NO. 1000 SERIES SINGLE TUBE & PIPE NOTCHING UNITS

#1000 STD. HOUSING TO ACCEPT PUNCH AND DIE ASSEMBLIES UP TO AND INCLUDING 2\(\frac{1}{8}\)" OUTSIDE DIMENSIONS

FOR PRODUCING 90° OR T-JOINTS USED IN POWER OR #8000 HAND PRESS SEPARATE PUNCH AND DIE REQUIRED FOR EACH OUTSIDE DIMENSION

APPROX. SHIPPING WEIGHT 15 LBS.

APPROX. SHIPPING WEIGHT 9 LBS.

CLEVELAND STEEL TOOL

APPROX. SHIPPING WEIGHT 6 LBS.

EDWARDS

Std. Single Notch Unit to notch 1\(\frac{1}{8}\)" - 40 pipe fully assembled

FOR A SMALL SURCHARGE WE OFFER THE FOLLOWING BASE PLATES AS STOCK ITEMS

HYDRAULIC MACHINE INC.

CLAUSING METAL MUNCHER

KINGSLAND

MUBEA

PIRANHA

SCOTCHMAN

SPARTAN

PEDDINGHAUS

UNI HYDRO
NO. 1000 H.D. SINGLE TUBE & PIPE NOTCHING UNITS

TOOLING TO NOTCH .187x2¼" LONG SLOT INTO 1"x2"x .087 RECTANGULAR TUBING

NO. 1000 H.D. HOUSING FOR APPLICATIONS EXCEEDING 8 TONS

TOOLING TO CUT SLOT .700 WIDE x 2.250 DEEP INTO 1½"-40 PIPE

APPROX. SHIPPING WEIGHT 13 LBS.

NO. 1000-1 SINGLE TUBE & PIPE NOTCHING UNITS

#1000-1 STD. HOUSING

NO. 1000-1 HOUSING WILL ACCEPT TOOLING FROM 2½" TO 3½" OUTSIDE DIM.

1130-1 TOOLING TO NOTCH 3"

SCHEDULE 40 PIPE MOUNTED IN 1000-1 STD. HOUSING

APPROX. SHIPPING WEIGHT 24 LBS.

TOOLING TO NOTCH 4 EQUALLY SPACED SLOTS 1"x2½" LONG. INDEXING NOT SHOWN

TOOLING MOUNTED IN MODIFIED 1000-1 HOUSING TO CUT OF STRIP-STOCK ¾"x1" AT 7° ANGLE

TOOLING MOUNTED IN MODIFIED 1000-1 HOUSING TO RADIUS .250x3" ALU. STOCK

APPROX. SHIPPING WEIGHT 12 LBS.

SLUG-FREE CUT-OFF DIES
NO. 1000-2 SINGLE TUBE & PIPE NOTCHING UNITS
FOR MAKING 90° OR T-JOINTS FOR USE IN POWER PRESS ONLY

PUNCH AND DIE ASSEMBLY FOR 4” PIPE SCHED 40.
TOOLING FOR 4” PIPE SCHED. 40 MOUNTED IN NO. 1000-2 STD. HOUSING.
1000-2 STANDARD HOUSING TO ACCEPT PUNCH AND DIE ASSEMBLIES FROM 3¾” O.D. TO 4½” O.D.

APPROX. SHIPPING WEIGHT 42 LBS.
APPROX. SHIPPING WEIGHT 100 LBS.
APPROX. SHIPPING WEIGHT 55 LBS.

#1000-3 NOTCH UNITS
4½” SCH. 40 PIPE MOUNTED IN 1000-3 STD. HOUSING
SPECIAL TOOLING MOUNTED IN 1000-3 MODIFIED HOUSING TO NOTCH 2” DEEP X 4” WIDE OPENING AT END OF ALU. EXTRUSION

1000-4 NOTCH UNITS
6” SCH. 40 PIPE MOUNTED IN 1000-4.
STD. HOUSING FOR DIM. COMPARISON 1½” SCH. 40 IN FRONT

NOTCHING IS AN ACCURATE AND ECONOMICAL WAY FOR THE FAST AND SPEEDY END PREPARATION OF TUBING OR PIPE.
NOTCHES WILL BE VIRTUALLY DISTORTION FREE (IDEAL FOR SILVER SOLDERING OR BRAZING.)
PUNCH WILL NOTCH FROM INSIDE OUT. TUBING OR PIPE WILL BE SUPPORTED BY ACCURATELY CONTOURED DIE-SECTIONS.

