

ROUND TOOLS

APELIO

Tool Size (mm)	Tool Station		REMARKS	STN SIZE
	Prefer	Second		
1.60 dia	T132	T233	Burring Tool Pre-Pierce - M3 Tap	1/2
2.00 dia	T132	T233	Burring Tool Pre-Pierce - M4 Tap	1/2
2.20 dia	T132	T233	Burring Tool Pre-Pierce - M5 Tap	1/2
2.50 dia	T132	T233		1/2
2.70 dia	T132	T233		1/2
2.85 dia	T132	T233	M3 Tap Pre-Pierce	1/2
3.00 dia	T132	T233		1/2
3.10 dia	T132	T233	M3 S/C Stud & 6BA S/C Stud	1/2
3.20 dia	T132	T233		1/2
3.40 dia	T233	T136		1/2
3.60 dia	T233	T136	4BA S/C Stud	1/2
3.70 dia	T233	T136	M4 Tap Pre-Pierce	1/2
3.80 dia	T233	T136		1/2
3.90 dia	T233	T136		1/2
4.00 dia	T108	T209		1/2
4.10 dia	T108	T209	M4 S/C Stud	1/2
4.25 dia	T233	T136		1/2
4.30 dia	T104	T205	M2.5 & M3 - Pemsert & Thin Wall-Standoff	1/2
4.50 dia	T136	T237		1/2
4.70 dia	T136	T237	M5 Tap Pre-Pierce & 2BA S/C Stud	1/2
4.80 dia	T136	T237	M3.5 Pemsert	1/2
4.90 dia	T136	T237		1/2
5.00 dia	T136	T237		1/2
5.20 dia	T136	T237		1/2

Tool Size (mm)	Tool Station		REMARKS	STN SIZE
	Prefer	Second		
5.40 dia	T124	T225	M4 Pemsert & 3.5M3 Thick Wall-Standoff	1/2

Page.2

ROUND TOOLS

APELIO

Tool Size (mm)	Tool Station		REMARKS	STN SIZE
	Prefer	Second		
5.60 dia	T237	T152	M3 Hankbush & 6BA Hankbush	1/2
6.00 dia	T237	T152		1/2
6.20 dia	T237	T152		1/2
6.40 dia	T152	T253	M5 Pemsert & M4 Avdel	1/2
6.60 dia	T152	T253		1/2
6.80 dia	T152	T253		1/2
6.90 dia	T152	T253	M3.5 Hankbush / M4 Hankbush / 4BA Hankbush	1/2
7.00 dia	T253	T132		1/2
7.20 dia	T253	T132	M4 Standoff / M5 Standoff / M5 Avdel	1/2
7.50 dia	T253	T132		1/2
8.00 dia	T132	T233	M5 Hankbush	1/2
8.30 dia	T132	T233		1/2
8.75 dia	T132	T233	M6 Pemsert	1/2
9.00 dia	T132	T233		1/2
9.25 dia	T132	T233		1/2
9.50 dia	T233	T136	M6 Hankbush & M6 Avdel	1/2
10.00 dia	T233	T136		1/2
10.20 dia	T233	T136		1/2
10.50 dia	T233	T136		1/2
11.00 dia	T233	T136		1/2
11.10 dia	T237	T152		1/2

Tool Size (mm)	Tool Station		REMARKS	STN SIZE
	Prefer	Second		
11.30 dia	T237	T152		1/2
12.00 dia	T237	T152		1/2
12.25 dia	T237	T152		1/2
12.70 dia	T237	T152	M8 Hankbush	1/2

Page.3

ROUND TOOLS

APELIO

Tool Size (mm)	Tool Station		REMARKS	STN SIZE
	Prefer	Second		
12.50 dia	T139	T155		1 1/4
13.00 dia	T113	T113		1 1/4
14.00 dia	T141	T155		1 1/4
14.30 dia	T155	T139		1 1/4
15.00 dia	T139	T155		1 1/4
15.90 dia	T102	T102		1 1/4
16.10 dia	T130	T155		1 1/4
16.50 dia	T155	T139		1 1/4
17.50 dia	T130	T155		1 1/4
18.00 dia	T155	T139		1 1/4
19.10 dia	T155	T139		1 1/4
20.00 dia	T141	T141		1 1/4
20.80 dia	T155	T139		1 1/4
22.20 dia	T155	T139		1 1/4
22.70 dia	T155	T139		1 1/4
23.00 dia	T139	T155		1 1/4
23.20 dia	T139	T155		1 1/4
24.50 dia	T139	T155		1 1/4

