

QUALITY FROM THE CUTTING EDGE OF FABRICATION

Form Tooling

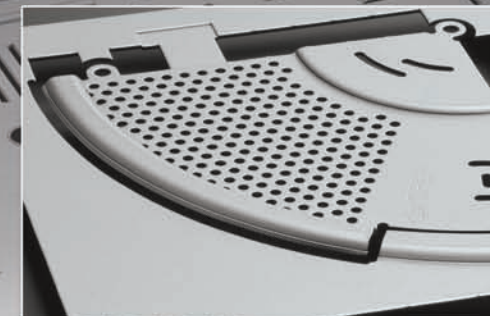


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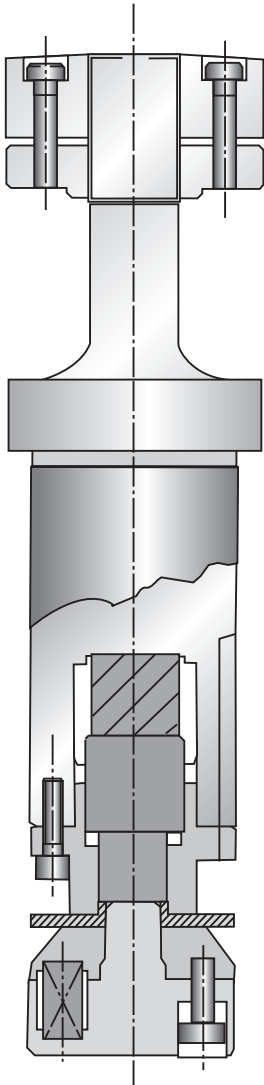
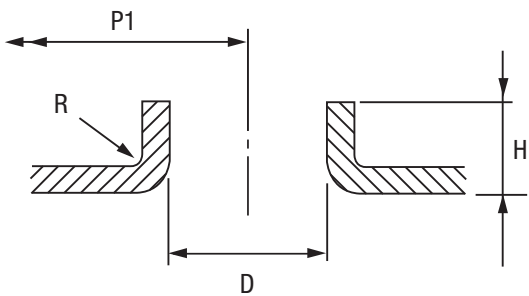
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TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .091"			
D MAX.	.830"	1.417"	2.912"	3.700"
H MAX.	.197"			
P1 MIN.*	.197" + D + 2x material thickness			
R	Amada will use the smallest radius that meets conditions.			

* This dimension MUST be specified when placing an order.

CONDITIONS

The conditions below must be met in order to use the tooling specification chart.

1) $H \geq \text{thickness} \times 2$

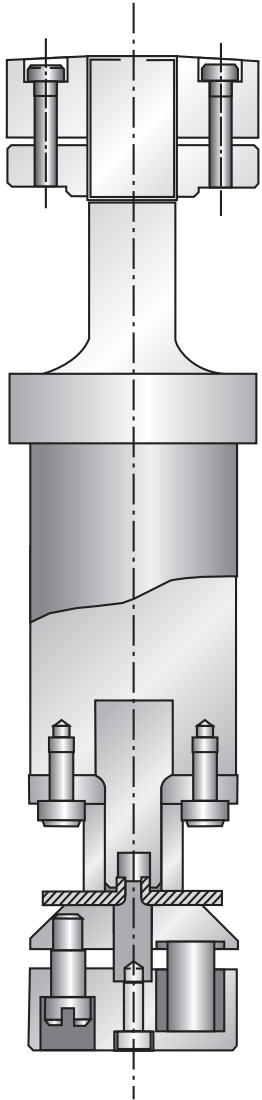
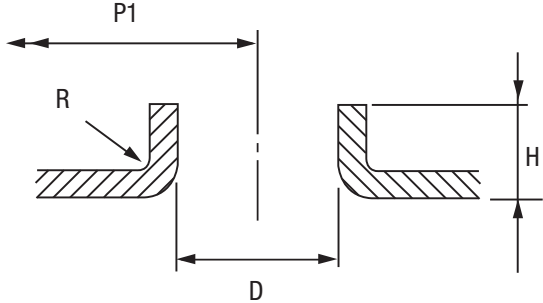
2) $H \leq D \times 0.4$

NOTES:

Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

All diagrams and pricing are for illustrating and estimating purposes only.
Actual tool design may vary causing the price and/or lead time to change.

For Sheet Metal Screws



TOOLING SPECIFICATION

STATION	1-1/4"
MATERIAL	mild steel
THICKNESS	.031" - .091"
D MAX.	.250"
H MAX.	.118"
P1 MIN.*	.440" + (D/2)
R	Amada will use the smallest radius that meets conditions.

* This dimension MUST be specified when placing an order.

NOTES:

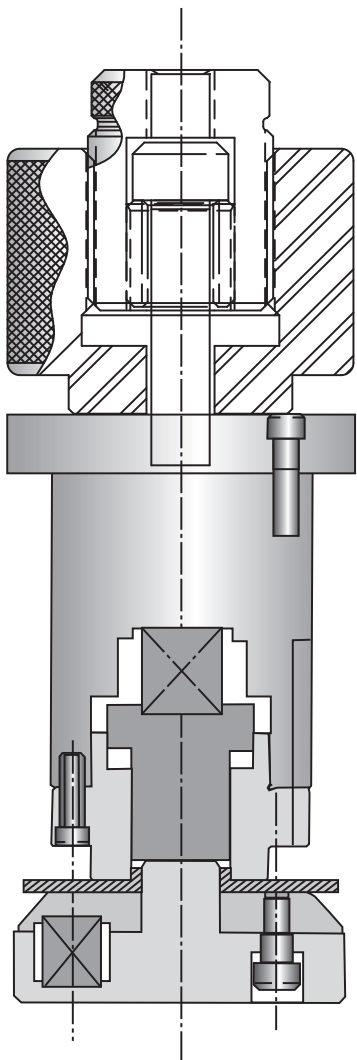
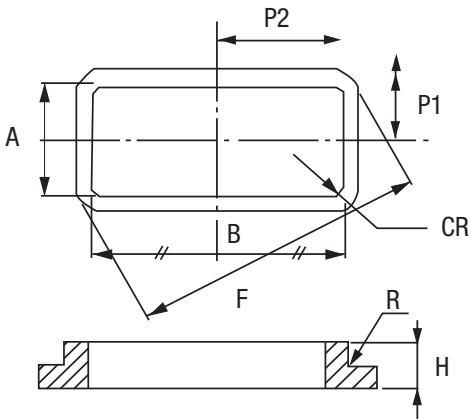
Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

SCREW SIZE	MATERIAL THICKNESS							Approx. pre-hole
	#22 .0299"	#20 .0359"	#18 .047"	#16 .059"	#14 .074"	#13 .090"	D	
#4-40	.127"	.136"	-	-	-	-	.090"	.045"
#5-40	.139"	.148"	.165"	.180"	-	-	.102"	.051"
#6-32	.144"	.153"	.171"	.185"	-	-	.107"	.053"
#8-32	-	.182"	.199"	.214"	.233"	-	.136"	.064"
#10-24	-	-	.213"	.228"	.247"	.267"	.150"	.069"
#1/4-20	-	-	.268"	.283"	.302"	.322"	.205"	.100"

Maximum diameter: .250"

AMADA does not recommend punching a pre-hole smaller than material thickness.

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TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .091"			
F MAX.	1.000"	1.417"	2.912"	3.700"
H MAX.	.197"			
P1 MIN.*	.197" + thickness + A			
P2 MIN.*	.197" + thickness + B			
R	Amada will use the smallest radius that meets conditions.			

* This dimension MUST be specified when placing order.

