

# Cleveland Punch & Die Co.

**PUNCHES • DIES • SHEAR BLADES**

**for MUBEA™ IRONWORKERS**



**phone 1-800-451-4342**

**fax 1-800-451-6877**

666 Pratt St. • Box 769 • Ravenna, Ohio 44266 • [www.clevelandpunch.com](http://www.clevelandpunch.com)

# CLEVELAND PUNCH & DIE COMPANY

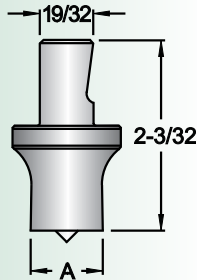
## Dimensions & Specifications

These pages illustrate our commonly used punches, dies and related tooling for Mubea™ Ironworkers. Refer to our **Cross Reference Catalog** for the proper tooling to fit your machine.

**STOCK PUNCHES & DIES ARE SHIPPED THE SAME DAY ORDERED!**

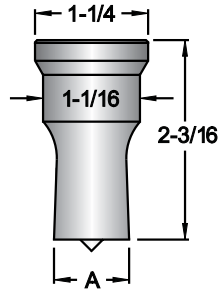
**\*MADE TO ORDER SIZES CAN BE SHIPPED IN AS LITTLE AS 24 HOURS!**

**BF-10\***



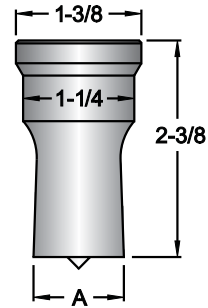
**H-1**

**IN STOCK**

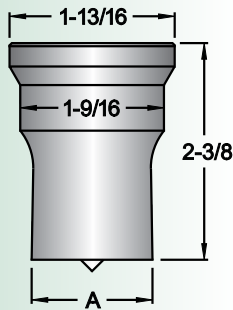


**H-2**

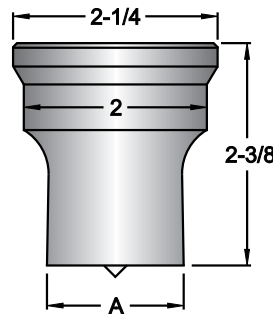
**IN STOCK**



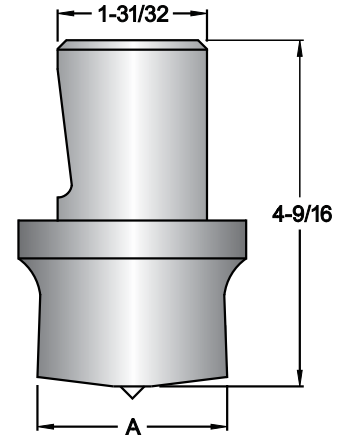
**H-3\***



**H-4\***

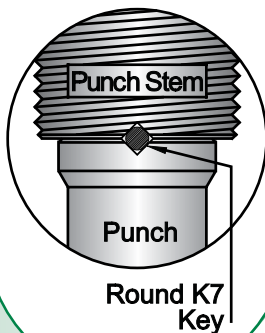


**H-5\***



**GREEN  
TEAM TIP:**

*H-1, H-2, H-3, and H-4 shaped punches require a **round, K7 key** to provide anti-rotational movement. K7 keys can be shipped from stock.*



**H-3 to H-2 Mubea™  
Punch Reducing  
Sleeve**

**IN STOCK**



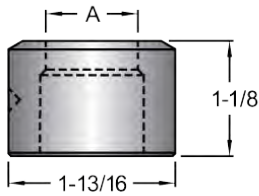
**MUBEA™ TOOLING**



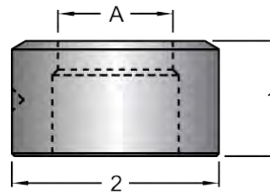
FOR MORE HOLES PER DOLLAR CALL  
**1-800-451-4342**  
 FAX 1-800-451-6877  
 www.clevelandpunch.com

\*MADE TO ORDER SIZES CAN BE SHIPPED IN AS LITTLE AS 24 HOURS!

