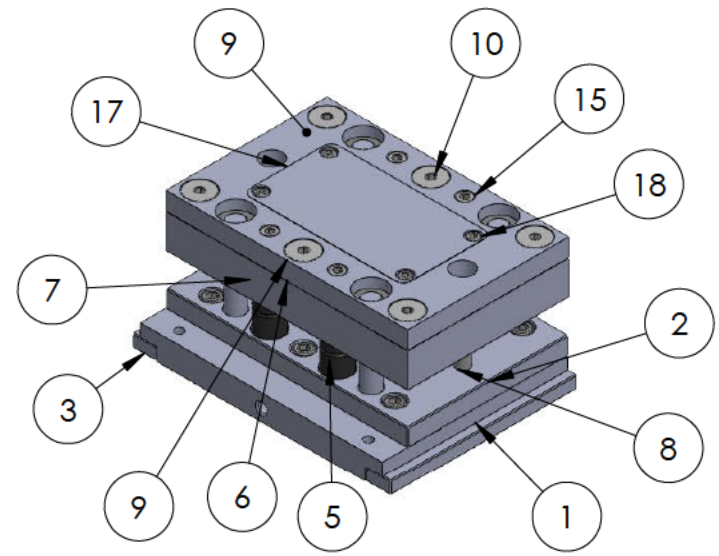
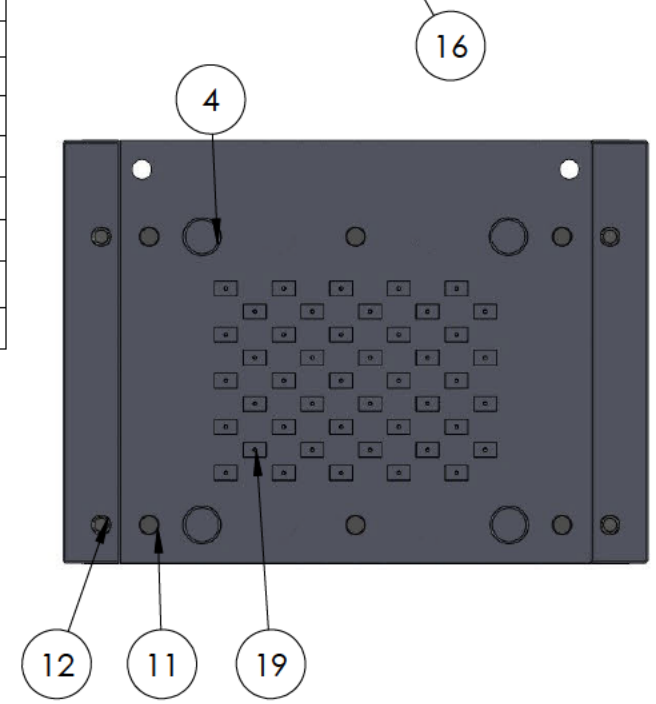
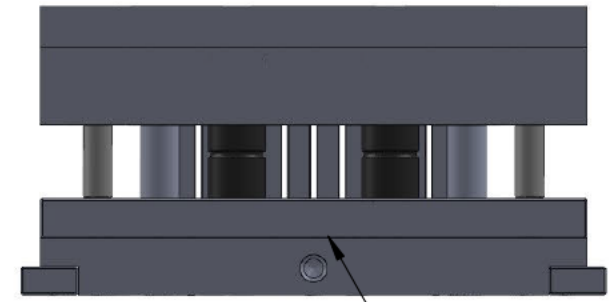


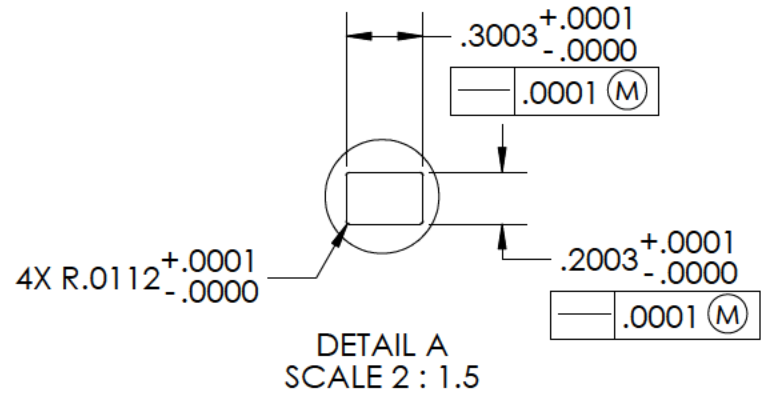
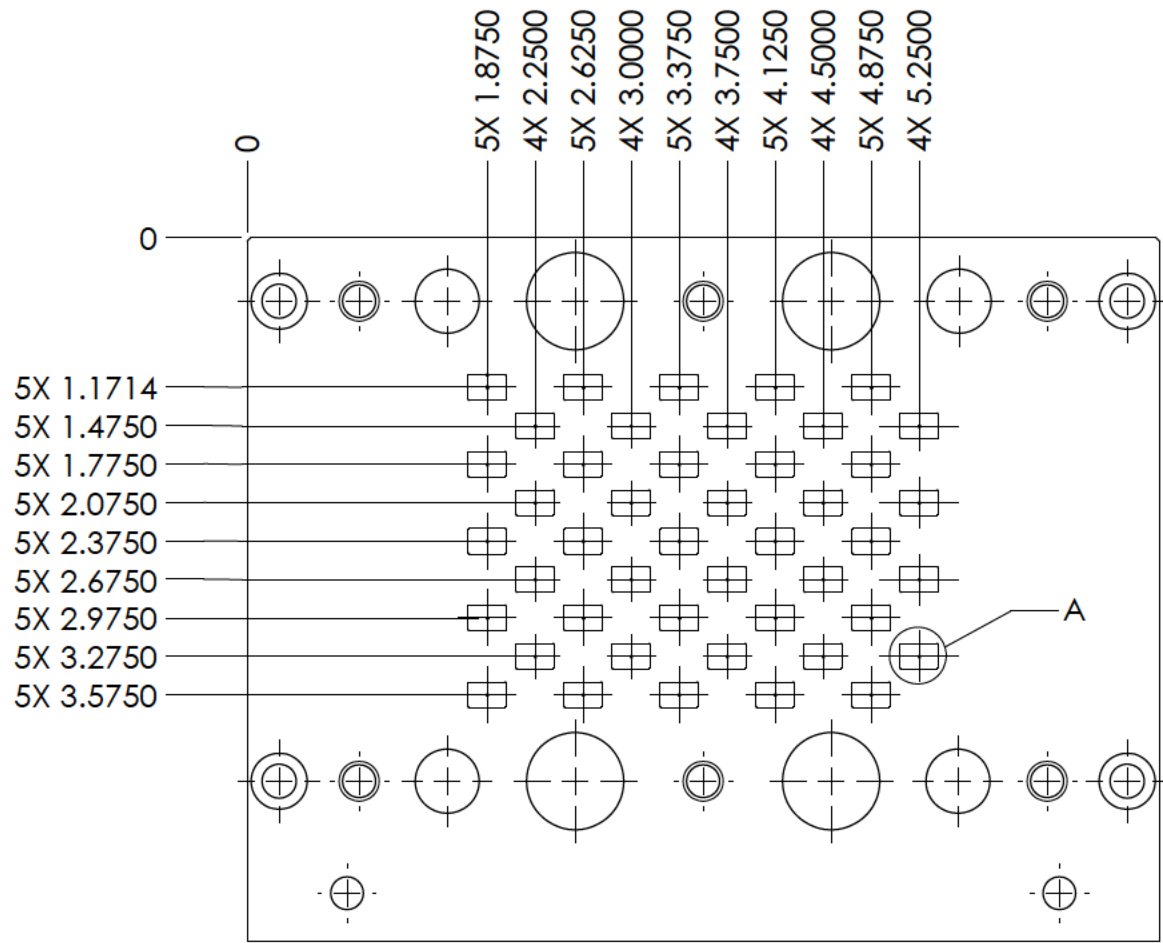


ITEM NO.	PART NUMBER	DESC. (FINISHED SIZES)	PURCHASING	QTY.
1	DIE SECTION-	7.1250 X 5.5000 X .7500	MANUFACTURED	1
2	STRIPPER PLATE-	7.1250 X 4.7500 X .5100	MANUFACTURED	1
3	RAIL	5.500 X .7500 X .3750	MANUFACTURED	2
4	PIN	.500 DIA X 3.450	THOMSON LINEAR BEARING	4
5	T3-170X25-HYSON	.750 DIA X 3.150	HYSON METAL FORMING SOLUTIONS	4
6	PUNCH HOLDER-	7.1250 X 4.750 X 1.000	MANUFACTURED	1
7	A-81420	.500 DIA BEARING	THOMSON LINEAR BEARING	4
8	91259A628	3/8"-5/16X18-SS	MCMASTER CARR	2
9	WEAR PLATE-	7.1250 X 4.7500 X .5350	MANUFACTURED	1
10	91253A622	HX-FHCS 3/8"-16X.750	MCMASTER CARR	6
11	90044A428	5/16"-18X11/16-SHCS	MCMASTER CARR	6
12	91251A537	1/4"-20X.500-SHCS	MCMASTER CARR	4
14	91259A507	3/16"-8X32-SS	MCMASTER CARR	45
15	96144A111	M6 X .750 X 12 MM	MCMASTER CARR	4
16	PUNCH REV 2	2.450" X 0.355" X 0.250"	MANUFACTURED	45
17	SPRING PLATE	4.7400 X 2.6150 X .2600	MANUFACTURED	1
18	91864A032	10-24 - 5/16 SHCS	MCMASTER CARR	4
19	STANDARD EJECTOR	2.5" X .12" OD. X 0.04" ID	MANUFACTURED	45
20	9434K12	0.25" X 0.12" OD X 0.088" ID	MCMASTER CARR	45