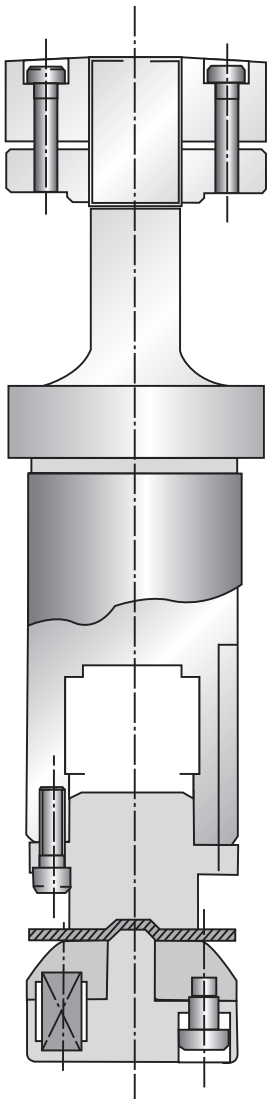
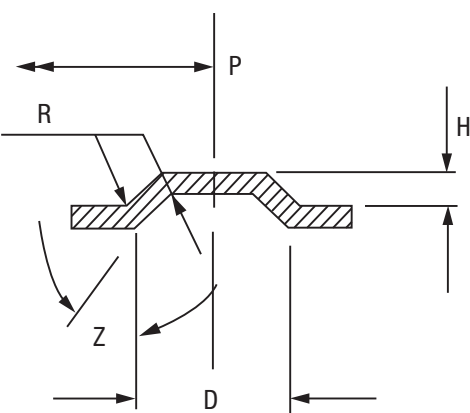
CONDITIONS

The conditions below must be met in order to use the tooling specification chart.

1) $H \geq \text{thickness} \times 2$
2) $H \leq A \times 0.4$
3) $H \leq CR$

NOTES:
The term "SHAPED" for this forming tool refers to a square, rectangle, obround only. All other shapes are considered special and will require a quotation. Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

All diagrams and pricing are for illustrating and estimating purposes only. Actual tool design may vary causing the price and/or lead time to change.



TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .125"			
D MAX.	1.000"	1.526"	3.020"	3.897"
H (30° - 45°)	.157" MAX.			
H (45° ≤ Z)	.256" MAX.			
P MIN.*	.197" + D			
R	Amada will use the smallest radius that meets conditions.			

* This dimension MUST be specified when placing an order.

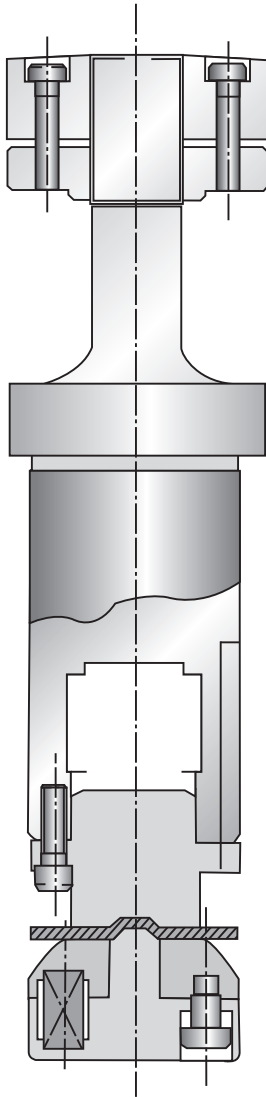
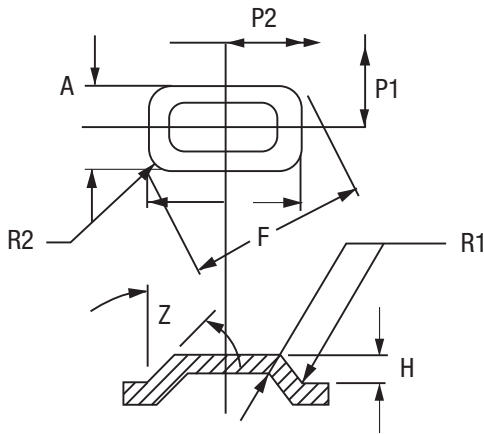
CONDITIONS

The conditions below must be met in order to use the tooling specification chart.

1) $H \leq \text{thickness} \times 4$
2) $H \leq D \times 0.3$
3) $Z \geq 30^\circ$

NOTES:
Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

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TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .125"			
F MAX.	1.000"	1.526"	2.912"	3.897"
H (30° - 45°)	.157" maximum			
H (45° ≤ Z)	.256" maximum			
P1 MIN.*	.197" + thickness + A			
P2 MIN.*	.197" + thickness + A			
R1	Amada will use the smallest radius that meets conditions.			

* This dimension MUST be specified when placing an order.

CONDITIONS

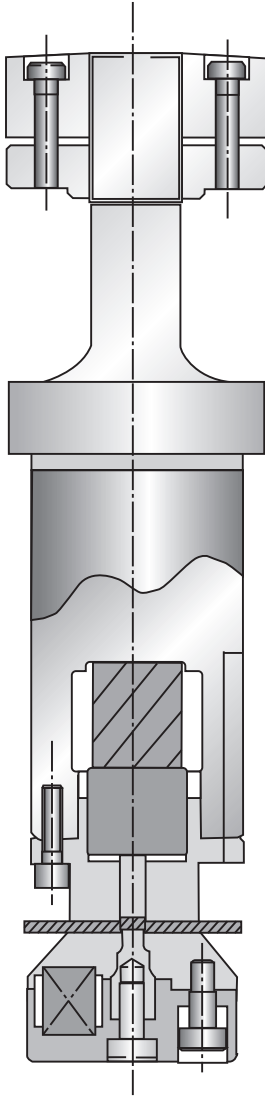
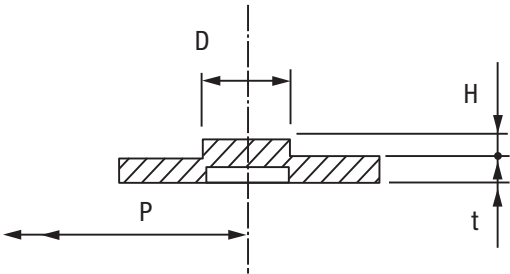
The conditions below must be met in order to use the tooling specification chart.

1) $H \leq \text{thickness} \times 3$
2) $H \leq A \times 0.3$
3) $H \leq R2$
4) $Z \geq 30^\circ$

NOTES:

The term "SHAPED" for this forming tool refers to a square, rectangle, obround or double D only. All other shapes are considered special and will require a quotation. Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

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TOOLING SPECIFICATION

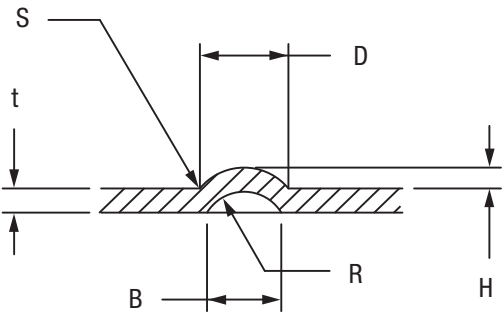
STATION	1/2"	1-1/4"
MATERIAL	mild steel	
MAX. THICKNESS	.031" - .063"	.031" - .125"
D MAX. - SOLID	-	.100" - 1.250"
D MAX. - CHIP	.079" - .250"	.100" - .312"
H MAX.	$H \leq \text{thickness} \times 0.6$	
P MIN.*	.157" + D	

* This dimension MUST be specified when placing an order.

NOTES:

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TOOLING SPECIFICATION

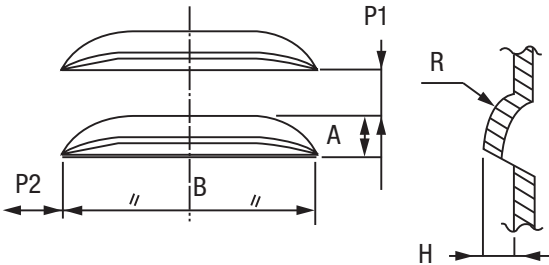
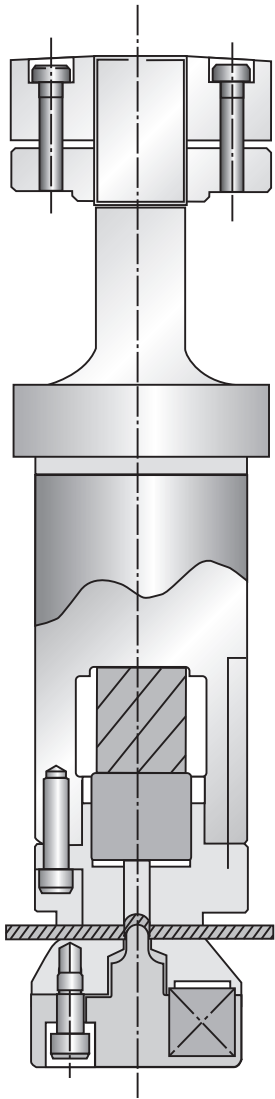
STATION	1/2"	1-1/4"	2"
MATERIAL	mild steel		
THICKNESS	.031" - .091"		
D MAX.	.315"	1.000"	1.526"
HEIGHT	0.090"	0.256"	0.256"
P1 MIN.	.197" + D		

CONDITIONS

The conditions below must be met in order to use the tooling specification chart.