Tool Size (mm)	Tool Station		REMARKS	STN SIZE
	Prefer	Second		
25.00 dia	T155	T139		1¼
25.40 dia	T127	T127		1¼
27.80 dia	T155	T139		1¼
29.00 dia	T139	T155		1¼
30.00 dia	T127	T127		1¼
32.00 dia	T251	T251		2
32.20 dia	T251	T251		2

Page.4

ROUND TOOLS

APELIO

Tool Size (mm)	Tool Station		REMARKS	STN SIZE
	Prefer	Second		
34.00 dia	T251	T251		2
35.00 dia	T251	T251		2
38.10 dia	T251	T251		2
39.00 dia	T251	T251		2
41.00 dia	T251	T251		2
41.30 dia	T251	T251		2
44.30 dia	T251	T251		2
49.30 dia	T251	T251		2
50.00 dia	T251	T251		2
50.80 dia	T251	T251		2
58.50 dia	T215	T215		3½
60.00 dia	T215	T215		3½
60.50 dia	T215	T215		3½
63.50 dia	T215	T215		3½
70.00 dia	T215	T215		3½

Tool Size (mm)	Tool Station		REMARKS	STN SIZE
	Prefer	Second		
75.00 dia	T215	T215		3½
85.00 dia	T215	T215		3½
110.00 dia	T201	T229		4½

SQUARE TOOLS

APELIO

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	STN SIZE
	Prefer	Second			
2.0 sq	T326	T338	---		½
2.0 sq	T326	T338	45		½
3.0 sq	T338	T306	---		½
4.8 sq	T338	T306	---		½
5.0 sq	T354	T354	---		½
5.0 sq	T338	T306	45		½
5.5 sq	T338	T306	---		½
6.4 sq	T310	T334	---		½
8.0 sq	T306	T334	---		½
9.5 sq	T303	T312	---		1¼
10.0 sq	T303	T303	45		1¼
10.0 sq	T216	T216	---		1¼

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	STN SIZE
	Prefer	Second			
11.1 sq	T328	T340			1¼
12.7 sq	T303	T312	---		1¼
13.1 sq	T303	T312	---		1¼
15.0 sq	T303	T312	---	3.0mm Rads on Corners	1¼
15.1 sq	T331	T331	---		1¼
20.0 sq	T303	T303	45		1¼
20.0 sq	T314	T216	---		1¼
21.0 sq	T312	T328	---		1¼
25.4 sq	T207	T207	---		2
50.0 sq	T215	T215	---		3½
80.0 sq	T201	T229	---		4½

Page.6

RECTANGULAR TOOLS

APELIO

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	Tool No	STN SIZE
	Prefer	Second				
5.0 x 1.5	T306	T338	0 & 90		TN205.15	½
5.0 x 2.0	T306	T338	0 & 90		TN205.02	½
5.5 x 2.5	T306	T338	0 & 90		TN2055.25	½
6.1 x 3.6	T306	T326	0 & 90		TN2061.36	½
5.1 x 3.5	T306	T310	0		TN2051.35	½
5.1 x 3.5	T310	T306	90		TN2051.35	½
6.0 x 1.0	T306	T338	0 & 90		TN206.01	½
6.5 x 4.5	T306	T338	0 & 90		TN2065.45	½
6.0 x 4.0	T306	T326	0 & 90		TN206.04	½