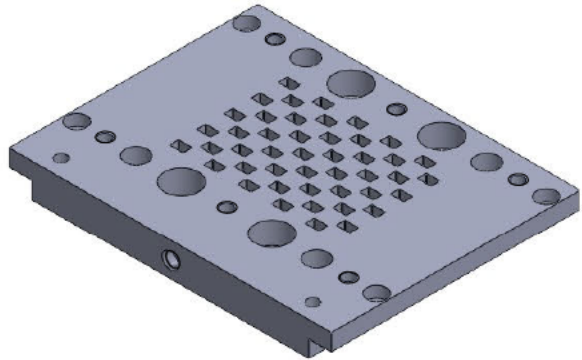
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<b>TITLE: DIE ASSEMBLY -</b> [REDACTED]		<b>APPROVED BY</b>	
DESCRIPTION: MATERIAL: REFER TO DRAWINGS		TOOL & DIE	DATE
HARDNESS: REFER TO DRAWINGS DATE CREATED: 2021-07-12		ENGINEERING	DATE
DRAWN BY: N. TRAN CUST. PART #:		DRAFTSMAN	DATE
SHEET SIZE: A SCALE: <b>2:5</b>			
TOLERANCES UNLESS SPECIFIED (INCHES)		±.030" .XXX ±.010" .XXX ±.005" .XXXX ±.0001" ANGLES ±1°	
SHEET 1 OF 12			

RO	NT	DRAWING CREATION	2021-03-29	N/A
REV	INT	REVISION	YYYY-MM-DD	DCN



- 5X 1.1714
- 5X 1.4750
- 5X 1.7750
- 5X 2.0750
- 5X 2.3750
- 5X 2.6750
- 5X 2.9750
- 5X 3.2750
- 5X 3.5750

- 5X 1.8750
- 4X 2.2500
- 5X 2.6250
- 4X 3.0000
- 5X 3.3750
- 4X 3.7500
- 5X 4.1250
- 4X 4.5000
- 5X 4.8750
- 4X 5.2500



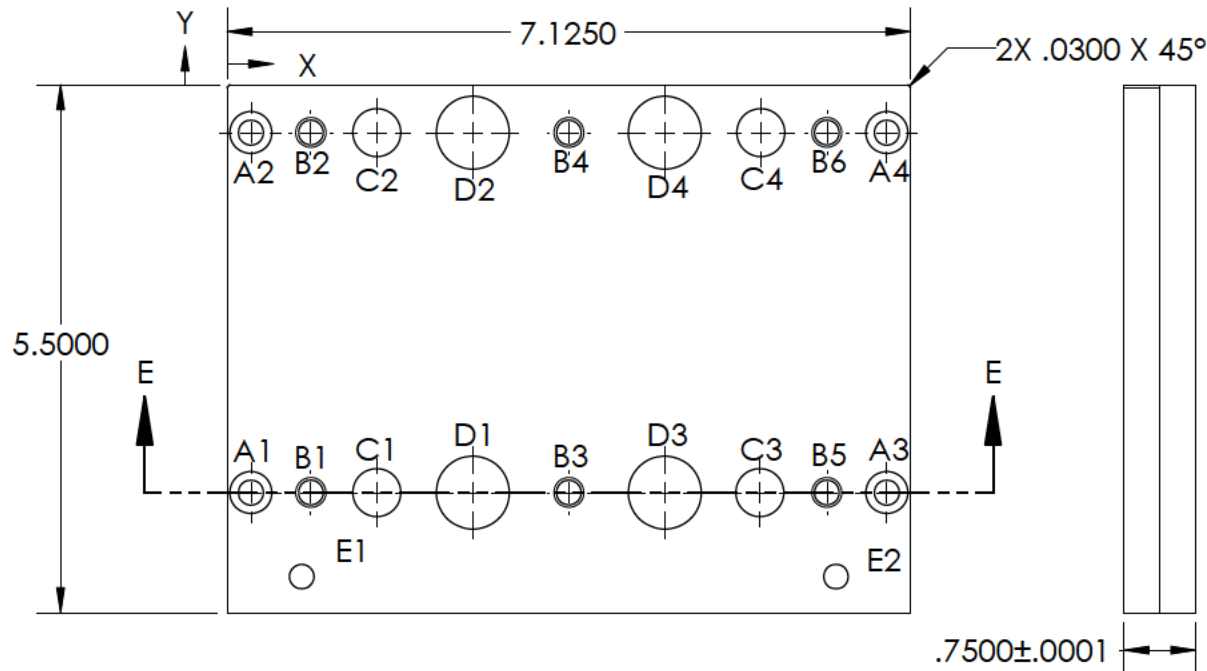
**NOTE:**

1. ALL DIMENSIONS USE NON-ACCUMULATIVE TOLERANCES
2. 45 X .3003" X .2003" THRU
3. PLEASE REFER TO STANDARD DRAWING

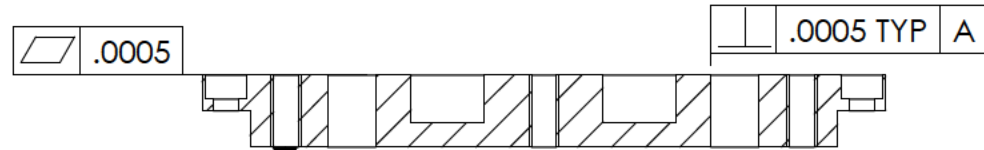
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<b>TITLE:</b> [REDACTED] DIE SECTION		<b>APPROVED BY</b>		SHEET SIZE: A SCALE: 1:1.5 
DESCRIPTION: 300 X .200 SOLDER DIE		TOOL & DIE	DATE	
MATERIAL: REFER TO STANDARD DRAWING		ENGINEERING	DATE	TOLERANCES UNLESS SPECIFIED (INCHES)
HARDNESS: REFER TO STANDARD DRAWING		DRAFTSMAN	DATE	.XX ±.030"
DATE CREATED: 2021-07-12				.XXX ±.010"
DRAWN BY: N. TRAN				.XXXX ±.005"
CUST. PART #:				ANGLES ±1°
				SHEET 2 OF 12

# DIE SECTION-STANDARD

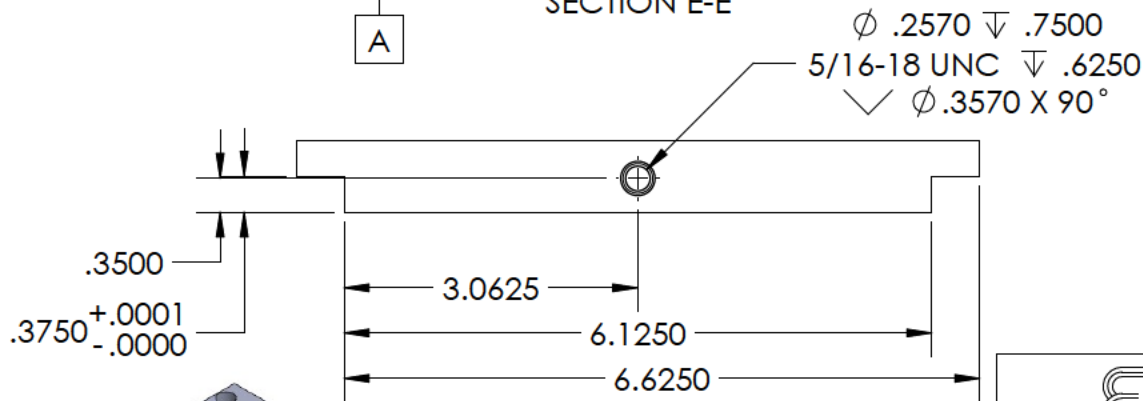
RO



TAG	X LOC	Y LOC	SIZE
A1	.2500	-4.2500	∅ .260 THRU ALL └ ∅ .438 ▽ .250
A2	.2500	-.5000	∅ .260 THRU ALL └ ∅ .438 ▽ .250
A3	6.8750	-4.2500	∅ .26 THRU ALL └ ∅ .44 ▽ .25
A4	6.8750	-.5000	∅ .26 THRU ALL └ ∅ .44 ▽ .25
B1	.8750	-4.2500	∅ .2570 THRU ALL 5/16-18 UNC THRU ALL
B2	.8750	-.5000	∅ .2570 THRU ALL 5/16-18 UNC THRU ALL
B3	3.5625	-4.2500	∅ .2570 THRU ALL 5/16-18 UNC THRU ALL
B4	3.5625	-.5000	∅ .2570 THRU ALL 5/16-18 UNC THRU ALL
B5	6.2500	-4.2500	∅ .2570 THRU ALL 5/16-18 UNC THRU ALL
B6	6.2500	-.5000	∅ .2570 THRU ALL 5/16-18 UNC THRU ALL
C1	1.5625±.0001	-4.2500±.0001	∅ .5000±.0001 THRU
C2	1.5625±.0001	-.5000±.0001	∅ .5000±.0001 THRU
C3	5.5525±.0001	-4.2500±.0001	∅ .5000±.0001 THRU
C4	5.5625±.0001	-.5000±.0001	∅ .5000±.0001 THRU
D1	2.5625	-4.2500	∅ .760 ▽ .500
D2	2.5625	-.5000	∅ .760 ▽ .500
D3	4.5625	-4.2500	∅ .760 ▽ .500
D4	4.5625	-.5000	∅ .760 ▽ .500
E1	.7800	-5.1250	∅ .2550 THRU
E2	6.3450	-5.1250	∅ .2550 THRU

