

# A Series Lineup

## A, AJ, AJD, AH, AHD, OA, AD, FCU, A-Notching and A-Shearing

- 8-3/8" shut height & 3-1/2" die height
- Material Thickness: Up to 3/4"
- Part Feed Clearance from 7/16" to 1-1/4"

### A Units (Pages 22 - 29)

The "A" punching units are the workhorses of the UniPunch product line. Available "A" holder widths are: 1", 1 1/4", 1 1/2", 2", 2 1/2", 3", 3 1/2", 5 1/2" and 8". Holder width is important because it defines the minimum hole to hole distance. The "A" Series are widely used in industry to punch mild steel up to 1/4" thickness. Depending on your material thickness, punch diameters are available up to 5.000" (127mm).


### AJ Units (Pages 30 - 34)

"AJ" punching units are ideal for punching angles and channels, aluminum extrusions and other formed parts. Available "AJ" holder widths are: 1", 1 1/4", 1 1/2", 2" and 2 1/2". Holder width is important because it defines the minimum hole to hole distance. The "AJ" units are widely used in industry to punch mild steel up to 1/4" thickness. Depending on your material thickness, punch diameters are available up to 1.500" (38.10mm).

The "AJ" Unit assembled with Pedestal Die uses a one piece pedestal die for punching close to a leg of angles, channels and extrusions. Pedestal dies are routinely modified to accommodate formed parts.

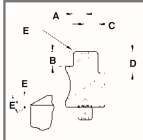
The "AJ" Unit assembled with Die Adapter is a two piece design; the die adapter accepts a button die. One benefit of using the "AJ" Unit with a die adapter is the ability to change button die sizes for multiple materials, at a lower cost.

A SERIES



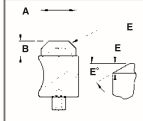
Two common types of altered pedestal dies are shown below; others are available. Submit a drawing of your part to the UniPunch Sales Department for a tooling recommendation.

**1288 Altered Ped Die - Flats**  
**Required parameters**  
 A = Front Flat Location      E = Chamfer  
 B = Front Flat Height      Specify Dia. or Shape  
 C = Rear Flat Location      TDC - Total Die Clearance  
 D = Rear Flat Height



Pedestal Dies are an alternative to die adapters. They can be modified to allow punching holes in oddly shaped angles, channels, and extrusions as illustrated above.

**1289 Altered Ped Die - Boss**  
**Required parameters**  
 A = Top Diameter      Specify Dia. or Shape  
 B = Front/Top Height      TDC - Total Die Clearance  
 E = Chamfer - 45° unless otherwise requested



### Feed Clearance Units "FCU" (Page 35)

"FCU" punching units feature extra wide feed openings that allow you to "front feed" parts such as channels, angles and extrusions. Available holder widths are: 1 1/4", 1 1/2" and 2 1/4". These units are used to punch mild steel up to 1/8" thickness. Depending on your material thickness, punch diameters are available up to .8750" (22.22mm). (For thicker material punching applications, see the "AJ" Series.)