



CATALOG 02/2015-WW-A.2

SYSTEM AMADA

CATALOG 02/2015-WW-A.2



SCOPE OF APPLICATION:

Deliveries and services provided by PASS Stanztechnik AG are effected exclusively according to PASS delivery and payment conditions. These conditions shall be deemed accepted at the latest upon receipt of the goods or services.

GENERAL REMARKS:

You can find our general terms and conditions on our Homepage under: www.pass-ag.com

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PASS STANDARD I STATION A

DIAMETER UP TO 12,7 MM



PUNCH BODY

Metric-thread M12 x 1,25

Punch body made with premium H-PM®
(higher hit counts)

Alignment pin for exact adjustment
(excludes round)



HEAD UNIT

Hexagon head screw
for simply assembling of
the punch assembly

Spring
for sheet thickness up to 6mm

2 mm length adjustment
by turning of the distance ring

PUNCH GUIDE

Surface-hardened and polished punch guide
for sheet thickness up to 6mm

Keyway:
Round: 0°
Square: 0-45°
Rect./ Oblong: 0-90-225°
asym. Shapes: 0-90-180-270°

Tool shape integrated in guide

PASS STANDARD I STATION A

DIAMETER UP TO 12,7 MM

PART.-NO.

COMPLETE PUNCH ASSEMBLY		
Round	4012A01	
Square	4012A02	
Rectangle	4012A03	
Oblong	4012A04	
*O.D. Ground Special Shapes	4012A0G	
* EDM Required Special Shapes	4012A0E	

HEAD UNIT (HEAD SCREW, SPRING, DISTANCE RING)		
for all shapes	4092A01	

PUNCH BODY (H-PM®)		
Round	4022A01	
Square	4022A02	
Rectangle	4022A03	
Oblong	4022A04	
*O.D. Ground Special Shapes	4022A0G	
* EDM Required Special Shapes	4022A0E	

PUNCH GUIDE		
Round	4032A01	
Square	4032A02	
Rectangle	4032A03	
Oblong	4032A04	
*O.D. Ground Special Shapes	4032A0G	
* EDM Required Special Shapes	4032A0E	

DIE (HWS)		
Round	4052A01	
Square	4052A02	
Rectangle	4052A03	
Oblong	4052A04	
*O.D. Ground Special Shapes	4052A0G	
* EDM Required Special Shapes	4052A0E	



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH	
Head screw	4092A31	TICN coating	
Spring	4092A11	T-MAX coating	
Distance ring	4092A21	WT-shear	
O-Ring (in punch guide)	4092A51	DOWT-shear	
PU-ejector Ø 3x6 (in punch)	4092P03	2 PT-shear	
PU-ejector Ø 6x10 (in punch)	4092P06	4 PT-shear	

COMPENSATING SHIMS FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE	
Piece (2 mm)	499A4S2	Additional keyway	

SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIE	
1x0,4 mm/1x0,8 mm/1x1,2 mm dick	499A1M1	Reinforced die	
Shimkeeper (0,5 mm)	499A1M95	H-PM® Quality	

PASS ALPHA I STATION A

DIAMETER UP TO 12,7 MM



HEAD UNIT

Canister
for sheet thickness up to 4mm

Continously and easy length adjustment in
assembled status



PUNCH BODY

Metric-thread M12 x 1,25

Punch body made with premium H-PM®
(higher hit counts)

Alignment pin for exact adjustment
(excludes round)



PUNCH GUIDE

Surface-hardened and polished punch guide
for sheet thickness up to 6mm

Keyway:
all shapes: 0 - 90°



STRIPPER

Interchangeable stripper plate

PASS ALPHA I STATION A

DIAMETER UP TO 12,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY		
Round	4013A01	
Square	4013A02	
Rectangle	4013A03	
Oblong	4013A04	
*O.D. Ground Special Shapes	4013A0G	
* EDM Required Special Shapes	4013A0E	

HEAD UNIT		
for all shapes	4093A01	

PUNCH BODY (H-PM®)		
Round	4023A01	
Square	4023A02	
Rectangle	4023A03	
Oblong	4023A04	
*O.D. Ground Special Shapes	4023A0G	
*EDM Required Special Shapes	4023A0E	

PUNCH GUIDE		
for all shapes	4033A05	

STRIPPER		
Round	4043A01	
Square	4043A02	
Rectangle	4043A03	
Oblong	4043A04	
*O.D. Ground Special Shapes	4043A0G	
*EDM Required Special Shapes	4043A0E	

DIE (HWS)		
Round	4052A01	
Square	4052A02	
Rectangle	4052A03	
Oblong	4052A04	
*O.D. Ground Special Shapes	4052A0G	
*EDM Required Special Shapes	4052A0E	



SPARE PARTS	ADDITIONAL COSTS FOR PUNCH	
O-Ring (in punch guide)	4092A51	TiCN coating
PU-ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU-ejector Ø 6x10 (in punch)	4092P06	WT-shear DOWT-shear 2 PT-shear 4 PT-shear

COMPENSATING SHIMS FOR PUNCH	ADDITIONAL COSTS FOR PUNCH GUIDE	
Not necessary	Additional keyway	

SET OF COMPENSATING SHIMS FOR DIE	ADDITIONAL COSTS FOR DIE	
1x0,4 mm/1x0,8 mm/1x1,2 mm	499A1M1	Reinforced die
Shimkeeper (0,5 mm)	499A1M95	H-PM® Quality

PASS ALPHA-COMPACT I STATION A

DIAMETER UP TO 12,7 MM



HEAD UNIT

Canister
for sheet thickness up to 4mm

Continously and easy length adjustment in
assembled status



PUNCH BODY

Metric-thread M12 x 1,25

Punch body made with premium H-PM®
(higher hit counts)

Alignment pin for exact adjustment
(excludes round)



PUNCH GUIDE

Surface-hardened and polished punch guide
for sheet thickness up to 6mm

Keyway:
Round: 0°
Square: 0-45°
Rect./Oblong: 0-90-225°
asym. Shapes: 0-90-180-270°

Tool shape integrated in guide

PASS ALPHA-COMPACT I STATION A

DIAMETER UP TO 12,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY

Round	4017A01
Square	4017A02
Rectangle	4017A03
Oblong	4017A04
*O.D. Ground Special Shapes	4017A0G
*EDM Required Special Shapes	4017A0E



HEAD UNIT

for all shapes	4093A01
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PUNCH BODY (H-PM®)

Round	4023A01
Square	4023A02
Rectangle	4023A03
Oblong	4023A04
*O.D. Ground Special Shapes	4023A0G
*EDM Required Special Shapes	4023A0E



PUNCH GUIDE

Round	4032A01
Square	4032A02
Rectangle	4032A03
Oblong	4032A04
*O.D. Ground Special Shapes	4032A0G
*EDM Required Special Shapes	4032A0E



DIE (HWS)

Round	4052A01
Square	4052A02
Rectangle	4052A03
Oblong	4052A04
*O.D. Ground Special Shapes	4052A0G
*EDM Required Special Shapes	4052A0E

SPARE PARTS

O-Ring (in punch guide)	4092A51	TiCN coating
PU-ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU-ejector Ø 6x10 (in punch)	4092P06	WT-shear DOWT-shear 2 PT-shear 4 PT-shear

ADDITIONAL COSTS FOR PUNCH

COMPENSATING SHIMS FOR PUNCH

Not necessary	Additional keyway
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ADDITIONAL COSTS FOR PUNCH GUIDE

COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm	499A1M1	Reinforced die
Shimkeeper (0,5 mm)	499A1M95	H-PM® Quality

ADDITIONAL COSTS FOR DIE

PASS BETA-V2® ABS I STATION A

DIAMETER UP TO 12,7 MM



HEAD UNIT

Canister
for sheet thickness up to 6 mm

Spring

10 mm length adjustment
by thread

Oil channel for sheet lubrication

On request, suitable for PDC-system



PUNCH BODY

Oil channel for sheet lubrication

Alignment pin for exact adjustment
(round version included)

Punch body made with premium H-PM®
(higher hit counts)



PUNCH GUIDE

Simple length adjustment in assembled state by
pressing the locking button

Surface-hardened and polished punch
guide for sheet thickness up to 6 mm

Keyway:
all shapes: 0 - 90 - 225°



STRIPPER

Interchangeable stripper plate
with oil channels

PASS BETA-V2® ABS I STATION A

DIAMETER UP TO 12,7 MM

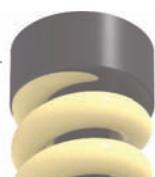
PART-NO.

COMPLETE PUNCH ASSEMBLY

Round	4019A01
Square	4019A02
Rectangle	4019A03
Oblong	4019A04
*O.D. Ground Special Shapes	4019A0G
*EDM Required Special Shapes	4019A0E

HEAD UNIT

for all shapes	4099A10
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Head Unit
for PDC-system
(without extra charge)

Part-No. „see left“-PDC
e.g.: 4019A01-PDC

PUNCH BODY (H-PM®)

Round	4029A01
Square	4029A02
Rectangle	4029A03
Oblong	4029A04
*O.D. Ground Special Shapes	4029A0G
*EDM Required Special Shapes	4029A0E

PUNCH GUIDE

for all shapes	4039A05
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STRIPPER

Round	4049A01
Square	4049A02
Rectangle	4049A03
Oblong	4049A04
*O.D. Ground Special Shapes	4049A0G
*EDM Required Special Shapes	4049A0E



DIE (HWS)

Round	4052A01
Square	4052A02
Rectangle	4052A03
Oblong	4052A04
*O.D. Ground Special Shapes	4052A0G
*EDM Required Special Shapes	4052A0E

SPARE PARTS

O-Ring (in punch guide)	4092A51	TiCN coating
PU-ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU-ejector Ø 6x10 (in punch)	4092P06	WT-shear DOWT-shear 2 PT-shear 4 PT-shear

ADDITIONAL COSTS FOR PUNCH

COMPENSATING SHIMS FOR PUNCH

Not necessary	Additional keyway
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ADDITIONAL COSTS FOR PUNCH GUIDE

COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm	499A1M1	Reinforced die
Shimkeeper (0,5 mm)	499A1M95	H-PM® Quality

ADDITIONAL COSTS FOR DIE

PASS BETA-COMPACT ABS I STATION A

DIAMETER UP TO 12,7 MM



HEAD UNIT

Canister
for sheet thickness up to 6 mm

Spring

10 mm length adjustment
by thread

Oil channel for sheet lubrication

On request, suitable for PDC-system



PUNCH BODY

Oil channel for sheet lubrication

Alignment pin for exact adjustment
(round version included)

Punch body made with premium H-PM®
(higher hit counts)



PUNCH GUIDE

Length adjustment by pulling down and turning

Surface-hardened and polished punch
guide for sheet thickness up to 6 mm

Keyway:
Round: 0°
Square: 0-45°
rect./oblong: 0-90-225°
asym. shapes: 0-90-180-270°

Tool shape with oil channels
integrated in guide

PASS BETA-COMPACT ABS I STATION A

DIAMETER UP TO 12,7 MM

PART-NO.

