



T O O L I N G   F O R   P U N C H   P R E S S E S



# JETFORM

CATALOG

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TOOLING FOR PUNCH PRESSES



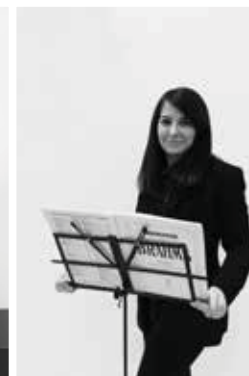
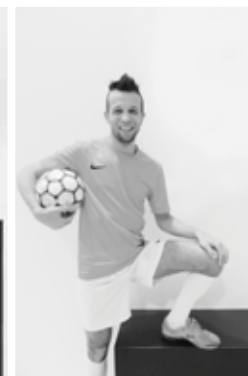
### A story of enthusiasm and passion

Matrix's natural vocation for innovation was enhanced in 2017, when Matrix joined the Salvagnini Group, a historic manufacturer of sheet metalworking machinery. This established Matrix as an international tool manufacturer.



### Our value lies in our team

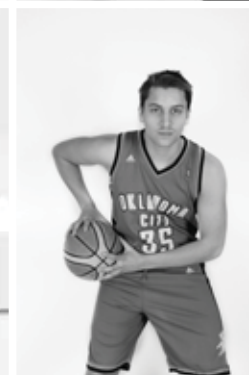
Each and every day, our energy and know-how transform our customers' needs into immediate and lasting added value. The tools we produce are the result of decades of experience and reflect our spirit for exploration.



### Each customer is special

We want to go beyond product quality and excellent service.

Our mission is to make our customers more competitive in their own sectors.

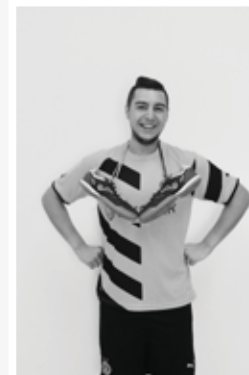


### Technology and reliability

The constant search for improvement and the use of excellent raw materials help us to establish lasting cooperation with our customers.

Each day we invest in the most advanced and reliable technology: sophisticated control systems, latest-generation software and constant machinery upgrading.

Our focus is always on the future.





## JETFORM

Forming is the process whereby the flatness of a sheet of metal is modified. The tools in the JETFORM range perform these operations, making punching machine use even more efficient. Many types of forming operations are possible. They can be combined with parting operations such as extrusion and coining.

The JETFORM insert-holder range is available for B, C, D and E stations. It follows the punch-holder philosophy of using interchangeable inserts to minimize the cost of new forming operations.

Matrix offers two different types of insert-holder, so as to better satisfy different customer needs.

The G series features precise tool height adjustment in steps, making it the best choice for punching machines where stroke adjustment is unpredictable or absent.

The W series, on the other hand, is non-adjustable, taking advantage of the precise stroke adjustment typical of latest-generation punching machines and making forming operations on such machines even more advantageous.

All insert-holders also allow all components to be fully lubricated by adding a specific oil from the top, either automatically or manually.



## LUBRICATION: INDISPENSABLE

This is one of the first rules to apply. As punching is a cutting process, lubrication in the processing area is essential for success. Lubrication plays a very important role in punching machines and, in particular, in punching tools.

When the tool passes through the material being cut, small amounts of this material may adhere to the surface of the punch.

Appropriate lubrication increases tool life by significantly reducing friction and thus overheating, as well as material accumulation on the tool.

On machines without an automatic lubrication system, the hole in the middle must be filled with oil for sliding surfaces on a daily basis and whenever the setup is changed.

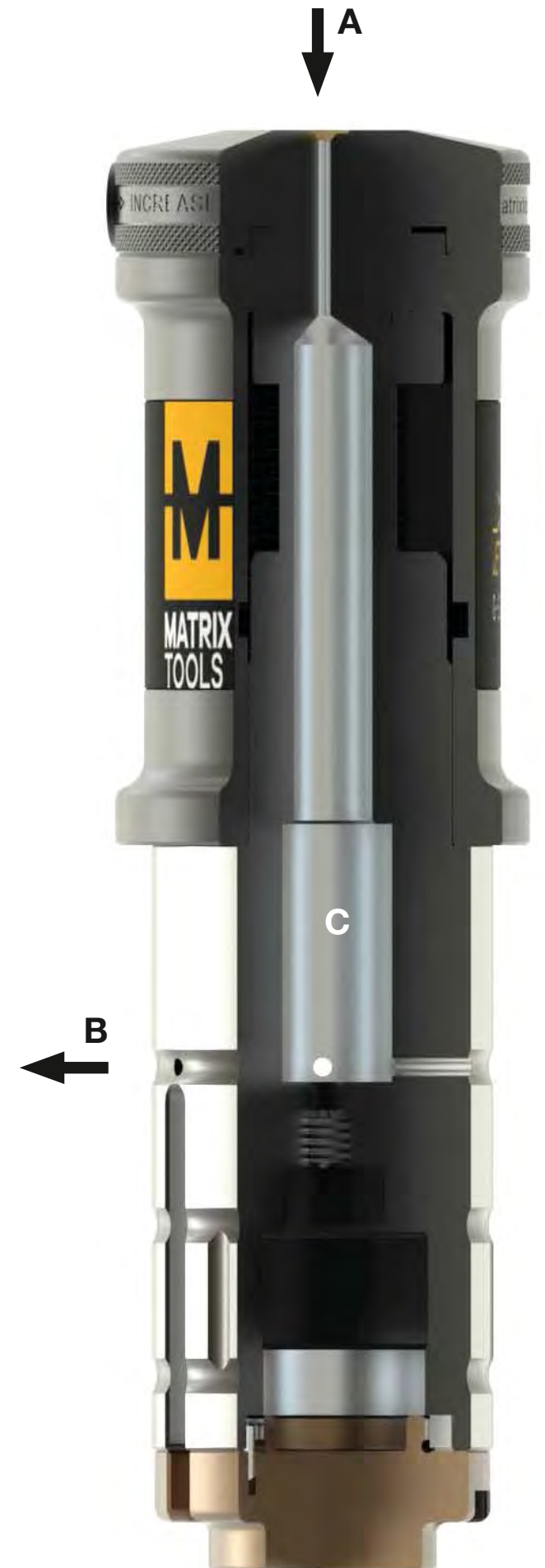
Failure to do so will cause excessive wear on the insert-holders.

The diagram on the left, valid for A and B stations, shows the areas affected by the presence of lubricant.

The letters indicate respectively:

- A** Hole for adding lubricant
- B** Hole that allows the lubricant to reach the contact area between the outside walls of the punch-holder and the seat in the punching machine
- C** Lubricant tank

Matrix can supply lubricants suitable for different types of processing. Volatile oils are also available if grease residue needs to be avoided.



## COMMON FORMINGS

jetform

Some of the most common sheet metal forming operations are embossing, countersinking, extrusion, engraving, louver forming and so on.

The wide diffusion of these forming operations means that we can handle an extensive range of standardized products, drastically reducing delivery times. This type of forming is in continuous expansion. Please contact our sales department to find out more about what is new.



**M01**  
ENGRAVED COUNTERSINK  
FORMING



**M02**  
EXTRUDED HOLE  
FORMING



**M03**  
ROUND EMBOSS  
FORMING



**M04**  
ROUND COUNTERSINK  
FORMING



**M09**  
CLIP  
PUNCHING AND FORMING



**M12**  
CURVED-BLADE LOUVER  
PUNCHING AND FORMING



**M13**  
BUTTON  
PUNCHING AND FORMING



**M14**  
ENGRAVING  
ENGRAVING



**M23**  
DOT MARKER  
ENGRAVING



**M24**  
CLIP WITH BUTTON  
PUNCHING AND FORMING



**M25**  
REINFORCED CLIP  
PUNCHING AND FORMING



**M10**  
MULTIPLE KNOCKOUT  
PUNCHING AND FORMING



**M22**  
CUSTOM LOGOS  
EMBOSS



**M26**  
EMBOSS FOR CABLES  
PUNCHING AND FORMING



**M27**  
BRIDGE WITH EXTRUDED HOLE  
PUNCHING AND FORMING



**M28**  
BEND  
FORMING



**M29**  
HINGE  
FORMING



**M33**  
NON-SLIP TREAD PLATE  
PUNCHING AND FORMING

## SPECIAL FORMINGS

jetform

Our technical department is able to develop the very best solutions for customer problems and requirements. Thanks to this versatility, there are practically no limits on the types of forming that can be made and we are able to satisfy the most complex and disparate requirements. The continuous search for new production solutions means that we continue to find new forming possibilities, creating three-dimensional shapes alongside normal high- or low-embossed logos.

## PROGRESSIVE FORMINGS AND SPECIAL APPLICATIONS

jetform

The latest technical solutions implemented in modern punching machines deliver decidedly superior tool control compared to the past. This has allowed us to develop new applications capable of fully exploiting their potential. Indeed, we have developed special tools for cutting protective film, creating continuous ribs and even deburring cut parts. These are just some examples of what you can get from your punching machine when you use tools produced by Matrix!



**M15**  
PROGRESSIVE LOUVER  
PUNCHING AND FORMING



**M20**  
PROGRESSIVE OBROUND EMBOSS  
FORMING



**M31**  
DEBURRER  
FORMING



**M32**  
FILM CUTTER  
ENGRAVING



**M41**  
ROLLFORM OFFSET  
FORMING



**M42**  
ROLLFORM RIB  
FORMING



TOOLING FOR PUNCH PRESSES



# JETFORM INSERT-HOLDERS



## JETFORM - G SERIES

Adjustable height

The accurate tool height adjustment, in 0.08 mm steps, offered by the G Series of insert-holders, maximizes the performance of punching machines that feature inaccurate or no stroke adjustment.



## JETFORM - G SERIES

### Adjustable height

A large number of tool configurations for the most common forming operations are already available for fast delivery. Please contact our sales department for an up-to-date list.



## JETFORM - W SERIES

Fixed height

The W Series of punch-holders makes forming operations on punching machines that already offer stroke adjustment extremely advantageous.



## JETFORM - W SERIES

Fixed height

A large number of tool configurations for the most common forming operations are already available for fast delivery. Please contact our sales department for an up-to-date list.







ROLLFORM

## M41 ROLLFORM - OFFSET

Complete Tool: TTB-JOFST

### SETS OF INSERTS

RollFORM tools are an evolution of our JetFORM range for high-speed forming operations on punching machines.

An efficient solution for making embosses and offsets on sheet metal, the RollFORM series reduces costs by using interchangeable inserts.