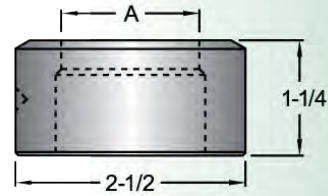
**H-1**  
 IN STOCK



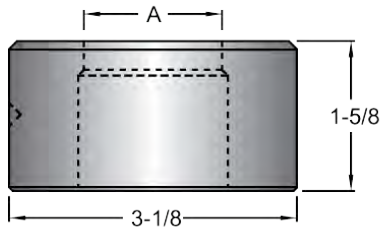
**H-2**  
 IN STOCK



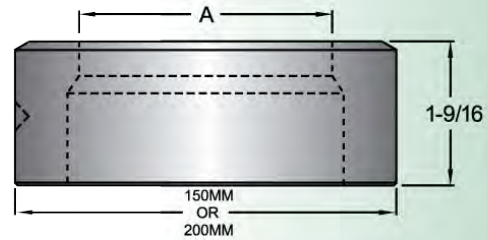
**H-3\***



**H-4\***



**H-5\***



**Mubea™ CN-H1**  
**Coupling Nut**  
 IN STOCK



**MUBEA™ TOOLING**

# CLEVELAND PUNCH & DIE COMPANY

## Stock Mubea™ Punches & Dies

The following table lists our stock round punches and dies for Mubea™ Ironworkers. Made to order sizes can be shipped in as little as 24 hours. Refer to our **Cross Reference Catalog** for the proper tooling to fit your machine.

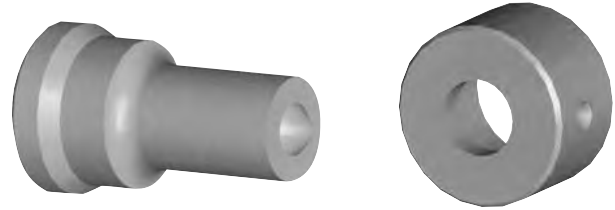
**STOCK PUNCHES & DIES ARE SHIPPED THE SAME DAY ORDERED!**

*\*MADE TO ORDER SIZES CAN BE SHIPPED IN AS LITTLE AS 24 HOURS!*

● Represents stock round sizes

### STOCK ROUND PUNCHES & DIES

Size	PUNCHES		DIES	
	H-1	H-2	H-1	H-2
1/8	●	●		
5/32	●	●	●	●
3/16	●	●	●	●
7/32	●	●	●	●
1/4	●	●	●	●
9/32	●	●	●	●
5/16	●	●	●	●
11/32	●	●	●	●
3/8	●	●	●	●
13/32	●	●	●	●
7/16	●	●	●	●
15/32	●	●	●	●
1/2	●	●	●	●
17/32	●	●	●	●
9/16	●	●	●	●
19/32	●	●	●	●
5/8	●	●	●	●
21/32	●	●	●	●
11/16	●	●	●	●
23/32	●	●	●	●
3/4	●	●	●	●
25/32	●	●	●	●
13/16	●	●	●	●
27/32	●	●	●	●
7/8	●	●	●	●
29/32	●	●	●	●
15/16	●	●	●	●
31/32	●	●	●	●
1	●	●	●	●
1-1/32	●	●	●	●
1-1/16	●	●	●	●
1-3/32	●	●	●	●
1-1/8	●	●	●	●
1-5/32	●	●	●	●
1-3/16	●	●	●	●
1-7/32	●	●	●	●
1-1/4	●	●	●	●
1-9/32			●	●



**GREEN TEAM TIP:**  
Punches last longer when used with a punch lubricant. For maximum punch life, use Cleveland Punch & Die's patented punch lubricant - **Punch Easy**.