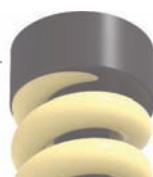
COMPLETE PUNCH ASSEMBLY		
Round	4018A01	
Square	4018A02	
Rectangle	4018A03	
Oblong	4018A04	
*O.D. Ground Special Shapes	4018A0G	
*EDM Required Special Shapes	4018A0E	

HEAD UNIT		
for all shapes	4095A10	

PUNCH BODY (H-PM®)		
Round	4025A01	
Square	4025A02	
Rectangle	4025A03	
Oblong	4025A04	
*O.D. Ground Special Shapes	4025A0G	
*EDM Required Special Shapes	4025A0E	

PUNCH GUIDE		
Round	4038A01	
Square	4038A02	
Rectangle	4038A03	
Oblong	4038A04	
*O.D. Ground Special Shapes	4038A0G	
*EDM Required Special Shapes	4038A0E	

DIE (HWS)		
Round	4052A01	
Square	4052A02	
Rectangle	4052A03	
Oblong	4052A04	
*O.D. Ground Special Shapes	4052A0G	
*EDM Required Special Shapes	4052A0E	



Head Unit
for PDC-system
(without extra charge)

Part-No. „see left“-PDC
e.g.: 4018A01-PDC



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH	
O-Ring (in punch guide)	4092A51	TICN coating	
PU-ejector Ø 3x6 (in punch)	4092P03	T-MAX coating	
PU-ejector Ø 6x10 (in punch)	4092P06	WT-shear	
		DOWT-shear	
		2 PT-shear	
		4 PT-shear	

COMPENSATING SHIMS FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE	
Not necessary		Additional keyway	

SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIE	
1x0,4 mm/1x0,8 mm/1x1,2 mm	499A1M1	Reinforced die	
Shimkeeper (0,5 mm)	499A1M95	H-PM® Quality	

PASS ALPHA ABS I STATION A

DIAMETER UP TO 12,7 MM



HEAD UNIT

Canister
for sheet thickness up to 4 mm

Continuously and easy
length adjustment
in assembled status

Oil channel for sheet lubrication



PUNCH BODY

Metric-thread M12 x 1,25

Oil channel for sheet lubrication

Punch body made with premium H-PM®
(higher hit counts)

Alignment pin for exact adjustment
(excludes round)



PUNCH GUIDE

Surface-hardened and polished punch
guide for sheet thickness up to 4 mm

Keyway:
all shapes: 0--90°



STRIPPER

Interchangeable stripper plate with oil pocket and
max. surface

PASS ALPHA ABS I STATION A

DIAMETER UP TO 12,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY		
Round	4011A01	
Square	4011A02	
Rectangle	4011A03	
Oblong	4011A04	
*O.D. Ground Special Shapes	4011A0G	
*EDM Required Special Shapes	4011A0E	
HEAD UNIT		
for all shapes	4091A10	
PUNCH BODY (H-PM®)		
Round	4021A01	
Square	4021A02	
Rectangle	4021A03	
Oblong	4021A04	
*O.D. Ground Special Shapes	4021A0G	
*EDM Required Special Shapes	4021A0E	
PUNCH GUIDE		
for all shapes	4031A05	
STRIPPER		
Round	4041A01	
Square	4041A02	
Rectangle	4041A03	
Oblong	4041A04	
*O.D. Ground Special Shapes	4041A0G	
*EDM Required Special Shapes	4041A0E	
DIE (HWS)		
Round	4052A01	
Square	4052A02	
Rectangle	4052A03	
Oblong	4052A04	
*O.D. Ground Special Shapes	4052A0G	
*EDM Required Special Shapes	4052A0E	



SPARE PARTS		ADDITIONAL COSTS FOR PUNCH	
O-Ring (in punch guide)	4092A51	TICN coating	
PU-ejector Ø 3x6 (in punch)	4092P03	T-MAX coating	
PU-ejector Ø 6x10 (in punch)	4092P06	WT-shear	
		DOWT-shear	
		2 PT-shear	
		4 PT-shear	
COMPENSATING SHIMS FOR PUNCH		ADDITIONAL COSTS FOR PUNCH GUIDE	
Not necessary		Additional keyway	
SET OF COMPENSATING SHIMS FOR DIE		ADDITIONAL COSTS FOR DIE	
1x0,4 mm/1x0,8 mm/1x1,2 mm	499A1M1	Reinforced die	
Shimkeeper (0,5 mm)	499A1M95	H-PM® Quality	

PASS STANDARD I STATION B

DIAMETER UP TO 31,7 MM



HEAD UNIT

Hexagon head screw for simply assembling of punch assembly

Spring
for sheet thickness up to 6mm

2 mm length adjustment
by turning of the distance ring



PUNCH BODY

Metric-thread M20 x 1,5

Punch body made with premium H-PM®
(higher hit counts)

Alignment pin for exact adjustment
(excludes round)



PUNCH GUIDE

Surface-hardened and polished punch guide
for sheet thickness up to 6mm

Keyway:
Round: 0°
Square: 0-45°
Rect./Oblong: 0-90-225°
asym. Shapes: 0-90-180-270°

Tool shape integrated in guide

PASS STANDARD I STATION B

DIAMETER UP TO 31,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY

Round	4012B01
Square	4012B02
Rectangle	4012B03
Oblong	4012B04
*O.D. Ground Special Shapes	4012B0G
*EDM Required Special Shapes	4012B0E



HEAD UNIT (HEAD SCREW, SPRING, DISTANCE RING)

for all shapes	4092B01
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PUNCH BODY (H-PM®)

Round	4022B01
Square	4022B02
Rectangle	4022B03
Oblong	4022B04
*O.D. Ground Special Shapes	4022B0G
*EDM Required Special Shapes	4022B0E



DIE (HWS)

Round	4052B01
Square	4052B02
Rectangle	4052B03
Oblong	4052B04
*O.D. Ground Special Shapes	4052B0G
*EDM Required Special Shapes	4052B0E

SPARE PARTS

Head screw	4092B31	TiCN coating
Spring	4092B11	T-MAX coating
Distance ring	4092B21	WT-coating
O-Ring (in punch guide)	4092B51	DOWT-shear
PU-ejector Ø 3x6 (in punch)	4092P03	2 PT-shear
PU-ejector Ø 6x10 (in punch)	4092P06	4 PT-shear

ADDITIONAL COSTS FOR PUNCH

COMPENSATING SHIMS FOR PUNCH

Piece (2 mm)	499B4S2	Additional keyway
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ADDITIONAL COSTS FOR PUNCH GUIDE

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1	Reinforced die
Shimkeeper (0,5 mm)	499B1M95	H-PM® Quality

ADDITIONAL COSTS FOR DIE

PASS ALPHA I STATION B

DIAMETER UP TO 31,7 MM



HEAD UNIT

Canister
for sheet thickness up to 4mm

Continously and easy length adjusment
in assembled status



PUNCH BODY

Metric-thread M20 x 1,5

Punch body made with premium H-PM®
(higher hit counts)

Alignment pin for exact adjustment
(excludes round)



PUNCH GUIDE

Surface-hardened and polished punch guide
for sheet thickness up to 6mm

Keyway:
all shapes: 0 - 45 - 90 - 180 - 270°



STRIPPER

Interchangeable stripper plate

PASS ALPHA I STATION B

DIAMETER UP TO 31,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY

Round	4013B01
Square	4013B02
Rectangle	4013B03
Oblong	4013B04
*O.D. Ground Special Shapes	4013B0G
*EDM Required Special Shapes	4013B0E



HEAD UNIT

for all shapes	4093B01
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PUNCH BODY (H-PM®)

Round	4023B01
Square	4023B02
Rectangle	4023B03
Oblong	4023B04
*O.D. Ground Special Shapes	4023B0G
*EDM Required Special Shapes	4023B0E

PUNCH GUIDE

for all shapes	4033B05
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STRIPPER

Round	4043B01
Square	4043B02
Rectangle	4043B03
Oblong	4043B04
*O.D. Ground Special Shapes	4043B0G
*EDM Required Special Shapes	4043B0E



DIE (HWS)

Round	4052B01
Square	4052B02
Rectangle	4052B03
Oblong	4052B04
*O.D. Ground Special Shapes	4052B0G
*EDM Required Special Shapes	4052B0E

SPARE PARTS

O-Ring (in punch guide)	4092B51	TiCN coating
PU-ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU-ejector Ø 6x10 (in punch)	4092P06	WT-shear DOWT-shear 2 PT-shear 4 PT-shear

ADDITIONAL COSTS FOR PUNCH

COMPENSATING SHIMS FOR PUNCH

Not necessary	Additional keyway
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ADDITIONAL COSTS FOR PUNCH GUIDE

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1	Reinforced die
Shimkeeper (0,5 mm)	499B1M95	H-PM® Quality

ADDITIONAL COSTS FOR DIE

PASS ALPHA-COMPACT I STATION B

DIAMETER UP TO 31,7 MM



HEAD UNIT

Canister
for sheet thickness up to 4mm

Continously and easy length adjustment
in assembled status



PUNCH BODY

Metric-thread M20x 1,5

Punch body made with premium H-PM®
(higher hit counts)

Alignment pin for exact adjustment
(excludes round)



PUNCH GUIDE

Surface-hardened and polished punch guide
for sheet thickness up to 6mm

Keyway:
Round: 0°
Square: 0-45°
Rect./Oblong: 0-45-90-135°
asym. Shapes: 0-90-180-270°

Tool shapes integrated in guide

PASS ALPHA-COMPACT I STATION B

DIAMETER UP TO 31,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY

Round	4017B01
Square	4017B02
Rectangle	4017B03
Oblong	4017B04
*O.D. Ground Special Shapes	4017B0G
*EDM Required Special Shapes	4017B0E



