

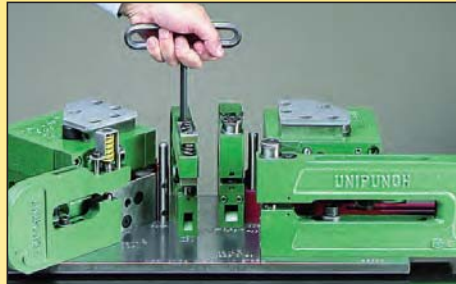
Turn your press brake or punch press into a hole punching profit center.

UniPunch Modular Tooling

- ✓ Works with existing presses
- ✓ Multiple holes and notches with one stroke
- ✓ Short lead time for ordering
- ✓ Fast changeover at the press
- ✓ Perfect for recurring jobs
- ✓ Low investment
- ✓ Precision held tolerances
- ✓ Reusable for different parts



Start with our tooling.



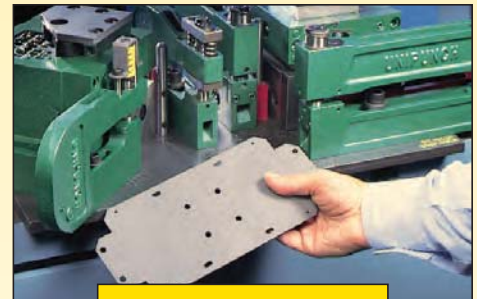
Mount it.



Install it in your press or stand alone system.



Punch it.

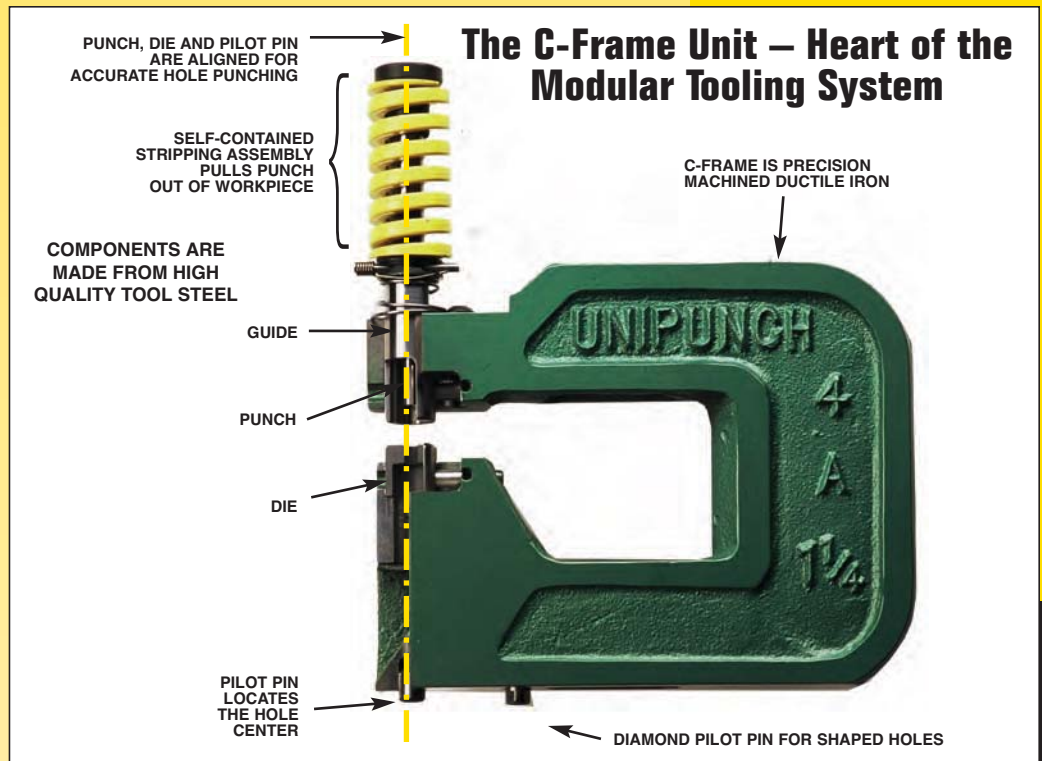


Profit.