1) $H \text{ MAX.} = D \times 0.3$
2) $H \leq \text{material thickness} \times 3$
3) $R > H$

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Actual tool design may vary causing the price and/or lead time to change.



TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .125"			
A MAX.	.315"	1.079"	1.181"	1.181"
B MAX.	.984"	1.769"	3.375"	4.200"
H MAX.	.236"	.256"		
P1 MIN.*	.197"			
P2 MIN.*	.315"			

* This dimension MUST be specified when placing an order.

CONDITIONS

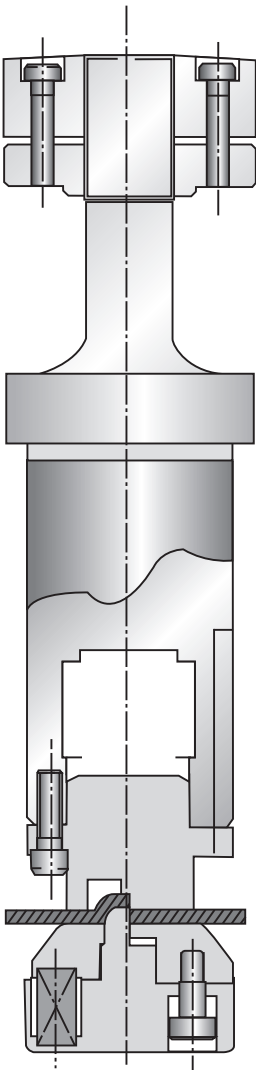
The conditions below must be met in order to use the tooling specification chart.

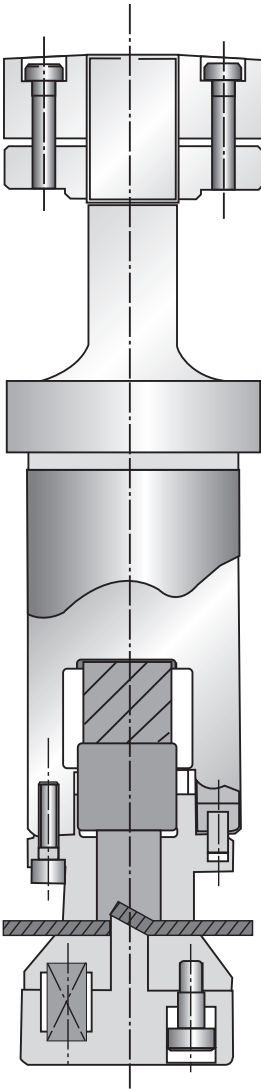
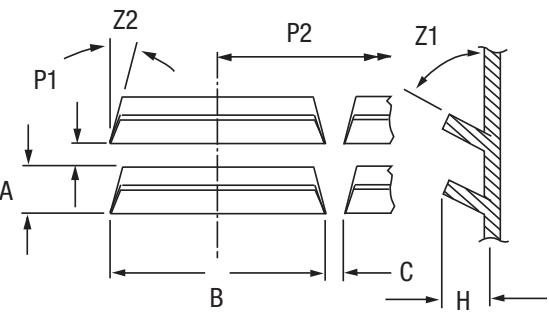
1) $H \leq A \times 0.6$
2) $H \geq \text{thickness} \times 3$
3) $R \geq H$

NOTES:
Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

Guide is keyed 0°, 90°, 180°, 270°.

All diagrams and pricing are for illustrating and estimating purposes only.
Actual tool design may vary causing the price and/or lead time to change.





TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .125"			
A MAX.	.315"	1.079"	1.181"	1.181"
B MAX.	.984"	1.769"	3.346"	4.134"
H MAX.*	.315"	.394"		
P1 MIN.*	.000"			
C MIN.*	.197"			

* This dimension MUST be specified when placing an order.

CONDITIONS

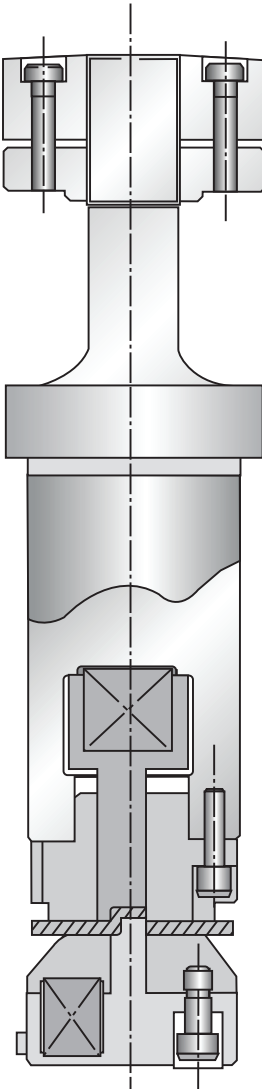
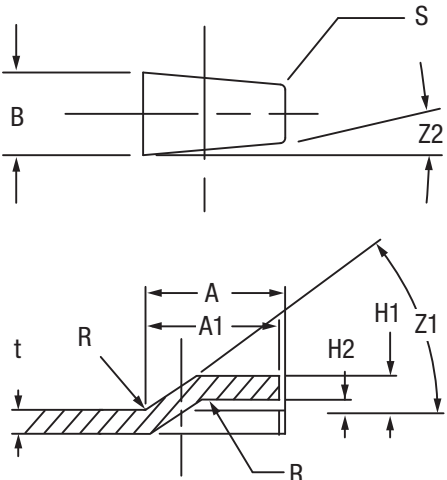
The conditions below must be met in order to use the tooling specification chart.

- 1) $Z2 \geq 2^\circ$
- 2) If $P1 = 0$, then $Z2 > 15^\circ$

NOTES:
Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

Guide is keyed 0°, 90°, 180°, 270°.

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Actual tool design may vary causing the price and/or lead time to change.



TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .125"			
A MAX.	.315"	1.079"	1.181"	1.181"
B MAX.	.984"	1.769"	3.346"	4.134"
H1 MAX.	.256"			

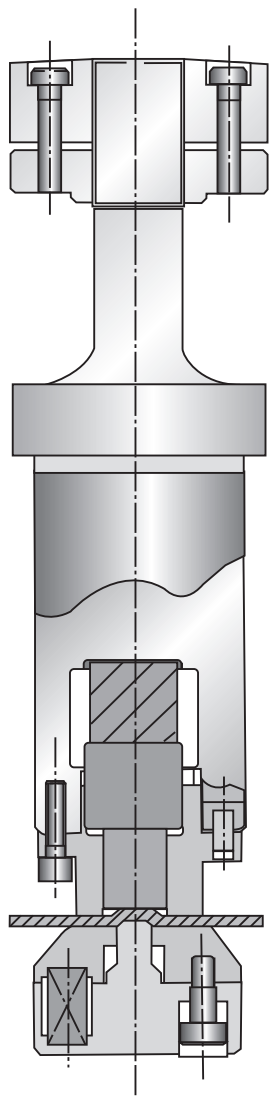
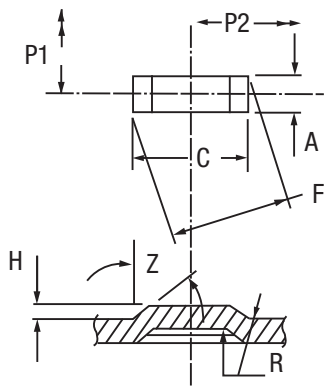
CONDITIONS

The radius will be .020" unless otherwise specified.