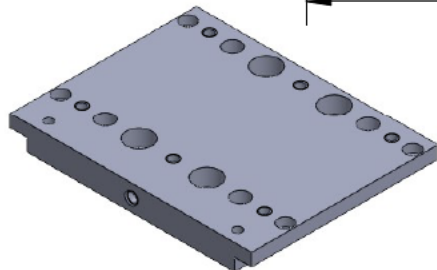


SECTION E-E



**NOTE:**

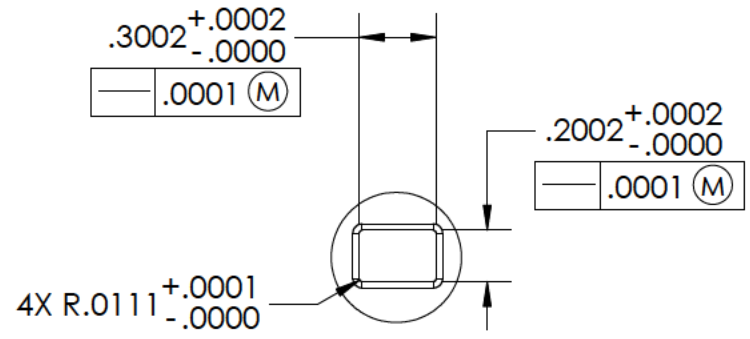
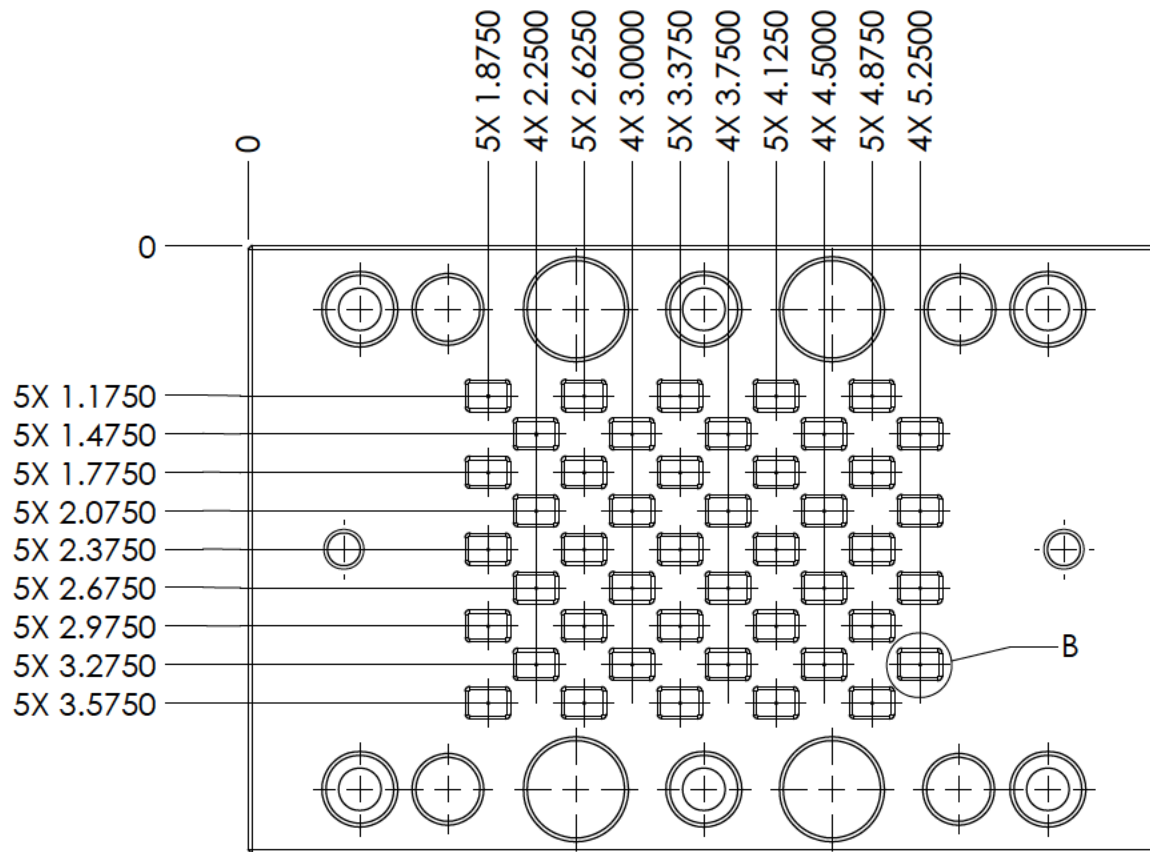
- 42 GRIND
  - 32
  - F.A.O.
- BREAK ALL OUTSIDE EDGES.  
PERPENDICULARITY APPLIES TO ALL C HOLES.



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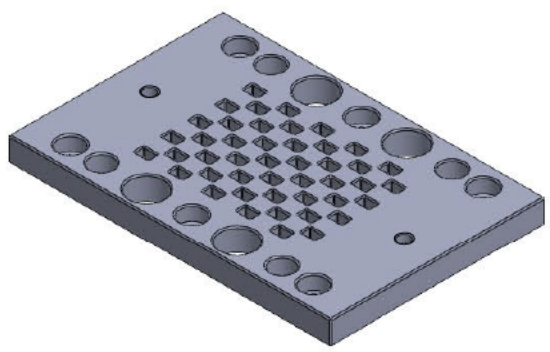
TITLE: DIE SECTION - STANDARD		APPROVED BY		SHEET SIZE: A
DESCRIPTION:				SCALE:
MATERIAL: D2 TOOL STEEL		TOOL & DIE	DATE	1:2
UNIFORM MATERIAL				TOLERANCES UNLESS SPECIFIED (INCHES)
HARDNESS: 58-60 RC		ENGINEERING	DATE	.XX ±.030"
DATE CREATED: 2021-07-06				.XXX ±.010"
DRAWN BY: N. TRAN		DRAFTSMAN	DATE	.XXXX ±.005"
CUST. PART #:				ANGLES ±1°
				SHEET 3 OF 12





DETAIL B  
SCALE 2 : 1.5

**NOTE:**

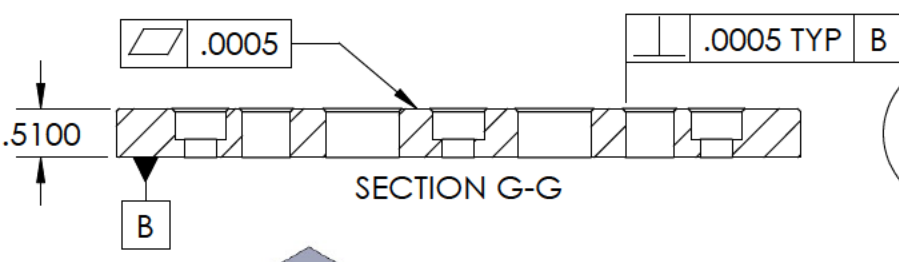
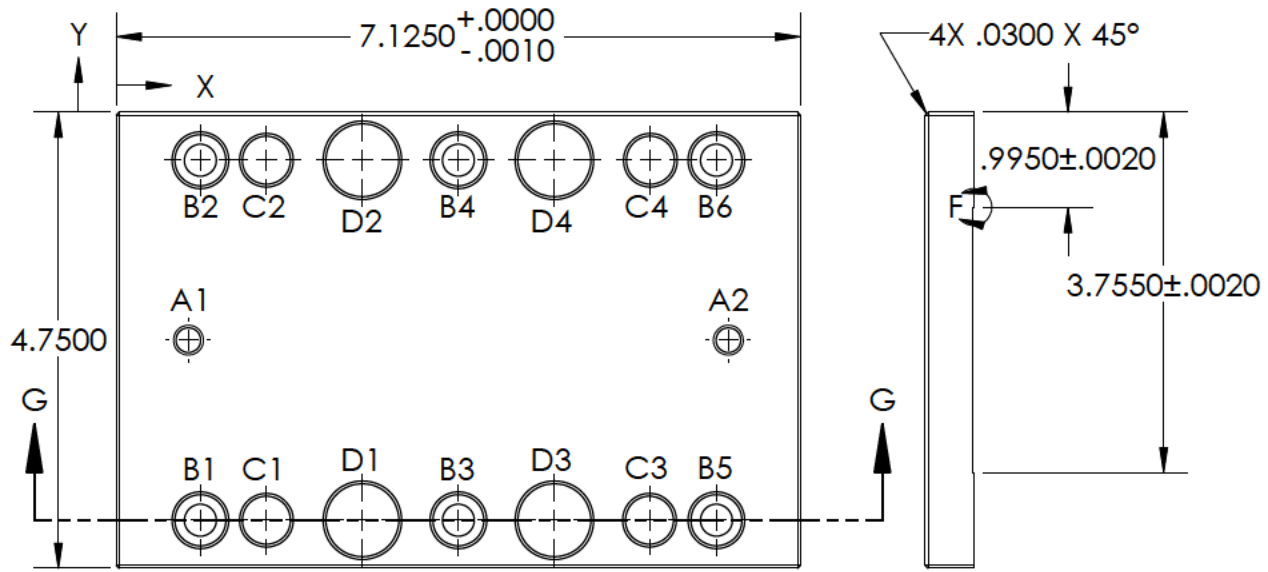
1. ALL DIMENSIONS USE NON-ACCUMULATIVE TOLERANCES
2. 45 X .3002" X .2002" THRU
3. .0250" X 45° CHAMFER ON ALL FEATURE HOLES, TOP SIDE ONLY, BOTTOM TO BE DEAD SHARP
4. PLEASE REFER TO STANDARD DRAWING