Use UniPunch Modular Tooling for multiple holes with each stroke of the press.

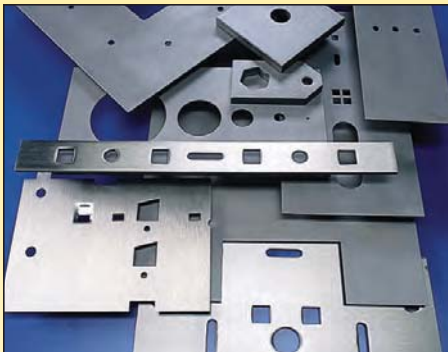
The UniPunch System

- Dependable tooling for today's short run, quick changeover environment
- Combinations of tooling and gauging accessories are easily set up
- Punch or notch material up to 3/4" thick



MOUNTING

UniPunch Modular Tooling: the solution for a variety of applications



Hole Punching & Notching Flat Parts



Aluminum Extrusions



Brake Formed / Roll Formed Parts



Angles, Channels & Structural Parts



Tube Punching – Round or Square Tubing



Other Parts

Ph: (800) 828-7061 • (715) 263-3900 • Email: info@unipunch.com • Web: www.unipunch.com

Mounting Methods

Match the method to your press and shop requirements

UniPunch provides several methods for mounting modular tooling in your press, press brake or single station system. The method you select will depend on your shop environment.

Using dedicated setups, the UniPunch system is perfectly aligned with lean manufacturing with fast changeover at the press for producing small (and/or large) lots quickly each time you need that part.

Straight Line Punching

Press Brakes Only



BED RAIL / STRIP TEMPLATE UNDER UNIT METHOD

- For straight line punching
- For the edge of sheets, angle iron and extrusions

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Fast Changeover from part to part



For Presses & Press Brakes

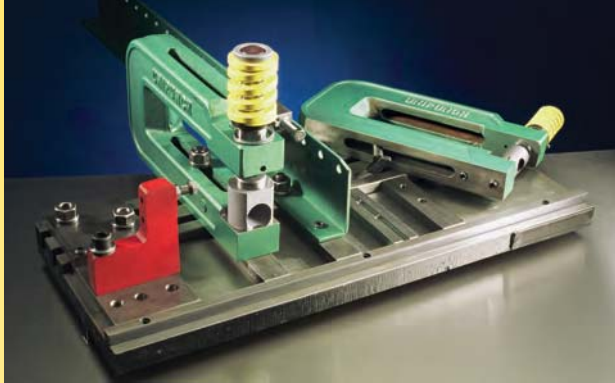
MOUNTING TEMPLATE METHOD

- Most popular method for all material thicknesses
- Makes identical parts consistently
- Allows units to be mounted outside the press for faster set up and tooling changeover
- Keyed, non-keyed and dovetail style templates are available

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Creating Prototypes

Press Brakes
Only



BED RAIL / UNISPACER METHOD

- For prototypes or short runs
- Straight line punching applications
- Unispacers are easily adjusted to accommodate varying hole patterns and part lengths

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All - Purpose

For Presses &
Press Brakes

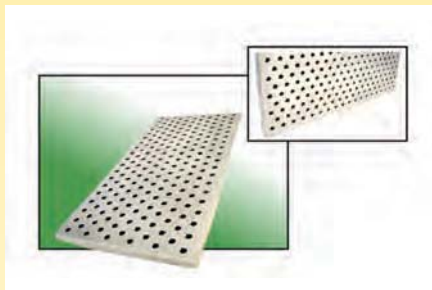
UniPunch can also provide the following equipment to accommodate your press type and mounting method.