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	Tool No	STN SIZE
	Prefer	Second				
7.0 x 4.0	T338	T334	0 & 90		TN207.04	1/2
8.0 x 4.0	T338	T334	0 & 90		TN208.04	1/2
8.0 x 4.5	T338	T334	0 & 90		TN208.45	1/2
8.0 x 5.0	T338	T334	0 & 90		TN208.05	1/2
10.0 x 7.0	T334	T310	0 & 90		TN210.07	1/2
10.1 x 1.6	T334	T310	0 & 90		TN2101.16	1/2
10.2 x 1.7	T326	T306	0		TN2102.17	1/2
10.2 x 1.7	T306	T326	90		TN2102.17	1/2
11.0 x 3.0	T334	T338	0		TN211.03	1/2
11.0 x 3.0	T338	T334	90		TN211.03	1/2
9.5 x 5.0	T312	T328	0 & 90		TN2095.05	1 1/4
12.0 x 2.0	T328	T312	0 & 90		TN212.02	1 1/4
12.0 x 6.0	T312	T328	0 & 90		TN212.06	1 1/4
13.0 x 7.0	T328	T340	0 & 90		TN213.07	1 1/4
13.0 x 12.0	T312	T303	0		TN213.12	1 1/4
13.0 x 12.0	T303	T312	90		TN213.12	1 1/4

Page.7

RECTANGULAR TOOLS

APELIO

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	Tool No	STN SIZE
	Prefer	Second				
15.0 x 2.0	T328	T312	0 & 90		TN215.02	1 1/4
15.0 x 4.0	T340	T303	0 & 90		TN215.04	1 1/4
15.0 x 6.0	T340	T303	0 & 90		TN215.06	1 1/4
15.0 x 10.0	T340	T303	0 & 90		TN215.1	1 1/4
15.0 x 13.0	T328	T340	0 & 90		TN215.13	1 1/4
15.8 x 8.9	T340	T303	0 & 90		TN2158.89	1 1/4

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	Tool No	STN SIZE
	Prefer	Second				
16.0 x 12.5	T340	T303	0 & 90		TN216.12	1¼
16.5 x 14.5	T340	T303	0 & 90		TN2165.14	1¼
19.1 x 9.5	T340	T303	0 & 90		TN2191.95	1¼
20.0 x 2.0	T303	T312	0 & 90		TN220.02	1¼
20.0 x 5.0	T342	T342	0 & 90		TN220.05	1¼
20.0 x 12.0	T303	T312	0 & 90	1.0mm Rads on Corners	TN220.12	1¼
20.7 x 11.1	T342	T342	0 & 90		TN2207.11	1¼
22.0 x 8.0	T303	T312	0 & 90		TN222.08	1¼
23.0 x 5.0	T312	T340	0 & 90		TN223.05	1¼
25.0 x 5.0	T342	T340	0 & 90		TN225.05	1¼
25.5 x 13.1	T312	T340	0 & 90		TN2255.13	1¼
26.4 x 9.9	T328	T340	45-135		TN264.99	1¼
30.0 x 1.3	T328	T340	0 & 90		TN230.13	1¼
30.0 x 2.0	T328	T340	0 & 90		TN230.02	1¼
30.0 x 5.0	T244	T244	0		TN230.05	1¼
28.4 x 23.4	T251	T251	0 & 90		TN2284.23	2
30.5 x 22.5	T251	T251	0 & 90		TN2305.22	2
30.7 x 13.1	T251	T251	0 & 90		TN2307.13	2
33.0 x 27.0	T251	T251	0 & 90		TN233.27	2

Page.8

RECTANGULAR TOOLS

APELIO

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	Tool No	STN SIZE
	Prefer	Second				
38.1 x 12.7	T251	T251	0 & 90		TN2381.12	2
44.5 x 13.1	T251	T251	0 & 90		TN2445.13	2
45.0 x 4.0	T251	T251	0 & 90		TN245.04	2