### H-3 to H-2 Mubea™ Punch Reducing Sleeve

**IN STOCK**



### Mubea™ CN-H1 Coupling Nut

**IN STOCK**



### MUBEA COUPLING NUTS

COUPLING NUT NUMBER	OLD COUPLING NUT NUMBER	HEXAGON SIZE	THREADS PER INCH	A	B	C	D	USE WITH PUNCH FIGURE NUMBER
				LARGEST O.D.	THREAD DIAMETER	BORE	LENGTH	
CN-H1	C-H1	2	2 PITCH	2-5/16	42mm	1.130	1-5/8	H-1
CN-H2*	C-H2	2-1/2	2 PITCH	2-29/32	52mm	1.228	1-5/8	H-2
CN-H3*	C-H3	2-1/2	2 PITCH	2-29/32	52mm	1.583	1-5/8	H-3
CN-H4*	C-H4	3-1/2	2 PITCH	4-1/16	64mm	2.012	1-9/16	H-4

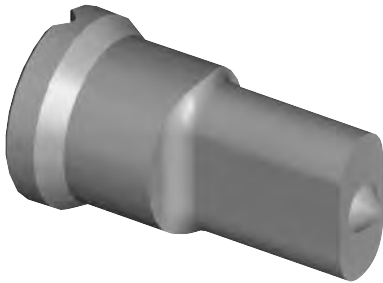
ROUND MUBEA™ TOOLING

FOR MORE HOLES PER DOLLAR CALL  
**1-800-451-4342**  
 FAX 1-800-451-6877  
 www.clevelandpunch.com

The following tables list our stock oblong punches & dies for Mubea™ Ironworkers. Made to order sizes can be shipped in as little as 24 hours. Refer to our **Cross Reference Catalog** for the proper tooling to fit your machine.

**STOCK PUNCHES & DIES ARE SHIPPED THE SAME DAY ORDERED!**

*\*MADE TO ORDER SIZES CAN BE SHIPPED IN AS LITTLE AS 24 HOURS!*



**STOCK OBLONG PUNCHES**

● Represents stock oblong sizes

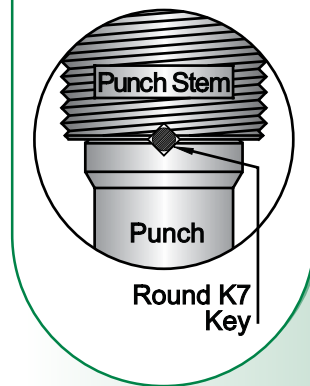
FIGURE NUMBER	H-1	H-2
5/16 x 1	●	●
11/32 x 1	●	●
3/8 x 1	●	●
13/32 x 3/4	●	●
13/32 x 1	●	●
7/16 x 3/4	●	●
7/16 x 1	●	●
7/16 x 1-1/4	●	●
1/2 x 1	●	●
17/32 x 1	●	●
9/16 x 3/4	●	●
9/16 x 1	●	●
9/16 x 1-1/4	●	●
5/8 x 1	●	●
11/16 x 1	●	●
13/16 x 1	●	●
13/16 x 1-1/4	●	●
7/8 x 1	●	●

**STOCK OBLONG DIES**

● Represents stock oblong sizes

FIGURE NUMBER	H-1	H-2
11/32 x 1-1/32	●	●
3/8 x 1-1/32	●	●
13/32 x 1-1/32	●	●
7/16 x 25/32	●	●
7/16 x 1-1/32	●	●
15/32 x 25/32	●	●
15/32 x 1-1/32	●	●
15/32 x 1-9/32	●	●
17/32 x 1-1/32	●	●
9/16 x 1-1/32	●	●
19/32 x 25/32	●	●
5/8 x 13/16	●	●
19/32 x 1-1/32	●	●
5/8 x 1-1/16	●	●
19/32 x 1-9/32	●	●
5/8 x 1-5/16	●	●
21/32 x 1-1/32	●	●
23/32 x 1-1/32	●	●
3/4 x 1-1/16	●	●
27/32 x 1-1/32	●	●
7/8 x 1-1/16	●	●
27/32 x 1-9/32	●	●
7/8 x 1-5/16	●	●
29/32 x 1-1/32	●	●

**GREEN TEAM TIP:**  
 H-1 and H-2 oblong punches require a **round, K7** key to provide anti-rotational movement. K7 keys can be shipped from stock.