T-SLOTTED PLATES

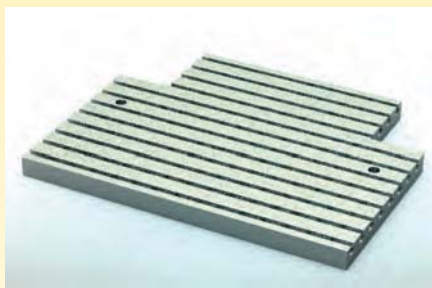
in standard widths from 12" to 30"

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**UNIVERSAL BASE PLATES with a uniform
pattern of 1/2"-13 tapped holes**

Page 14



**CUSTOM BED RAILS AND T-SLOTTED PLATES
manufactured to your specifications**

Contact the UniPunch Sales Department

Note: For further information on press mounting and gauging methods,
contact the UniPunch Sales Department or visit our website at www.unipunch.com

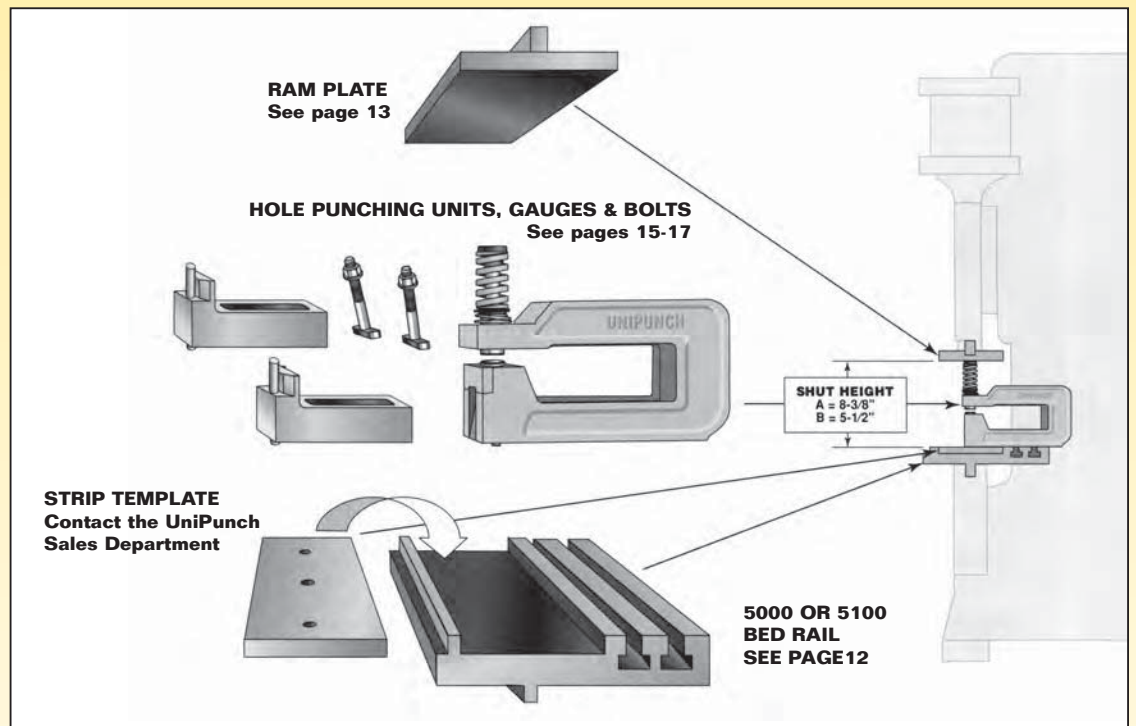
Straight Line Punching In Press Brakes

The Strip Template in a Bed Rail is a solution for locating units for punching many holes in a row in flat metal, extrusions and structural shapes. A Strip Template measures $\frac{1}{2}$ " x $4\frac{1}{2}$ " and is long enough for your part. This fits into the recess in the Bed Rail. Hole-to-hole accuracy is maintained by the precision machined Strip Template. The pilot pin in the base of each unit assures accurate positioning of the holes in the part to be punched.