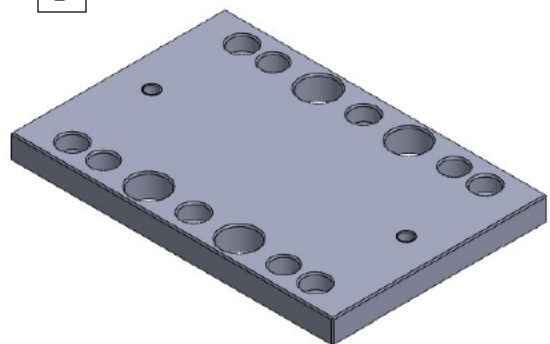
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<b>TITLE:</b> [REDACTED] <b>STRIPPER PLATE</b>		<b>APPROVED BY</b>	
DESCRIPTION: 300 X .200 SOLDER DIE		TOOL & DIE	DATE
MATERIAL: REFER TO STANDARD DRAWING			
HARDNESS: REFER TO STANDARD DRAWING		ENGINEERING	DATE
DATE CREATED: 2021-07-12			
DRAWN BY: N. TRAN		DRAFTSMAN	DATE
CUST. PART #:			
		TOLERANCES UNLESS SPECIFIED (INCHES) .X ±.030" .XX ±.010" .XXX ±.005" .XXXX ±.0001" ANGLES ±1°	
		SHEET 4 OF 12	

# STRIPPER PLATE-STANDARD

RO



TAG	X LOC	Y LOC	SIZE
A1	.7500	-2.3750	Ø .257 THRU ALL 5/16-18 UNC THRU ALL
A2	6.3750	-2.3750	Ø .257 THRU ALL 5/16-18 UNC THRU ALL
B1	.8750	-4.2500	Ø .332 THRU Ø .531 ∇ .323 ✓ Ø .591 X 82°
B2	.8750	-.5000	Ø .332 THRU Ø .531 ∇ .323 ✓ Ø .591 X 82°
B3	3.5625	-4.2500	Ø .332 THRU Ø .531 ∇ .323 ✓ Ø .591 X 82°
B4	3.5625	-.5000	Ø .332 THRU Ø .531 ∇ .323 ✓ Ø .591 X 82°
B5	6.2500	-4.2500	Ø .332 THRU Ø .531 ∇ .323 ✓ Ø .591 X 82°
B6	6.2500	-.5000	Ø .332 THRU Ø .531 ∇ .323 ✓ Ø .591 X 82°
C1	1.5625±.0001	-4.2500±.0001	Ø .5000 ±.0001 THRU ✓ Ø .560 X 82°
C2	1.5625±.0001	-.5000±.0001	Ø .5000 ±.0001 THRU ✓ Ø .560 X 82°
C3	5.5525±.0001	-4.2500±.0001	Ø .5000 ±.0001 THRU ✓ Ø .560 X 82°
C4	5.5625±.0001	-.5000±.0001	Ø .5000 ±.0001 THRU ✓ Ø .560 X 82°
D1	2.5625	-4.2500	Ø .760 THRU ✓ Ø .820 X 82°
D2	2.5625	-.5000	Ø .760 THRU ✓ Ø .820 X 82°
D3	4.5625	-4.2500	Ø .760 THRU ✓ Ø .820 X 82°
D4	4.5625	-.5000	Ø .760 THRU ✓ Ø .820 X 82°



**NOTE:**

- 42 GRIND  
32
- F.A.O.
  - BREAK ALL OUTSIDE EDGES.
  - DETAIL A HAS TO BE SHARP.
  - PERPENDICULARITY APPLIES TO ALL C HOLES.

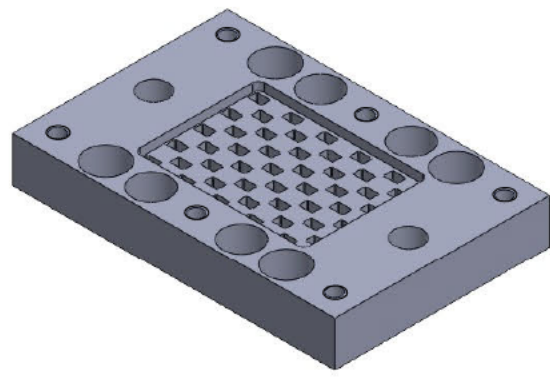
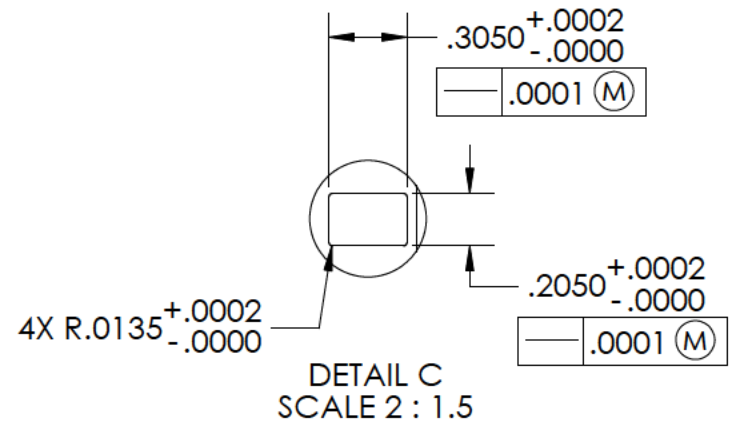
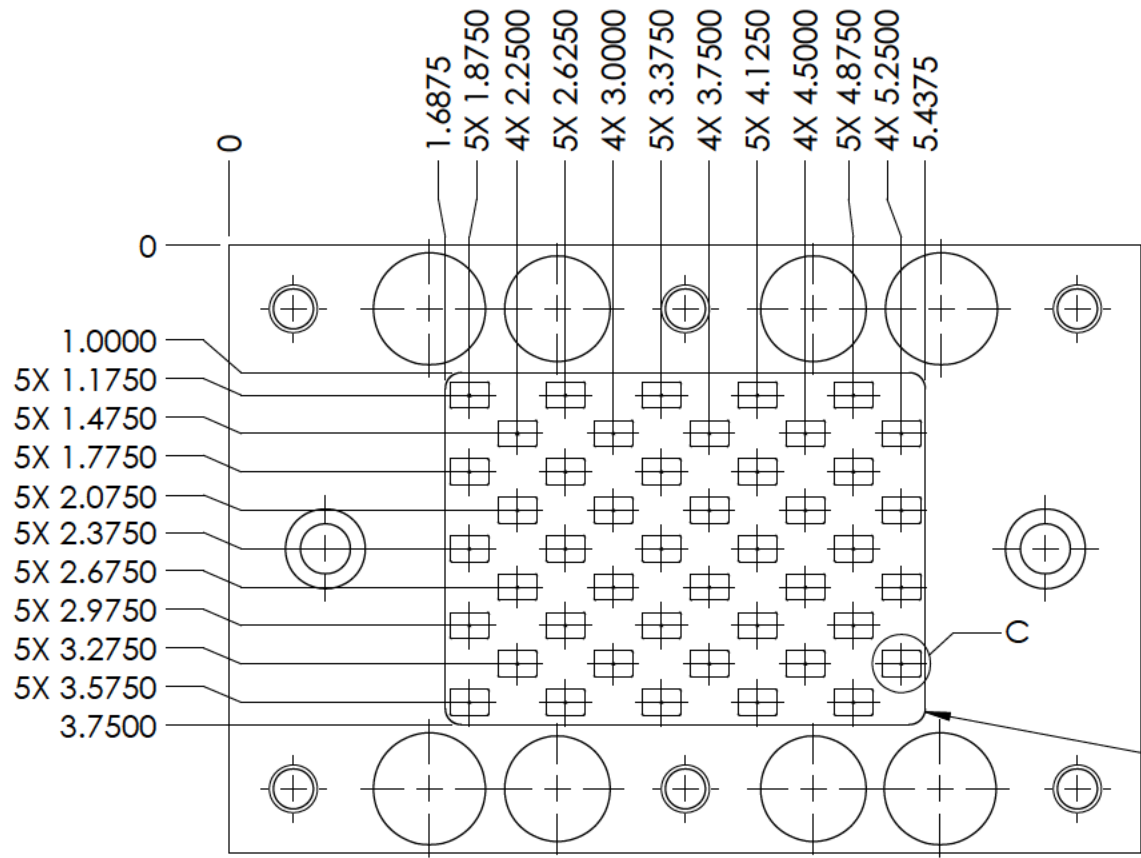


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TITLE: STRIPPER PLATE - STANDARD		APPROVED BY		SHEET SIZE: A	SCALE: 1:2
DESCRIPTION:		TOOL & DIE	DATE	TOLERANCES UNLESS SPECIFIED (INCHES)	
MATERIAL: D2 TOOL STEEL					
UNIFORM MATERIAL		ENGINEERING	DATE	X ±.030" XX ±.010" XXX ±.005" XXXX ±.0005" ANGLES ±1°	
HARDNESS: 58-60 RC					
DATE CREATED: 2021-07-06		DRAFTSMAN	DATE	SHEET 5 OF 12	
DRAWN BY: N. TRAN					
CUST. PART #:					

