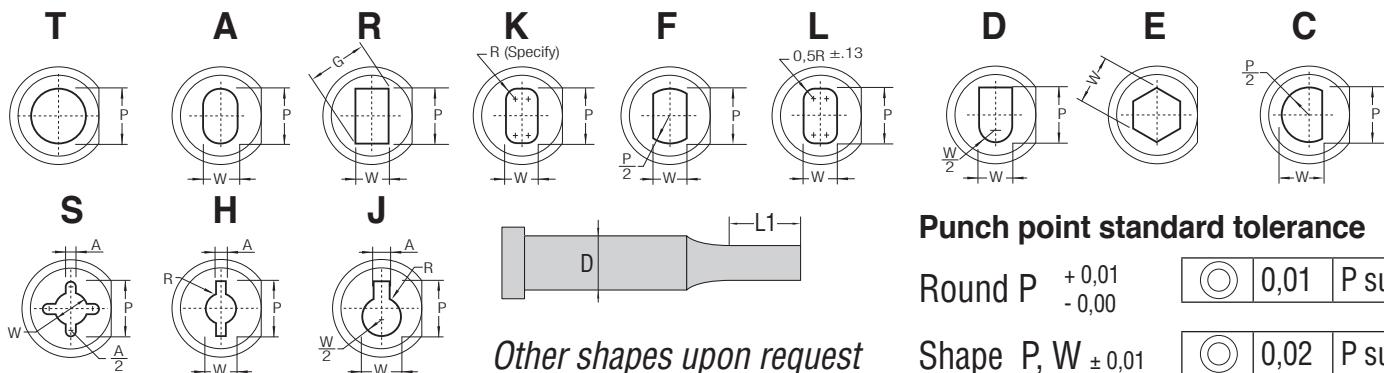


Geometry size and tolerance of the built-in punch guiding shape is always referred to the nominal punch size.



Radial clearance between punch and punch point guiding hole is max. 0,1 mm.

Reference to nitrogen punching unit code	\varnothing punch	Short model stripper head punch length = 100 mm code	\varnothing f mm	Long model stripper head punch length = 100 mm code	\varnothing f mm
3L P01A	10	42 S 15	1,5	42 S 16	1,5
3L P02A	13	42 S 17	3	42 S 18	3
3L P03A	16	42 S 17	3	42 S 18	3
3L P04A	20	42 S 21	3	42 S 22	3
3L P05A	25	42 S 21	3	42 S 22	3
3L P06A	32	42 S 25	3	42 S 26	3
3L P07A	40	42 S 27	3	42 S 28	3

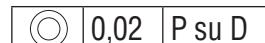


Punch point standard tolerance

Round P $+0,01$
 $-0,00$



Shape P, W $\pm 0,01$



Other shapes upon request



The punch is not included!

How to order only the nitrogen unit

Example: 5 3L P04 YW

5

Quantity

3L P04A

Nitrogen unit code

YW

Initial stripping force

How to order the nitrogen punching unit with punch point guiding shape built-in the stripper head Example: 5 3L P04 YW 42 S 22 A P=.. W=..

5	3L P04A	YW	42 S 22	A	P =... W =...
Quantity	Nitrogen unit code	Initial stripping force	Stripper head model	Form of punch point guiding built-in	Nominal sizes of punch point in mm

How to order only the stripper head with punch point guiding built-in Example: 5 42 S 22 A P=... W=...

5	42 S 22	A	P =... W =...
Quantity	Stripper head model	Form of punch point guiding built-in	Nominal sizes of punch point in mm

How to order only the stripper head without punch point guiding shape built-in (basic model) Example: 5 42 S 22

5	42 S 22
Quantity	Stripper head model

Clamp jig for moulding the stripper head



! To build-in the punch point guiding shape and/or contour the stripper head it is required to remove the stripper head from the nitrogen unit body.
The clamp jig is always re-usable.
Size, fixing and orientation of the anti-rotation correspond to the same of the nitrogen unit body.

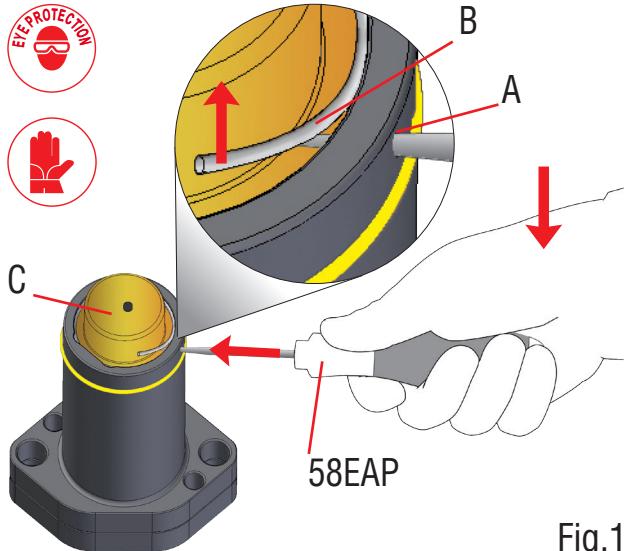


Fig.1

To remove the stripper head C, press and lift up the C-ring B through the hole A. Tool required 58EAP.