NOTES:
Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

Guide is keyed 0°, 90°, 180°, 270°

All diagrams and pricing are for illustrating and estimating purposes only.
Actual tool design may vary causing the price and/or lead time to change.

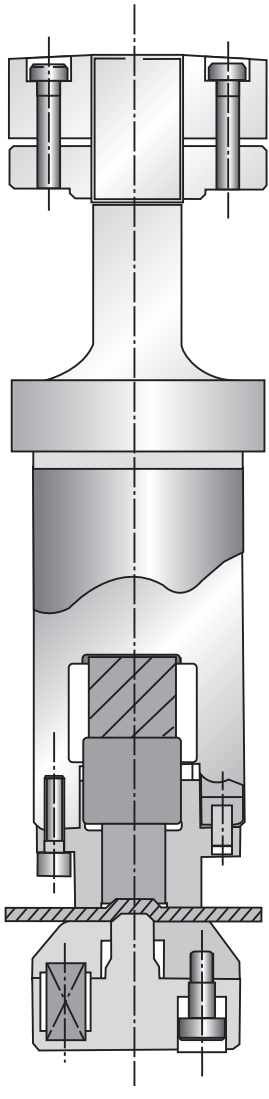
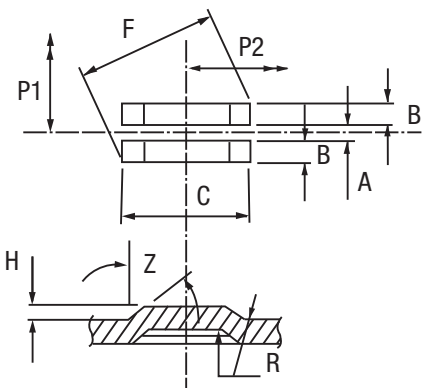


TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .125"			
F MAX.	1.000"	1.830"	3.020"	3.890"
H (30° - 45°)	.157" MAX.			
H (45° ≤ Z)	.256" MAX.			
A MAX.	.079" or material thickness			
Z MIN.	30°			
R	Amada will use the smallest radius that meets conditions.			

NOTES:
Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

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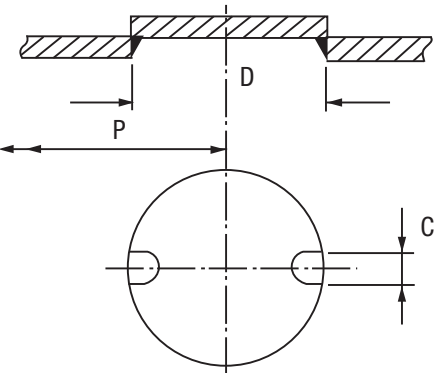


TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .125"			
F MAX.	1.000"	1.830"	3.020"	3.890"
H MAX.	.256"			
A & B MIN.	.079" or material thickness			
Z MIN.	30°			
R	Amada will use the smallest radius that meets conditions.			

NOTES:
Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

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Actual tool design may vary causing the price and/or lead time to change.



TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .125"			
D MAX.	.187" - 1.250"	1.750"	3.020"	3.897"
P MIN.*	.197" + D			

* This dimension MUST be specified when placing an order.

CONDITIONS

The conditions below must be met in order to use the tooling specification chart.

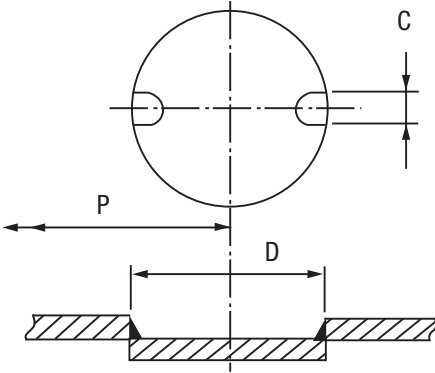
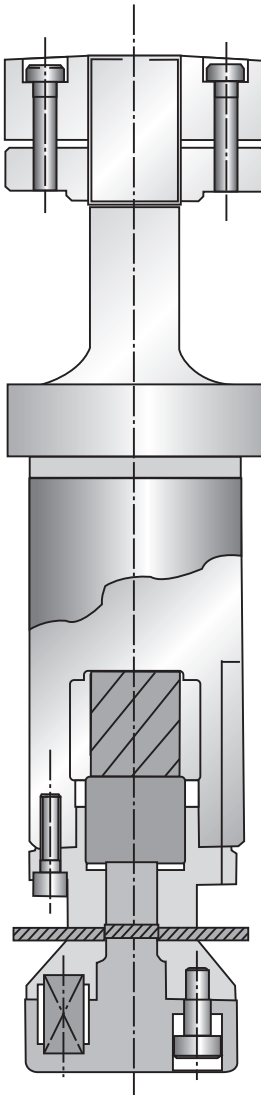
- 1) Required tonnage $\leq$ machine tonnage x 0.7
- 2) Width of tab (C) = thickness x 2*

* Please specify number of tabs.

NOTES:

Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

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Actual tool design may vary causing the price and/or lead time to change.



TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .105"			
D MAX.	1.063"	2.000"	3.250"	4.400"
P MIN.*	.197" + D			

* This dimension MUST be specified when placing an order.

** Requires Guide Assembly.

CONDITIONS

The conditions below must be met in order to use the tooling specification chart.

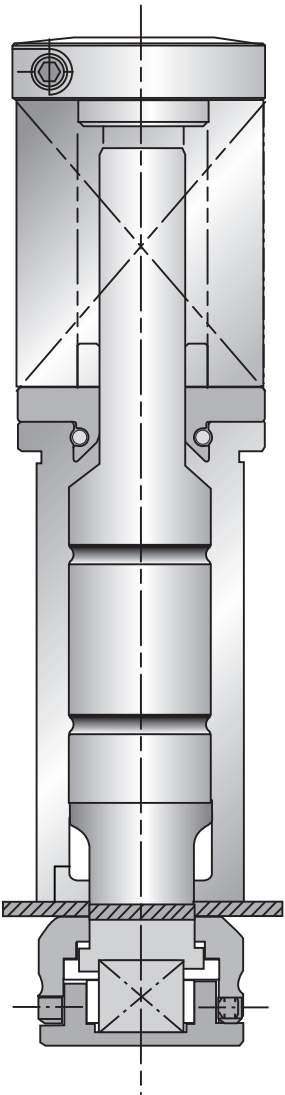
- 1) Required tonnage $\leq$ machine tonnage x 0.7
- 2) Width of tab (C) = thickness x 2*

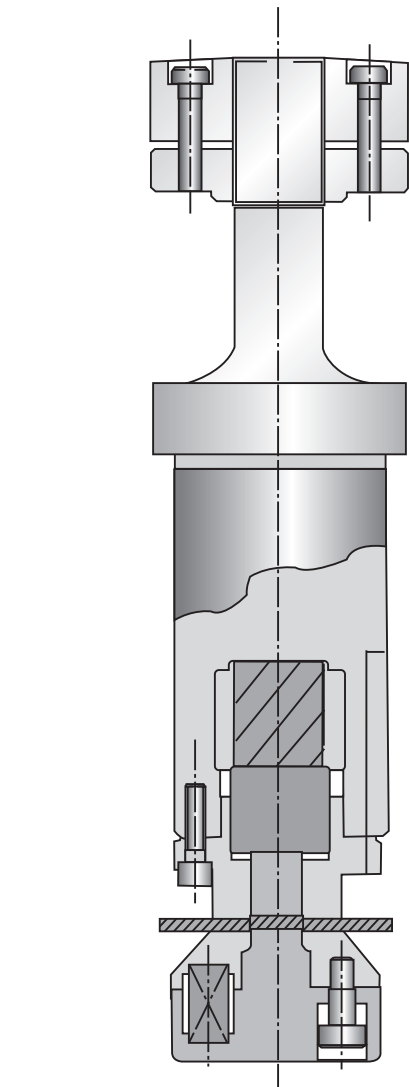
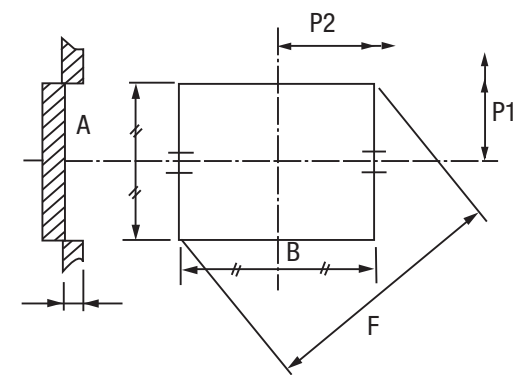
* Please specify number of tabs.