Sets of inserts are designed to be used with a specific material and thickness.

Standard sets of inserts are designed for forming operations up to 3.2 mm high, whereas special sets of inserts are designed for heights from 1.5 to 4.7 mm.

RollFORM tools require hydraulic or electric punching machines with ram stroke control and the appropriate software applications.



## M42 ROLLFORM - RIB

Complete Tool: TTB-JRB

### SETS OF INSERTS

RollFORM tools are an evolution of our JetFORM range for high-speed forming operations on punching machines.

An efficient solution for making embosses and offsets on sheet metal, the RollFORM series reduces costs by using interchangeable inserts.

Sets of inserts are designed to be used with a specific material and thickness.

Standard sets of inserts are designed for forming operations up to 3.2 mm high, whereas special sets of inserts are designed for heights from 1.5 to 4.7 mm.

RollFORM tools require hydraulic or electric punching machines with ram stroke control and the appropriate software applications.



## M43 ROLLFORM - PINCHER

Complete Tool: TTB-JPNCH

### SETS OF INSERTS

RollFORM tools are an evolution of our JetFORM range for high-speed forming operations on punching machines.

An efficient solution for partially cutting the sheet so as to make it easier to separate the parts.

The RollFORM series guarantees reduced costs thanks to interchangeable inserts.

The sets of inserts are designed to be used on a wide range of materials and thicknesses.

RollFORM tools require hydraulic or electric punching machines with ram stroke control and the appropriate software applications.



Upper Insert-holder



Lower Insert-holder



PINCHER Upper Insert



Support



Support



PINCHER Lower Insert



Lower Insert-holder



T O O L I N G F O R P U N C H P R E S S E S



# JETFORM SETS OF INSERTS



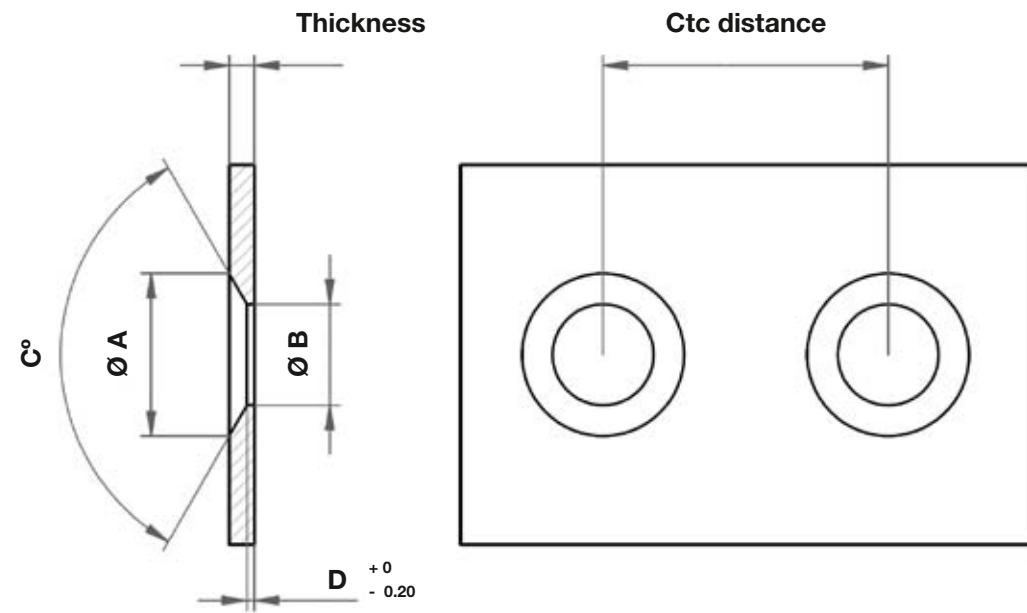
## M01 ENGRAVED COUNTERSINK



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

### SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set. If the forming is destined to house a screw, and the top of the screw needs to be below the surface of the sheet, the data sheet for the screw must be provided.



Measurements Required (indicate the most important ones)					
A	B	C°	D	Thickness	Ctc distance

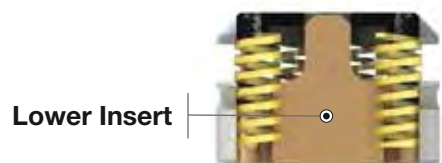
Dimensional Limits			
Material	C°	Thickness	Maximum Forming (Thickness - D)
Mild steel	Maximum 100°	1.20 to 2.00	85 %
		2.10 to 3.00	60 %
		Above 3.00	50 %
Aluminum	Maximum 100°	Above 1.20	85 %
Stainless Steel	Maximum 100°	1.20 to 2.00	85 %
		2.10 to 3.00	60 %
		Above 3.00	50 %

All measurements are expressed in mm

In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.



Upper Insert-holder



Lower Insert-holder



Upper Insert



Stripper



Springs



Lower Insert



Screws

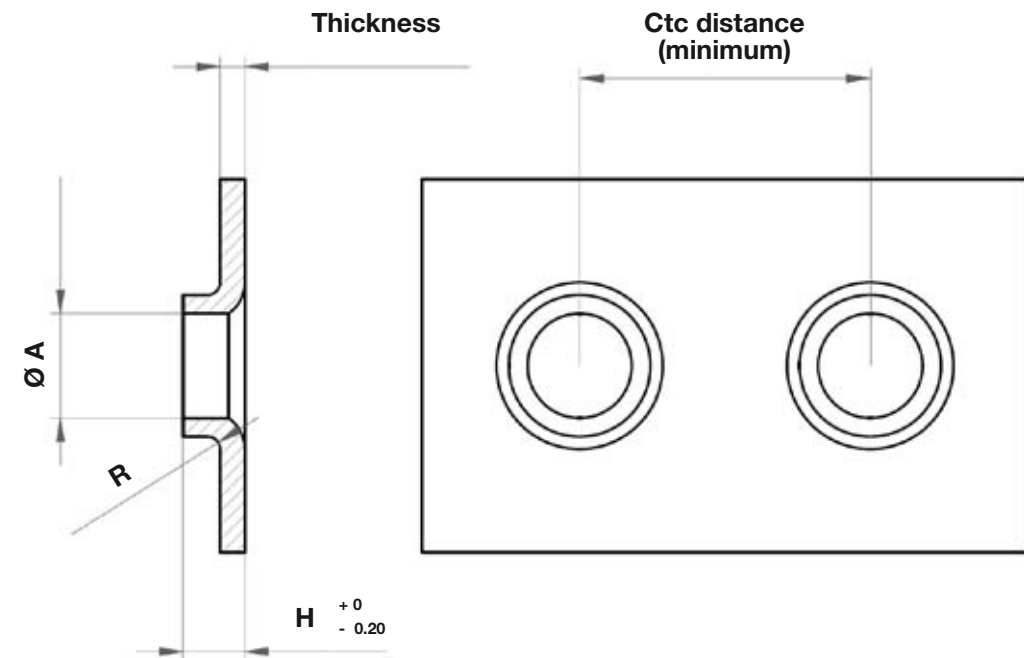
## M02 EXTRUDED HOLE



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

### SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set. Processing requires an appropriate pre-hole. Multiple forming operations close together could distort the sheet. Each set of inserts is composed of the elements shown below. All lower inserts are equipped with B type coating.



Measurements Required (indicate the most important ones)

Thread	A	Thickness	H	R	Ctc distance

Dimensional Limits

A	H	Thickness
Maximum 10	Maximum 2.5 x Thickness	Maximum 5

Standard Set of Inserts for Thick Turret B Station

Thread	A	Pre-hole	Thickness	Code of Set of Inserts	H	R	Ctc distance
M4	3.3	2.0 ±10%	0.80 to 1.00	FB09237421.305	2.5	0.5	10.8
			1.10 to 1.30	FB09237421.979	3.0	0.6	11.1
			1.40 to 1.60	FB09237421.A43	3.75	0.75	11.55
M5	4.2	2.5 ±10%	0.80 to 1.00	FB09237422.305	2.5	0.5	11.7
			1.10 to 1.30	FB09237422.979	3.0	0.6	12.0
			1.40 to 1.60	FB09237422.A43	3.75	0.75	12.45
M6	5.0	3.0 ±10%	0.80 to 1.00	FB09237423.305	2.5	0.5	12.5
			1.10 to 1.30	FB09237423.979	3.0	0.6	12.8
			1.40 to 1.60	FB09237423.A43	3.75	0.75	13.25
M8	6.8	4.1 ±10%	0.80 to 1.00	FB09237424.305	2.5	0.5	14.3
			1.10 to 1.30	FB09237424.979	3.0	0.6	14.6
			1.40 to 1.60	FB09237424.A43	3.75	0.75	15.05
			1.90 to 2.10	FB09237424.217	5.0	1.0	15.8
M10	8.5	5.1 ±10%	0.80 to 1.00	FB09237424.305	2.5	0.5	16.0
			1.10 to 1.30	FB09237424.979	3.0	0.6	16.3
			1.40 to 1.60	FB09237424.A43	3.75	0.75	16.75
			1.90 to 2.10	FB09237424.217	5.0	1.0	17.5

All measurements are expressed in mm

In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.



# M03 ROUND EMBOSS



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

## SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set. Processing requires an appropriate pre-hole.  
Multiple forming operations close together could distort the sheet.  
If the forming is destined to house a screw, and the screw thread needs to be beneath the surface of the sheet, the data sheet for the screw must be provided.  
Each set of inserts is composed of the elements shown below.