FOR FIRST CUT SLIP TUBING OR PIPE OVER PUNCH, THEN CYCLE PRESS. FOR SECOND CUT ROTATE TUBING OR PIPE 180°. LINE UP FIRST CUT WITH PUNCH AND OUTSIDE CONTOUR WITH DIE-SECTION, THEN RECYLE PRESS. NO EXTRA FINISHING WILL BE REQUIRED.

BACK TO BACK HOUSING TO ACCOMODATE TWO PUNCH DIE ASSEMBLIES OF SAME OR DIFFERENT DIM. P.O.R.
TRIPLE HOUSING TO ACCOMODATE THREE PUNCH & DIE ASSEMBLIES OF SAME OR DIFFERENT DIM. P.O.R.
NO. 1300 FLATTEN AND TRIM DIE
FOR SQUARE TUBING
FLATTEN TO CREATE SPEAR POINT
PLEASE CALL WITH TUBE DIMENSION

NO. 1350 FLATTEN TRIM AND PIERCE DIE
FOR ROUND TUBING
PLEASE CALL FOR QUOTATION

NO. 1400 SERIES V-NOTCH DIES FOR FLAT STOCK

- **NO. 1400-2**
  - MAX. DEPTH OF CUT 2"
  - MAX. MATERIAL THICKNESS .187
  - APPROX. SHIP. WEIGHT 32 LBS.

- **NO. 1400-1**
  - MAX. DEPTH OF CUT 1"
  - MAX. MAT. THICKNESS .187
  - APPROX. SHIPPING WEIGHT 15 LBS.

- **NO. 1400-3**
  - MAX. DEPTH OF CUT 3"
  - MAX. MAT. THICKNESS .125
  - APPROX. SHIPPING WEIGHT 63 LBS.

LARGER SIZES AND DIFFERENT ANGLES QUOTED ON REQUEST

NO. 1500 ANGLE NOTCH UNIT
FOR USE IN POWER PRESS

- **NO. 1515**
  - TOOLING FOR 1 1/4" SCHEDULE
  - 40 MOUNTED INTO NO. 1500 STANDARD HOUSING
  - APPROX. SHIPPING WEIGHT 62 LBS.

- **NO. 1500**
  - ANGLE NOTCH UNITS HAVE BEEN DESIGNED TO PRODUCE ACCURATE TRUE CONTORED NOTCHES ON TUBING OR PIPE. THE NOTCH IS IDEALLY SUITABLE FOR WELDING, BRAZING OR SILVER SOLDERING.
  - EACH UNIT CONSISTS OF TWO PUNCH AND DIE ASSEMBLIES REQUIRING TWO OPERATIONS TO COMPLETE PART. TWO PARTS HOWEVER CAN BE INSERTED IN TOOLING TO FINISH ONE PART PER PRESS CYCLE.
  - IN FIRST STATION TUBING OR PIPE IS INSERTED TO PRODUCE A DEEP CUT WITH RADIUSED OR ELIPTICAL END. IN SECOND STATION TUBING OR PIPE WILL BE INSERTED AT THE REQUIRED ANGLE AND FIRST NOTCH LINED UP WITH PUNCH OF SECOND OPERATION. PUNCH THEN WILL SHAPE TWO SIDE WALLS ON DOWNSTROKE PLUS CUT BOTTOM SIDE OF TUBING OR PIPE IF REQUIRED.
  - APPROX. SHIPPING WEIGHT 35 LBS.

