



STANDARD PUNCH – METRIC M 12 - M 75 + PG 7 - PG 48

with 3 cutting tips – punch, die and tension screw • Made in Germany by ALFRA



Punching steel sheets mild steel ($F = 370 \text{ N/mm}^2$) and plastics – quickly, easily, cleanly and without burrs!

- Suitable for sheet metal mild steel ($F = 370 \text{ N/mm}^2$) thickness:
 - 2.0 mm with screws $\varnothing 9.5 \text{ mm}$ or
 - 3.0 mm with screws $\varnothing 19.0 \text{ mm}$.
- Exceeding these values can lead to damages on the tension screws. When operating with the spanner, make sure you grease the tension screws. (lubricating paste Prod.-No. 33005)
- Pre-drilling: Screws $\varnothing 9.5 \text{ mm}$: $\varnothing 11.0 \text{ mm}$
Screws $\varnothing 19.0 \text{ mm}$: $\varnothing 20.5 \text{ mm}$
- Using tension screws with ball bearings > saves energy during hand operation, by reducing the friction between the punch and die.



Puncher cutting diagram



Prod.-No. 01336



Prod.-No. 01340

\varnothing in mm	Size Metrisch	Size PG	Size INCH	Size Conduit & Pipe Size	Prod.-No. (punch, die +tension screw)	Suitable tension screw $\varnothing \times l$ in mm	Prod.-No.	Suitable tension screw with ball bearing $\varnothing \times l$ in mm	Prod.-No.
12,7	M 12	7	1/2	0.500	1001	9,5 x 40	1335	9,5 x 50	1339
15,2	-	9		0.598	1005	9,5 x 40	1335	9,5 x 50	1339
16,2	M 16	-		0.638	1009	9,5 x 40	1335	9,5 x 50	1339
18,6	-	11		0.732	1021	9,5 x 40	1335	9,5 x 50	1339
19,0	-	-	3/4	0.748	1025	9,5 x 40	1335	9,5 x 50	1339
20,0	-	-		0.787	1029	9,5 x 40	1335	9,5 x 50	1339
20,4	M 20	13		0.803	1033	9,5 x 40	1335	9,5 x 50	1339
22,0	-	-		0.866	1041	9,5 x 40	1335	9,5 x 50	1339
22,5	-	16	7/8	0.886	1045	9,5 x 40	1335	9,5 x 50	1339
25,0	-	-		0.984	1053	9,5 x 50	1336	9,5 x 50	1339
25,4	M 25	-	1	1.000	1057	9,5 x 50	1336	9,5 x 50	1339
28,3	-	21		1.114	1069	9,5 x 50	1336	9,5 x 50	1339
28,3	-	21		1.114	1073	19,0 x 55	1337	19,0 x 55	1340
30,1	-	-		1.185	1085	9,5 x 50	1336	9,5 x 50	1339
30,5	-	-	1 7/32	1.201	1093	9,5 x 50	1336	9,5 x 50	1339
31,7	-	-	1 1/4	1.248	1101	9,5 x 50	1336	9,5 x 50	1339
32,5	M 32	-		1.280	1105	9,5 x 50	1336	9,5 x 50	1339
34,6	-	-		1.362	1117	19,0 x 55	1337	19,0 x 55	1340
35,0	-	-	1 3/8	1.378	1121	9,5 x 50	1336	9,5 x 50	1339
35,0	-	-	1 3/8	1.378	1125	19,0 x 55	1337	19,0 x 55	1340
37,0	-	29		1.457	1129	19,0 x 55	1337	19,0 x 55	1340
38,0	-	-	1 1/2	1.496	1133	19,0 x 55	1337	19,0 x 55	1340
40,5	M 40	-		1.594	1149	19,0 x 55	1337	19,0 x 55	1340
42,8	-	-		1.685	1157	19,0 x 55	1337	19,0 x 55	1340
43,2	-	-	1 11/16	1.701	1161	19,0 x 55	1337	19,0 x 55	1340
47,0	-	36		1.850	1165	19,0 x 75	1338	19,0 x 75	1341
49,6	-	-	1 15/16	1.953	1169	19,0 x 75	1338	19,0 x 75	1341
50,5	M 50	-		1.988	1177	19,0 x 75	1338	19,0 x 75	1341
54,0	-	42	2 1/8	2.126	1189	19,0 x 75	1338	19,0 x 75	1341
60,0	-	48		2.362	1201	19,0 x 75	1338	19,0 x 75	1341
61,5	-	-	2 3/8	2.421	1205	19,0 x 75	1338	19,0 x 75	1341
63,5	M 63	-	2 1/2	2.500	1209	19,0 x 75	1338	19,0 x 75	1341
For 68.0 mm onwards the operation with a screw spanner is still possible, but we recommend the application of hydraulic devices.									
68,0	-	-		2.677	1241	19,0 x 75	1338	19,0 x 75	1341
70,0	-	-	2 3/4	2.756	1221	19,0 x 75	1338	19,0 x 75	1341
75,5	M 75	-	2 7/8	2.972	1225	19,0 x 75	1338	19,0 x 75	1341
76,2	-	-	3	3.000	1229	19,0 x 75	1338	19,0 x 75	1341
80,0	-	-	3 1/8	3.150	1237	19,0 x 75	1338	19,0 x 75	1341
82,0	-	-		3.228	1245	19,0 x 75	1338	19,0 x 75	1341
Punch									
89,0	-	1251	3 1/2	3.504	3"	1252			
92,0	-	1253	3 5/8	3.622		1254			
100,5	-	1257		3.957		1258			
115,5	-	1265	4 1/2	4.547	4"	1266			
120,0	-	1267		4.724		1268			
Die									

From 89.0 mm the application of hand, foot or electrohydraulic pumps is necessary. Necessary accessories: Hydraulic tension screw 28.3 x 155 mm Prod.-No. 01398 and lock nut No. 7. Prod.-No. 01419