Upper Insert



Stripper



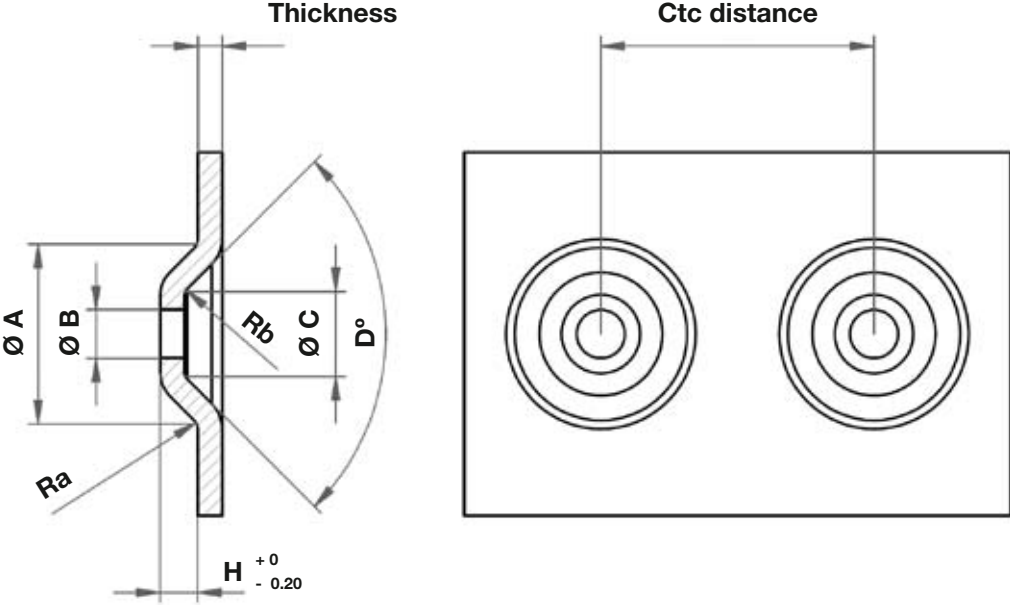
Springs



Lower Insert



Screws



Measurements Required (indicate the most important ones)								
A	B	C	D°	H	Ra	Rb	Thickness	Ctc distance

Dimensional Limits				
Station	D°	H	Thickness	Recommended Center-to-center Distance
B	Minimum 80°	Maximum 6	0.50 to 3.00	Minimum A + 3 x Thickness
C	Minimum 80°	Maximum 7	0.50 to 3.00	Minimum A + 3 x Thickness
D	Minimum 80°	Maximum 7	0.50 to 3.00	Minimum A + 3 x Thickness

All measurements are expressed in mm



In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.



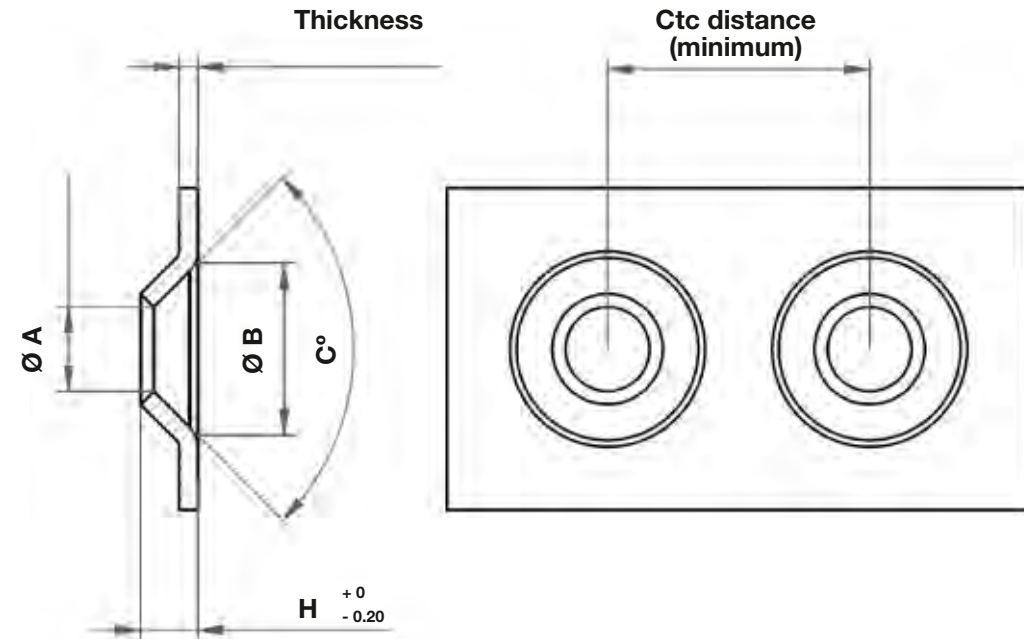
## M04 ROUND COUNTERSINK



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

### SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set. Processing requires an appropriate pre-hole.  
Multiple forming operations close together could distort the sheet.  
If the forming is destined to house a screw, and the screw thread needs to be beneath the surface of the sheet, the data sheet for the screw must be provided.  
Each set of inserts is composed of the elements shown below.



Measurements Required (indicate the most important ones)					
A	B	Thickness	H	C°	Ctc distance

Standard Set of Inserts for Thick Turret B Station								
Screw	A	B	Pre-hole	Thickness	Code of Set of Inserts	H	C°	Ctc distance
M4	4.5	9.2	3.66 ±10%	0.80 to 1.20	FB09237239.305	3.06	90°	14.0
			4.43 ±10%	1.50 to 1.90	FB09237239.BP5	3.55	90°	14.61
			4.43 ±10%	2.00 to 2.50	FB09237239.844	3.91	90°	15.0
M5	5.5	11.2	4.25 ±10%	0.80 to 1.20	FB09237240.305	3.56	90°	16.0
			5.02 ±10%	1.50 to 1.90	FB09237240.BP5	4.05	90°	16.6
			5.57 ±10%	2.00 to 2.50	FB09237240.844	4.41	90°	17.0
M6	6.5	13.2	4.83 ±10%	0.80 to 1.20	FB09237241.305	4.06	90°	18.0
			5.61 ±10%	1.50 to 1.90	FB09237241.BP5	4.55	90°	18.6
			6.16 ±10%	2.00 to 2.50	FB09237241.844	4.91	90°	19.0
M8	8.5	17.4	5.92 ±10%	0.80 to 1.20	FB09237242.305	5.16	90°	22.2
			6.70 ±10%	1.50 to 1.90	FB09237242.BP5	5.65	90°	22.8
			7.25 ±10%	2.00 to 2.50	FB09237242.844	6.01	90°	23.2
M10	12	21.6	9.13 ±10%	0.80 to 1.20	FB09237243.305	5.51	90°	26.4
			9.91 ±10%	1.50 to 1.90	FB09237243.BP5	6.0	90°	27.0
			10.46 ±10%	2.00 to 2.50	FB09237243.844	6.36	90°	27.4

All measurements are expressed in mm

In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.



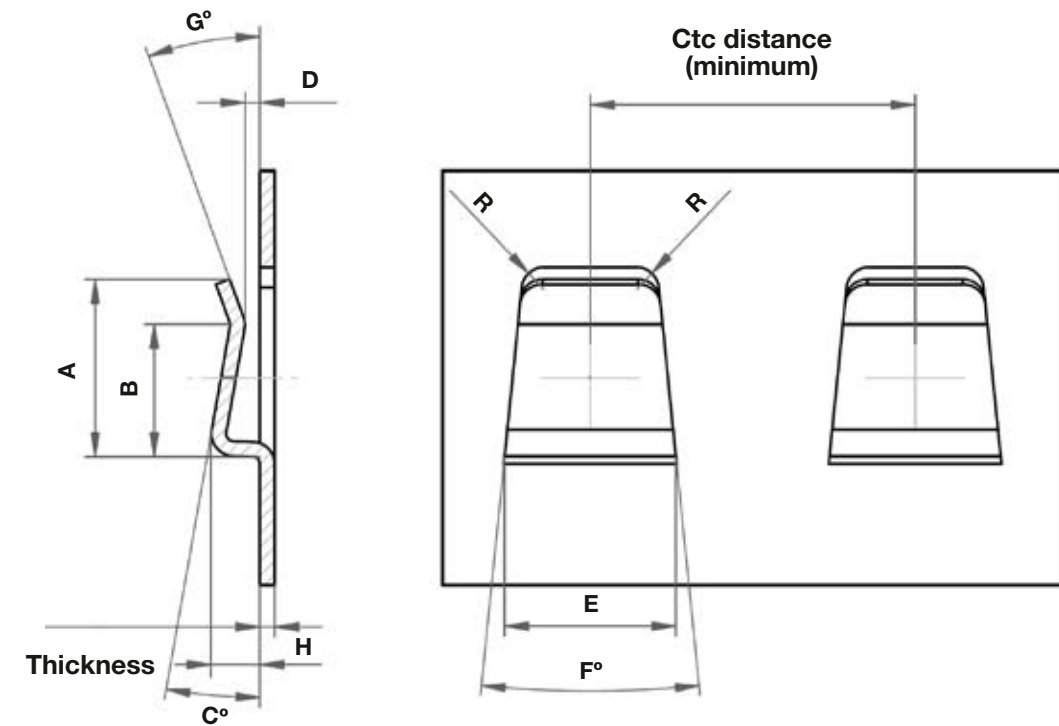
## M09 ELASTIC CLIP



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

### SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set.



Measurements Required (indicate the most important ones)

A	Thickness	B	C°	D	E	F°	H	Ctc distance

Dimensional Limits

F°	H
Minimum 10°	Maximum 5

Standard Set of Inserts for Thick Turret B Station

A	Thickness	Code of Set of Inserts	B	C	D	E	F°	H	Ctc distance
12	0.80 to 1.00	FB08237255.305	5.34	3.63	1.00	11,599	11,592	4.30	22.00
	1.10 to 1.30	FB08237255.979	5.46	3.70	1.20	11,600	11,408	4.90	
	1.40 to 1.60	FB08237255.A43	5.64	3.81	1.50	11,603	11,144	5.80	

All measurements are expressed in mm

In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.

# M10 KNOCKOUT



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

## SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set.



Spring



Ejector



Upper Insert



Stripper



Springs



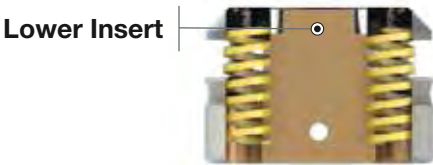
Lower Insert



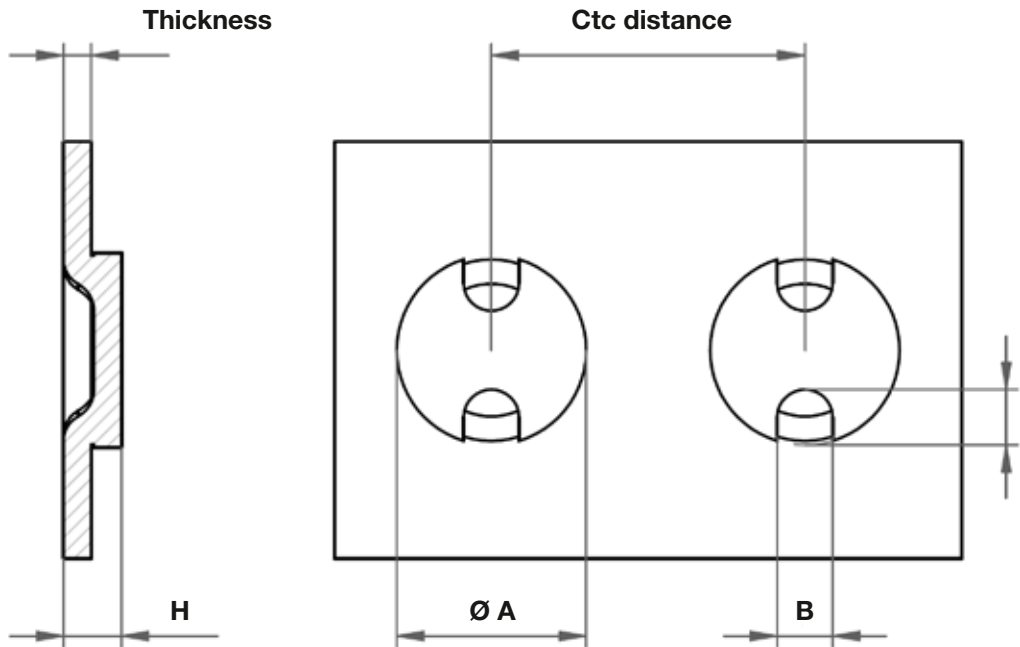
Screws



Upper Insert-holder



Lower Insert-holder



Measurements Required (indicate the most important ones)					
A	B	C	H	Thickness	Ctc distance

Dimensional Limits		
B	C	Thickness
3 x Thickness	2.5 x Thickness	Maximum 3

All measurements are expressed in mm



In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.