Note: To achieve straight line punching and fast changeover at your press brake, use a dedicated setup on a keyed template. **See page 9**
To achieve straight line punching and prototyping, consider using Unispacers. **See page 10**

BED RAIL / STRIP TEMPLATE UNDER UNIT METHOD

- For straight line punching the edge of sheets, angle iron and extrusions.
- Strip Template, $\frac{1}{2}$ " (12.7mm) x $4\frac{1}{2}$ " (114.3mm) x specific length, fits into bed rail recess.
- The pilot pin in the base of each unit assures accurate positioning of holes in the part to be punched.
- Part print tolerance accuracy expected is **.005" (.13mm)**.



MOUNTING

Faster Changeover from part to part Presses & Press Brakes

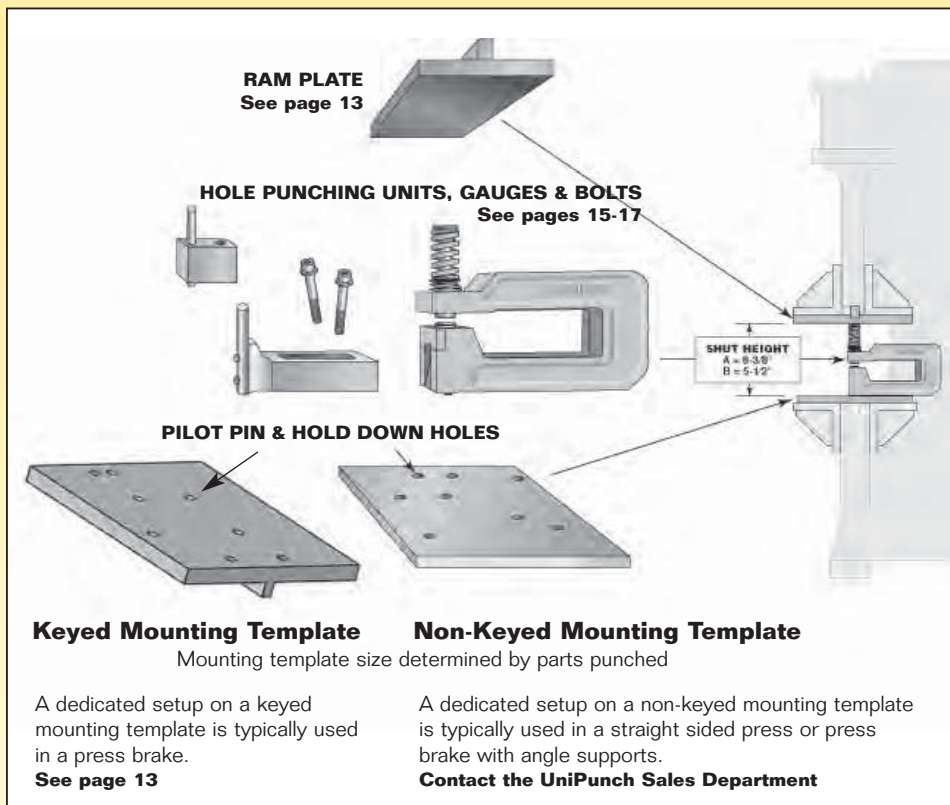
Dedicated setups are ready when you are. A dedicated setup is a combination of UniPunch press tooling assigned to a specific part, pre-assembled onto a template and ready for quick installation into a press. The UniPunch tooling is assigned to the part for the life of the part. If the part is no longer required, the tooling can be disassembled and rededicated in a new setup for a different part.