NOTES:

Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

All diagrams and pricing are for illustrating and estimating purposes only.
Actual tool design may vary causing the price and/or lead time to change.





TOOLING SPECIFICATION

FORM UP

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .125"			
F MAX.	1.000"	1.810"	2.912"	3.897"
P1 MIN.*	.197" + A			
P2 MIN.*	.197" + B			

FORM DOWN

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .105"			
F MAX.	1.063"	2.000"	3.250"	4.400"
P1 MIN.*	.197" + A			
P2 MIN.*	.197" + B			

* This dimension MUST be specified when placing an order.

CONDITIONS

The conditions below must be met in order to use the tooling specification chart.

- 1) Required tonnage $\leq$ machine tonnage x 0.7
- 2) Width of tab thickness = thickness x 1.5

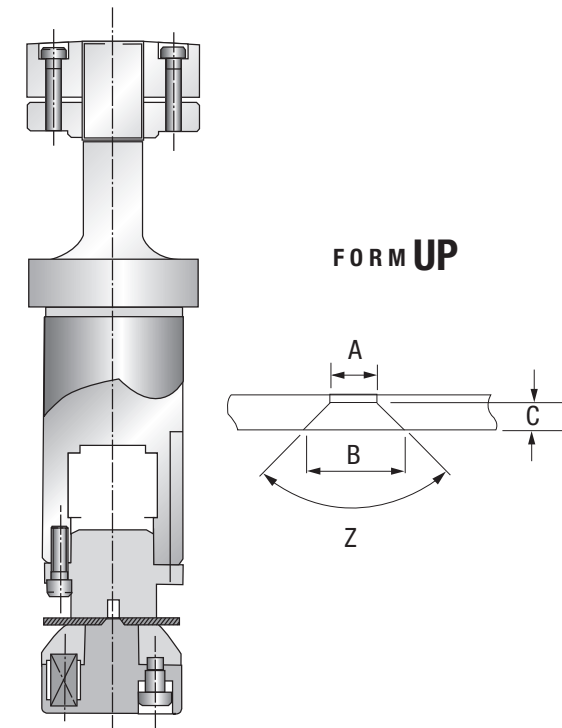
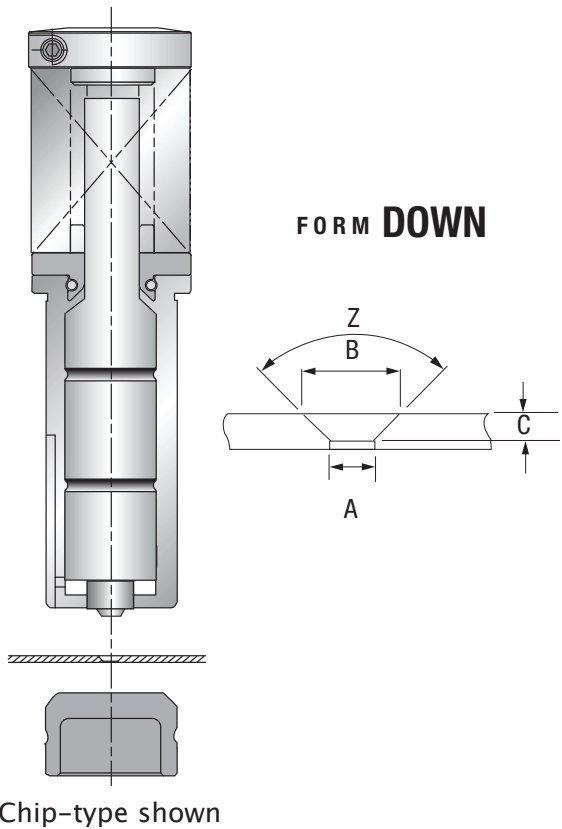
Please specify number of tabs.

NOTES:

Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

The term "SHAPED" for this forming tool refers to a square, rectangle, obround or double D only. All other shapes are considered special and will require a quotation.

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TOOLING SPECIFICATION

FORM DOWN

STATION	1-1/4"	2"
MATERIAL	mild steel	
THICKNESS	.047" min	
B MAX. - SOLID	.787"	1.526"
C MAX.	thickness x 0.8	

* Requires Guide Assembly.

FORM UP

STATION	1-1/4"	2"
MATERIAL	mild steel	
MAX. THICKNESS	.047" min	
B MAX. - SOLID	.787"	1.526"
C MAX.	thickness x 0.8"	

CONDITIONS

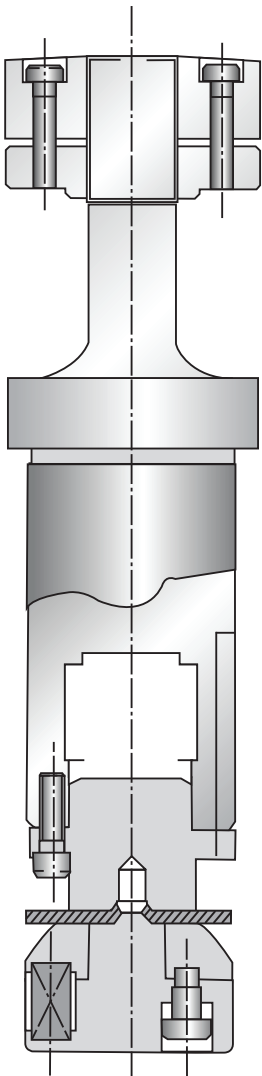
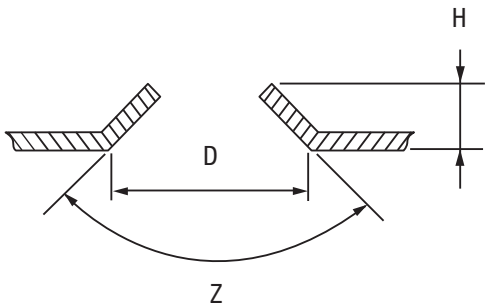
The conditions below must be met in order to use the tooling specification chart.

- 1) MAX. B for chip type = .531"
- 2) MAX. thickness for chip type = .150"

NOTES:

Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

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TOOLING SPECIFICATION

FORM UP

STATION	1-1/4"	2"
MATERIAL	mild steel	
THICKNESS	.031" - .125"	
D MAX.	1.000"	1.526"
H MAX.	.197"	

FORM DOWN

STATION	1-1/4"	2"
MATERIAL	mild steel	
THICKNESS	.031" - .125"	
D MAX.	1.063"	2.000"
H MAX.	.197"	