## M12 LOUVER



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

### SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set.



Screws

Upper Insert



Upper Parting Insert



Stripper



Springs



Lower Insert



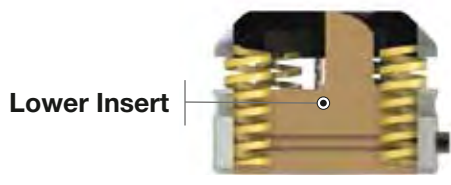
Screws



Upper Insert

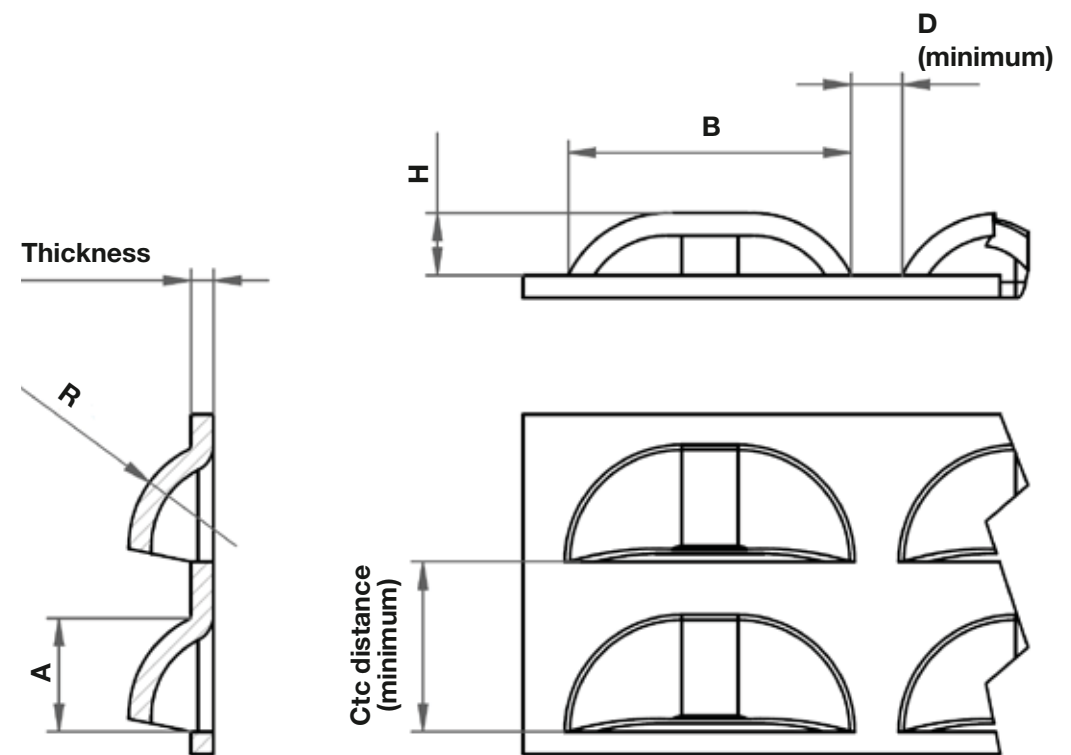
Upper Parting Insert

Upper Insert-holder



Lower Insert

Lower Insert-holder



Measurements Required (indicate the most important ones)							
Thickness	Station	A	B	C	H	R	Ctc distance

Dimensional Limits		
Station	B	H
B	25.00	5.50
C	50.00	6.00
D	80.00	7.00

Standard Set of Inserts for Thick Turret								
Thickness	Station	Code of Set of Inserts	A	B	C	H	R	Ctc distance
0.80 to 2.00	B	FB08236968	10.00	25.00	4.50	5.50	9.50	15.00
	C	FB10236968	12.00	50.00	10.50	6.00	10.00	17.00
	D	FB12236968	15.00	80.00	16.50	7.00	14.00	20.00

All measurements are expressed in mm

In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.

# M13 SHEAR BUTTON

The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

## SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set.



Spring



Ejector



Upper Insert



Stripper



Springs



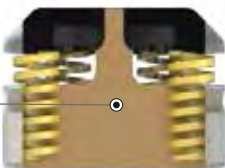
Lower Insert



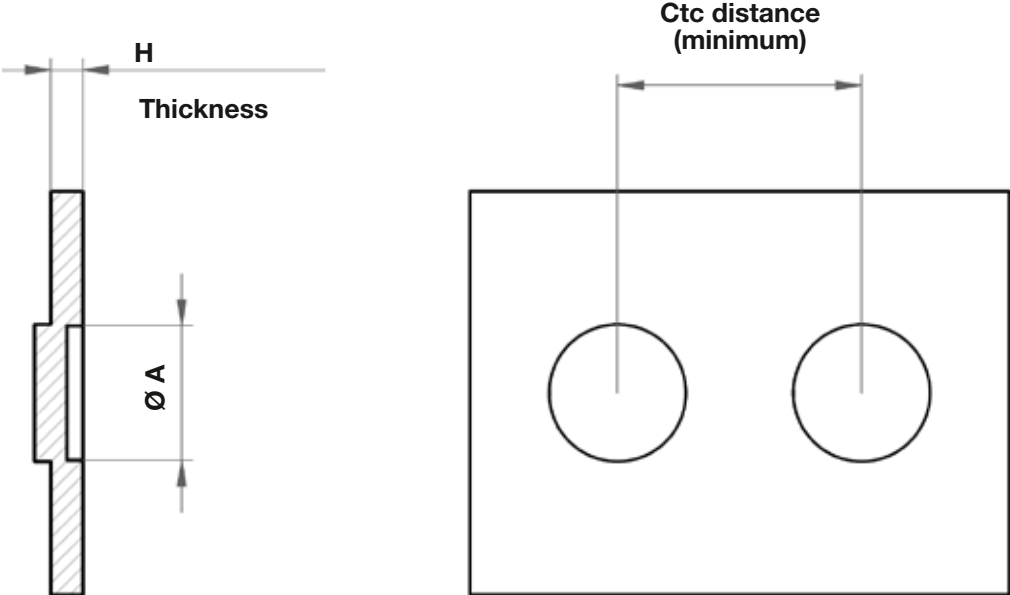
Screws



Upper Insert-holder



Lower Insert-holder



Measurements Required (indicate the most important ones)

A	Thickness	H	Ctc distance

Standard Set of Inserts for Thick Turret B Station

A	Code of Set of Inserts	Thickness	H	Ctc distance
5.00	FB09237471	1.00 to 4.00	Maximum Thickness x1.5	9.10
8.00	FB09237470			12.10

All measurements are expressed in mm



In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.

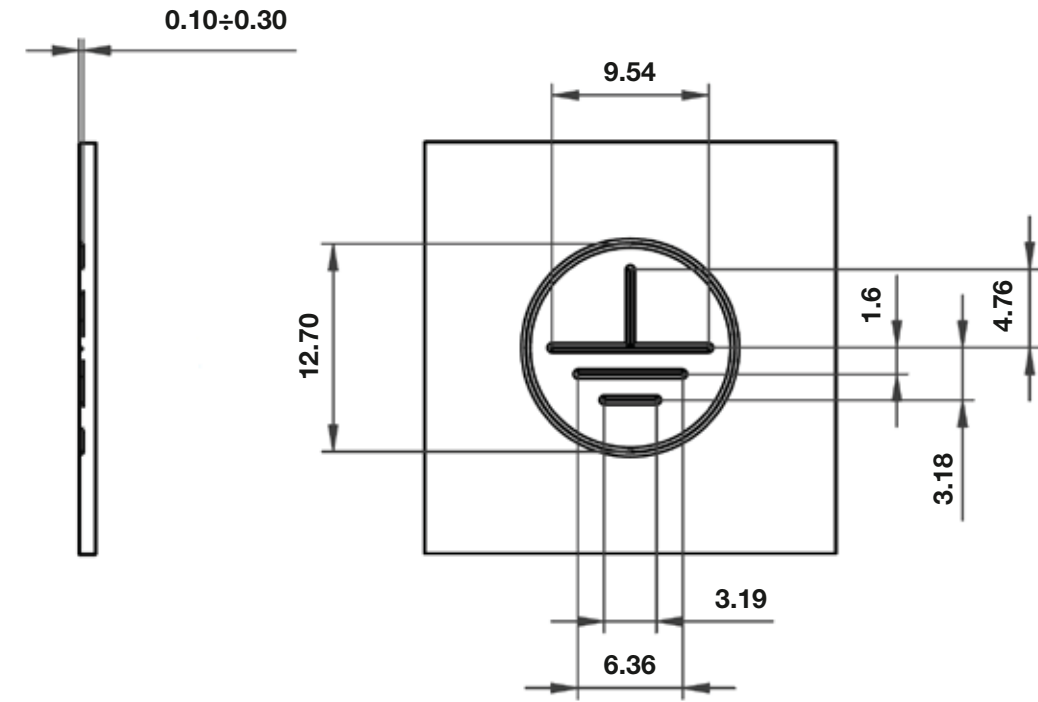
## M14 EARTH SYMBOL



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

### SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set.  
The set of inserts offered can obtain a standard earth symbol with or without a circle, either upwards or downwards.