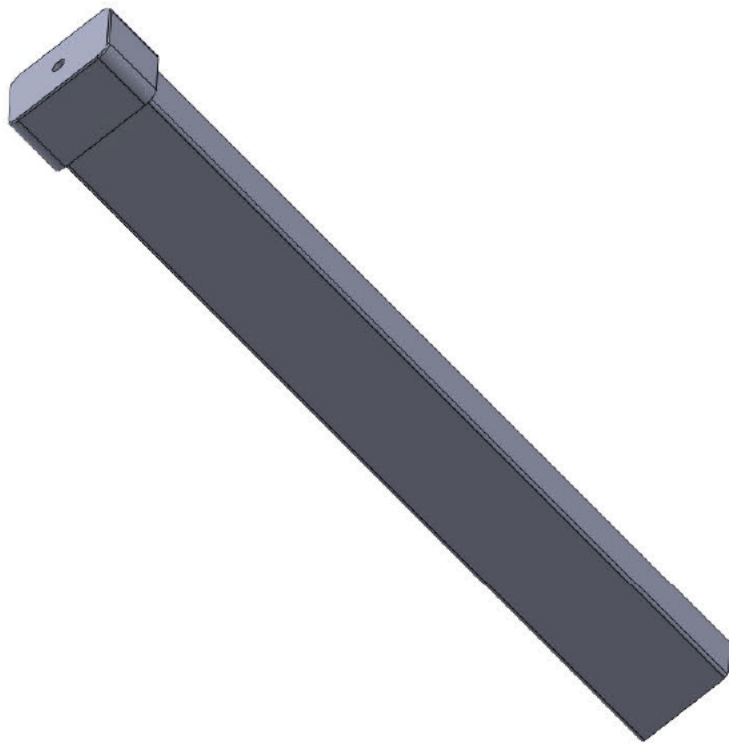
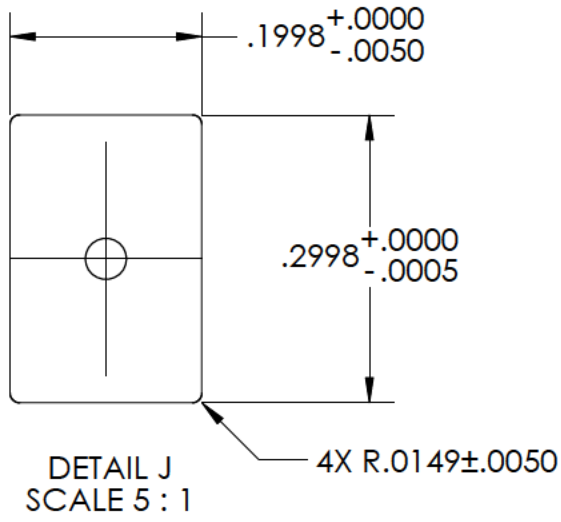
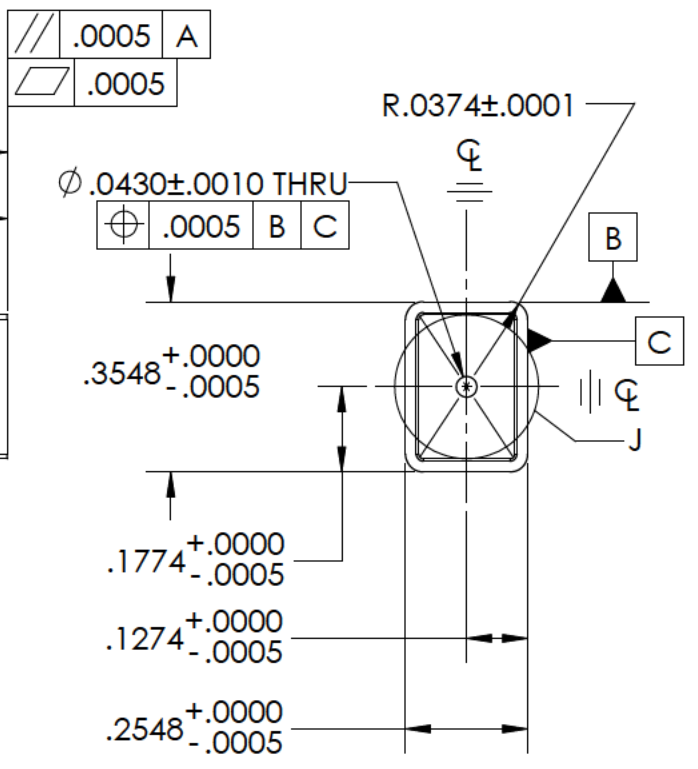
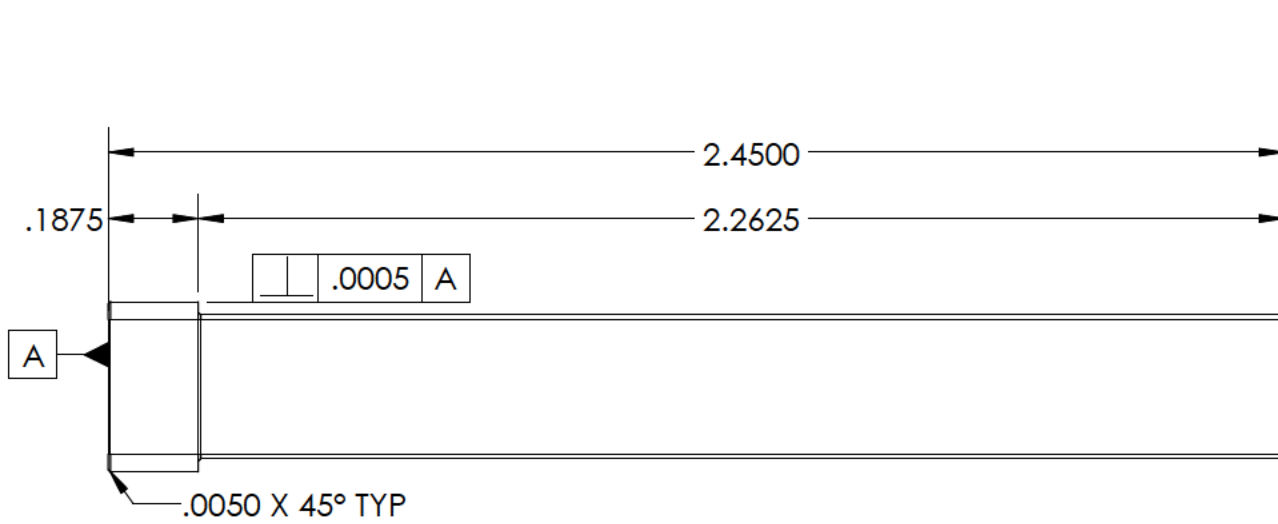






**NOTE:**

1. ALL DIMENSIONS USE NON-ACCUMULATIVE TOLERANCES
2. 45 X .3050" X .2050" THRU
3. POCKET IS .1900" DEEP
4. PLEASE REFER TO STANDARD DRAWING

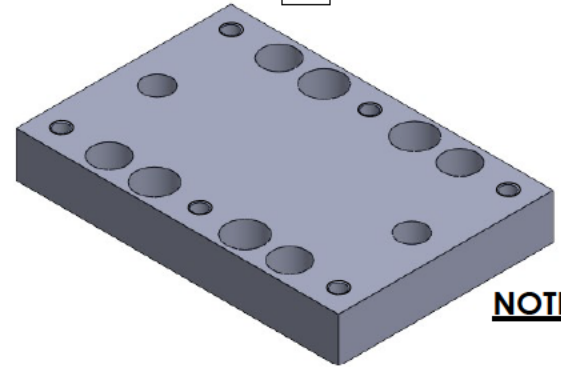
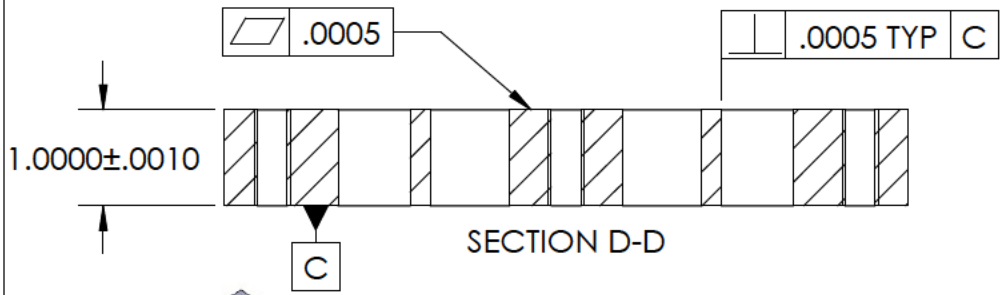
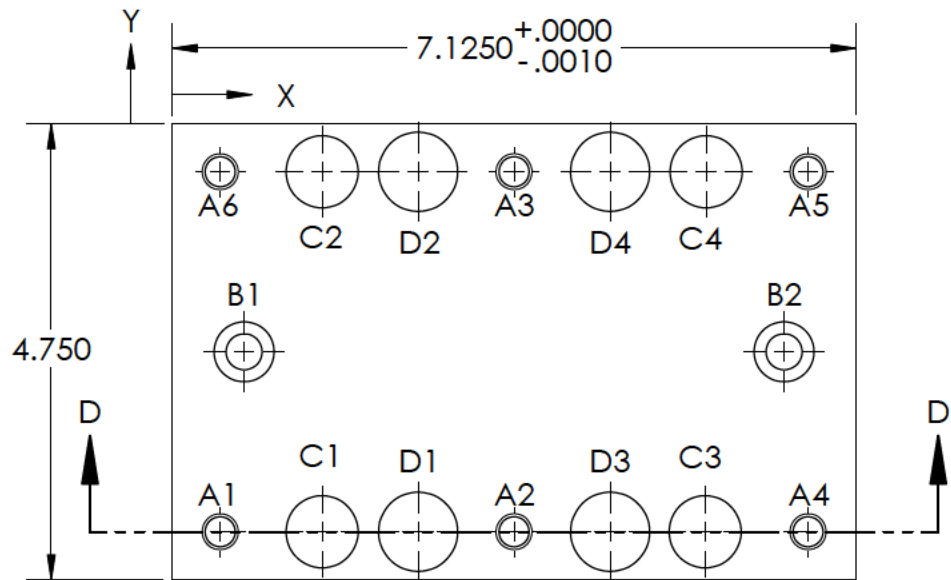
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<b>TITLE:</b> [REDACTED] <b>PUNCH HOLDER</b>	<b>APPROVED BY</b>		TOLERANCES UNLESS SPECIFIED (INCHES)
DESCRIPTION: [REDACTED] SOLDER DIE	TOOL & DIE	DATE	
MATERIAL: REFER TO STANDARD DRAWING	ENGINEERING	DATE	.XX ±.030" .XXX ±.010" .XXXX ±.005" .XXXXX ±.0001" ANGLES ±1°
HARDNESS: REFER TO STANDARD DRAWING	DRAFTSMAN	DATE	
DATE CREATED: 2021-07-12			SHEET 6 OF 12
DRAWN BY: N. TRAN			
CUST. PART #:			



