

# G Series

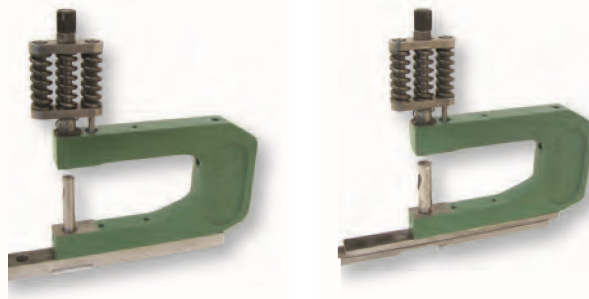
## G - Triple Spring Unit

- 7-1/2" shut height
- Material Thickness up to 3/16"
- Adjustable punch head extends tool life

### G Units (Page 70)

The UniPunch 'G' Series Triple Spring Unit has a 7½" shut height. They are designed for round hole punching. The advantage of the Triple Spring Unit comes from the additional stripping spring force that allows the unit to be used to punch .3125" round holes in 3/16" material. (For thicker punching applications, see the "A" or "B" series.)

### G - Triple Spring

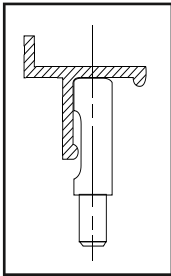


Fixed Base

Adjustable Base

The G series units are mounted to the UniPunch 5110 bed rail with either the fixed base or the adjustable base. The fixed base is designed for straight line punching. The adjustable base allows 3/4" adjustment front to back (a total of 1 ½").

### G Series Usage



'G' Series units are designed for punching holes as close as ¾" center-to-center. These units feature a pedestal die which is an advantage for punching formed parts such as aluminum extrusions, roll formed parts and small channels and angles because the pedestal die can be modified to accommodate the profile of the part.

(For flat parts with close hole centers, UniPunch recommends the BX-3/4 because it can be used alongside other B series units. (See page 55). The G-3/4 units are commonly used by storm door and window manufacturers and in the recreational vehicle industry and by fabricators of other aluminum extrusions.