Standard Set of Inserts for Thick Turret B Station			
Circle	Type	Code of Set of Inserts	Thickness
Yes	from the bottom	FB08238173	0.50 to 4.00
	from the top	FB08237273	
No	from the bottom	FB08238174	0.50 to 4.00
	from the top	FB08237274	

All measurements are expressed in mm





# M15 PROGRESSIVE LOUVER



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

### SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set.



Screws



Upper Insert



Upper Parting Insert



Stripper



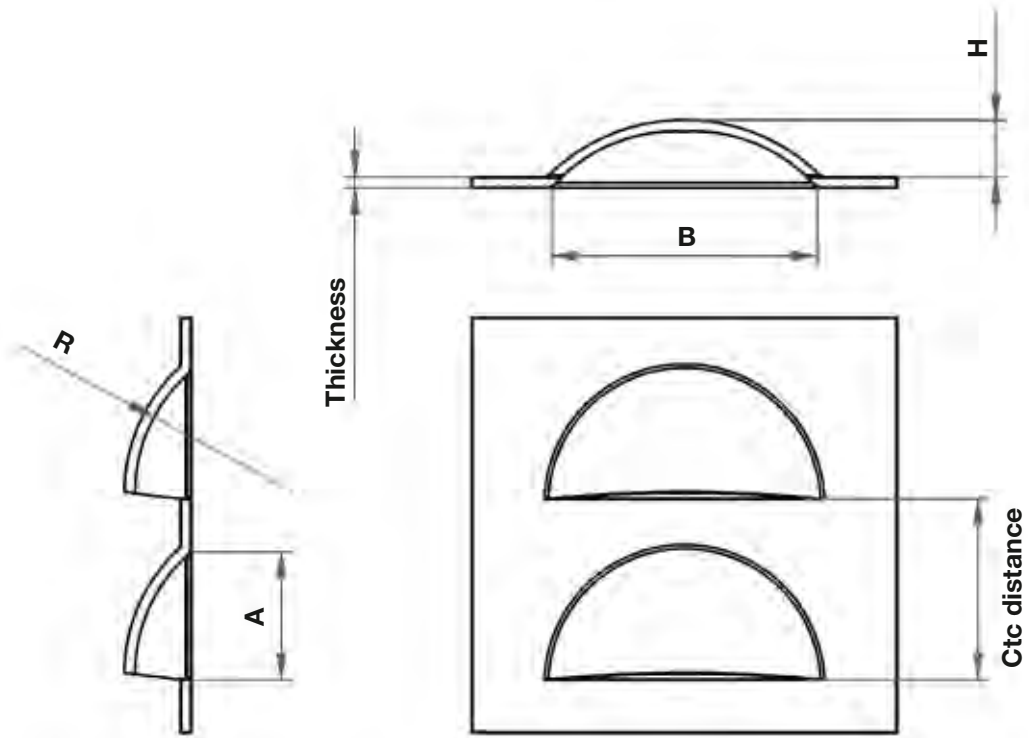
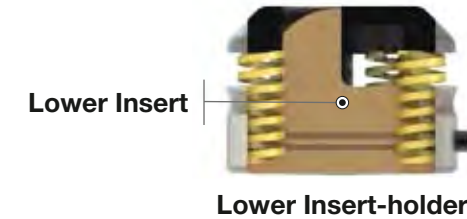
Springs



Lower Insert



Screws



Standard Set of Inserts for Thick Turret							
Station	A	B	H	R	Thickness	Code of Set of Inserts	Ctc distance
B	12.00	25.00	5.30	15.00	0.80 to 1.20	FB08237476.305	17.00
					1.30 to 1.70	FB08237476.A43	17.00
					1.80 to 2.50	FB08237476.844	17.00

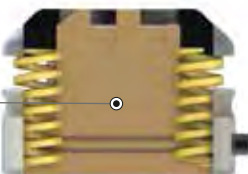
All measurements are expressed in mm



M17 SEAT FOR SELF-THREADING SCREW



Spring  
Ejector  
Upper Insert  
Upper Insert-holder



Lower Insert  
Lower Insert-holder

**SETS OF INSERTS**  
Can be used on W and G Series insert-holders, not included in the standard set.



Spring

Ejector

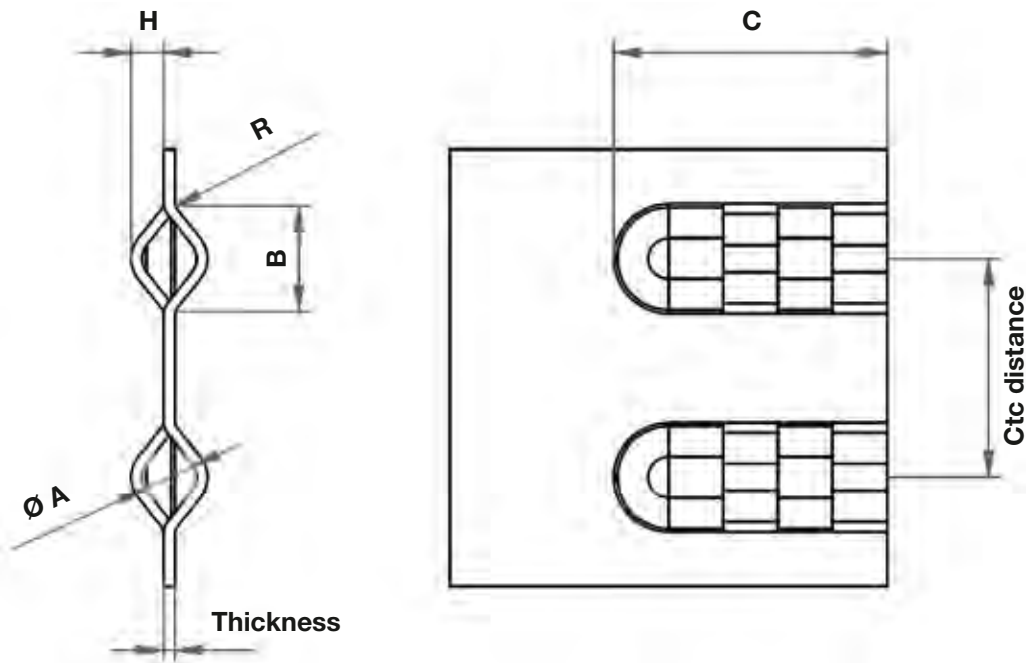
Upper Insert

Stripper

Springs

Lower Insert

Screws



Measurements Required (indicate the most important ones)						
Thickness	Ø A	B	C	H	R	Ctc distance

All measurements are expressed in mm



In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.



## M20 PROGRESSIVE OBROUND EMBOSS



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

### SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set.



Upper Insert



Stripper



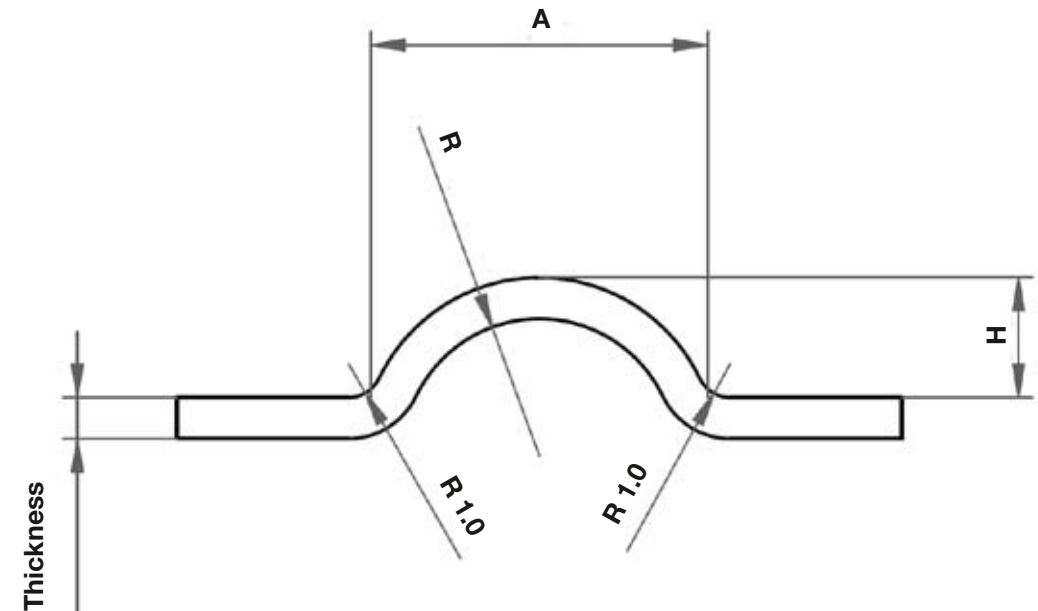
Springs



Lower Insert



Screws



Measurements Required (indicate the most important ones)

R	A	Thickness	H

Dimensional Limits

A	H
Minimum H x 2	Maximum 5.00

Standard Set of Inserts for Thick Turret B Station

R	A	Thickness	Code of Set of Inserts	H
4.00	9.83	0.80 to 1.60	FB08237291.979	3.50
	11,533	2.00 to 3.00	FB08237291.218	

All measurements are expressed in mm





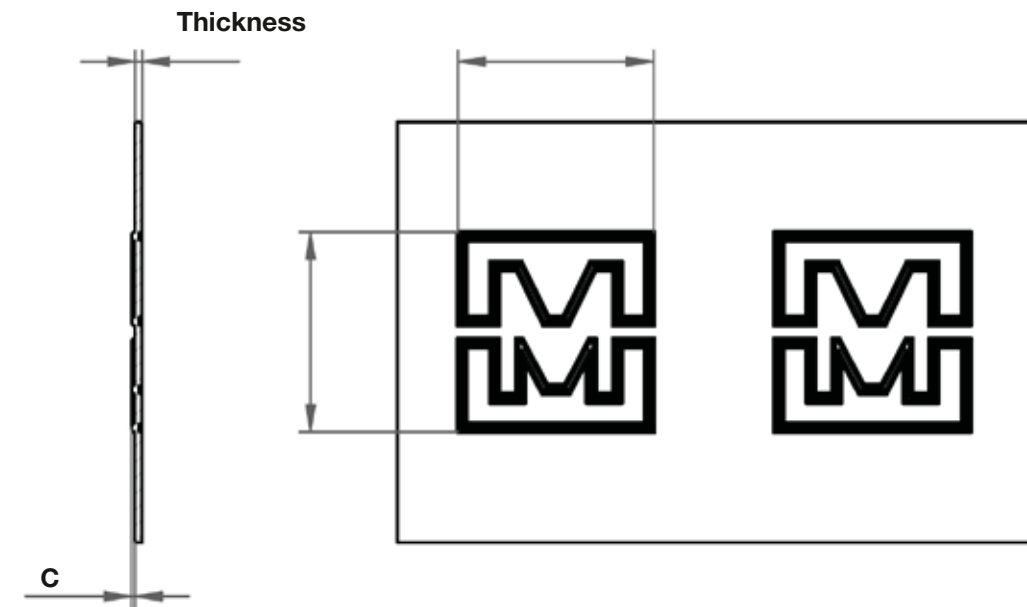
## M22 LOGOS



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

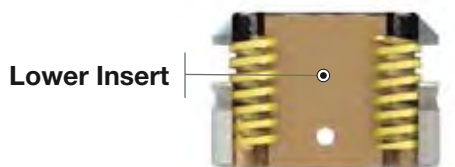
### SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set. In addition to using technical drawings in .DWG or .DXF format, tools for logos can also be created from images in the most common formats or even from .PDF files.