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	Tool No	STN SIZE
	Prefer	Second				
5.5 x 1.5	T338	T306	0 & 90		TN355.25	1/2
6.8 x 4.8	T338	T306	0 & 90		TN368.48	1/2
7.0 x 4.0	T338	T306	0		TN307.04	1/2
7.0 x 4.0	T334	T338	90		TN307.04	1/2
7.0 x 5.5	T334	T338	0 & 90		TN307.55	1/2
7.5 x 3.5	T338	T306	0 & 90	Cut Away Sleeve	TN375.35	1/2
8.0 x 2.0	T338	T306	0 & 90		TN308.02	1/2
9.0 x 5.0	T306	T326	0		TN309.05	1/2
9.0 x 5.0	T326	T324	90		TN309.05	1/2
9.2 x 3.2	T338	T326	0 & 90		TN392.32	1/2
10.0 x 1.5	T338	T306	0 & 90		TN310.15	1/2
10.0 x 6.0	T338	T306	0 & 90		TN310.06	1/2
10.0 x 7.0	T338	T306	0 & 90		TN310.07	1/2
11.0 x 5.5	T338	T306	0 & 90		TN311.55	1/2
11.0 x 7.0	T338	T306	0 & 90		TN311.07	1/2
12.0 x 7.0	T338	T306	0 & 90		TN312.07	1/2
5.0 x 3.0	T312	T328	0 & 90		TN305.03	1 1/4
10.0 x 5.5	T312	T328	0 & 90		TN310.55	1 1/4
12.0 x 6.0	T312	T328	0 & 90		TN312.06	1 1/4
12.0 x 8.0	T312	T328	0 & 90		TN312.08	1 1/4
12.7 x 6.4	T340	T340	0 & 90		TN3127.64	1 1/4
13.0 x 8.0	T328	T340	75		TN313.08	1 1/4
15.0 x 6.0	T328	T340	0 & 90		TN315.06	1 1/4
15.0 x 7.0	T340	T303	0 & 90		TN315.07	1 1/4
15.0 x 10.0	T340	T303	0 & 90		TN315.1	1 1/4

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	Tool No	STN SIZE
	Prefer	Second				

Page.11

SPECIAL TOOLS

APELIO

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	M CODE	Tool No	STN SIZE
	Prefer	Second					
3.00 dia	T132	T233	---	Half Pierce - Down Form	M544	TN503.3	1/2
4.00 dia	T132	T233	---	Up Form C/sk Tool Quatro	M563	TN504.1	1/2
4.30 dia	T310	T306	---	M2 C/Sink - All Gauges	M562	TN502	1/2
4.4 x 3.8	T306	T310	0 & 90	Double - D with Lugs		TN504.4	1/2
5.0 x 3.0	T306	T310	0 & 90	Double - D Punch (2.5 Rads)		TN505.3	1/2
5.30 dia	T310	T306	---	M2.5 C/Sink - All Gauges	M562	TN502.5	1/2
5.9 x 3.3	T306	T310	0 & 90	Double - D Punch		TN559.33	1/2
6.0 x 5.7	T306	T310	90-180	D - Punch		TN506.57	1/2
6.40 dia	T310	T306	---	M3 C/Sink - All Gauges	M562	TN503	1/2
6.4 x 6.1	T306	T310	180-270	D - Punch			1/2
8.0 x 8.3	T306	T310	0 & 90	Triangle c/w Rads (Opt Data)			1/2
8.60 dia	T310	T306	---	M4 C/Sink - All Gauges	M562	TN504	1/2
9.2 x 8.2	T310	T334	0-360	D - Punch		TN592.82	1/2
9.5 x 9.5	T310	T334	0 & 90	9.5 a/f Hexagon		TN509.5	1/2
6.9 x 6.0	T310	T334	0 & 90	6.9 a/f Hexagon		TN569.60	1/2
9.7 x 8.0	T310	T334	0 & 90	Double - D Punch		TN597.8	1/2
9.7 x 8.9	T310	T334	0 & 90	D- Punch		TN597.89	1/2
10.4 x 7.5	T334	T338	0 & 90	Double - D Punch			1/2
10.4 x 8.8	T334	T338	0 & 90	Double - D Punch		TN5104.88	1/2
10.60 dia	T310	T306	---	M5 C/Sink - All Gauges	M562	TN505	1/2
10.00 x 6.5	T310	T306	0 & 90	U shape relief cutout for taps		TN510.65	1/2