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<b>TITLE:</b> PUNCH		<b>APPROVED BY</b>		TOLERANCES UNLESS SPECIFIED (INCHES) .XX ±.030" .XXX ±.010" .XXXX ±.005" .XXXXX ±.0005" ANGLES ±1°
DESCRIPTION:		TOOL & DIE	DATE	
MATERIAL: M2 TOOL STEEL		ENGINEERING	DATE	SHEET 7 OF 12
HARDNESS: 58-60 RC		DRAFTSMAN	DATE	
DATE CREATED: 2021-07-16				
DRAWN BY: N. TRAN				
CUST. PART #:				

**PUNCH HOLDER-STANDARD**

**RO**



- NOTE:**
- 42 GRIND  
32
- F.A.O.  
BREAK ALL EDGES.  
PERPENDICULARITY APPLIES TO ALL C HOLES.
- 1.
  - 2.
  - 3.

TAG	X LOC	Y LOC	SIZE
A1	.5000	-4.2500	Ø .313 THRU ALL 3/8-16 UNC THRU ALL
A2	3.5625	-4.2500	Ø .313 THRU ALL 3/8-16 UNC THRU ALL
A3	3.5625	-.5000	Ø .313 THRU ALL 3/8-16 UNC THRU ALL
A4	6.6250	-4.2500	Ø .313 THRU ALL 3/8-16 UNC THRU ALL
A5	6.6250	-.5000	Ø .313 THRU ALL 3/8-16 UNC THRU ALL
A6	.5000	-.5000	Ø .313 THRU ALL 3/8-16 UNC THRU ALL
B1	.7500	-2.3750	Ø .375 THRU └─┘ Ø .625 ∇ .460
B2	6.3750	-2.3750	Ø .375 THRU └─┘ Ø .625 ∇ .460
C1	1.5625±.0001	-4.2500±.0001	Ø .7500±.0001 THRU
C2	1.5625±.0001	-.5000	Ø .7500±.0001 THRU
C3	5.5625±.0001	-4.2500±.0001	Ø .7500±.0001 THRU
C4	5.5625±.0001	-.5000	Ø .7500±.0001 THRU
D1	2.5625	-4.2500	Ø .825 THRU
D2	2.5625	-.5000	Ø .825 THRU
D3	4.5625	-4.2500	Ø .825 THRU
D4	4.5625	-.5000	Ø .825 THRU

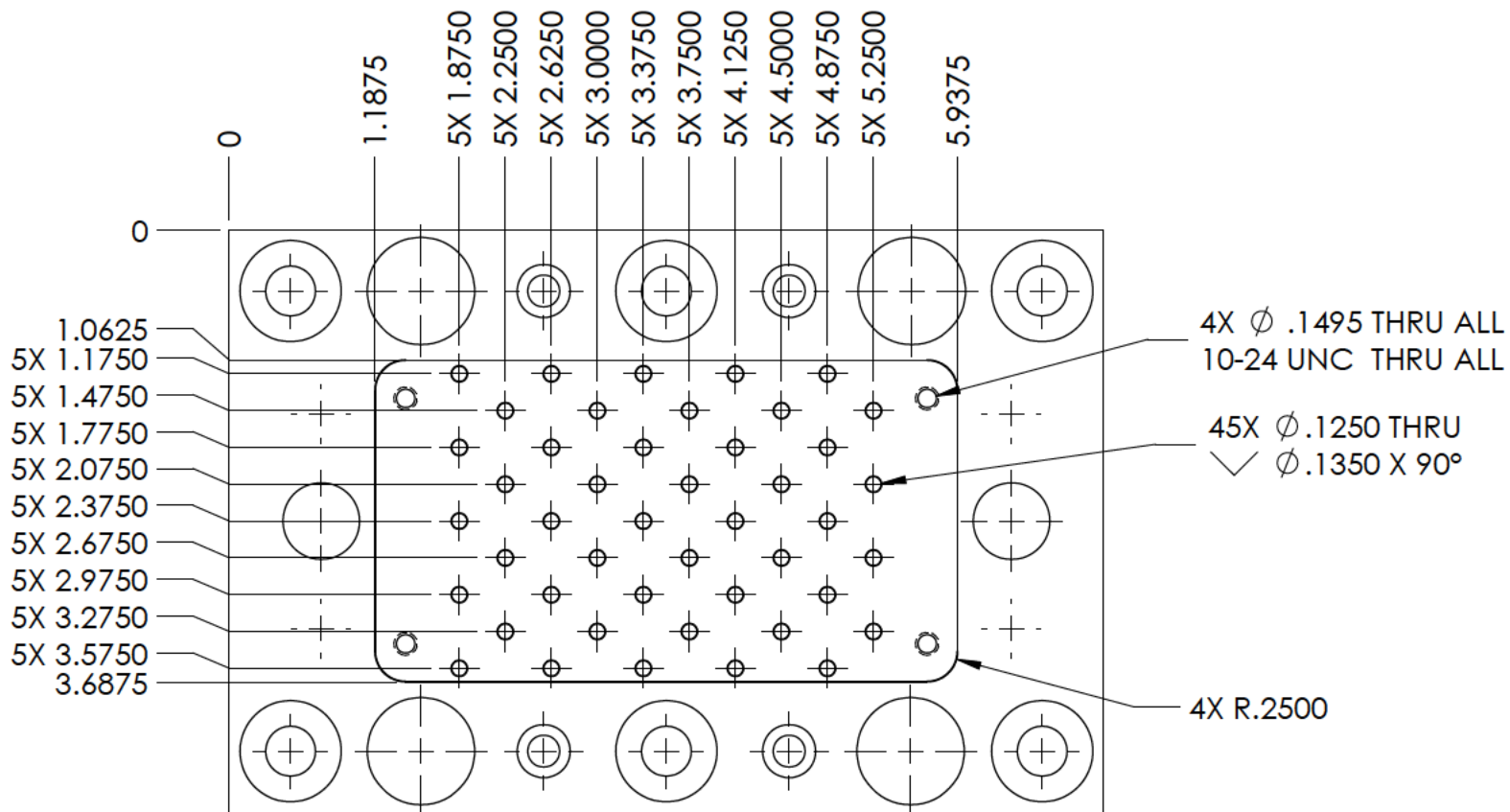


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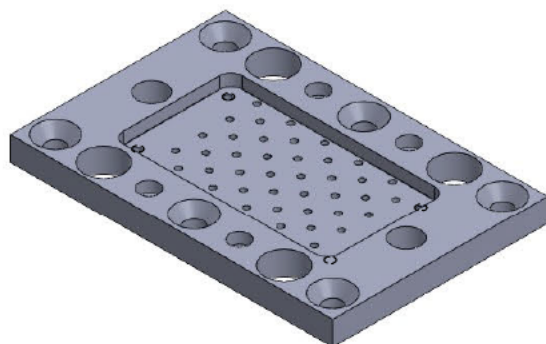
<b>TITLE: PUNCH HOLDER - STANDARD</b>		<b>APPROVED BY</b>		SHEET SIZE: A	
DESCRIPTION:				SCALE:	
MATERIAL: AISI TYPE A2 TOOL STEEL		TOOL & DIE	DATE	1:2	TOLERANCES UNLESS SPECIFIED (INCHES)
UNIFORM MATERIAL		ENGINEERING	DATE	.XX ±.030"	.XXX ±.010"
HARDNESS: 58-60 RC					
DATE CREATED: 2021-07-06				ANGLES	±1°
DRAWN BY: N. TRAN				SHEET 8 OF 12	
CUST. PART #:					