CONDITIONS

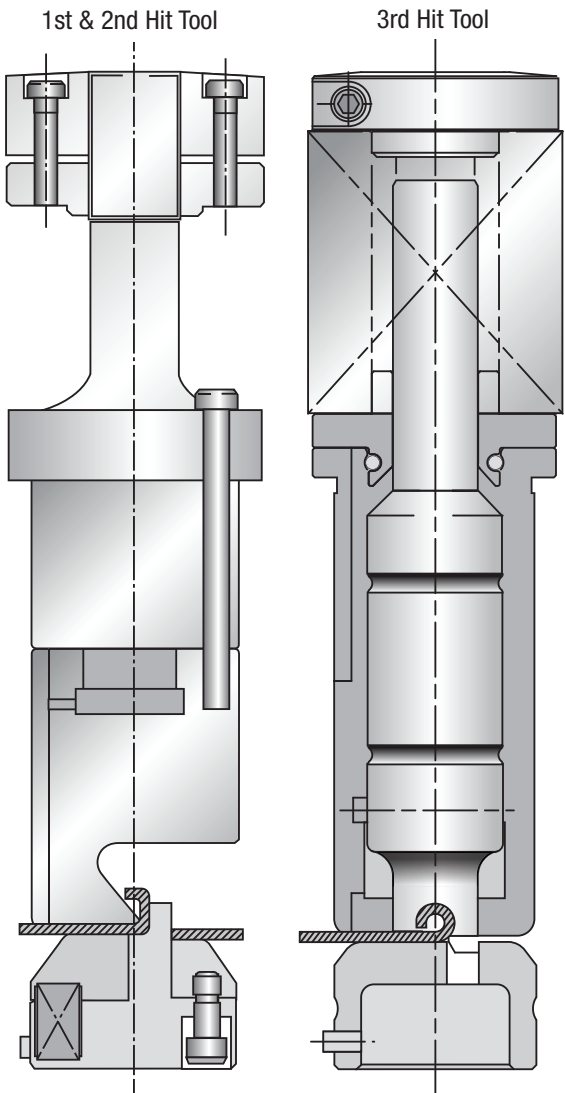
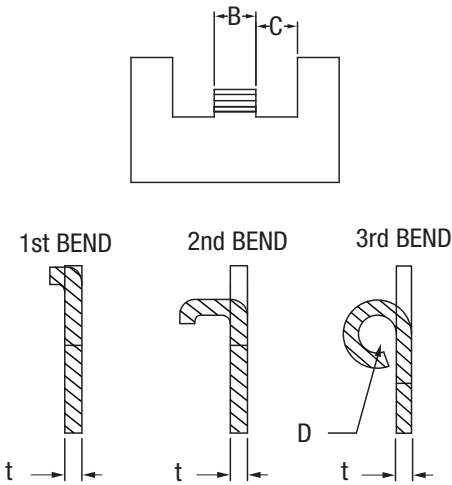
The conditions below must be met in order to use the tooling specification chart.

- 1) Material thickness $\leq D - (H \times 2.8)$
- 2) Material thickness $\leq H \times 1.4$

NOTES:

Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

All diagrams and pricing are for illustrating and estimating purposes only. Actual tool design may vary causing the price and/or lead time to change.



TOOLING SPECIFICATION

TOOL 1

STATION	1-1/4"
MATERIAL	mild steel
THICKNESS	.060"
D MAX.	.187"

TOOL 2

STATION	1-1/4"
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CONDITIONS

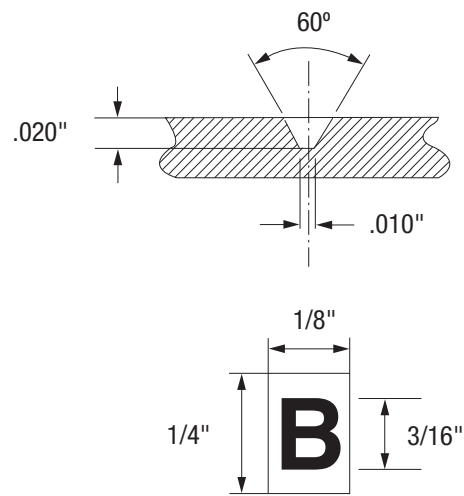
The conditions below must be met in order to use the tooling specification chart.

- MAX. Material "t" = .060"
- MAX. Length "B" = .875"
- C MIN. = .197"
- D MIN. = material thickness x 2

NOTES:

Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

All diagrams and pricing are for illustrating and estimating purposes only. Actual tool design may vary causing the price and/or lead time to change.



Standard chip and character size.

TOOLING SPECIFICATION

FORM DOWN

STATION	1-1/4"	2"	3-1/2"
ONE ROW OF	10	13	23
TWO ROWS OF	10	13	23
THREE ROWS OF	-	-	23

* Requires Guide Assembly.

FORM UP

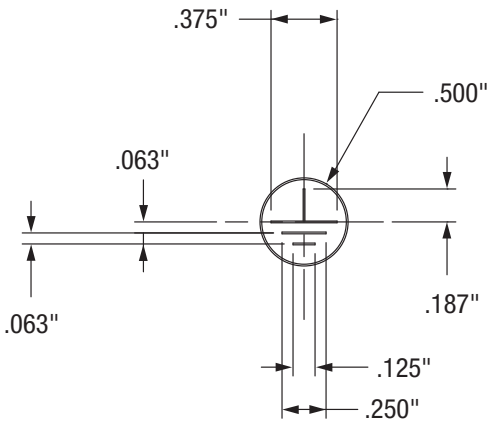
STATION	1-1/4"	2"	3-1/2"
ONE ROW OF	10	13	23
TWO ROWS OF	10	13	23
THREE ROWS OF	-	-	23

CODE#	CHIP	CODE#	CHIP	CODE#	CHIP
99001K	A	99014K	N	99040K	0
99002K	B	99040K	O	99041K	1
99003K	C	99016K	P	99042K	2
99004K	D	99017K	Q	99043K	3
99005K	E	99018K	R	99044K	4
99006K	F	99019K	S	99045K	5
99007K	G	99020K	T	99046K	6
99008K	H	99021K	U	99047K	7
99009K	I	99022K	V	99048K	8
99010K	J	99023K	W	99049K	9
99011K	K	99024K	X	99027K	() BLANK
99012K	L	99025K	Y	99028K	(-) DASH
99013K	M	99026K	Z	99029K	/
				99030K	&
				99031K	(.) PERIOD

Range of material thickness to be marked must be specified when placing an order.

NOTES:
Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

All diagrams and pricing are for illustrating and estimating purposes only. Actual tool design may vary causing the price and/or lead time to change.



GROUND SYMBOL MARKING TOOL W/ CIRCLE

FORM UP

STATION	1-1/4"
MATERIAL	mild steel
THICKNESS	.031" - .125"

FORM DOWN

STATION	1/2"	1-1/4"
MATERIAL	mild steel	
THICKNESS	.031" - .125"	

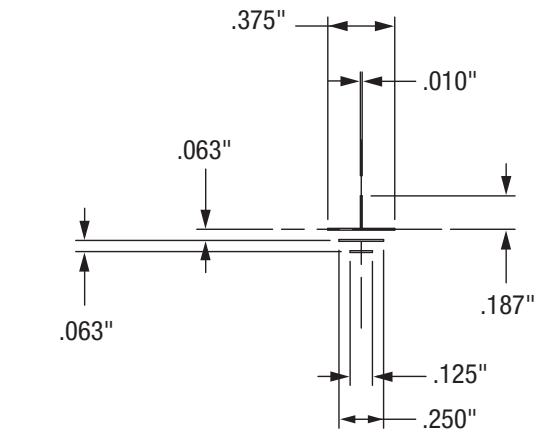
GROUND SYMBOL MARKING TOOL W/O CIRCLE

FORM UP

STATION	1-1/4"
MATERIAL	mild steel
THICKNESS	.031" - .125"

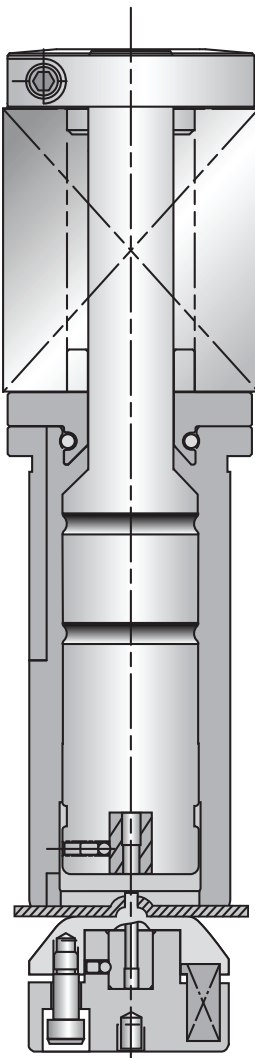
FORM DOWN

STATION	1/2"	1-1/4"
MATERIAL	mild steel	
THICKNESS	.031" - .125"	



NOTES:
Standard size based on 1/2" diameter circle. Other sizes available upon request. Maximum coining depth is .020". Machine type must be specified.