Upper Insert

Upper Insert-holder



Lower Insert

Lower Insert-holder



Upper Insert



Stripper



Springs



Lower Insert



Screws

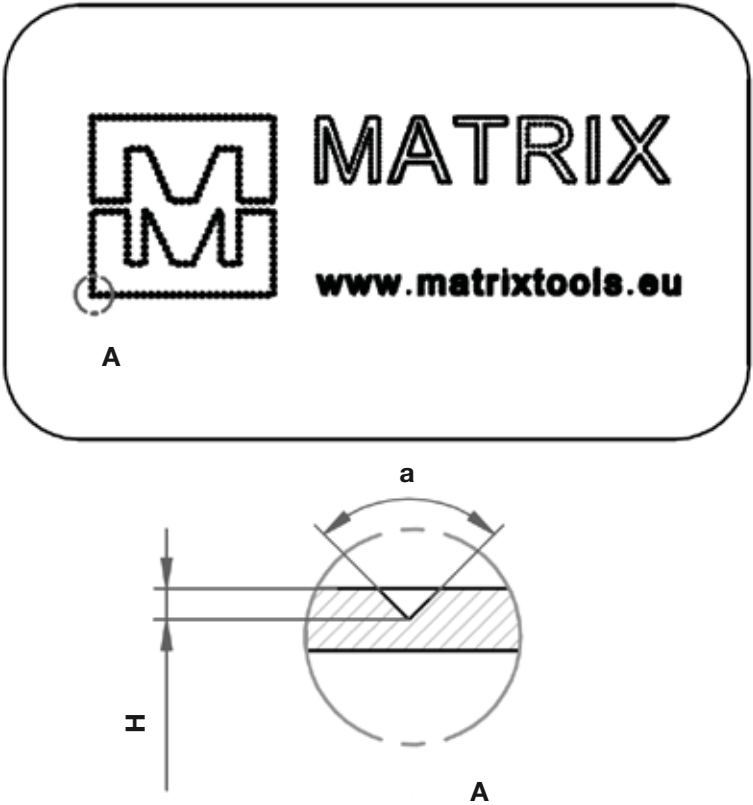
# M23 MICRODOT MARKER



The inserts shown are for downward forming operations.  
Please contact our Sales Office if you require upward forming operations.

## SETS OF INSERTS

Available for both A and B Stations.  
Can be used on W and G Series insert-holders, not included in the standard set.  
Requires hydraulic or electric punching machines with ram stroke control. If this is not available, we also offer a specific upper insert-holder with compensation spring.  
The depth of penetration (H) depends on the thickness and type of material and on the power of the punching machine.  
Warning: reduce to the minimum the speed at which the insert approaches the sheet.



Standard Set of Inserts for Thick Turret		
Station	Code of Set of Inserts	a
A	FAZL238197	90°
B	FB09238197	90°

All measurements are expressed in mm



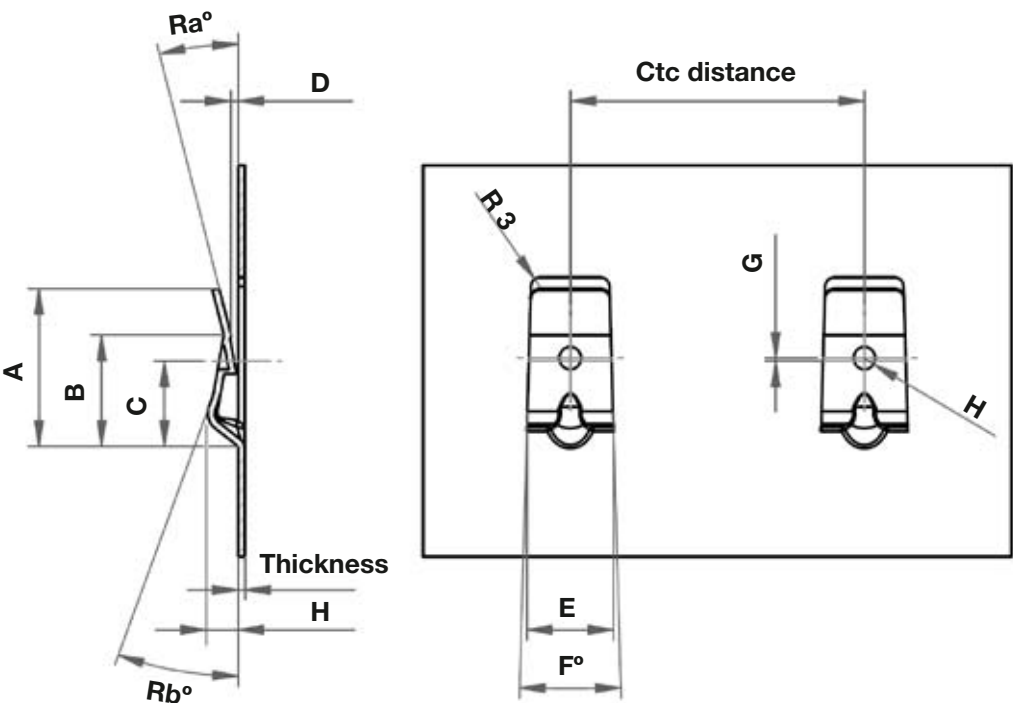
# M24 CLIP WITH BUTTON



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

## SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set.  
This solution allows materials to be joined together without the need for screws or operations such as riveting or welding.



Measurements Required (indicate the most important ones)									
Thickness	A	B	C	D	E	F°	G	H	Ctc distance

All measurements are expressed in mm



In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.



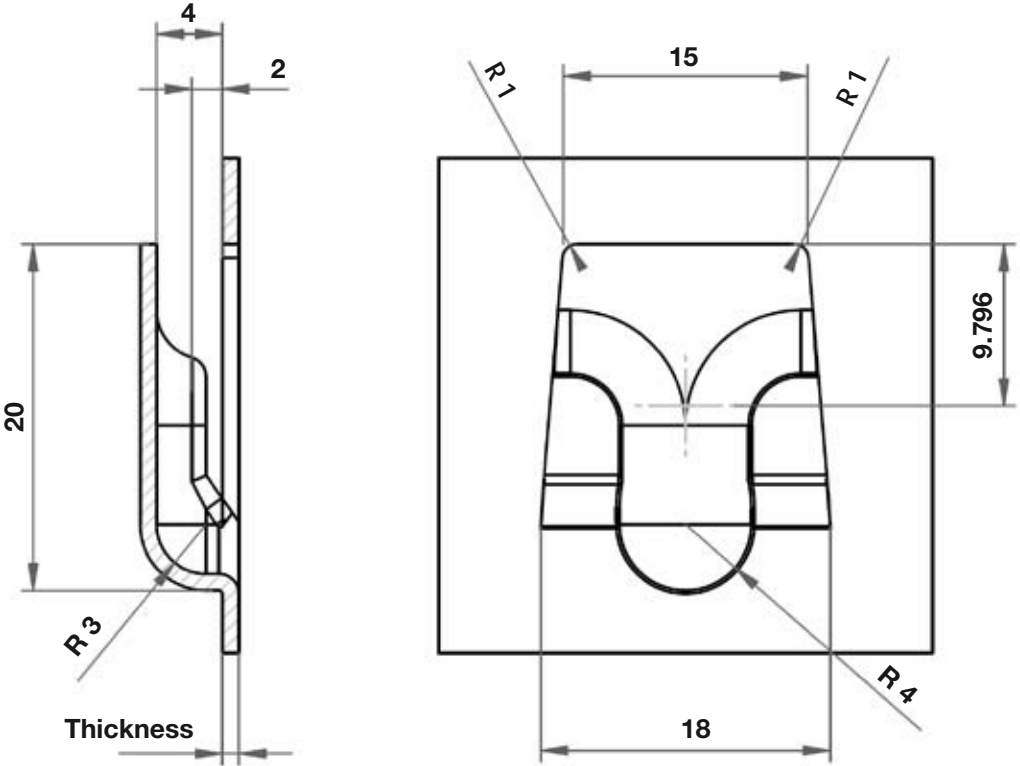
# M25 REINFORCED CLIP



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.

## SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set.



Standard Set of Inserts for Thick Turret B Station	
Thickness	Code of Set of Inserts
0.80 to 1.00	FB082372AA.305

All measurements are expressed in mm



# M26 EMBOSS FOR CABLES



The inserts shown are for downward forming operations. Please contact our Sales Office if you require upward forming operations.

### SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set. Before using this specific set of inserts, a suitably sized M02-type extruded hole must be made.