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	M CODE	Tool No	STN SIZE
	Prefer	Second					
10.7 x 10.7	T306	T310	0 & 90	10.7 a/f Hexagon		TN510.7	1/2
11.0 x 10.5	T334	T338	90-180	D - Punch		TN511.15	1/2
12.2 x 11.0	T334	T338	45-135	Double - D Punch		TN512.11	1/2
12.2 x 11.5	T334	T338	0 & 90	Double Key		TN5122.15	1/2

Page.12

SPECIAL TOOLS

APELIO

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	M CODE	Tool No	STN SIZE
	Prefer	Second					
12.7 x 11.5	T334	T338	0 & 90	Double - D Punch		TN5127.11	1/2
12.7 x 11.9	T334	T338	90-180	D - Punch		TN5127.12	1/2
12.80 dia	T310	T306	---	M6 C/Sink - All Gauges	M562	TN506	1/2
5.30 dia	T111	T139	---	M2.5 Up-Form C/Sink - 14g	M563	TN502.51	1 1/4
6.00 dia	T111	T155	---	Rivet C/Sink - 20g Matl	M562	TN506.12	1 1/4
1.00 dia	T155	T139	---	Dot Punch - Up Form	M560	TN1	1 1/4
1.00 dia	T111	T139	---	Dot Punch - Down Form	M561	TN1.1	1 1/4
3.00 dia	T312	T328	---	M3 Taptite - Up Form + Ø1.6	M523	TN503.1	1 1/4
3.00 dia	T312	T328	---	M3 Taptite - Down Form	M524	TN503.2	1 1/4
3.00 dia	T130	T155	---	M3 Burring - Up Form + Ø1.6	M523	TN503.16	1 1/4
4.00 dia	T132	T233	---	Half Pierce - Down Form	M545	TN504.5	1 1/4
4.00 dia	T139	T155	---	M4 Taptite - Up Form	M529	TN504.02	1 1/4
4.00 dia	T130	T155	---	M4 Burring - Up Form + Ø2.0	M523	TN504.2	1 1/4
5.00 dia	T130	T155	---	M5 Burring - Up Form + Ø2.2	M523	TN505.22	1 1/4
6.40 dia	T155	T139	---	M3 C/Sink UP-Form (16g)	M563	TN506.41	1 1/4
6.70 dia	T310	T326	---	M3 special C/Sink (20g)	M563	TN506.42	1/2
8.40 dia	T155	T139	---	M4 C/Sink UP-Form (18g)	M563	TN508.41	1 1/4
7.0 x 4.0	T216	T216	0	Half Pierce (MHG)	M517	TN507.01	1 1/4

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	M CODE	Tool No	STN SIZE
	Prefer	Second					
10.0 dia	T155	T139	---	C/Sink & Down Form	M530	TN510.1	1¼
10.0 dia	T155	T139	---	10.0 Dia Indent (Belgravium)	M516	TN510.2	1¼
10.0 x 5.0	T312	T303	0&90	Indent Tool	M511	TN510.5	1¼
10.60 dia	T111	T312	---	M5 C/Sk u/form Tips (10g)	M566	TN510.61	1¼
10.60 dia	T111	T312	---	M5 C/Sk - 5.0/6.0mm thk Matl	M562	TN505.6	1¼
10.80 dia	T111	T312	---	M5 C/Sk special 120°	M566	TN505.12	½
11.0 x 11.0	T356	T356	0 & 90	Maltese Cross - 3.0mm Rads		TN511.11	1¼