HEAD UNIT

for all shapes	4093B01
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PUNCH BODY (H-PM®)

Round	4023B01
Square	4023B02
Rectangle	4023B03
Oblong	4023B04
*O.D. Ground Special Shapes	4023B0G
*EDM Required Special Shapes	4023B0E



DIE (HWS)

Round	4052B01
Square	4052B02
Rectangle	4052B03
Oblong	4052B04
*O.D. Ground Special Shapes	4052B0G
*EDM Required Special Shapes	4052B0E

SPARE PARTS

O-Ring (in punch guide)	4092B51	TICN coating
PU-ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU-ejector Ø 6x10 (in punch)	4092P06	WT-shear DOWT-shear 2 PT-shear 4 PT-shear

ADDITIONAL COSTS FOR PUNCH

COMPENSATING SHIMS FOR PUNCH

Not necessary	Additional keyway
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ADDITIONAL COSTS FOR PUNCH GUIDE

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1	Reinforced die
Shimkeeper (0,5 mm)	499B1M95	H-PM® Quality

ADDITIONAL COSTS FOR DIE

PASS BETA-V2® ABS I STATION B

DIAMETER UP TO 31,7 MM



HEAD UNIT

Canister
for sheet thickness up to 6 mm

Spring

10 mm length adjustment
by thread

Oil channel for sheet lubrication

On request, suitable for PDC-system



PUNCH BODY

Oil channel for sheet lubrication

Alignment pin for exact adjustment
(round version included)

Punch body made with premium H-PM®
(higher hit counts)



PUNCH GUIDE

Simple length adjustment in assembled state by
pressing the locking button

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Keyway:
all shapes: 0 - 90 - 225°

STRIPPER

Interchangeable stripper plate with oil channels

PASS BETA-V2® ABS I STATION B

DIAMETER UP TO 31,7 MM

PART.-NO.

COMPLETE PUNCH ASSEMBLY

Round	4019B01
Square	4019B02
Rectangle	4019B03
Oblong	4019B04
*O.D. Ground Special Shapes	4019B0G
*EDM Required Special Shapes	4019B0E

HEAD UNIT

for all shapes	4099B10
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PUNCH BODY (H-PM®)

Round	4029B01
Square	4029B02
Rectangle	4029B03
Oblong	4029B04
*O.D. Ground Special Shapes	4029B0G
*EDM Required Special Shapes	4029B0E

PUNCH GUIDE

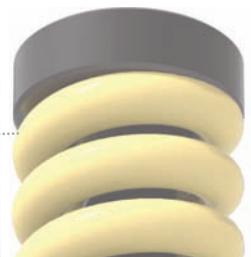
for all shapes	4039B05
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STRIPPER

Round	4049B01
Square	4049B02
Rectangle	4049B03
Oblong	4049B04
*O.D. Ground Special Shapes	4049B0G
*EDM Required Special Shapes	4049B0E

DIE (HWS)

Round	4052B01
Square	4052B02
Rectangle	4052B03
Oblong	4052B04
*O.D. Ground Special Shapes	4052B0G
*EDM Required Special Shapes	4052B0E



Head Unit
for PDC-system
(without extra charge)

Part.-No. „see left“-PDC
e.g.: 4019B01-PDC



SPARE PARTS

O-Ring (in punch guide)	4092B51	TiCN coating
PU-ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU-ejector Ø 6x10 (in punch)	4092P06	WT-shear

ADDITIONAL COSTS FOR PUNCH

DOWT-shear
2 PT-shear
4 PT-shear

COMPENSATING SHIMS FOR PUNCH

Not necessary	Additional keyway
---------------	-------------------

ADDITIONAL COSTS FOR PUNCH GUIDE

SET OF COMPENSATING SHIMS FOR DIE	ADDITIONAL COSTS FOR DIE
1x0,4 mm/1x0,8 mm/1x1,2 mm	Reinforced die
Shimkeeper (0,5 mm)	H-PM® Quality

PASS BETA-COMPACT ABS I STATION B

DIAMETER UP TO 31,7 MM



HEAD UNIT

Canister
for sheet thickness up to 6 mm

Spring

10 mm length adjustment
by thread

Oil channel for sheet lubrication

On request, suitable for PDC-system



PUNCH BODY

Oil channel for sheet lubrication

Alignment pin for exact adjustment
(round version included)

Punch body made with premium H-PM®
(higher hit counts)



PUNCH GUIDE

Length adjustment by pulling down and turning

Surface-hardened and polished punch
guide for sheet thickness up to 6 mm

Keyway:

Round: 0°

Square: 0-45°

rect./oblong: 0-90-225°

asym. shapes: 0-90-180-270°

Tool shape with oil channels integrated
in guide

PASS BETA-COMPACT ABS I STATION B

DIAMETER UP TO 31,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY

Round	4018B01
Square	4018B02
Rectangle	4018B03
Oblong	4018B04
*O.D. Ground Special Shapes	4018B0G
*EDM Required Special Shapes	4018B0E

HEAD UNIT

for all shapes	4095B10
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PUNCH BODY (H-PM®)

Round	4025B01
Square	4025B02
Rectangle	4025B03
Oblong	4025B04
*O.D. Ground Special Shapes	4025B0G
*EDM Required Special Shapes	4025B0E

PUNCH GUIDE

Round	4038B01
Square	4038B02
Rectangle	4038B03
Oblong	4038B04
*O.D. Ground Special Shapes	4038B0G
*EDM Required Special Shapes	4038B0E

DIE (HWS)

Round	4052B01
Square	4052B02
Rectangle	4052B03
Oblong	4052B04
*O.D. Ground Special Shapes	4052B0G
*EDM Required Special Shapes	4052B0E



Part.-No. „see left“-PDC
e.g.: 4018B01-PDC



SPARE PARTS

O-Ring (in punch guide)	4092B51	TICN coating
PU-ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU-ejector Ø 6x10 (in punch)	4092P06	WT-shear DOWT-shear 2 PT-shear 4 PT-shear

ADDITIONAL COSTS FOR PUNCH

COMPENSATING SHIMS FOR PUNCH

Not necessary	Additional keyway
---------------	-------------------

ADDITIONAL COSTS FOR PUNCH GUIDE

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1	Reinforced die
Shimkeeper (0,5 mm)	499B1M95	H-PM® Quality

ADDITIONAL COSTS FOR DIE

PASS ALPHA ABS I STATION B

DIAMETER UP TO 31,7 MM



HEAD UNIT

Canister
for sheet thickness up to 4 mm

Continuously and easy length adjustment in assembled status

Oil channel for sheet lubrication



PUNCH BODY

Metric-thread M20 x 1,5

Oil channel for sheet lubrication

Punch body made with premium H-PM®
(higher hit counts)

Alignment pin for exact adjustment
(excludes round)



PUNCH GUIDE

Surface-hardened and polished punch
guide for sheet thickness up to 4 mm

Keyway:
all shapes: 0--90°



STRIPPER

Interchangeable stripper plate with oil pocket and
max. surface

PASS ALPHA ABS I STATION B

DIAMETER UP TO 31,7 MM

PART-NO.

COMPLETE PUNCH ASSEMBLY

Round	4011B01
Square	4011B02
Rectangle	4011B03
Oblong	4011B04
*O.D. Ground Special Shapes	4011B0G
*EDM Required Special Shapes	4011B0E



HEAD UNIT

for all shapes	4091B10
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PUNCH BODY (H-PM®)

Round	4021B01
Square	4021B02
Rectangle	4021B03
Oblong	4021B04
*O.D. Ground Special Shapes	4021B0G
*EDM Required Special Shapes	4021B0E

PUNCH GUIDE

for all shapes	4031B05
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STRIPPER

Round	4041B01
Square	4041B02
Rectangle	4041B03
Oblong	4041B04
*O.D. Ground Special Shapes	4041B0G
*EDM Required Special Shapes	4041B0E



DIE (HWS)

Round	4052B01
Square	4052B02
Rectangle	4052B03
Oblong	4052B04
*O.D. Ground Special Shapes	4052B0G
*EDM Required Special Shapes	4052B0E

SPARE PARTS

O-Ring (in punch guide)	4092B51	TiCN coating
PU-ejector Ø 3x6 (in punch)	4092P03	T-MAX coating
PU-ejector Ø 6x10 (in punch)	4092P06	WT-shear DOWT-shear 2 PT-shear 4 PT-shear

ADDITIONAL COSTS FOR PUNCH

COMPENSATING SHIMS FOR PUNCH

Not necessary	Additional keyway
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ADDITIONAL COSTS FOR PUNCH GUIDE

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm	499B1M1	Reinforced die
Shimkeeper (0,5 mm)	499B1M95	H-PM® Quality

ADDITIONAL COSTS FOR DIE

PASS STANDARD I STATION C

DIAMETER UP TO 50,8 MM



GUIDE ASSEMBLY

Screw M12

Springs for sheet thickness up to 6mm

3 mm length adjustment
by using compensating shims

Keyway: 0 - 90°

Surface-hardened and polished punch guide
for sheet thickness up to 6mm

Clamping-screws to fix the strippers



PUNCH BODY

Thread M12

Punch body made with premium H-PM®
(higher hit counts)



STRIPPER

Interchangeable stripper plate

PASS STANDARD I STATION C

DIAMETER UP TO 50,8 MM

PART-NO.

GUIDE ASSEMBLY

for all shapes 499C01



PUNCH BODY (H-PM®)

Round 4022C01

Square 4022C02

Rectangle 4022C03

Oblong 4022C04

*O.D. Ground Special Shapes 4022C0G

* EDM Required Special Shapes 4022C0E

STRIPPER

Round 4032C01

Square 4032C02

Rectangle 4032C03

Oblong 4032C04

*O.D. Ground Special Shapes 4032C0G

* EDM Required Special Shapes 4032C0E



DIE (HWS)

Round 4052C01

Square 4052C02

Rectangle 4052C03

Oblong 4052C04

*O.D. Ground Special Shapes 4052C0G

* EDM Required Special Shapes 4052C0E

SPARE PARTS

PU-ejector Ø 3x6 (in punch)

4092P03 TICN coating

PU-ejector Ø 6x10 (in punch)

4092P06 T-MAX coating

Set clamping-springs with screws

499C71 WT-shear

Quiding key with screws

499C63 DOWT-shear

ADDITIONAL COSTS FOR PUNCH

2 PT-shear

4 PT-shear

Additional keyway

SET OF COMPENSATING SHIMS FOR PUNCH

1x0,4 mm/1x0,8 mm/1x1,2 mm

499C1S1

ADDITIONAL COSTS FOR PUNCH GUIDE

Additional keyway

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm

499C2M1

ADDITIONAL COSTS FOR DIE

H-PM® Quality

PASS BETA-V2® ABS I STATION C

DIAMETER UP TO 50,8 MM



GUIDE ASSEMBLY

Screw M12

Springs for sheet thickness up to 6 mm

Oil channel for sheet lubrication

Simple 10 mm length adjustment
in assembled state by
pressing the locking button

Keyway: 0-90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Fast and easy clamping system
for stripper

Suitable for PDC-system



PUNCH BODY

Thread M12 with oil channel for sheet lubrication

Punch body made with premium H-PM®
(higher hit counts)



STRIPPER

Interchangeable stripper plate with oil channels

PASS BETA-V2® ABS I STATION C

DIAMETER UP TO 50,8 MM

PART-NO.