Upper Insert

Upper Insert-holder



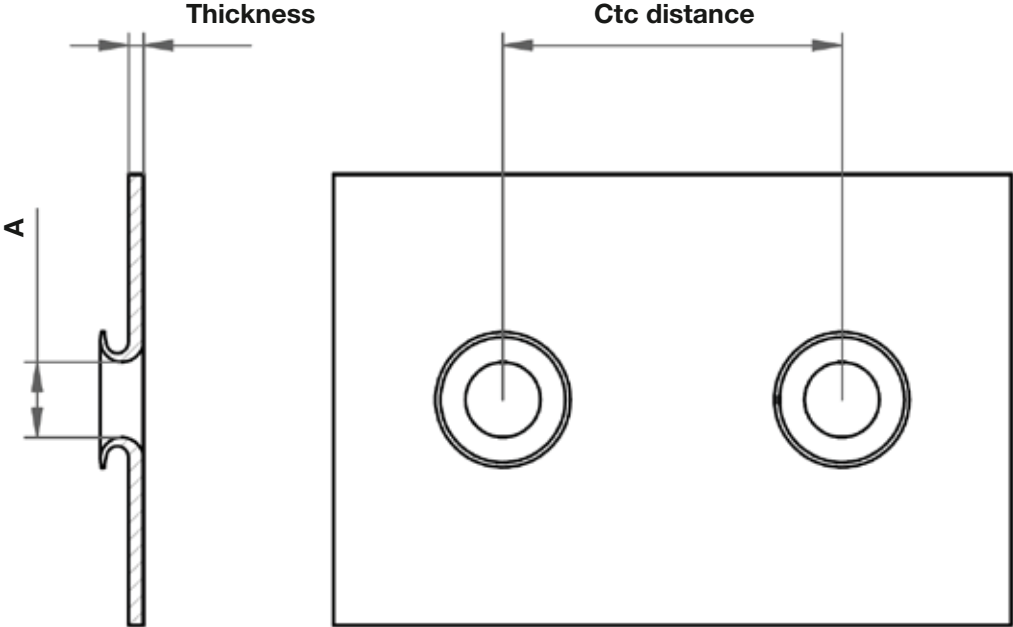
Die



Upper Insert



Die



Measurements Required (indicate the most important ones)		
Thickness	A	Ctc distance

All measurements are expressed in mm

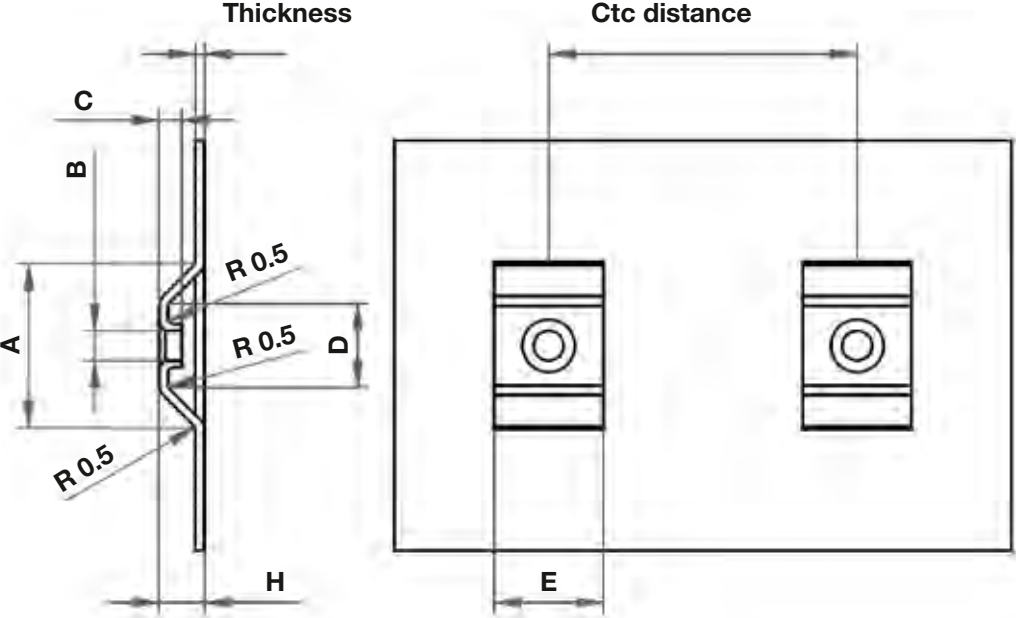


In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.

# M27 BRIDGE WITH EXTRUDED HOLE



The inserts shown are for upward forming operations.  
Please contact our Sales Office if you require downward forming operations.



Measurements Required (indicate the most important ones)							
Thickness	A	B	C	D	E	H	Ctc distance

All measurements are expressed in mm



In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.



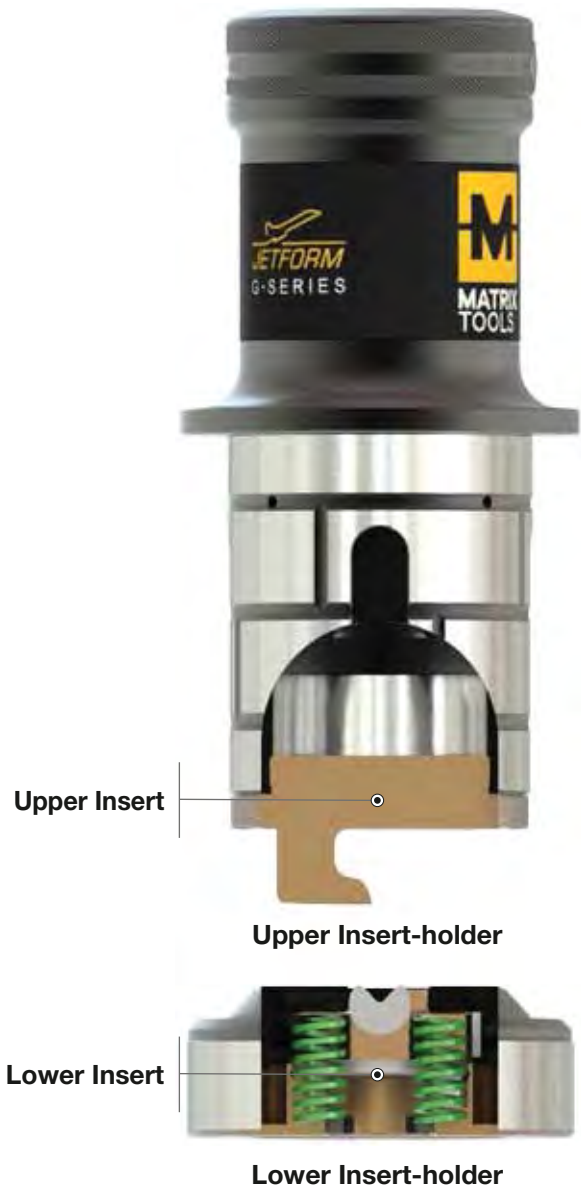
# M28 BENDING TOOL



The inserts shown are for upward forming operations.

## SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set. Before using this specific set of inserts, a suitably sized hole must be created.



Upper Insert



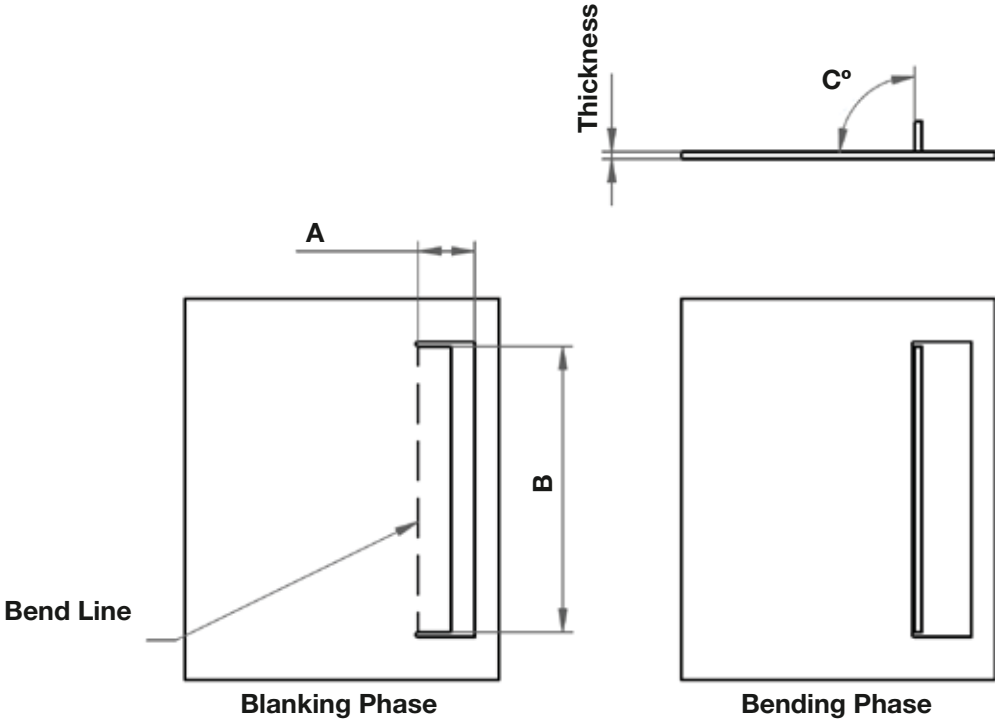
Stripper



Lower Insert



Springs



Standard Set of Inserts for Thick Turret						
Station	A	B	C°	Thickness	Total Height	Code of Set of Inserts
C	Min. 12	Max. 50	Max. 91	Max. 1.50	Minimum 8 - Maximum 17	FB102369AH
D	Min. 12	Max. 80	Max. 91	Max. 1.50	Minimum 10 - Maximum 16	FB122369AH