Page.13

SPECIAL TOOLS

APELIO

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	M CODE	Tool No	STN SIZE
	Prefer	Second					
11.0 x 11.0	T312	T319	0 & 90	Maltese Cross - 4.0mm Rads		TN511.04	1¼
11.5 x 10.0	T244	T216	0	Triangle Tool (Labplant)		TN511.54	1¼
12.0 dia	T155	T139	---	12.0 Dia Indent (Pace)	M532	TN512	1¼
12.0 x 12.0	T340	T303	0 & 90	Lance & Up-Form (Datac)	M534	TN512.12	1¼
12.2 x 10.6	T340	T303	0 & 90	Double - D Punch		TN5122.1	1¼
12.80 dia	T111	T312	---	M6 C/Sk - 5.0/6.0mm thk Matl	M562	TN506.6	1¼
13.0 dia	T155	T139	---	13.0 Dia Indent Downform	M543	TN513.1	1¼
13.0 x 3.0	T244	T244	0	Bridge Tool (Racal)	M531	TN513.03	1¼
14.0 x 13.0	T340	T303	0-270	D- Punch		TN514.13	1¼
14.3 x 13.5	T340	T303	0 & 90	Double - D Punch		TN5143.13	1¼
14.5 x 11.0	T340	T303	0 & 90	SCSI Knockout	M504	TN5145.11	1¼
15.0 x 5.0	T340	T303	0 & 90	Tab Tool Up-Form (Schott)			1¼
15.0 x 10.0	T312	T303	0 & 90	C-Shaped Punch (PSS)		TN515.1	1¼
15.0 x 13.0	T312	T303	90&180	D- Punch		TN515.13	1¼
15.0 x 15.0	T244	T216	0	Multi Radius Tool		TN515.15	1¼

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	M CODE	Tool No	STN SIZE
	Prefer	Second					
15.0 x 15.0	T312	T303	0	Indent Tool		TN515.05	1¼
16.0 dia	T111	T312	---	M8 C/Sk	M562	TN548	1¼
16.0 x 6.0	T216	T244	0	2-Way Corner Notch (Schott)		TN516.06	1¼
16.0 x 13.0	T303	T312	0 & 90	Double - D Punch		TN516.13	1¼
17.0 x 6.0	T244	T244	0	Lance & Up-Form (Pedestals)	M535	TN517.06	1¼
17.0 x 15.0	T303	T312	0 & 90	15.0 a/f Key Punch			1¼
17.1 x 16.1	T303	T312	0-360	D- Punch		TN517.16	1¼
18.0 dia	T155	T139	---	18.0 Dia Indent (Pace)	M518	TN518	1¼
18.0 x 17.0	T303	T312	0 & 90	Double - D Punch		TN518.17	1¼
19.0 dia	T155	T139	---	Dimple Tool - Down Form	M519	TN519	1¼

Page.14

SPECIAL TOOLS

APELIO

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	M CODE	Tool No	STN SIZE
	Prefer	Second					
19.0 x 14.0	T244	T216	0 360	Schott Foot - Down Form	M520	TN519.14	1¼
19.1 x 17.0	T303	T312	0 & 90	Double - D Punch		TN5191.17	1¼
20.0 dia	T312	T328	---	Electrical K/Out - Up Form	M502	TN520	1¼
20 x 3.0	T216	T244	0 & 90	3 x Ø3.0 Gang Tool		TN520.03	1¼
20 x 6.0	T244	T216	0 & 90	3 x Ø6.0 Gang Tool		TN520.06	1¼
20.0 x 20.0	T303	T312	0 & 90	0.5mm Indent-DownForm(Focus)	M525	TN520.2	1¼
20.5 x 11.4	T312	T328	0 & 90	Cinch Punch		TN5205.11	1¼
21.0 dia	T155	T139	---	Dimple Tool - Down Form	M521	TN521	1¼
21.0 x 16.0	T312	T328	0 & 90	Left Hand Hook Form			1¼
21.0 x 16.0	T328	T312	0 & 90	Right Hand Hook Form			1¼
22.0 x 13.1	T312	T328	0 & 90	D - Punch (8.15 Rad)			1¼
22.5 dia	T155	T139	---	Dimple Tool - Up Form	M522	TN522.5	1¼