DEDICATED TEMPLATE METHOD

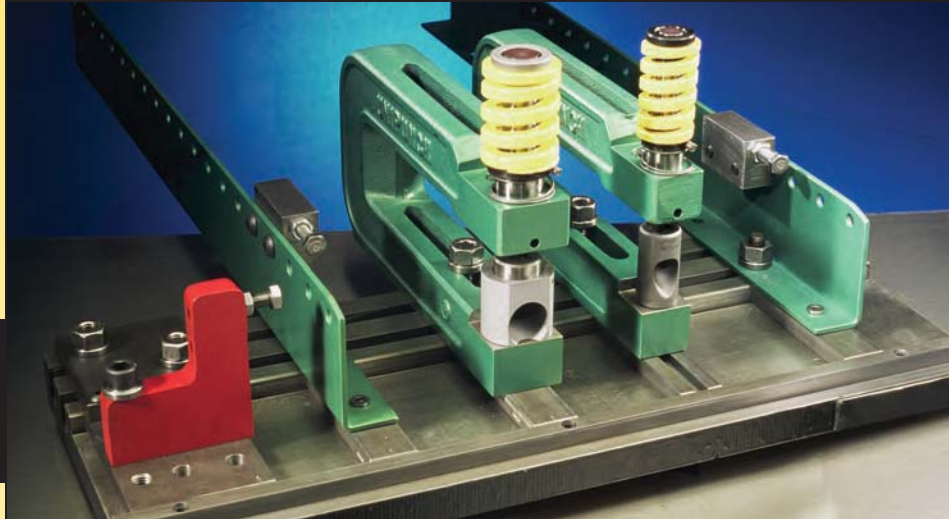
- The most popular method for all material thicknesses.
- Make identical parts consistently.
- Allows units to be mounted outside the press for fast changeover at the press.