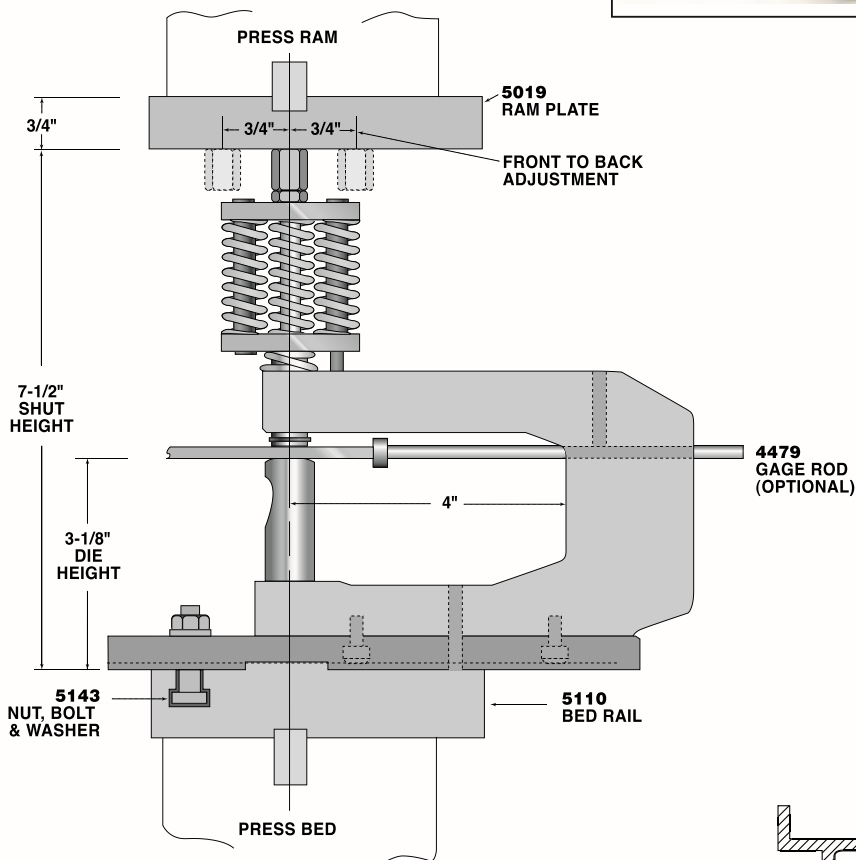
### PRESS BRAKE MOUNTING ACCESSORIES FOR ALL G SERIES UNITS

RAM PLATE (6" WIDE X 3/4" THICK)			BED RAIL G SERIES		
Part No.	Length	Shipping Weight	Part No.	Length	Shipping Weight
5019-24	24"	33 lbs.	5110-48	48"	92 lbs.
5019-48	48"	56 lbs.	5110-72	72"	138 lbs.
5019-72	72"	84 lbs.	5110-96	96"	184 lbs.
5019-96	96"	112 lbs.	5110-120	120"	230 lbs.
5019-120	120"	140 lbs.	5110-144	144"	276 lbs.
5019-144	144"	168 lbs.			



### Triple Spring Unit Press Brake mounting method shown

Single spring unit mounted in the same method and operates at 6 1/4" shut height.



The G series units are mounted to the UniPunch 5110 bed rail with either the fixed base or the adjustable base. The fixed base is designed for straight line punching. The adjustable base allows 3/4" adjustment front to back (a total of 1 1/2").

### TYPICAL SPECIAL DIE

Made to suit customer requirements

### NUT, BOLT AND WASHER SET

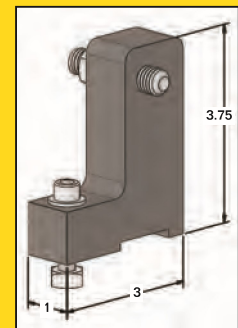
Part No.
5143

### END GAUGE ASSEMBLY

Part No.
5085



Adjustable End Stop has an adjustment screw for quick compensation for various work piece sizes.



Triple Spring Unit  
**G-3/4"**  
 19.0 mm width

**SPECIFICATIONS & OPERATING INSTRUCTIONS**

OPERATING SHUT HEIGHT:	7-1/2" (190.50mm)
MIN. SHUT HEIGHT:	7-5/16" (185.72mm)
UNIT OPEN HEIGHT:	8" (203.2mm)
DIE HEIGHT:	3-1/8" (79.4mm)
MAX. MATERIAL THICKNESS (MILD STEEL):	3/16" (4.8mm)

MATERIAL FEED CLEARANCE:	3/16" (4.8mm)
MIN. DIE CLEARANCE:	.006" (.15mm)
MAX. PUNCH DIAMETER:	.3125" (7.94mm)
MIN. PUNCH DIAMETER:	.0937" (2.38mm)
MAX. MATERIAL THICKNESS (STAINLESS STEEL):	.062" (1.57mm)

**KITS AND SHIMS**

Hardware kit:	9385
Punch shim:	N.A.
Die shim:	N.A.

	COMPLETE ROUND UNITS		COMMON DIMENSIONS	
	Model No.	Max. Punch Diameter	Throat Depth	Shipping Weight
<b>UNITS WITH FIXED BASE</b>	G-4221	.156	4"	7 lbs.
	G-4222	.250	4"	7 lbs.
	G-4226	.3125	4"	7 lbs.
<b>UNITS WITH ADJUSTABLE BASE</b>	GA-4221	.156	4"	7 lbs.
	GA-4222	.250	4"	7 lbs.
	GA-4226	.3125	4"	7 lbs.

To order a unit less punch and die, add the suffix "- LPD".