**DRILL SPOTS**

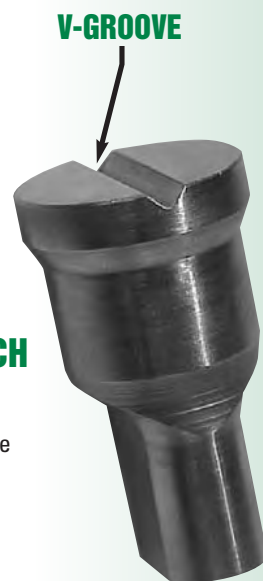
**DRILL SPOT LOCATORS**

H-1 and H-2 oblong dies are stocked with two drill spot locators indexed at 90°.



**V-GROOVE IN HEAD OF PUNCH**

H-1 and H-2 oblong punches are stocked with a V-Groove in the head of the punch.



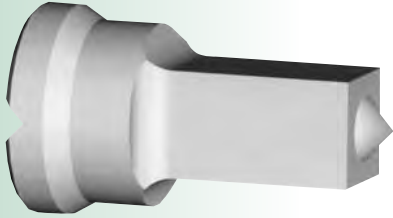
**OBLONG MUBEA™ TOOLING**

# CLEVELAND PUNCH & DIE COMPANY

The following tables list our stock square punches and dies for Mubea™ Ironworkers. Refer to our **Cross Reference Catalog** for the proper tooling to fit your machine.

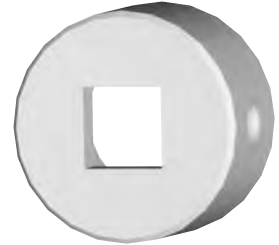
**STOCK PUNCHES & DIES ARE SHIPPED THE SAME DAY ORDERED!**  
**MADE TO ORDER SIZES CAN BE SHIPPED IN AS LITTLE AS 24 HOURS!**

■ Represents stock square sizes



## V-GROOVE IN HEAD OF PUNCH

H-1 and H-2 square punches are stocked with a V-Groove in the head of the punch.



## DRILL SPOT LOCATORS

H-1 and H-2 square dies are stocked with one drill spot locator.

### STOCK SQUARE PUNCHES

Size	FIGURE NUMBER	
	H-1	H-2
5/16	■	■
3/8	■	■
13/32	■	■
7/16	■	■
1/2	■	■
17/32	■	■
9/16	■	■
5/8	■	■
11/16	■	■
3/4	■	■
25/32	■	■

### STOCK SQUARE DIES

Size	FIGURE NUMBER	
	H-1	H-2
11/32	■	■
13/32	■	■
7/16	■	■
15/32	■	■
17/32	■	■
9/16	■	■
19/32	■	■
21/32	■	■
23/32	■	■
25/32	■	■
13/16	■	■

#### PLEASE NOTE:

**We stock 1/32" & 1/16" clearance die sizes. Other made to order die sizes such as clearances recommended for gauge stock, can be shipped in as little as 24 hours.**

#### OSHA WARNING

It is the user's responsibility that the machine and tooling be set up and used in accordance with local and national OSHA Laws and ANSI B11.5 standards for safety.

*Do not permit unqualified personnel to setup or operate the machine. Extreme care should be used at all times.*

#### GREEN TEAM TIP:

*You must check the diagonal of your square sizes to ensure that the punches will pass through the bore of your coupling nut without interference. The diagonal of a square can be determined by multiplying the size of the square by 1.414.*