MOUNTING



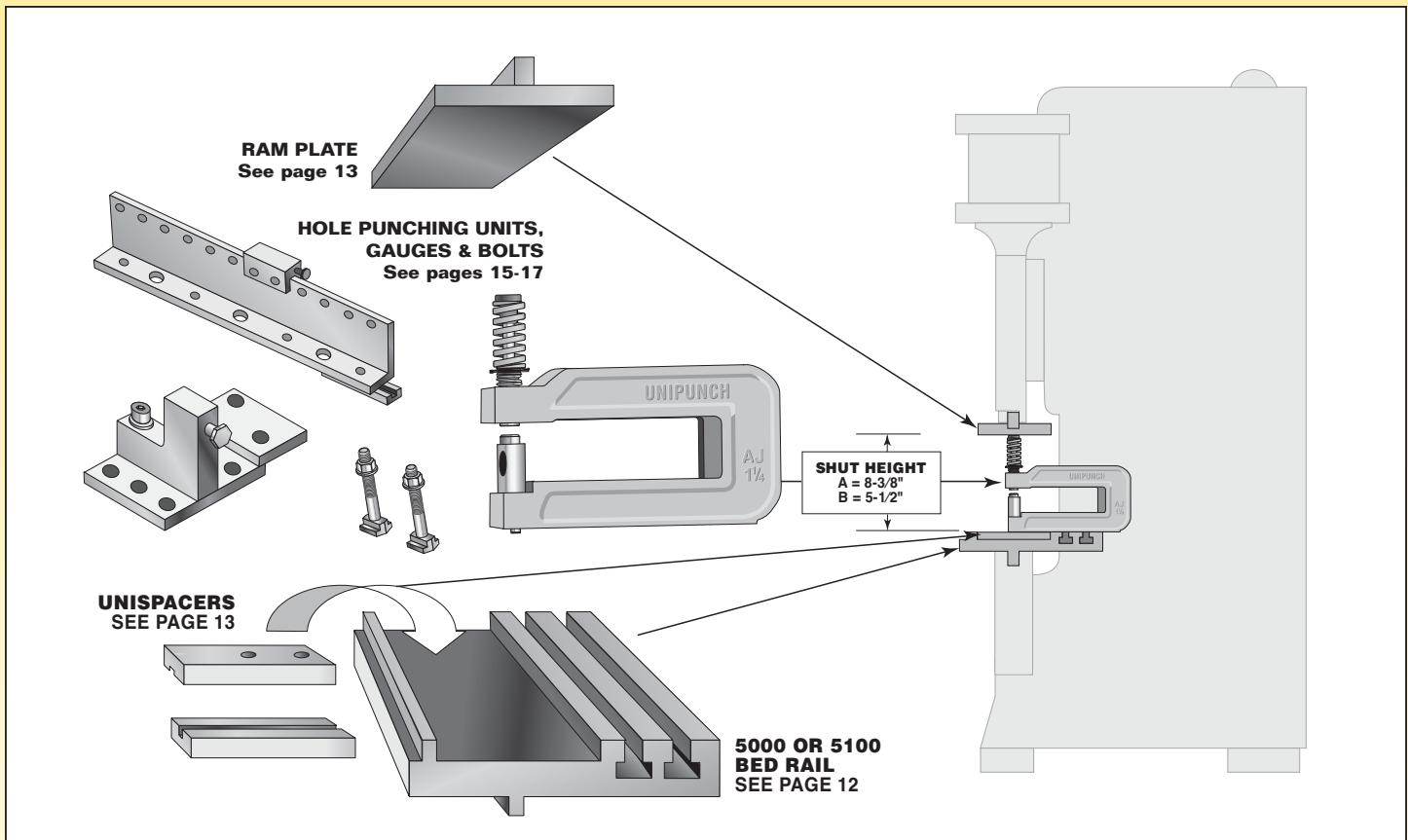
Creating Prototypes In Press Brakes

Unispacers fit into the recess in the Bed Rail and permit straight line punching of prototypes in flat metal, extrusions and structural shapes. If the preliminary hole locations change, Unispacers offer a quick and easy method to relocate the holes... simply reposition the Unispacers on the Bed Rail. For a staggered line of holes, use the slotted side of the Unispacer.



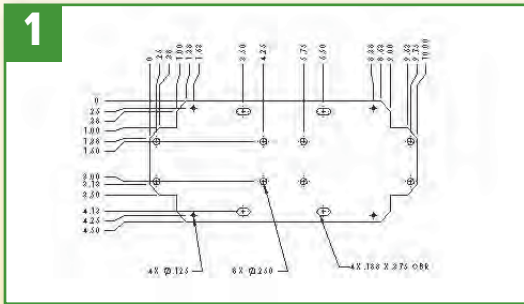
BED RAIL / UNISPACER METHOD

- For prototype or short run straight line punching applications with varying part lengths.
- Quick and easy set up and relocation of holes makes this a preferred mounting method.
- Unispacer fits into Bed Rail recess.
- Unispacer has two .376" diameter holes on one side to accept unit pilot pins and .376" slot on opposite side for unit front to back adjustment.



Mounting: The Basic Steps

It's easy to start using UniPunch tooling. This overview demonstrates using the UniPunch modular system in a dedicated setup. Here's how...



1 Start by sending us a drawing or sample part.



2 Based on your requirements, UniPunch will recommend appropriate tooling and gauging.



3 Once an order is placed, UniPunch will provide a layout drawing for your approval.



4 With your approval, UniPunch will manufacture the mounting template to precisely locate the holes according to your specifications.



5 UniPunch will ship the appropriate tooling along with the template.



6 When you receive the tooling you will assemble the units on the template using the provided layout drawing.



7 Depending on the application, material can be hand fed (as shown) or fed off a coil.



8 You can punch and notch multiple holes with each stroke of the press.



9 The tooling in the dedicated setup is assigned to the part for the life of the part. Here it is shown stored on a shelf, ready for the next time that part is required.

If the part is no longer required, the modular tooling can be disassembled and remounted on a new template for a different part.