- **NO. 1515 DOUBLE HOUSING TO ACCEPT**
  - PUNCH & DIE ASSEMBLIES UP TO 1.900 O.D.
  - APPROX. SHIP. WEIGHT 75 LBS.

- **NO. 1515 ANGLE NOTCH TOOLING TO NOTCH 1 1/4" SCHED. 40 PIPE AT 35° STAIRRAIL CONFIGURATION**
  - APPROX. SHIPPING WEIGHT 62 LBS.
NO. 1550 ANGLE NOTCH TOOLING
FOR USE IN POWER PRESS. 3 PRESS CYCLES REQUIRED

NO. 1550 DOUBLE HOUSING TO ACCEPT PUNCH AND DIE ASSEMBLIES TO 1.900 O.D. MAX.

SUITABLE FOR LONG SECTIONS OF TUBING OR PIPE. 3 HITS REQUIRED TO COMPLETE OPERATION. SEPARATE PUNCH AND DIE ASSEMBLIES REQUIRED FOR EACH O.D. AND ANGLE

NO. 1565 TOOLING FOR 1½”-SCH. 40 MOUNTED IN NO. 1550 DOUBLE HOUSING

NO. 1565 PUNCH & DIE ASSEMBLIES TO NOTCH 1½” SCH. 40 PIPE AT 35°

APPROX. SHIPPING WEIGHT 32 LBS.

APPROX. SHIPPING WEIGHT 59 LBS.

NO. 1500 & NO. 1550 SPECIAL APPLICATIONS

TOOLING TO PRODUCE HUB MANUFACTURED FROM SCHEDULE 80 STAINLESS

2-3 PRESS CYCLES ARE REQUIRED IN MOST CASES. HOWEVER USING OUTRIGGERS TO LOCATE PART, ONE COMPLETED PART CAN, IN MOST INSTANCES, BE OBTAINED PER PRESS CYCLE

TOOLING TO PRODUCE KNIFE EDGE ON 1½” SCHEDULE 40 STAINLESS STEEL

TOOLING TO PRODUCE PART AS SHOWN. 4 PRESS CYCLES ARE REQUIRED

TOOLING TO REMOVE HALF OF 4”x4”x.125 SQUARE TUBING 2½” DEEP

PAGE 6
NO. 1800 VEE-NOTCH DIE

NO. 1810 FOR 1.00 X 1.00 SQUARE TUBING FRONT LOAD UNIT
FOR SQUARE OR RECTANGULAR TUBING. LIGHT DISTORTION ON SIDE OF ENTRY. DIFFERENT INSERTS FOR EACH SIZE AND ANGLE
NO. 1807 FOR 3/4" x 3/4" SQUARE TUBING. FRONT LOAD UNIT.

TOOLING LINED UP TO MANUFACTURE FRAME USING 3/8" x 3/8" x .065 SQUARE TUBING
STROKE REQUIREMENT FOR FRONT LOAD UNIT MATERIAL - DIM X3

APPROX. SHIPPING WEIGHT 56 LBS.
APPROX. SHIPPING WEIGHT 38 LBS.

NO. 2000 DOUBLE NOTCH UNITS

DOUBLE NOTCH DIES CUT BOTH SIDES OF TUBING WITH SINGLE STROKE OF PRESS ASSURING ACCURACY WITH MINIMUM BURR AND DISTORTION. DIFFERENT INSERTS REQUIRED FOR EACH O.D. OR DIFFERENT FIT-UPS

SPECIAL APPLICATION. PLEASE CALL FOR FREE ESTIMATE

STROKE REQUIREMENT 2"-3"
PRESS REQUIREMENTS 10-15 TONS

APPROX. SHIPPING WEIGHT 52 LBS.

No. 2000 INSERTS FOR 1¼" O.D. x .049 WALL

2 OPERATIONS REQUIRED TO FINISH PART ILLUSTRATED ON BOTTOM. 1ST OPERATION NOTCHES OUT SLOT .600 WIDE X .800 DEEP ON BOTH SIDES OF PUNCH PRESS PRODUCED PART. WITH CHANGEOVER OF TOOLING .090 BY 1.450 TOTAL LENGTH SLOT PART IS COMPLETED.