GUIDE ASSEMBLY

for all shapes 4039C01



Reversible plate adapter
with keyway for
PDC-system

PUNCH BODY (H-PM®)

Round 4029C01

Square 4029C02

Rectangle 4029C03

Oblong 4029C04

*O.D. Ground Special Shapes 4029C0G

*EDM Required Special Shapes 4029C0E

STRIPPER

Round 4049C01

Square 4049C02

Rectangle 4049C03

Oblong 4049C04

*O.D. Ground Special Shapes 4049C0G

*EDM Required Special Shapes 4049C0E

DIE (HWS)

Round 4052C01

Square 4052C02

Rectangle 4052C03

Oblong 4052C04

*O.D. Ground Special Shapes 4052C0G

*EDM Required Special Shapes 4052C0E



Part-no.: „see left“ -2
(e.g.: 4052C04-2)

SPARE PARTS

PU-ejector Ø 3x6 (in punch)

4092P03 TICN coating

PU-ejector Ø 6x10 (in punch)

4092P06 T-MAX coating

ADDITIONAL COSTS FOR PUNCH

WT-shear

DOWT-shear

2 PT-shear

4 PT-shear

Additional keyway

SET OF COMPENSATING SHIMS FOR PUNCH

Not necessary

ADDITIONAL COSTS FOR PUNCH GUIDE

Additional keyway

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm

499C2M1

ADDITIONAL COSTS FOR DIE

H-PM® Quality

PASS BETA-V2® ABS SLITTING TOOL I STATION C



GUIDE ASSEMBLY

Screw M12

Springs for sheet thickness up to 6 mm

Oil channel for sheet lubrication

Simple 10 mm length adjustment
in assembled state by
pressing the locking button

Keyway: 0-90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Fast and easy clamping system
for stripper

Suitable for PDC-system



SLITTING TOOL ADAPTER

2 fixing threads M6

Thread M12 with oil channel for sheet lubrication



SLITTING TOOL

Slitting Tool made with premium H-PM®
(higher hit counts)

STRIPPER

Interchangeable stripper plate with oil channels

PASS BETA-V2® ABS SLITTING TOOL I STATION C

PART-NO.

GUIDE ASSEMBLY

for all shapes 4039C01

SLITTING TOOL ADAPTER

for all shapes 4229CT00

SLITTING TOOL (MAX. 6,35X50) / (H-PM®)

Rectangle 4029CT03

Oblong 4029CT04

*O.D. Ground Special Shapes 4029CT0G

*EDM Required Special Shapes 4029CT0E

STRIPPER

Rectangle 4049CT03

Oblong 4049CT04

*O.D. Ground Special Shapes 4049CT0G

*EDM Required Special Shapes 4049CT0E

REVERSIBLE PLATE ADAPTER

4399CT00

REVERSIBLE PLATE (H-PM®)

Rectangle 4052CT03

Oblong 4052CT04

*O.D. Ground Special Shapes 4052CT0G

*EDM Required Special Shapes 4052CT0E



Reversible plate adapter
with keyway for
PDC-system



SPARE PARTS

PU-ejector Ø 3x6 (in punch)

ADDITIONAL COSTS FOR PUNCH

PU-ejector Ø 6x10 (in punch)

4092P03 TICN coating

4092P06 T-MAX coating

WT-shear

DOWT-shear

2 PT-shear

4 PT-shear

Additional keyway

SET OF COMPENSATING SHIMS FOR SLITTING TOOL ADAPTER

Not necessary

ADDITIONAL COSTS FOR PUNCH GUIDE

Additional keyway

SET OF COMPENSATING SHIMS FOR REVERSIBLE PLATE

1x0,4 mm/1x0,8 mm/1x1,2 mm

499CT60

PASS ALPHA-V2 ABS I STATION C

DIAMETER UP TO 50,8 MM



GUIDE ASSEMBLY

Screw M14

Springs for sheet thickness up to 6 mm

Oil channel for sheet lubrication

Simple 10 mm length adjustment
in assembled state by
pressing the locking button

Keyway: 0-90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Suitable for PDC-system



PUNCH BODY

Thread M14 with oil channel for sheet lubrication

Punch body made with premium H-PM®
(higher hit counts)

STRIPPER

Interchangeable stripper plate with oil channels

PASS ALPHA-V2 ABS I STATION C

DIAMETER UP TO 50,8 MM

PART-NO.

GUIDE ASSEMBLY		
	for all shapes	4031C01
PUNCH BODY (H-PM®)		
	Round	4021C01
	Square	4021C02
	Rectangle	4021C03
	Oblong	4021C04
	*O.D. Ground Special Shapes	4021C0G
	*EDM Required Special Shapes	4021C0E
PUNCH GUIDE		
	for all shapes	---
STRIPPER		
	Round	4041C01
	Square	4041C02
	Rectangle	4041C03
	Oblong	4041C04
	*O.D. Ground Special Shapes	4041C0G
	*EDM Required Special Shapes	4041C0E
DIE (HWS)		
	Round	4052C01
	Square	4052C02
	Rectangle	4052C03
	Oblong	4052C04
	*O.D. Ground Special Shapes	4052C0G
	*EDM Required Special Shapes	4052C0E



Reversible plate adapter
with keyway for
PDC-system



Part-no.: „see left“ -2
(e.g.: 4052C04-2)

SPARE PARTS	ADDITIONAL COSTS FOR PUNCH	
PU-ejector Ø 3x6 (in punch)	4092P03	TiCN coating
PU-ejector Ø 6x10 (in punch)	4092P06	T-MAX coating WT-shear DOWT-shear 2 PT-shear 4 PT-shear Additional keyway
SET OF COMPENSATING SHIMS FOR PUNCH	ADDITIONAL COSTS FOR PUNCH GUIDE	
Not necessary	Additional keyway	
SET OF COMPENSATING SHIMS FOR DIE	ADDITIONAL COSTS FOR DIE	
1x0,4 mm/1x0,8 mm/1x1,2 mm	499C2M1	H-PM® Quality

PASS STANDARD I STATION D

DIAMETER UP TO 88,9 MM



GUIDE ASSEMBLY

Screw M12

Springs for sheet thickness up to 6mm

3 mm length adjustment
by using compensating shims

Keyway: 0 - 90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Clamping-screw to fix the strippers



PUNCH BODY

Thread M12

Punch body made with premium H-PM
(higher hit counts)



STRIPPER

Interchangeable stripper plate

PASS STANDARD I STATION D

DIAMETER UP TO 88,9 MM

PART-NO.

GUIDE ASSEMBLY

for all shapes 499D01



PUNCH BODY (H-PM®)

Round 4022D01

Square 4022D02

Rectangle 4022D03

Oblong 4022D04

*O.D. Ground Special Shapes 4022D0G

* EDM Required Special Shapes 4022D0E

STRIPPER

Round 4032D01

Square 4032D02

Rectangle 4032D03

Oblong 4032D04

*O.D. Ground Special Shapes 4032D0G

* EDM Required Special Shapes 4032D0E

DIE (HWS)

Round 4052D01

Square 4052D02

Rectangle 4052D03

Oblong 4052D04

*O.D. Ground Special Shapes 4052D0G

* EDM Required Special Shapes 4052D0E



SPARE PARTS

PU-ejector Ø 3x6 (in punch) 4092P03 TICN coating

PU-ejector Ø 6x10 (in punch) 4092P06 T-MAX coating

Set clamping-springs with screws 499D71 WT-shear

Quiding key with screws 499D63 DOWT-shear

ADDITIONAL COSTS FOR PUNCH

2 PT-shear

4 PT-shear

Additional keyway

SET OF COMPENSATING SHIMS FOR PUNCH

1x0,4 mm/1x0,8 mm/1x1,2 mm

ADDITIONAL COSTS FOR PUNCH

Additional keyway

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm

ADDITIONAL COSTS FOR DIE

H-PM® Quality

PASS BETA-V2® ABS I STATION D

DIAMETER UP TO 88,9 MM



GUIDE ASSEMBLY

Screw M12

Springs for sheet thickness up to 6 mm

Oil channel for sheet lubrication

Simple 10 mm length adjustment
in assembled state by
pressing the locking button

Keyway: 0-90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Fast and easy clamping system
for stripper

Suitable for PDC-system



PUNCH BODY

Thread M12 with oil channel for sheet lubrication

Punch body made with premium H-PM®
(higher hit counts)



STRIPPER

Interchangeable stripper plate with oil channels

PASS BETA-V2® ABS I STATION D

DIAMETER UP TO 88,9 MM

PART-NO.