**NOTE:**

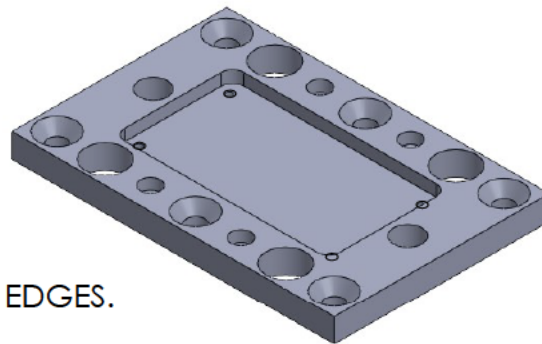
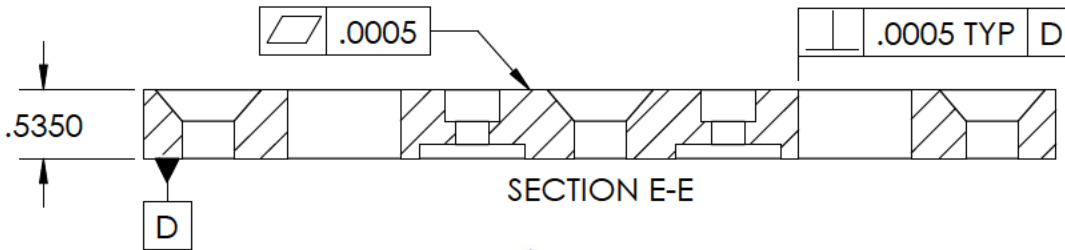
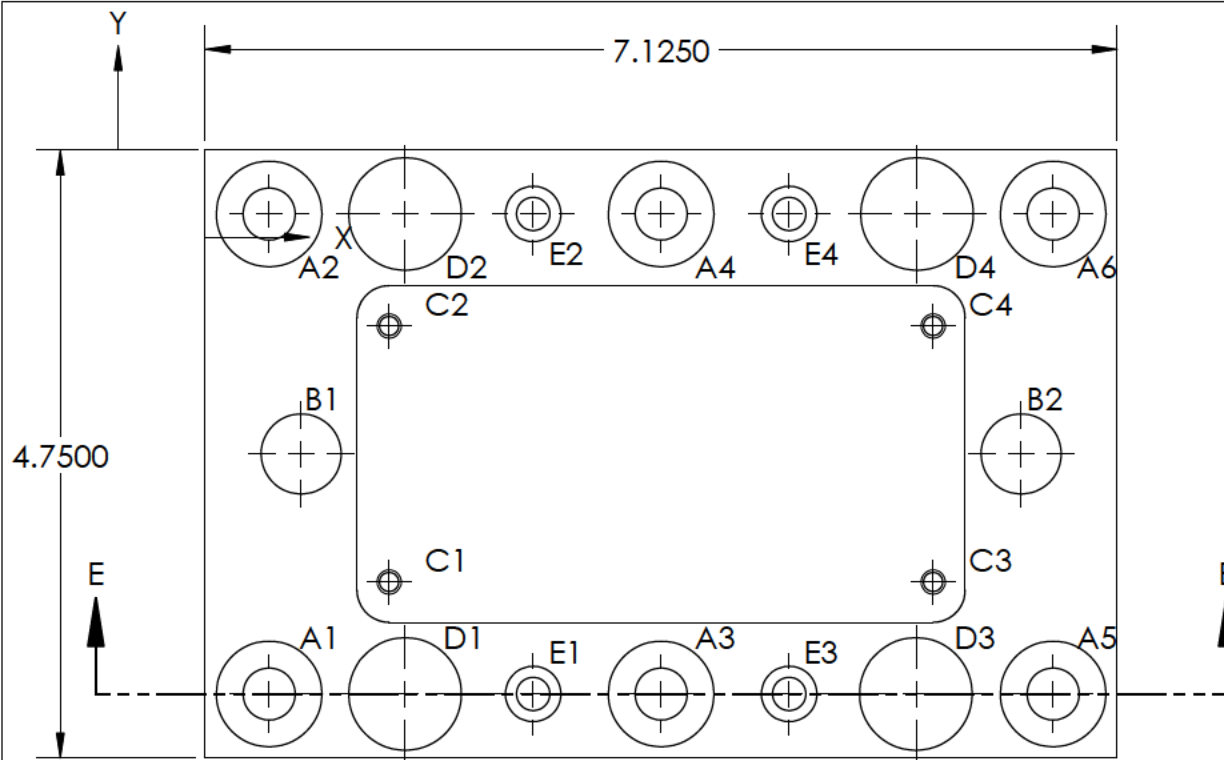
1. ALL DIMENSIONS USE NON-ACCUMULATIVE TOLERANCES
2. POCKET IS .2600" DEEP
3. PLEASE REFER TO STANDARD DRAWING



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<b>TITLE:</b> [REDACTED] <b>WEAR PLATE</b>		<b>APPROVED BY</b>	
<b>DESCRIPTION:</b> [REDACTED] <b>SOLDER DIE</b>		TOOL & DIE	DATE
<b>MATERIAL:</b> REFER TO STANDARD DRAWING			
<b>HARDNESS:</b> REFER TO STANDARD DRAWING		ENGINEERING	DATE
<b>DATE CREATED:</b> 2021-07-12			
<b>DRAWN BY:</b> N. TRAN		DRAFTSMAN	DATE
<b>CUST. PART #:</b>			
		TOLERANCES UNLESS SPECIFIED (INCHES) .X ±.030" .XX ±.010" .XXX ±.005" .XXXX ±.0001" ANGLES ±1°	
		SHEET 9 OF 12	

# WEAR PLATE-STANDARD

RO



TAG	X LOC	Y LOC	SIZE
A1	.5000	-4.2500	∅ .406 THRU ALL ✓ ∅ .825 X 82°
A2	.5000	-.5000	∅ .41 THRU ALL ✓ ∅ .83 X 82°
A3	3.5625	-4.2500	∅ .41 THRU ALL ✓ ∅ .83 X 82°
A4	3.5625	-.5000	∅ .41 THRU ALL ✓ ∅ .83 X 82°
A5	6.6250	-4.2500	∅ .41 THRU ALL ✓ ∅ .83 X 82°
A6	6.6250	-.5000	∅ .41 THRU ALL ✓ ∅ .83 X 82°
B1	.7500	-2.3750	∅ .625 THRU
B2	6.3750	-2.3750	∅ .625 THRU
C1	1.4375	-3.3750	∅ .1495 THRU ALL 10-24 UNC THRU ALL
C2	1.4375	-1.3750	∅ .1495 THRU ALL 10-24 UNC THRU ALL
C3	5.6875	-3.3750	∅ .1495 THRU ALL 10-24 UNC THRU ALL
C4	5.6875	-1.3750	∅ .1495 THRU ALL 10-24 UNC THRU ALL
D1	1.5625±.0001	-4.2500±.0001	∅ .8800±.0001 THRU
D2	1.5625±.0001	-.5000±.0001	∅ .8800±.0001 THRU
D3	5.5525±.0001	-4.2500±.0001	∅ .8800±.0001 THRU
D4	5.5625±.0001	-.5000±.0001	∅ .8800±.0001 THRU
E1	2.5625	-4.2500	∅ .26 THRU ALL └ ∅ .43 ▽ .25
E2	2.5625	-.5000	∅ .26 THRU ALL └ ∅ .43 ▽ .25
E3	4.5625	-4.2500	∅ .26 THRU ALL └ ∅ .43 ▽ .25
E4	4.5625	-.5000	∅ .26 THRU ALL └ ∅ .43 ▽ .25

**NOTE:**

1. BREAK ALL SHARP EDGES.

42 GRIND  
32

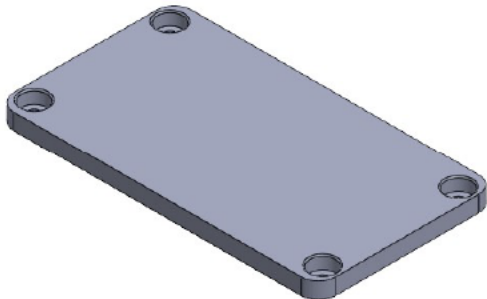
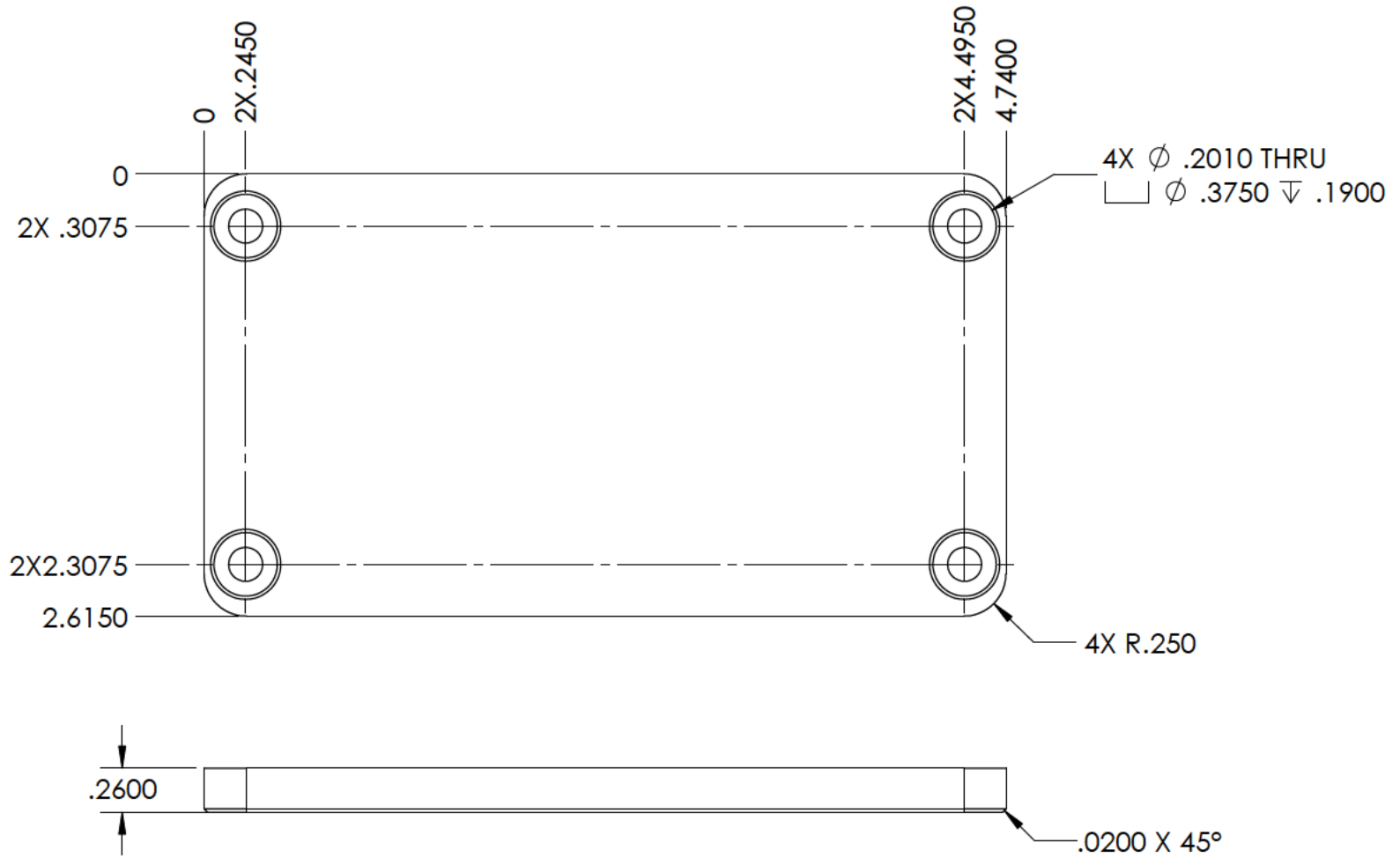
2. F.A.O.  
3. PERPENDICULARITY APPLIES TO ALL D HOLES.