SQUARE MUBEA™ TOOLING



# **Punch-Easy<sup>®</sup>** **Patented** **Punch and Die Lubricant**

**Punch-Easy<sup>®</sup>** is a non-pigmented honey colored heavy duty odorless punching and shearing oil for thick materials. It is used on ferrous or non ferrous steels where scoring, galling and friction is a problem. It is a particularly good punch and shear oil for thick high carbon steel, armor plate, grader blade, farm implement tools and stainless steels. Punch-Easy<sup>®</sup> is unparalleled for high production and multiple stage punching or stamping operations. Actual pyrometer readings indicate an operating heat reduction in drawn parts, punches and dies of 40%. It is to be used for cold application and not made for hot application. Punch-easy<sup>®</sup> may be used as received or diluted with light mineral oil for less severe jobs. **Punch-Easy<sup>®</sup> is now available in quarts, gallons, 5-gallon reusable pails, case lots and 55-gallon drums. Use Punch-Easy today!**



**"Punch Easy"** doubles my tooling life when punching thicker material.

-T.V.  
Pennsylvania

**P**unches, dies, shears receive less scoring and galling.  
**U**tilize more press time by decreased tool changes.  
**N**ew tool life making better holes for a longer time.  
**C**leans easy with any standard cleaner if required.  
**H**olds lubrication to tools for rust prevention when not in use.  
**E**ase of application with brush or swab.  
**A**pproved and tested for the toughest punching and shear jobs.  
**S**mooth increased production with more parts per tool.  
**Y**our best bet is to use **Punch-Easy**.

**"Punch Easy"** eliminated my customer's galling problem immediately.

-M.M.  
Dealer, New York

**"Punch Easy"** solved the problem of the end of our punches pulling off.

-R.W.  
Dealer, Oklahoma

**1-800-451-4342** phone  
**1-800-451-6877** fax

666 Pratt St. • Box 769 • Ravenna, Ohio 44266

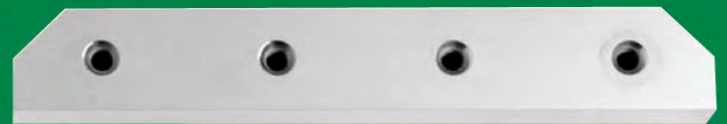
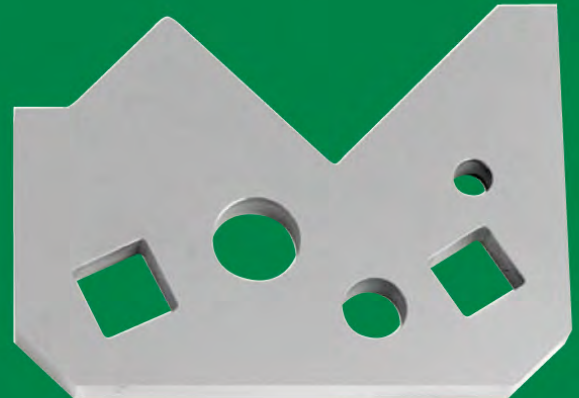
[www.clevelandpunch.com](http://www.clevelandpunch.com) • E-mail: [sales@clevelandpunch.com](mailto:sales@clevelandpunch.com)

© Cleveland Punch & Die Company

**MORE HOLES PER DOLLAR**

This catalog is the property of The Cleveland Punch & Die Company. All rights reserved. Reproduction of any part of this catalog without the **expressed written consent** of The Cleveland Punch & Die Company is strictly prohibited. **COPYRIGHT©2005**

# Cleveland Punch & Die Co.



### Returns

Returned tooling will not be accepted without prior authorization. No credit issued on used or damaged tooling. Special tooling can not be returned. Returned tooling must be shipped prepaid. Restocking charge is 25% of list price.

### Shortages

All claims must be made within ten days of invoice date.

### Terms

F.O.B. Ravenna, Ohio. Net 30 days

### Changes

All reference to sizes, dimensions, drawings, specifications, whether on drawings, written or otherwise are subject to change without notice.



phone **1-800-451-4342**

fax **1-800-451-6877**

666 Pratt St. • Box 769 • Ravenna, Ohio 44266

www.clevelandpunch.com • E-mail: sales@clevelandpunch.com



© Cleveland Punch & Die Company • 666 Pratt Street, Box 769 • Ravenna, Ohio 44266