GUIDE ASSEMBLY

for all shapes 4039D01



PUNCH BODY (H-PM®)

Round 4029D01

Square 4029D02

Rectangle 4029D03

Oblong 4029D04

*O.D. Ground Special Shapes 4029D0G

* EDM Required Special Shapes 4029D0E

STRIPPER

Round 4049D01

Square 4049D02

Rectangle 4049D03

Oblong 4049D04

*O.D. Ground Special Shapes 4049D0G

* EDM Required Special Shapes 4049D0E

DIE (HWS)

Round 4052D01

Square 4052D02

Rectangle 4052D03

Oblong 4052D04

*O.D. Ground Special Shapes 4052D0G

* EDM Required Special Shapes 4052D0E

Reversible plate adapter
with keyway for
PDC-system

Part-no.: „see left“ -2
(e.g.: 4052D04-2)



SPARE PARTS

PU-ejector Ø 3x6 (in punch)

4092P03 TICN coating

PU-ejector Ø 6x10 (in punch)

4092P06 T-MAX coating

ADDITIONAL COSTS FOR PUNCH

WT-shear

DOWT-shear

2 PT-shear

4 PT-shear

Additional keyway

SET OF COMPENSATING SHIMS FOR PUNCH

Not necessary

ADDITIONAL COSTS FOR PUNCH

Additional keyway

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm

499D2M1

ADDITIONAL COSTS FOR DIE

H-PM® Quality

PASS BETA-V2® ABS SLITTING TOOL I STATION D



GUIDE ASSEMBLY

Screw M12

Springs for sheet thickness up to 6 mm

Oil channel for sheet lubrication

Simple 10 mm length adjustment
in assembled state by
pressing the locking button

Keyway: 0-90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Fast and easy clamping system
for stripper

Suitable for PDC-system



SLITTING TOOL ADAPTER

4 fixing threads M6

Thread M12 with oil channel for sheet lubrication

SLITTING TOOL

Slitting Tool made with premium H-PM®
(higher hit counts)

STRIPPER

Interchangeable stripper plate with oil channels

PASS BETA-V2® ABS SLITTING TOOL I STATION D

PART-NO.

GUIDE ASSEMBLY

for all shapes 4039D01

SLITTING TOOL ADAPTER

for all shapes 4229DT00

SLITTING TOOL (MAX. 6,35X85) / (H-PM®)

Rectangle 4029DT03

Oblong 4029DT04

*O.D. Ground Special Shapes 4029DT0G

*EDM Required Special Shapes 4029DT0E

STRIPPER

Rectangle 4049DT03

Oblong 4049DT04

*O.D. Ground Special Shapes 4049DT0G

*EDM Required Special Shapes 4049DT0E

REVERSIBLE PLATE ADAPTER

4399DT00

REVERSIBLE PLATE (H-PM®)

Rectangle 4052DT03

Oblong 4052DT04

*O.D. Ground Special Shapes 4052DT0G

*EDM Required Special Shapes 4052DT0E



Reversible plate adapter
with keyway for
PDC-system



Part-no.: „see left“ -2
(e.g.: 4052DT04-2)

SPARE PARTS

PU-ejector Ø 3x6 (in punch)

ADDITIONAL COSTS FOR PUNCH

PU-ejector Ø 6x10 (in punch)

4092P03 TICN coating

4092P06 T-MAX coating

WT-shear

DOWT-shear

2 PT-shear

4 PT-shear

Additional keyway

SET OF COMPENSATING SHIMS FOR SLITTING TOOL ADAPTER

Not necessary

ADDITIONAL COSTS FOR PUNCH GUIDE

Additional keyway

SET OF COMPENSATING SHIMS FOR REVERSIBLE PLATE

1x0,4 mm/1x0,8 mm/1x1,2 mm

499DT60

PASS BETA-V2® ABS SLITTING TOOL I STATION D

CLOSE TO THE CLAMP



GUIDE ASSEMBLY

Screw M12

Springs for sheet thickness up to 6 mm

Oil channel for sheet lubrication

Simple 10 mm length adjustment
in assembled state by
pressing the locking button

Keyway: 0-90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Fast and easy clamping system
for stripper

Suitable for PDC-system

SLITTING TOOL ADAPTER

4 fixing threads M6

Thread M12 with oil channel for sheet lubrication

SLITTING TOOL

Slitting Tool made with premium H-PM®
(higher hit counts)

STRIPPER

Interchangeable stripper plate with oil channels

One or two-sided relief for punching close to clamp

PASS BETA-V2® ABS SLITTING TOOL I STATION D

CLOSE TO THE CLAMP

	PART-NO.
GUIDE ASSEMBLY	
for all shapes	4039DTP01
SLITTING TOOL ADAPTER	
for all shapes	4229DT00
SLITTING TOOL (MAX. 6,35X85) / (H-PM®)	
Rectangle	4029DT03
Oblong	4029DT04
*O.D. Ground Special Shapes	4029DT0G
*EDM Required Special Shapes	4029DT0E
STRIPPER ONE-SIDED FREE	
Rectangle	4049DTP03-1
Oblong	4049DTP04-1
*O.D. Ground Special Shapes	4049DTP0G-1
*EDM Required Special Shapes	4049DTP0E-1
STRIPPER TWO-SIDED FREE	
Rectangle	4049DTP03-2
Oblong	4049DTP04-2
*O.D. Ground Special Shapes	4049DTP0G-2
*EDM Required Special Shapes	4049DTP0E-2
DIE ONE-SIDED FREE (HWS)	
Rectangle	4052DTP03-1
Oblong	4052DTP04-1
*O.D. Ground Special Shapes	4052DTP0G-1
*EDM Required Special Shapes	4052DTP0E-1
DIE TWO-SIDED FREE (HWS)	
Rectangle	4052DTP03-2
Oblong	4052DTP04-2
*O.D. Ground Special Shapes	4052DTP0G-2
*EDM Required Special Shapes	4052DTP0E-2



Reversible plate adapter
with keyway for
PDC-system



Part-no.: „see left“ -2
(e.g.: 4052DTP04-2)

SPARE PARTS	ADDITIONAL COSTS FOR PUNCH
PU-ejector Ø 3x6 (in punch)	TiCN coating
PU-ejector Ø 6x10 (in punch)	T-MAX coating WT-shear DOWT-shear 2 PT-shear 4 PT-shear Additional keyway
SET OF COMPENSATING SHIMS FOR SLITTING TOOL ADAPTER	ADDITIONAL COSTS FOR PUNCH GUIDE
Not necessary	Additional keyway
SET OF COMPENSATING SHIMS FOR DIE	ADDITIONAL COSTS FOR DIE
1x0,4 mm/1x0,8 mm/1x1,2 mm	H-PM® Quality

PASS ALPHA-V2 ABS I STATION D

DIAMETER UP TO 88,9 MM



GUIDE ASSEMBLY

Screw M14

Spring for sheet thickness up to 6 mm

Oil channel for sheet lubrication

Simple 10 mm length adjustment
in assembled state by
pressing the locking button

Keyway: 0-90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Suitable for PDC-system



PUNCH BODY

Thread M14 with oil channel for sheet lubrication

Punch body made with premium H-PM®
(higher hit counts)

STRIPPER

Interchangeable stripper plate with oil channels

PASS ALPHA-V2 ABS I STATION D

DIAMETER UP TO 88,9 MM

PART-NO.

GUIDE ASSEMBLY		
	for all shapes	4031D01
PUNCH BODY (H-PM®)		
	Round	4021D01
	Square	4021D02
	Rectangle	4021D03
	Oblong	4021D04
	*O.D. Ground Special Shapes	4021D0G
	* EDM Required Special Shapes	4021D0E
PUNCH GUIDE		
	for all shapes	---
STRIPPER		
	Round	4041D01
	Square	4041D02
	Rectangle	4041D03
	Oblong	4041D04
	*O.D. Ground Special Shapes	4041D0G
	* EDM Required Special Shapes	4041D0E
DIE (HWS)		
	Round	4052D01
	Square	4052D02
	Rectangle	4052D03
	Oblong	4052D04
	*O.D. Ground Special Shapes	4052D0G
	* EDM Required Special Shapes	4052D0E



Reversible plate adapter
with keyway for
PDC-system



Part-no.: „see left“ -2
(e.g.: 4052D04-2)

SPARE PARTS

		ADDITIONAL COSTS FOR PUNCH
PU-ejector Ø 3x6 (in punch)	4092P03	TiCN coating
PU-ejector Ø 6x10 (in punch)	4092P06	T-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Additional keyway

SET OF COMPENSATING SHIMS FOR PUNCH

Not necessary

SET OF COMPENSATING SHIMS FOR DIE	ADDITIONAL COSTS FOR DIE
1x0,4 mm/1x0,8 mm/1x1,2 mm	499D2M1 H-PM® Quality

PASS STANDARD I STATION E

DIAMETER UP TO 114.3 MM



GUIDE ASSEMBLY

Screw M12

Springs for sheet thickness up to 6 mm

3 mm length adjustment
by using compensating shims

Keyway: 0 - 90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Clamping-screws to fix the strippers

PUNCH BODY

Thread M12

Punch body made with premium H-PM
(higher hit counts)

STRIPPER

Interchangeable stripper plate

PASS STANDARD I STATION E

DIAMETER UP TO 114,3 MM

PART-NO.

GUIDE ASSEMBLY

for all shapes 499E01



PUNCH BODY (H-PM®)

Round	4022E01
Square	4022E02
Rectangle	4022E03
Oblong	4022E04
*O.D. Ground Special Shapes	4022E0G
*EDM Required Special Shapes	4022E0E

STRIPPER

Round	4032E01
Square	4032E02
Rectangle	4032E03
Oblong	4032E04
*O.D. Ground Special Shapes	4032E0G
*EDM Required Special Shapes	4032E0E

DIE (HWS)

Round	4052E01
Square	4052E02
Rectangle	4052E03
Oblong	4052E04
*O.D. Ground Special Shapes	4052E0G
*EDM Required Special Shapes	4052E0E



Reversible plate adapter
with keyway for
PDC-system

Part-no.: „see left“ -2
(e.g.: 4052E04-2)

SPARE PARTS

PU-ejector Ø 3x6 (in punch)	4092P03	TICN coating
PU-ejector Ø 6x10 (in punch)	4092P06	T-MAX coating
Set clamping-springs with screws	499E71	WT-shear
Quiding key with screws	499E63	DOWT-shear
		2 PT-shear
		4 PT-shear
		Additional keyway

ADDITIONAL COSTS FOR PUNCH

SET OF COMPENSATING SHIMS FOR PUNCH

1x0,4 mm/1x0,8 mm/1x1,2 mm 499E3S1 Additional keyway

ADDITIONAL COSTS FOR PUNCH GUIDE

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm 499E2M1 H-PM® Quality

PASS BETA-V2® ABS I STATION E

DIAMETER UP TO 114.3 MM



GUIDE ASSEMBLY

Screw M12

Springs for sheet thickness up to 6 mm

Oil channel for sheet lubrication

Simple 10 mm length adjustment
in assembled state by
pressing the locking button

Keyway: 0-90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Fast and easy clamping system
for stripper

Suitable for PDC-system

PUNCH BODY

Thread M12 with oil channel for sheet lubrication

Punch body made with premium H-PM®
(higher hit counts)

STRIPPER

Interchangeable stripper plate with oil channels

PASS BETA-V2® ABS I STATION E

DIAMETER UP TO 114,3 MM

PART-NO.