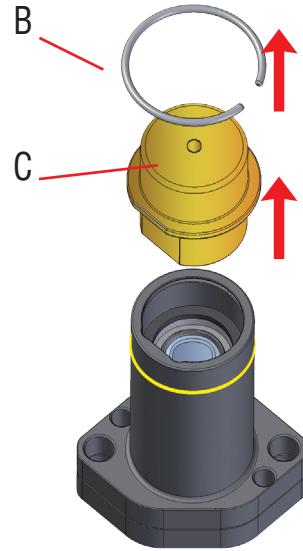


Fig.2

Remove the C-ring B from the groove and take the stripper head C out of the unit body.

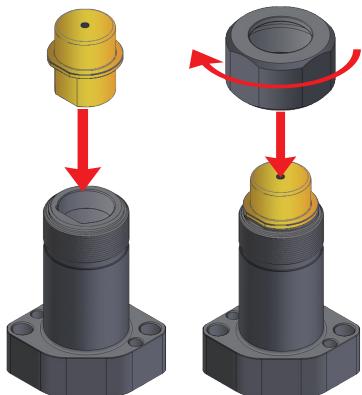


Fig.3

Select the appropriate model of clamp jig and position the stripper head into the lodging hole. Screw and lock the retaining nut.

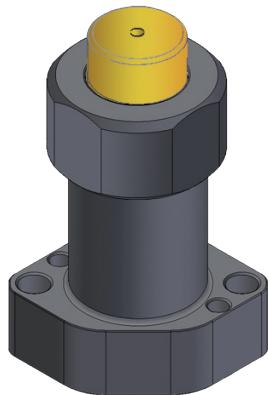
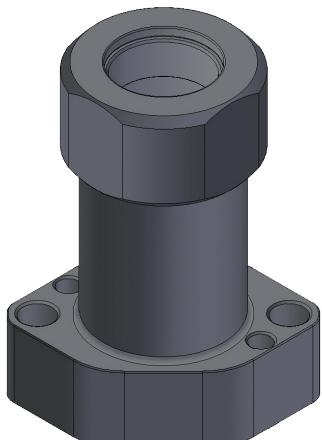
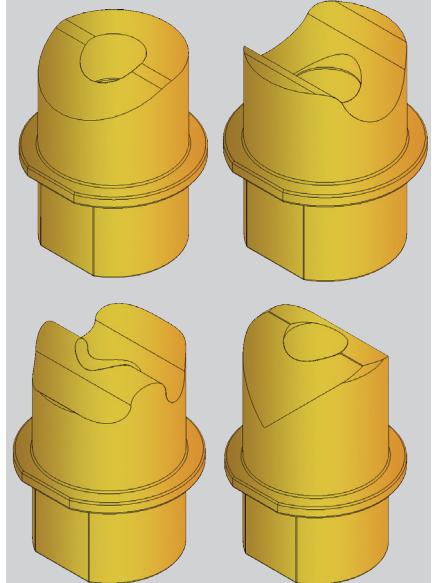


Fig.4

Position and lock the clamp jig on the machine tool, wire EDM and/or tool plate and proceed with the required machining.
After that re-assemble the stripper head on the nitrogen unit body following the reverse procedure.

Examples of moulded contour stripper heads

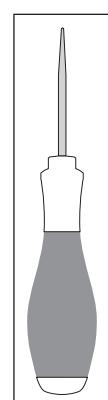


Reference to
nitrogen unit
code

Stripper head
clamp jig
code

3L P01A (GR/BU ...)	3L MP01A
3L P02A (GR/BU ...)	3L MP02A
3L P03A (GR/BU ...)	3L MP02A
3L P04A (GR/BU ...)	3L MP04A
3L P05A (GR/BU ...)	3L MP04A
3L P06A (GR/BU ...)	3L MP06A
3L P07A (GR/BU ...)	3L MP07A

Cod. 58EAP



Retaining
C-ring removal
tool

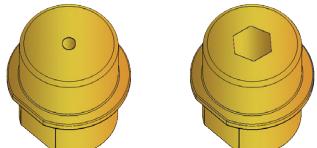


Nitrogen punching unit with removable and mouldable stripper

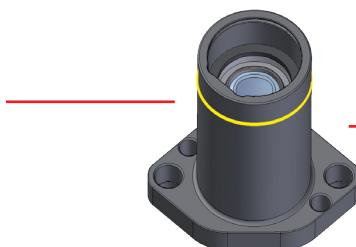


Stripper head retaining C-ring

Removable and
mouldable stripper
head.
Basic model
with 3 mm hole.



Force identification
color ring



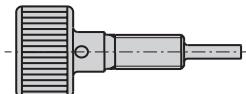
Removable
and mouldable
stripper head
with punch
point guiding
shape built-in.

Nitrogen and
shoulder
style punch
retainer unit.



Hardened bottom
counter plate

Discharging and charging devices



Discharging device **Cod. DDS-M6/3**



Charging adapter **Cod. ADM08** (included in the Cod. 39DMA set)
To be used in combination with units Cod. 39DMCILA + Cod. 39DMCPVA.
For more details see: Nitrogen cylinders catalogue.



Cejin male quick fit adapter for direct charging **Cod. QDFV02**
To be used in combination with unit Cod. 39DMCPVA only.
For more details see: Nitrogen cylinders catalogue.

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