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	M CODE	Tool No	STN SIZE
	Prefer	Second					
22.5 x 20.1	T312	T328	0 & 90	Emka Latch Tool - 20.1a/f		TN5225.2	1¼
23.0 x 5.0	T216	T244	0	Lance & Up-Form (Litronics)	M526	TN523.05	1¼
24.0 x 13.0	T244	T216	0	Lance & Up-Form (Splice)	M515	TN524.13	1¼
25.0 dia	T312	T328	---	Electrical K/Out - Up Form	M503	TN525	1¼
25.0 x 6.5	T244	T340	0 - 360	Trapezoid		TN525.65	1¼
25.0 x 17.0	T328	T340	0 & 90	Indent - Down Form (Datac)	M525	TN525.17	1¼
25.0 x 20.0	T328	T340	0 & 90	Lance & Up-Form			1¼
25.5 x 17.0	T328	T340	0 & 90	Manual Override Cam - Blank			1¼
26.0 x 10.0	T244	T216	0	118.0 Dia Arc Tool		TN526.1	1¼
30.0 x 5.0	T244	T244	0	Trapezoid		TN530.05	1¼
30.0 x 6.0	T340	T342	0 & 90	D/form rectangle indent (16g)		TN530.06	1¼
30.0 x 10.0	T244	T216	0	¼ Radius Tool		TN526.1	1¼
14.0 x 12.0	T251	T235	0 & 90	Up-Form Foot (Datac 6000)	M527	TN514.12	2

Page.15

SPECIAL TOOLS

APELIO

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	M CODE	Tool No	STN SIZE
	Prefer	Second					
17.0 x 17.0	T235	T235	0	M3 Tapping Tool	M08	TN503.03	2
17.0 x 17.0	T235	T235	0	M4 Tapping Tool	M08	TN504.04	2
17.0 x 17.0	T235	T235	0	M5 Tapping Tool	M08	TN505.05	2
24.3 x 12.8	T251	T235	0 & 90	5.0sq @45' Gang Tool		TN505.45	2
27.0 x 27.0	T251	T235	0 & 90	PEM Indent (Pace)		TN527.27	2
28.0 x 25.0	T251	T235	0	Special Triangle			2
30.0 dia	T251	T235		Burring Tool (Afos)			2
32.0 dia	T251	T235	---	Dimple Tool - Down Form	M533	TN532	2
33.0 x 15.0	T251	T235	0	Hook Bracket			2

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	M CODE	Tool No	STN SIZE
	Prefer	Second					
34.0 x 27.0	T251	T235	0 & 90	7.0mm Rads on Corners		TN534.27	2
35.0 dia	T251	T235	---	Burring Tool (Afos)			2
36.0 x 20.0	T251	T235	0 & 90	Logo Indent (Opt Data)	M536	TN536.2	2
40.0 x 12.0	T251	T235	0 & 90	Indent Down-Form (Datac)	M542	TN540.12	2
40.0 x 13.0	T235	T215	0 - 360	6.0mm Deep Louvre Up-Form	M541	TN540.13	2
41.5 x 40.0	T251	T235	0 & 90	Cam Base - Blank			2
42.0 x 30.8	T251	T235	0 & 90	Cam - Blank			2
47.8 x 17.2	T251	T235	0 - 360	Small Scart Tool (Pace)			2
40.0 dia	T215	T215	---	Burring Tool (Afos)			3½
40.0 x 40.0	T215	T215	0 & 90	Corner Swage Up-Form	M540	TN540.4	3½
42.0 x 41.0	T215	T243	0	T - Blanking Tool (Shores)			3½
43.0 x 351.0	T215	T243	0	Logo Indent (Focus IT)			3½
45.0 dia	T215	T215	---	Burring Tool (Afos)			3½
48.2 x 17.8	T215	T243	0 - 360	Large Scart Tool (Pace)		TN5482.17	3½
50.0 dia	T215	T215	---	Swage Up-Form			3½
51.5 x 36.0	T215	T243	0 & 90	KNX - End Profile			3½

Page.16

SPECIAL TOOLS

APELIO

Tool Size (mm)	Tool Station		Angle Setting	REMARKS	M CODE	Tool No	STN SIZE
	Prefer	Second					
54.0 x 35.0	T215	T243	0 & 90	Corner Notch (Pace)			3½
73.0 x 50.0	T215	T243	0 & 90	Blanking Tool - 10mm Rads			3½
73.5 x 24.0	T215	T243	0 & 90	Latch - Blank			3½
70.0 x 70.0	T215	T215	0 - 90	Teddy Bear Tool (Splice)		TN553	3½
75.0 x 15.0	T215	T215	0 - 360	6.0mm Deep Louvre Up-Form	M510	TN575.15	3½
87.7 x 35.2	T229	T201	0 & 90	10.0sq Gang Tool		TN5110	4½