GUIDE ASSEMBLY

for all shapes 4039E01



Reversible plate adapter
with keyway for
PDC-system

PUNCH BODY (H-PM®)

Round 4029E01

Square 4029E02

Rectangle 4029E03

Oblong 4029E04

*O.D. Ground Special Shapes 4029E0G

* EDM Required Special Shapes 4029E0E

STRIPPER

Round 4049E01

Square 4049E02

Rectangle 4049E03

Oblong 4049E04

*O.D. Ground Special Shapes 4049E0G

* EDM Required Special Shapes 4049E0E

DIE (HWS)

Round 4052E01

Square 4052E02

Rectangle 4052E03

Oblong 4052E04

*O.D. Ground Special Shapes 4052E0G

* EDM Required Special Shapes 4052E0E



Part-no.: „see left“ -2
(e.g.: 4052E04-2)

SPARE PARTS

PU-ejector Ø 3x6 (in punch)

4092P03 TICN coating

PU-ejector Ø 6x10 (in punch)

4092P06 T-MAX coating

ADDITIONAL COSTS FOR PUNCH

WT-shear

DOWT-shear

2 PT-shear

4 PT-shear

Additional keyway

SET OF COMPENSATING SHIMS FOR PUNCH

Not necessary

ADDITIONAL COSTS FOR PUNCH

Additional keyway

SET OF COMPENSATING SHIMS FOR DIE

1x0,4 mm/1x0,8 mm/1x1,2 mm

ADDITIONAL COSTS FOR DIE

499E2M1 H-PM® Quality

PASS BETA-V2® ABS SLITTING TOOL I STATION E



GUIDE ASSEMBLY

Screw M12

Springs for sheet thickness up to 6 mm

Oil channel for sheet lubrication

Simple 10 mm length adjustment
in assembled state by
pressing the locking button

Keyway: 0-90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Fast and easy clamping system
for stripper

Suitable for PDC-system

SLITTING TOOL ADAPTER

4 fixing threads M6

Thread M12 with oil channel for sheet lubrication

SLITTING TOOL

Slitting Tool made with premium H-PM®
(higher hit counts)

STRIPPER

Interchangeable stripper plate with oil channels

PASS BETA-V2® ABS SLITTING TOOL I STATION E

PART-NO.

GUIDE ASSEMBLY

for all shapes 4039E01

SLITTING TOOL ADAPTER

for all shapes 4229ET00

SLITTING TOOL (MAX. 6,35X111) / (H-PM®)

Rectangle 4029ET03

Oblong 4029ET04

*O.D. Ground Special Shapes 4029ET0G

*EDM Required Special Shapes 4029ET0E

STRIPPER

Rectangle 4049ET03

Oblong 4049ET04

*O.D. Ground Special Shapes 4049ET0G

*EDM Required Special Shapes 4049ET0E

REVERSIBLE PLATE ADAPTER

4399ET00

REVERSIBLE PLATE (H-PM®)

Rectangle 4052ET03

Oblong 4052ET04

*O.D. Ground Special Shapes 4052ET0G

*EDM Required Special Shapes 4052ET0E



Reversible plate adapter
with keyway for
PDC-system



Part-no.: „see left“ -2
(e.g.: 4052ET04-2)

SPARE PARTS

PU-ejector Ø 3x6 (in punch)

4092P03

ADDITIONAL COSTS FOR PUNCH

PU-ejector Ø 6x10 (in punch)

4092P06

TICN coating

T-MAX coating

WT-shear

DOWT-shear

2 PT-shear

4 PT-shear

Additional keyway

SET OF COMPENSATING SHIMS FOR SLITTING TOOL ADAPTER

Not necessary

ADDITIONAL COSTS FOR PUNCH GUIDE

Additional keyway

SET OF COMPENSATING SHIMS FOR REVERSIBLE PLATE

1x0,4 mm/1x0,8 mm/1x1,2 mm

499ET60

PASS BETA-V2® SLITTING TOOL I STATION E

CLOSE TO THE CLAMP



GUIDE ASSEMBLY

Screw M12

Springs for sheet thickness up to 6 mm

Oil channel for sheet lubrication

Simple 10 mm length adjustment
in assembled state by
pressing the locking button

Keyway: 0-90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Fast and easy clamping system
for stripper

Suitable for PDC-system

SLITTING TOOL ADAPTER

4 fixing thread M6

Thread M12 with oil channel for sheet lubrication

SLITTING TOOL

Slitting Tool made with premium H-PM®
(higher hit counts)

STRIPPER

Interchangeable stripper plate with oil channels

One or two-sided relief for punching close to clamp

PASS BETA-V2® SLITTING TOOL I STATION E

CLOSE TO THE CLAMP

PART-NO.

GUIDE ASSEMBLY		
	for all shapes	4039ETP01
SLITTING TOOL ADAPTER		
	for all shapes	4229ET00
TRENNSTEMPEL (MAX. 6,35X111) / (H-PM®)		
Rectangle	4029ET03	
Oblong	4029ET04	
*O.D. Ground Special Shapes	4029ET0G	
*EDM Required Special Shapes	4029ET0E	
STRIPPER ONE-SIDED FREE		
Rectangle	4049ETP03-1	
Oblong	4049ETP04-1	
*O.D. Ground Special Shapes	4049ETP0G-1	
*EDM Required Special Shapes	4049ETP0E-1	
STRIPPER TWO-SIDED FREE		
Rectangle	4049ETP03-2	
Oblong	4049ETP04-2	
*O.D. Ground Special Shapes	4049ETP0G-2	
*EDM Required Special Shapes	4049ETP0E-2	
DIE ONE-SIDED FREE (HWS)		
Rectangle	4052ETP03-1	
Oblong	4052ETP04-1	
*O.D. Ground Special Shapes	4052ETP0G-1	
*EDM Required Special Shapes	4052ETP0E-1	
DIE TWO-SIDED FREE (HWS)		
Rectangle	4052ETP03-2	
Oblong	4052ETP04-2	
*O.D. Ground Special Shapes	4052ETP0G-2	
*EDM Required Special Shapes	4052ETP0E-2	



Reversible plate adapter
with keyway for
PDC-system



Part-no.: „see left“ - 2
(e.g.: 4052ETP04-2)

SPARE PARTS	ADDITIONAL COSTS FOR PUNCH
PU-ejector Ø 3x6 (in punch)	TiCN coating
PU-ejector Ø 6x10 (in punch)	T-MAX coating WT-shear DOWT-shear 2 PT-shear 4 PT-shear Additional keyway
SET OF COMPENSATING SHIMS FOR SLITTING TOOL ADAPTER	ADDITIONAL COSTS FOR PUNCH GUIDE
Not necessary	Additional keyway
SET OF COMPENSATING SHIMS FOR DIE	ADDITIONAL COSTS FOR DIE
1x0,4 mm/1x0,8 mm/1x1,2 mm	H-PM® Quality

PASS ALPHA-V2 ABS I STATION E

DIAMETER UP TO 114.3 MM



GUIDE ASSEMBLY

Screw M14

Springs for sheet thickness up to 6 mm

Oil channel for sheet lubrication

Simple 10 mm length adjustment
in assembled state by
pressing the locking button

Keyway: 0-90°

Surface-hardened and polished punch guide
for sheet thickness up to 6 mm

Suitable for PDC-system



PUNCH BODY

Thread M14 with oil channel for sheet lubrication

Punch body made with premium H-PM®
(higher hit counts)

STRIPPER

Interchangeable stripper plate with oil channels

PASS ALPHA-V2 ABS I STATION E

DIAMETER UP TO 114,3 MM

PART-NO.

GUIDE ASSEMBLY		
	for all shapes	4031E01
PUNCH BODY (H-PM®)		
	Round	4021E01
	Square	4021E02
	Rectangle	4021E03
	Oblong	4021E04
	*O.D. Ground Special Shapes	4021E0G
	* EDM Required Special Shapes	4021E0E
PUNCH GUIDE		
	for all shapes	---
STRIPPER		
	Round	4041E01
	Square	4041E02
	Rectangle	4041E03
	Oblong	4041E04
	*O.D. Ground Special Shapes	4041E0G
	* EDM Required Special Shapes	4041E0E
DIE (HWS)		
	Round	4052E01
	Square	4052E02
	Rectangle	4052E03
	Oblong	4052E04
	*O.D. Ground Special Shapes	4052E0G
	* EDM Required Special Shapes	4052E0E



Reversible plate adapter
with keyway for
PDC-system



Part-no.: „see left“ -2
(e.g.: 4052E04-2)