All diagrams and pricing are for illustrating and estimating purposes only. Actual tool design may vary causing the price and/or lead time to change.



TOOLING SPECIFICATION

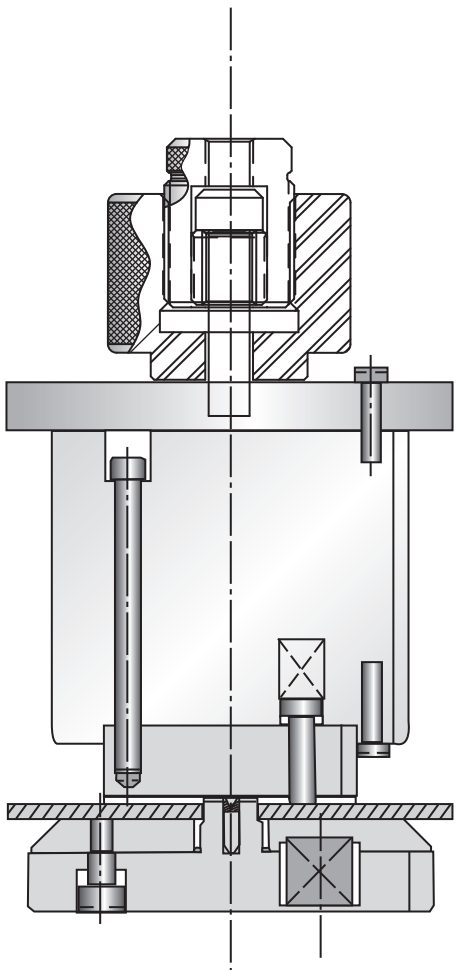
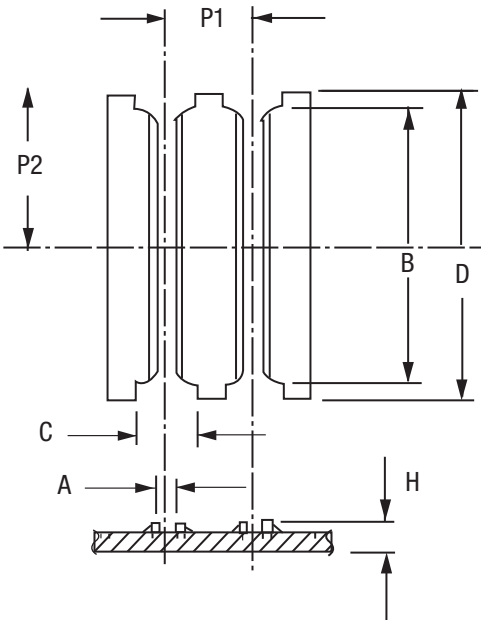
STATION	1-1/4"
MATERIAL	mild steel

THREAD SIZE	MATERIAL THICKNESS
TYPE "A" SCREWS	
6 – 18	.020" – .030"
8 – 15	.025" – .040"
10 – 12	.030" – .045"
12 – 11	.035" – .054"
14 – 10	.038" – .060"
20 – 9	.050" – .060"
TYPE "B" AND "AB" SCREWS	
6 – 20	.020" – .030"
8 – 18	.020" – .030"
10 – 16	.020" – .030"
12 – 14	.030" – .040"
1/4 – 14	.030" – .040"
5/16 – 12	.030" – .040"
TYPE "C" SCREWS (MACHINE SCREWS)	
6 – 32	.010" – .020"
8 – 32	.010" – .020"
10 – 24	.015" – .025"
10 – 32	.010" – .020"
1/4 – 20	.020" – .030"
5/16 – 18	.020" – .030"

Amada recommends two additional tools for use with a Tinnerman Nut Tool.

- 1) Special shape pre-hole tool
- 2) Countersink tool (not always required)

All diagrams and pricing are for illustrating and estimating purposes only.
Actual tool design may vary causing the price and/or lead time to change.

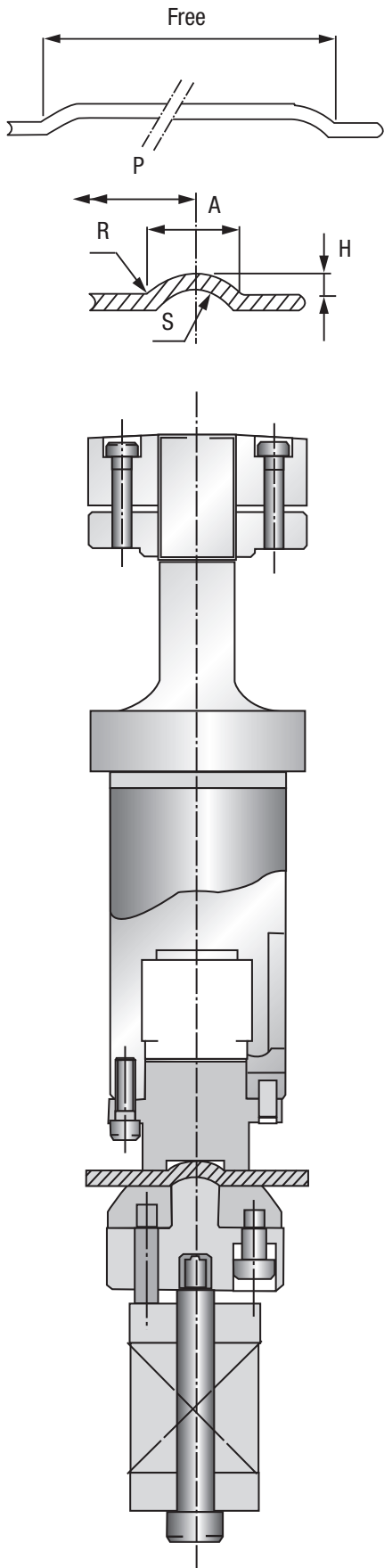


TOOLING SPECIFICATION

STATION	2"	3-1/2"	4-1/2"
MATERIAL	mild steel		
B MAX.	1.760"	3.200"	4.200"
H MAX.	.197"		
A MIN.	material thickness		

NOTES:
Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

All diagrams and pricing are for illustrating and estimating purposes only.
Actual tool design may vary causing the price and/or lead time to change.



TOOLING SPECIFICATION

STATION	1-1/4"	2"	3-1/2"	4-1/2"
MATERIAL	mild steel			
THICKNESS	.031" - .125"			
A MAX.	.480"	1.102"	1.181"	2.559"
H MAX.	.236"	.256"		
P MIN.*	.400" + A			
R	Amada will use the smallest radius that meets conditions.			

* This dimension MUST be specified when placing an order.

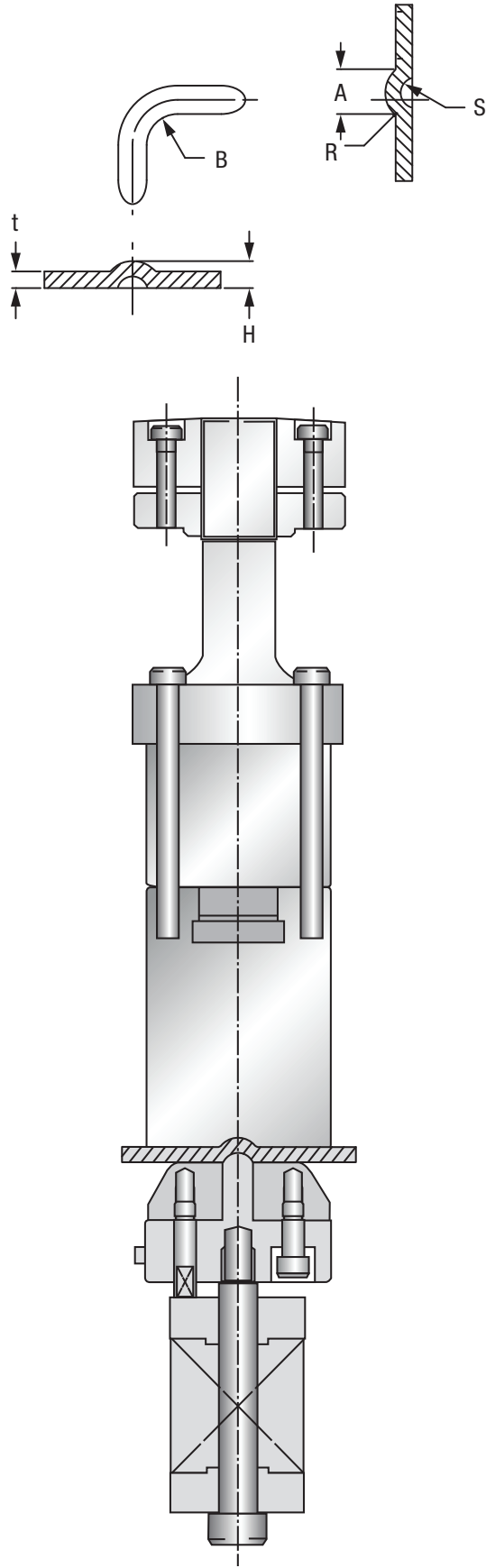
CONDITIONS

The conditions below must be met in order to use the tooling specification chart.