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TITLE: WEAR PLATE - STANDARD		APPROVED BY		SHEET SIZE: A	SCALES
DESCRIPTION:		TOOL & DIE	DATE	1:1.5	
MATERIAL: AISI TYPE A2 TOOL STEEL					
UNIFORM MATERIAL		ENGINEERING	DATE	TOLERANCES UNLESS SPECIFIED (INCHES)	
HARDNESS: 58-60 RC				X ±.030" XX ±.010" XXX ±.005" XXXX ±.0005" ANGLES ±1°	
DATE CREATED: 2021-07-06		DRAFTSMAN	DATE	SHEET 10 OF 12	
DRAWN BY: N. TRAN					
CUST. PART #:					



**NOTE:**

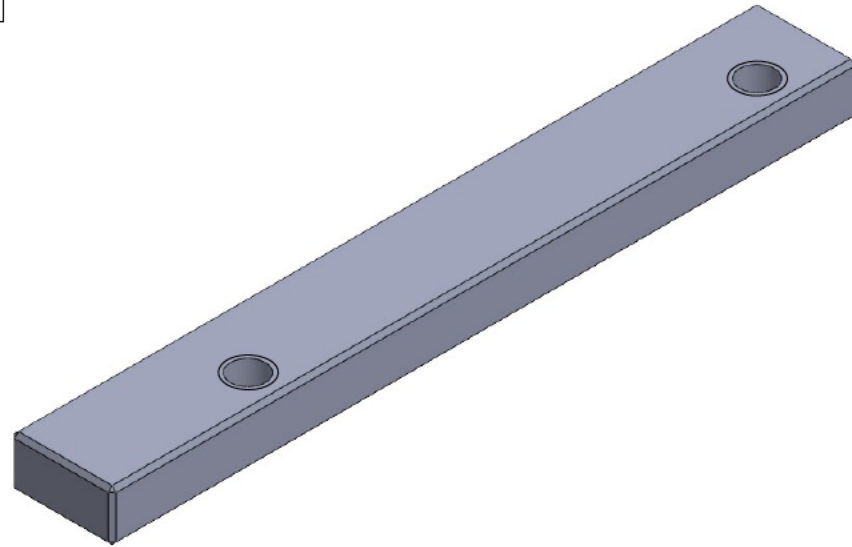
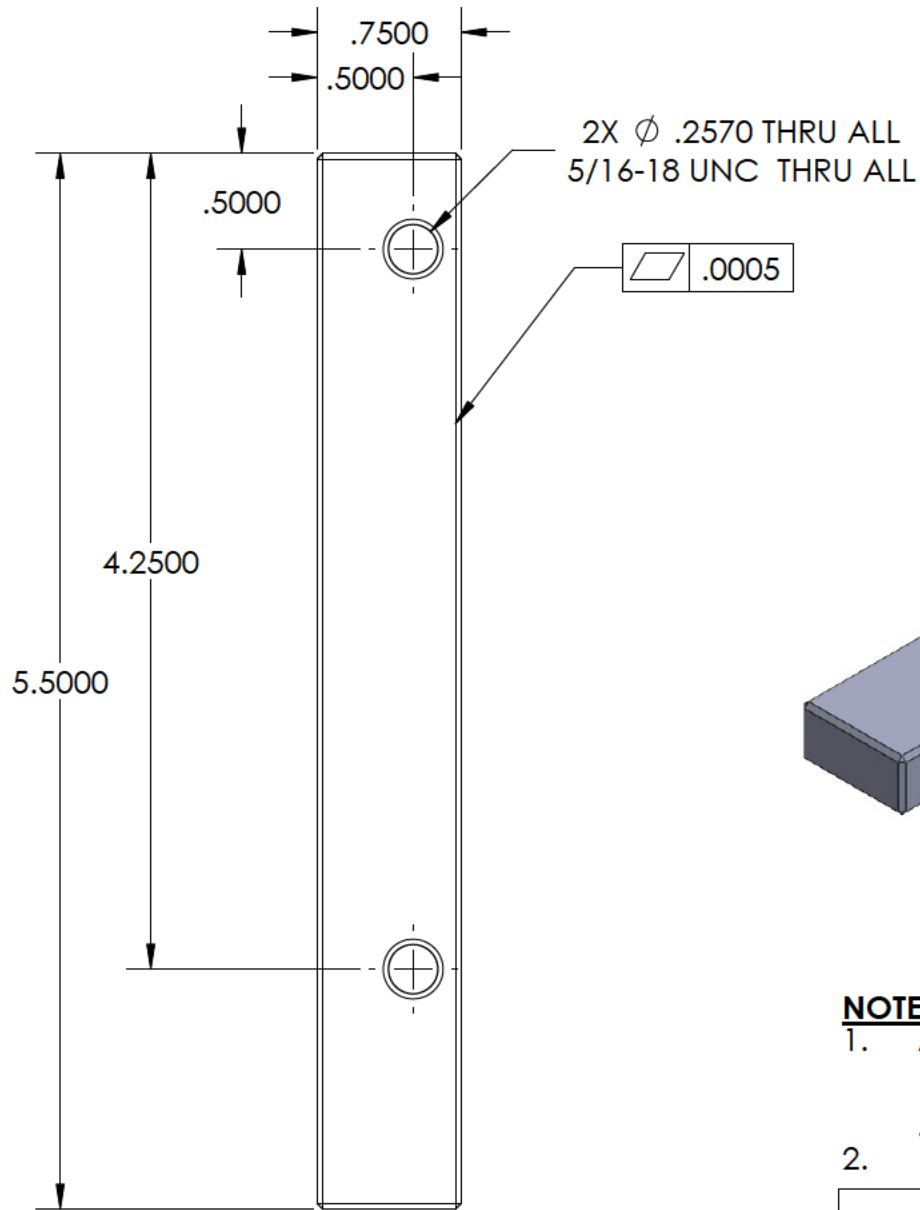
- BREAK ALL SHARP EDGES.  
42 GRIND  
32
- F.A.O.



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<b>TITLE: SPRING PLATE - STANDARD</b>		<b>APPROVED BY</b>		SHEET SIZE: A	
DESCRIPTION:		TOOL & DIE	DATE	SCALE:	
MATERIAL: AISI TYPE A2 TOOL STEEL				1:1	TOLERANCES UNLESS SPECIFIED (INCHES)
UNIFORM MATERIAL		ENGINEERING	DATE	.XX	±.030"
HARDNESS: 58-60 RC				.XXX	±.010"
DATE CREATED: 2021-07-06		DRAFTSMAN	DATE	.XXXX	±.005"
DRAWN BY: N. TRAN				.XXXXX	±.0005"
CUST. PART #:				ANGLES	±1°
				SHEET	1 OF 12



**NOTE:**

- ALL EDGES MUST BE CHAMFERED .0300 X 45°  
42 GRIND  
32
- F.A.O.



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<b>TITLE: RAIL - STANDARD</b>		<b>APPROVED BY</b>		SHEET SIZE: A	
DESCRIPTION: RAIL FOR SOLDER DIE		TOOL & DIE	DATE	SCALE: 1:1	
MATERIAL: D2 TOOL STEEL				TOLERANCES UNLESS SPECIFIED (INCHES)	
UNIFORM MATERIAL				.XX	±.030"
HARDNESS: 58-60 RC				.XXX	±.010"
DATE CREATED: 2021-02-25		ENGINEERING	DATE	.XXXX	±.005"
DRAWN BY: N. TRAN				.XXXXX	±.0005"
CUST. PART #:		DRAFTSMAN	DATE	ANGLES	±1°
				SHEET	12 OF 12