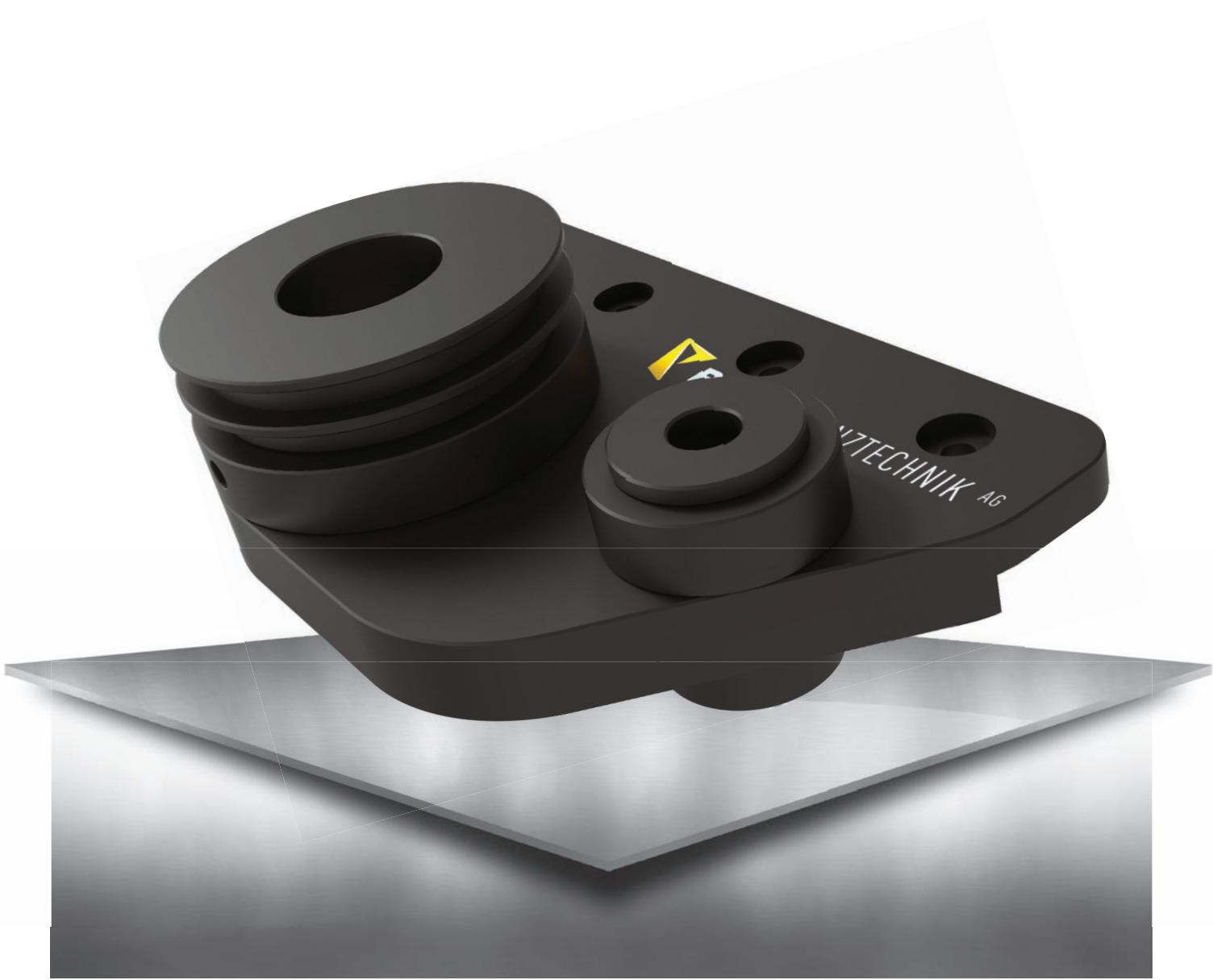
SPARE PARTS

		ADDITIONAL COSTS FOR PUNCH
PU-ejector Ø 3x6 (in punch)	4092P03	TiCN coating
PU-ejector Ø 6x10 (in punch)	4092P06	T-MAX coating
		WT-shear
		DOWT-shear
		2 PT-shear
		4 PT-shear
		Additional keyway

SET OF COMPENSATING SHIMS FOR PUNCH

Not necessary

SET OF COMPENSATING SHIMS FOR DIE	ADDITIONAL COSTS FOR DIE
1x0,4 mm/1x0,8 mm/1x1,2 mm	499E2M1 H-PM® Quality



ACCESSORIES

PASS ACCESSORIES FOR YOUR
THICK TURRET SYSTEM

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PASS Assembly adapter kit	Page 58
PASS Assembling set	Page 59
PASS Adapter	Page 60
PASS Shimkeeper	Page 61

PASS ASSEMBLY ADAPTER KIT

Station A



Station B



Station C



Station D



Station E



PART-NO.

COMPLETE SET ASSEMBLY KIT

Set consists of: 499M09SET

5 assembly adapter

1 assembling plate



equipped plate with adapter

PASS ASSEMBLING SET

FOR PASS GUIDE ASSEMBLY / STAT. C, D, E AND FOR PASS MULTITOOL GUIDE ASSEMBLY / STAT.D
/ FOR PASS ps:multi-thread

PART-NO.

ASSEMBLING SET - CONSISTING OF

Torque wrench / 25-130Nm 499MONKIT

incl. 4 socket wrench
SW 7 / SW10 / SW 12 / SW 14

Multipurpose Grease 400 gr.
Triangular Whetstone

Diamond needle file with quick-acting clamp



PASS ADAPTER

Punch adapter

Surface-hardened and polished



Die adapter

Surface-hardened and polished

2 Clamp screws



PASS ADAPTER		STATION	PART-NO.
Punch adapter	B/A	401BAS1	
Die adapter	B/A	401BAM1	
Punch adapter	C/B	401CBS1	
Die adapter	C/B	401CBM1	
Punch adapter	D/A	401DAS1	
Die adapter	D/A	401DAM1	
Punch adapter	D/B	401DBS1	
Die adapter	D/B	401DBM1	
Punch adapter	D/C	401DCS1	
Die adapter	D/C	401DCM1	

PASS DIES (WITH BRUSH INSERTS)

	STATION	PART-NO.
PASS DIES WITH BRUSH INSERTS		
1x Ø13	A	441711A01
3x Ø13	B	441711B01
7x Ø13	C	441711C01
19x Ø13	D	441711D01
35x Ø13	E	441711E01





SPECIAL SHAPES

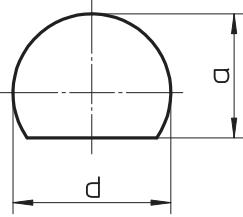
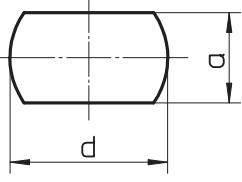
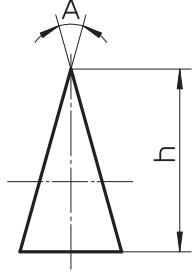
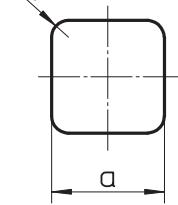
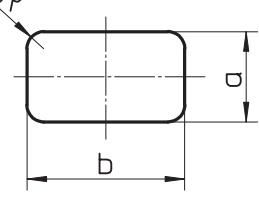
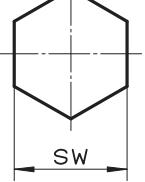
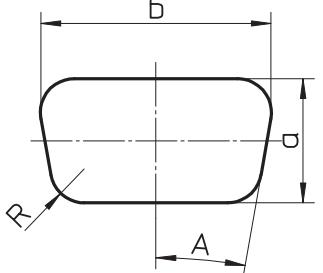
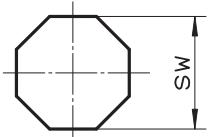
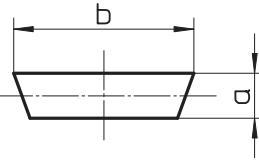
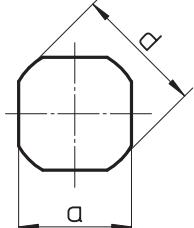
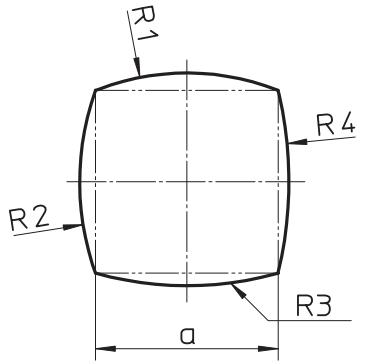
INFORMATION ABOUT OUR TOOLS
FOR YOUR THICK TURRET SYSTEM

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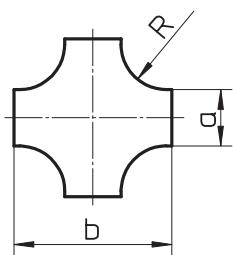
O.D. GROUND SPECIAL SHAPES

HK UP TO 50,8 MM

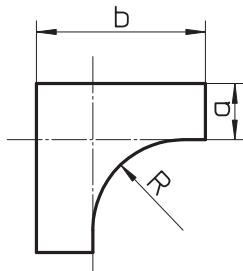
 <p>G01</p>	 <p>G02</p>	 <p>G03</p>
 <p>G04</p>	 <p>G05</p>	 <p>G06</p>
 <p>G07</p>	 <p>G08</p>	 <p>G09</p>
 <p>G10</p>	 <p>G11</p>	

EDM REQUIRED SPECIAL SHAPES

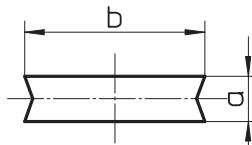
HK UP TO 50,8 MM



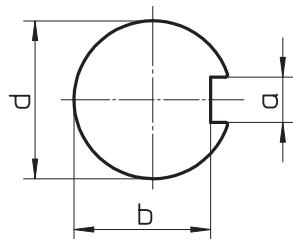
E01



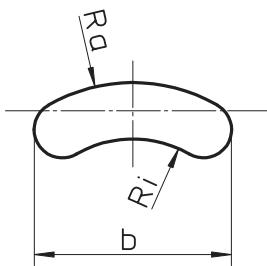
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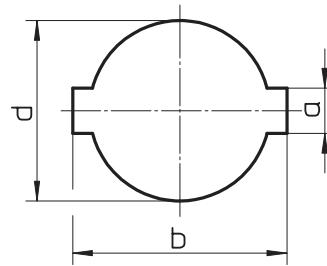
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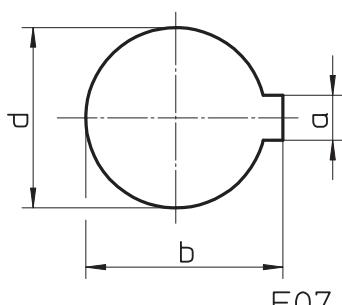
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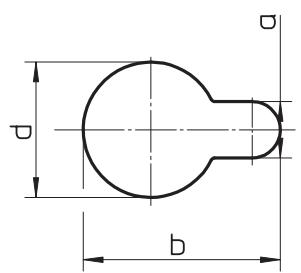
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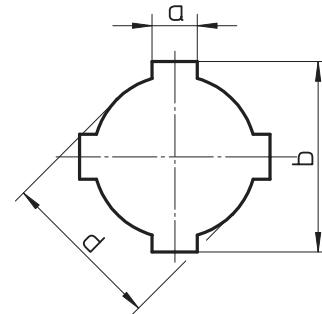
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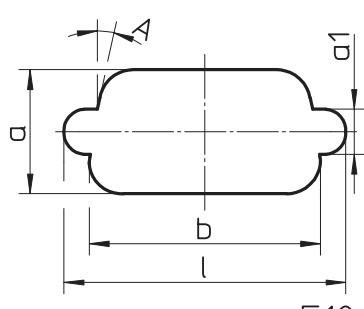
E07



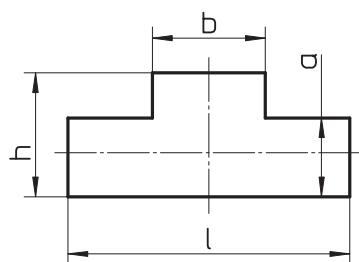
E08



E09



E10



E11



FOR ALL THOSE, WHO LIKE TO UNDERSTAND EXACTLY

IMPORTANT INFORMATION ABOUT OUR TOOLS
FOR YOUR THICK TURRET SYSTEM

INDEX

Steel information	Seite 68
Life-time of tools / regrinding advice	Seite 69

PASS STEEL IDENTIFICATIONS

HWS

HWS is known as secondary hardened cold work steel with superior toughness. This type of steel is especially suitable for dies.