APPROX. SHIPPING WEIGHT 12 LBS.
NO. 2000 DOUBLE NOTCH DIE

DOUBLE UNIT TO NOTCH BOTH SIDES 1.000 WIDE BY 1.000 DEEP WITH ONE PRESS CYCLE

SPECIAL APPLICATIONS PLEASE CALL FOR FREE ESTIMATE

DOUBLE UNIT TO NOTCH TWO SLOTS 5MM WIDE X 6.1MM DEEP. 180° OPPOSED IN ONE PRESS CYCLE

NO. 3000 CUT OFF DIE FOR SQUARE TUBING

FOR USE IN POWER PRESS

MAX. CAPACITY 2 1/2”

16.00”
10.00”

SHIPPING WEIGHT APPR. 150 LBS

MAX. CAPACITY 1 1/2”

8.00”
8.00”

SHIPPING WEIGHT APPR. 55 LBS

STROKE REQUIREMENT TUBING TO BE CUT x 1.5”
No. 4000 SWAGING DIE
FOR USE IN POWER PRESS
CALL FOR FREE ESTIMATE

No. 4500 ANGULAR TUBE CUT OFF DIE

ONE SET OF INSERTS and BLADES INCLUDED WITH EACH DIE

AVAILABLE WITH HORIZONTAL CROSS CUT
ROUND TUBING ONLY - 60° MAX.
DETAILS ON REQUEST

PLEASE CALL FOR DETAILS
NO. 5000 STD. TUBE CUT OFF DIE

FOR USE IN POWER PRESS,

Tube Cut Off Die cuts off tubing to required length, leaving ends clean with minimum burr or distortion.

ONE SET OF INSERTS and BLADES INCLUDED WITH EACH DIE

Set of inserts needed for each O.D.

<table>
<thead>
<tr>
<th>MAXIMUM CAPACITY</th>
<th>SHUT HEIGHT</th>
<th>STROKE</th>
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<tbody>
<tr>
<td>5000 - 1  1&quot; Round</td>
<td>1/2 x 1 1/4 Rectang.</td>
<td>7&quot;</td>
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<tr>
<td>5000 - 2  2&quot; Round</td>
<td>1 1/2 Square</td>
<td>3/4 x 2 Rectang.</td>
</tr>
<tr>
<td>5000 - 3  3&quot; Round</td>
<td>2&quot; Square</td>
<td>1 1/4 x 2 1/2 Rectang.</td>
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NO. 6000 STD. ECONO TUBE CUT OFF DIE

FOR USE IN POWER PRESS, 7" SHUT HEIGHT, 3" MINIMUM STROKE  35 TONS

Ends of tubing will be sheared square. Will give light distortion on top of thin wall round tubing (dimple effect).

ONE SET OF INSERTS and BLADES INCLUDED WITH EACH DIE

INSERTS:
Same as #5000 - 2 unit
PIERCING TOOLING, MANDREL TYPE

TOOLING TO PUNCH 18 SLOTS .375 x 1.125 ON 4" CENTERS INTO 3" ROUND 089 TUBING

To pierce square, round or rectangular tubing or pipe with minimum burr or distortion. 1 side only or 2 sides. 96" maximum length.

PRICE AND DETAILS QUOTED ON REQUEST
MULTIPLE HOLE PIERCING TO PIERCE 10 HOLES PER PRESS CYCLE

NO. 8000 PRO HAND PRESSES

PRESSES FOR SPECIAL APPLICATIONS QUOTED ON REQUEST

UNIT NOT INCLUDED SOLD SEPARATELY

Will accommodate our #1000 series housing notch up to 2” std. pipe or tubing to 2-1/2” O.D. will be shipped completely assembled HANDLE (1” PIPE) NOT INCLUDED

$3/8 \times 9”$ LONG SLOT PUNCHED INTO $1\frac{1}{4} \times 2” \times 120$ WALL RECTANGULAR TUBING.
2 PRESS CYCLES REQUIRED