

# W.A. Whitney Tooling

## Whitney Tooling Styles

Whitney manufactures three different styles of punches for its lines of punch presses — 28XX, 36TC and 44TC.

Tooling for other Whitney products, such as Beamlines, Anglematics and Portable Presses, as well as all major brands of Ironworker is included in the Piranha Ironworker Tooling Catalog ([Download pdf](#)).



## 28XX Tooling

28XX Tooling is quick change tooling used with presses that have manual tool change. Tools are loaded from beneath the punching cylinder. The punch is secured into the cylinder by clamping against a whistle notch located in the punch shank.

28XX Punches are available up to 5.000" (127 mm) in diameter. All round punches through 1.453" (36.9 mm) diameter (or equivalent size shape) are flat-faced, with a center point on the punch face. Larger punches are standard with 1/8" (3.2 mm) concave shear and no center point. Square punches with a single side dimension between 0.986" (25.04 mm) and 2.000" (50.8 mm) are standard with 1/8" (3.2 mm) double concave shear. Other shear types are available at customer request.

All shaped punches have a single pin location that allows for 0° and 90° positioning. Other pin locations can be specified and provided at additional cost.

## 36TC Tooling

36TC™ Tooling is a cartridge style tool used with punch presses that have automatic tool change, or manual cartridge style tool change. Tools are loaded into the cylinder from the front. The punch is secured into the cylinder by a groove in the punch shank and a lock-up mechanism that clamps on the front of the tool.

36TC Punches are available up to 5.000" (127 mm) in diameter. All round punches through 1.719" (43.66 mm) diameter (or equivalent size shape) are flat faced (Style I). Punches 1.720" (43.69 mm) through 2.469" (62.7 mm) in diameter are standard with 1/4" (6.35 mm) concave

# W.A. Whitney Tooling

shear (Style II). Punches 2.470" (62.74 mm) and larger are standard with 7/16" (11.11 mm) shear (Style III). Concave shear punches are not recommended for material over 1/4" (6.35 mm) thick. House top shear punches are recommended for material over 1/4" (6.35 mm) thick and for high shear strength materials. Other shear types are available at customer request.

All shaped punches have a single pin location that allows for 0° and 90° positioning. Other pin locations can be specified and provided at additional cost.

Punches .750" (19.0 mm) and smaller (diameter or equivalent shapes) are available as economical inserts. Interchangeable inserts fit into the Whitney insert punch holders. Insert punches are also available in HSS or TuffSkin™. Insert punches limited to 40 tons.

## **44TC Tooling**

44TC Tooling, a heavy-duty version of 36TC, Tooling has a larger diameter shank that withstands heavier punching loads. Tools are loaded into the cylinder from the front. The punch is secured into the cylinder by a groove in the punch shank, and a lock-up mechanism that clamps on the front of the tool.

44TC Punches are available up to 3.000" (76.2 mm) in diameter. All sizes are standard as flat faced.

Shaped punches have a single pin location that allows for 0° and 90° positioning. Other pin locations can be specified and provided at additional cost.

Punches .750" (19.0 mm) and smaller (diameter or equivalent shapes) are available as economical inserts. These interchangeable inserts fit into the Whitney Insert Punch Holders. Insert punches limited to 40 tons.

---