Advantage for customer:

- excellent cost in accordance to performance

H-PM®

H-PM® steel is known as steel made on a powder-metallurgical base with a high degree of purity.

This guarantees a segregational uniformed microstructure in the complete cross-section of the tool.

Advantage for customer:

- excellent cost in accordance to performance
- good stability for edges by increased toughness
- high tool life-time due to the unformed microstructure
- increased current hit-flex-capability; suitable as an excellent base for dies

X3-PM

The X3-PM is known as a high-end powder-metallurgical steel with the best possible performance characteristics for punches in the punching technology due to the best possible degree of purity.

The segregational uniformed microstructure with high vanadium concentration in the complete cross-section of the punch guarantees best possible wear resistant regarding tool life-time.

Advantage for customer:

- best efficiency by multiple increase of the punch hit count
- best possible stability for cutting edges
- extremely high abrasion resistance
- utmost compressive strength

X8-PM

The X8-PM is known as a high-end powder metallurgical steel with the best possible performance characteristics for dies in the punching technology caused by best possible degree of purity.

The high ductility of the segregational uniformed microstructure guarantees best possible fatigue limit. This kind of steel is especially suitable for dies with risk-breakage in regards to special contours.

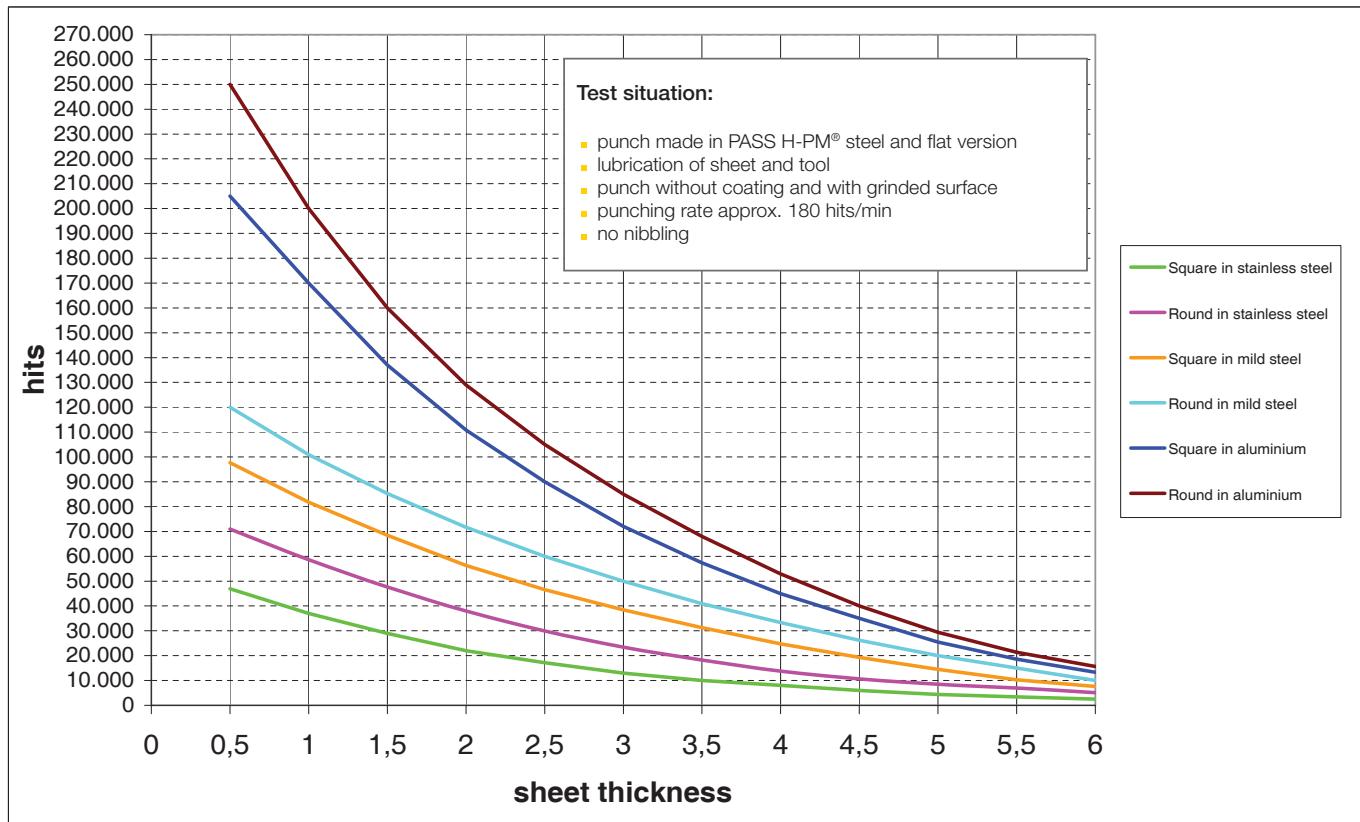
Advantage for customer:

- best possible absorption of hit-flex stress; prevents fatigue breakage.
- high abrasion resistance



LIFE-TIME OF TOOLS / REGRIND ADVICE

PASS punches and dies are made of high-end special steel in order to guarantee best life-time of tools together with high robustness.



INFLUENCING FACTORS

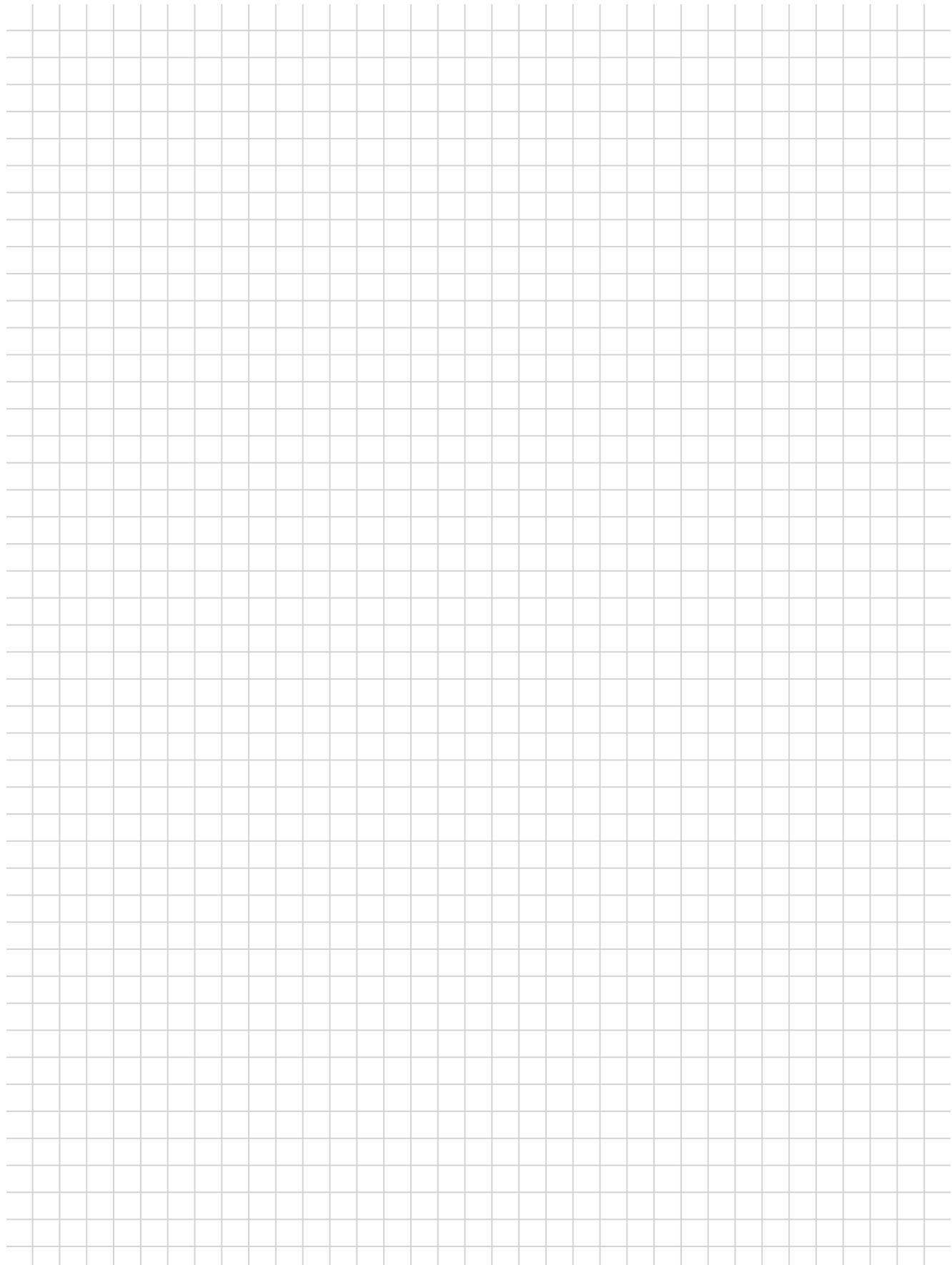
FACTOR

Zinc coated sheet / stainless steel with foil / aluminium anodized	0,5 - 0,8
No sheet-lubrication	0,4 - 0,6
Punch coating (TICN for stainless steel / T-MAX for zinc coated steel / A-Max for aluminium / C-Max for copper)	2,0 - 4,0
PASS-punch made with special X3-PM steel	6,0 - 10,0
Nibbling	0,7 - 0,9
Corner-punching	0,5 - 0,7
Whisper Tool	0,8 - 0,9
Punching rate > 300 hits / min.	0,8 - 0,9
Cutting part with EDM surface	0,4 - 0,8
Cutting part with polished surface	1,5 - 3,0
Cutting part smaller than 1,5x sheet thickness	0,6 - 0,8
Cutting part smaller than 1,0x sheet thickness	0,3 - 0,5
Using of a too close radius	0,4 - 0,9

An average decrease of the tool life of 5-10% per regrind has to be taken in account for the first regrind.

NOTES

NOTES



SALVAGNINI | **THICK TURRET** | **TRUMPF**



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