All measurements are expressed in mm

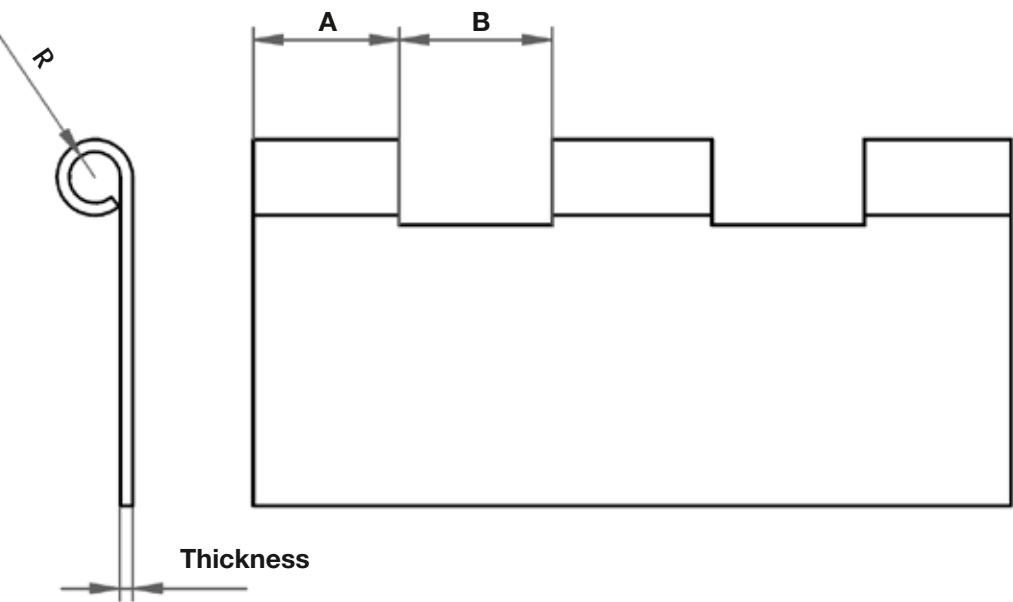
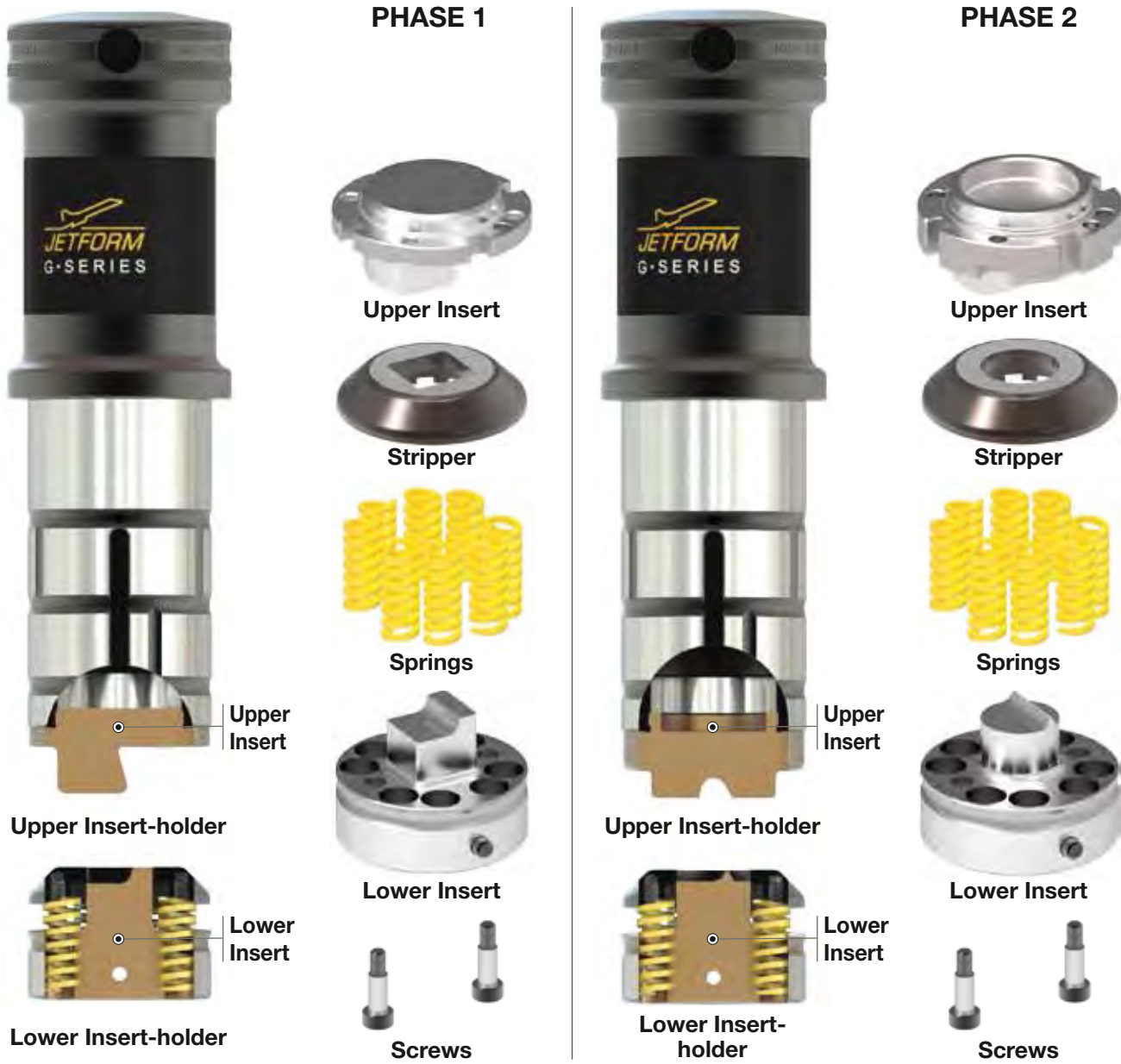


# M29 HINGE



## SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set. To obtain the result shown, two distinct processing phases must be performed, each requiring a specific set of inserts.



Measurements Required (indicate the most important ones)			
Thickness	A	B	R

Dimensional Limits	
Thickness	R
0.80 to 1.50	0.80 to 2.38

All measurements are expressed in mm



In addition to the model of machine and the type of material, there is no need to indicate all the measurements, but only the most important ones. If further information is required, our Technical Department will contact you.

# M31 DEBURRER



Upper Insert-holder



Lower Tool



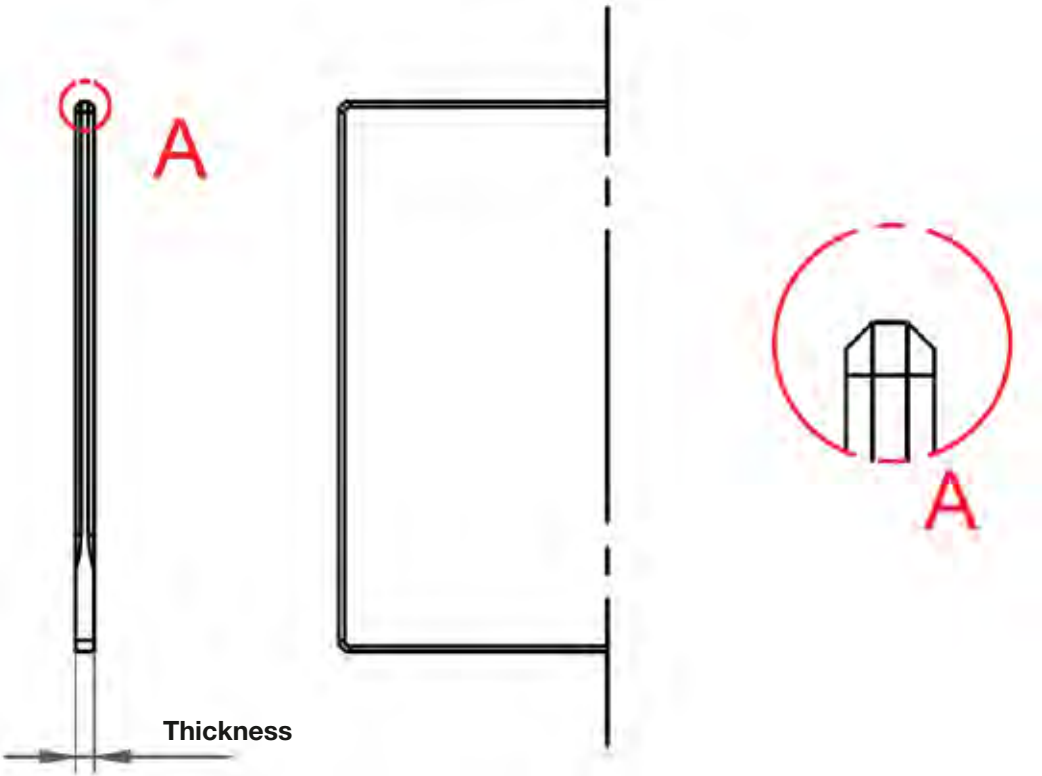
Upper Insert



Lower Tool

## SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set. Requires hydraulic or electric punching machines with ram stroke control and the appropriate software applications.



Standard Set of Inserts for Thick Turret B Station	
Thickness	Code of Set of Inserts
Max 6.00	FB092300AN

All measurements are expressed in mm



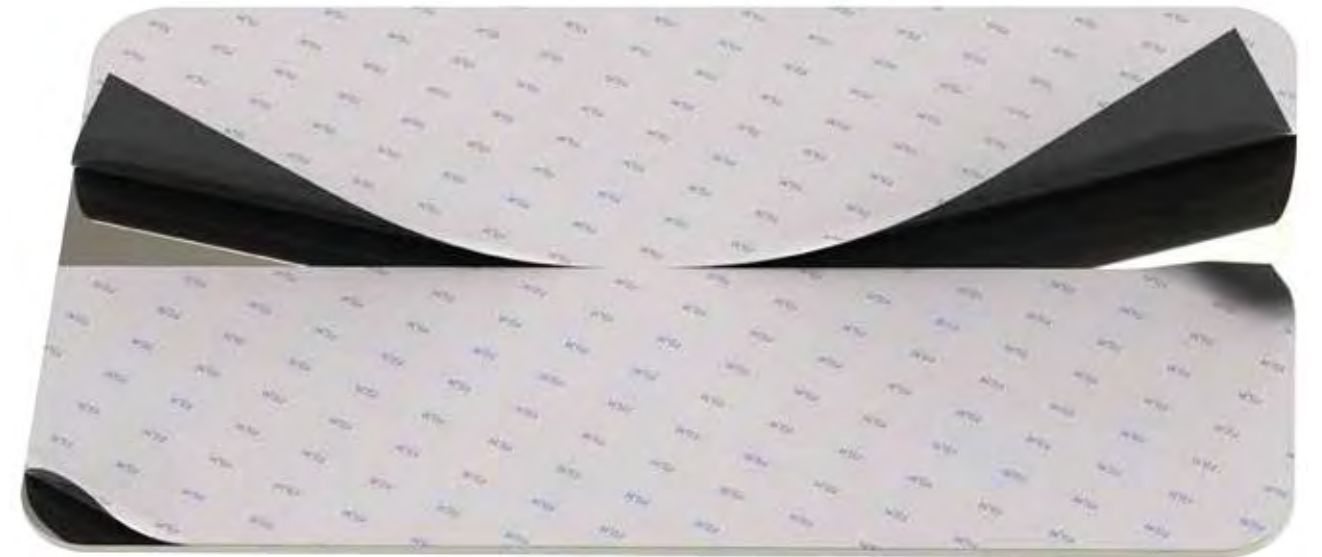


## M32 FILM CUTTER



## SETS OF INSERTS

Can be used on W and G Series insert-holders, not included in the standard set. Requires hydraulic or electric punching machines with ram stroke control and the appropriate software applications. Recommended working speed between 2 and 6 m/min. Warning: reduce to the minimum the speed at which the insert approaches the sheet.



Standard Set of Inserts for Thick Turret	
Station	Code of Set of Inserts
A	FAZL2381AP
B	FB092381AP





EMX THICK TURRET  
SMX THICK TURRET  
MULTIMATRIX  
■ **JETFORM**  
TRUMPF®  
EUROMAC®  
IRONWORKER  
GRINDING

MADE IN ITALY