1) $H \leq A \times 0.4$
2) $H \leq \text{thickness} \times 3$
3) $S \geq H$

NOTES:
Tools with heavy duty die spring assemblies cannot be used in an Octo machine.

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Actual tool design may vary causing the price and/or lead time to change.



TOOLING SPECIFICATION

STATION	1-1/4"	
A MAX.	0.480"	
t MAX.	CRS & AL	0.060"
	SS	0.047"
H MAX.	0.197"	
B MIN.	0.591"	
Form Feed Pitch	0.039"	

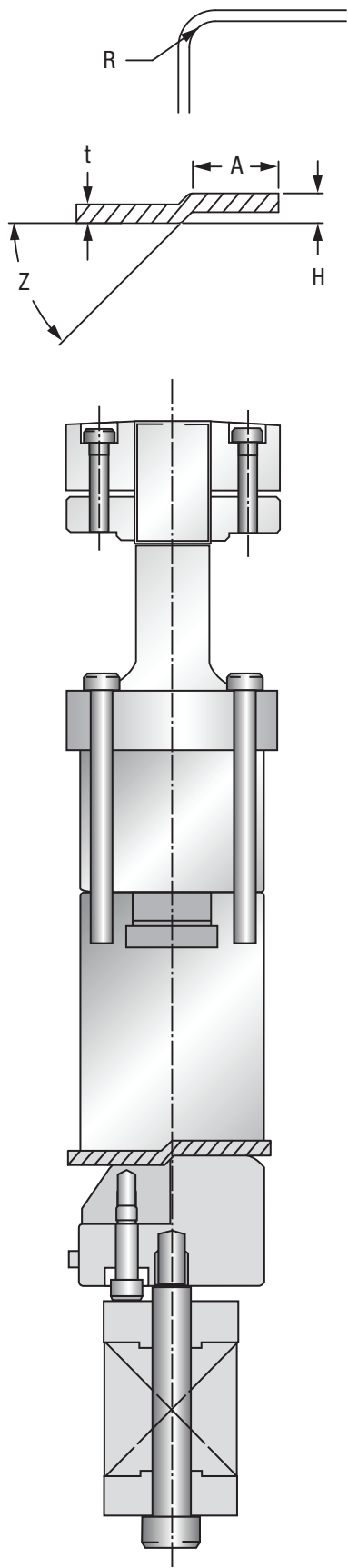
CONDITIONS

The conditions below must be met in order to use the tooling specification chart.

1) $H \leq A \times 0.3$
2) $H \leq \text{thickness} \times 3$
3) $R = H$

NOTES:
This tool will have an external spring pack. It will not fit an Octo machine.

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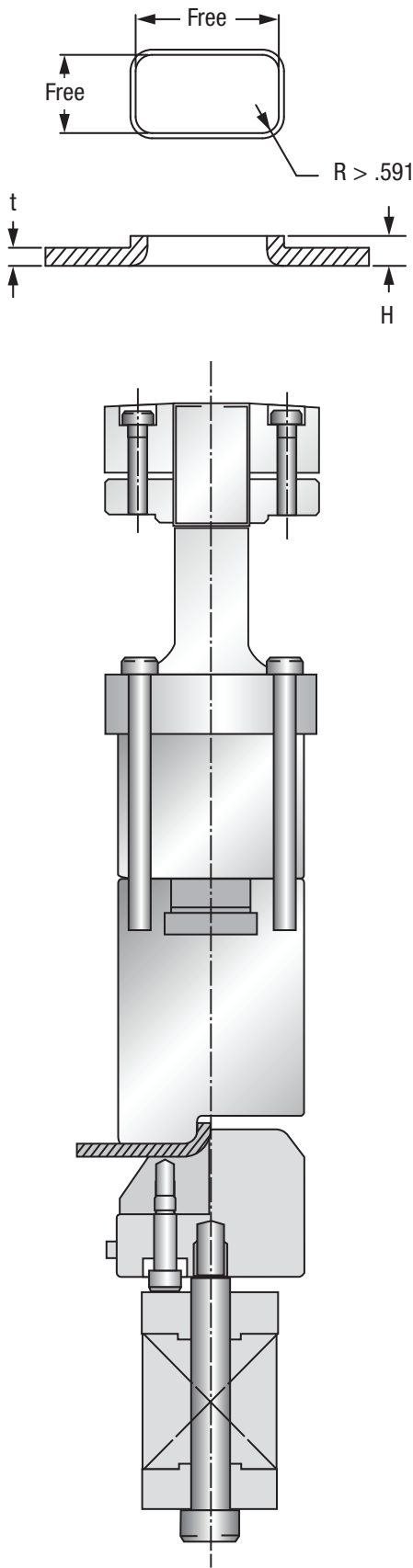
TOOLING SPECIFICATION

STATION	1-1/4"	
A MAXIMUM	0.591"	
t MAX.	CRS & AL	0.060"
	SS	0.047"
H MAX.	0.197"	
Z MAX.	60°	
	90° when offset = material thickness	
R MIN.	0.591"	
Form Feed Pitch	0.039"	

CONDITIONS

NOTES:
This tool will have an external spring pack. It will not fit an Octo machine.

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Actual tool design may vary causing the price and/or lead time to change.



TOOLING SPECIFICATION

STATION	1-1/4"	
t MAX.	CRS & AL	0.060"
	SS	0.047"
H MAX.	0.197"	
R MIN.	0.591"	
Form Feed Pitch	0.039"	

CONDITIONS

NOTES:
This tool will have an external spring pack. It will not fit an Octo machine.

All diagrams and pricing are for illustrating and estimating purposes only.
Actual tool design may vary causing the price and/or lead time to change.

TERMS AND CONDITIONS

CREDIT/PAYMENT

All purchases are C.O.D. unless credit approved. If account is past due, Amada America, Inc. reserves the right to hold shipment or require C.O.D. terms. Credit/Payment terms are Net 30 days from the date of invoice. Past due accounts are subject to interest charges. Early payment or cash discounts will not be accepted.

ORDERS

Minimum of \$25.00. Please write your Amada America, Inc. customer account number on all purchase orders to expedite processing. Also, please specify machine model, material type, and thickness.

F.O.B.

All orders are F.O.B. Batavia N.Y. (unless otherwise specified).

SPECIAL ORDERS

Special orders can NOT be cancelled, returned, or refunded

RETURNED MATERIAL

Returns are only accepted with prior approval from Amada America, Inc.'s Tooling Department Manager. There will be a 25% re-stocking fee on all standard items. All items must be returned unused and with freight prepaid. Returns will not be accepted after 30 days from the original shipment date.

DELIVERY

Delivery on special items will be established at time of order.

PURCHASE ORDER NUMBER

Purchase order number must accompany all telephone orders. Verbal orders will not be processed without a purchase order number.

DAMAGE OR SHORTAGE CLAIMS

All claims must be made within ten calendar days of receipt of tooling.

PRICING

All prices in this catalog are subject to change without notice. All prices provided by Amada America, Inc. in the form of a written quotation are valid for thirty days following the date of the quote.

NOTES