



Precision Meets Perfection,
Economical Solutions.



2024

85 Series Catalog

Visit us: www.ketecooling.com



“ Precision Meets Perfection, Economical Solutions. ”

About Us

Innovative Solutions for Fabrication Challenges

Founded in 1998, KETEC Precision Tooling is the **largest manufacturer of Punch Press and Press Brake tooling in China and Asia.**

With over 25 years of unremitting efforts in product innovation and development, as well as manufacturing refinement - In 2010, our Punch Press and Press Brake tools were appointed by the government as the industrial standard in China. As the leader of CNC tooling for the sheet metal fabrication industry. Our products have always been well-known **high-quality, customer-centric, and cost-effective.**

Empowering Metal Fabricators with Top-notch Tooling Solutions

Staying competitive in the manufacturing industry means having better flexibility, quality and efficiency while maintaining a sustainable profit.

That's why many manufacturers choose us. Through our unwavering commitment to quality control, refined manufacturing processes, and consultative customer service, we partner with our customers to minimize costs, boost revenue, and sustain their competitive edge.



Milestones

2004

Obtained Certifications

KETEC®'s trademark was registered as an international trademark and obtained ISO certification - **ISO9000:2000**.



2008

Equipped with High Capacity

Experienced tremendous growth and built our current manufacturing facilities **encompassing a total of 13 acres** in Conghua, Guangzhou, China.



2010

Became National Standard

The National Standardization Committee of China **commissioned KETEC to draft the standard** for "Tooling for CNC Turret Punch Machine." In July of the same year, the Ministry of Industry and IT of China issued and implemented the standard **JB/T10928-2010** for "CNC Turret Punch Press Tooling."



2012

Largest in Asia

KETEC became the **largest exporter by volume** and manufacturer of CNC sheet metal tooling in Asia with an annual revenue of **\$45 Million USD**.



2020

Customer Centric

Implemented both **ERP and CRM software** company-wide to better serve our customers.



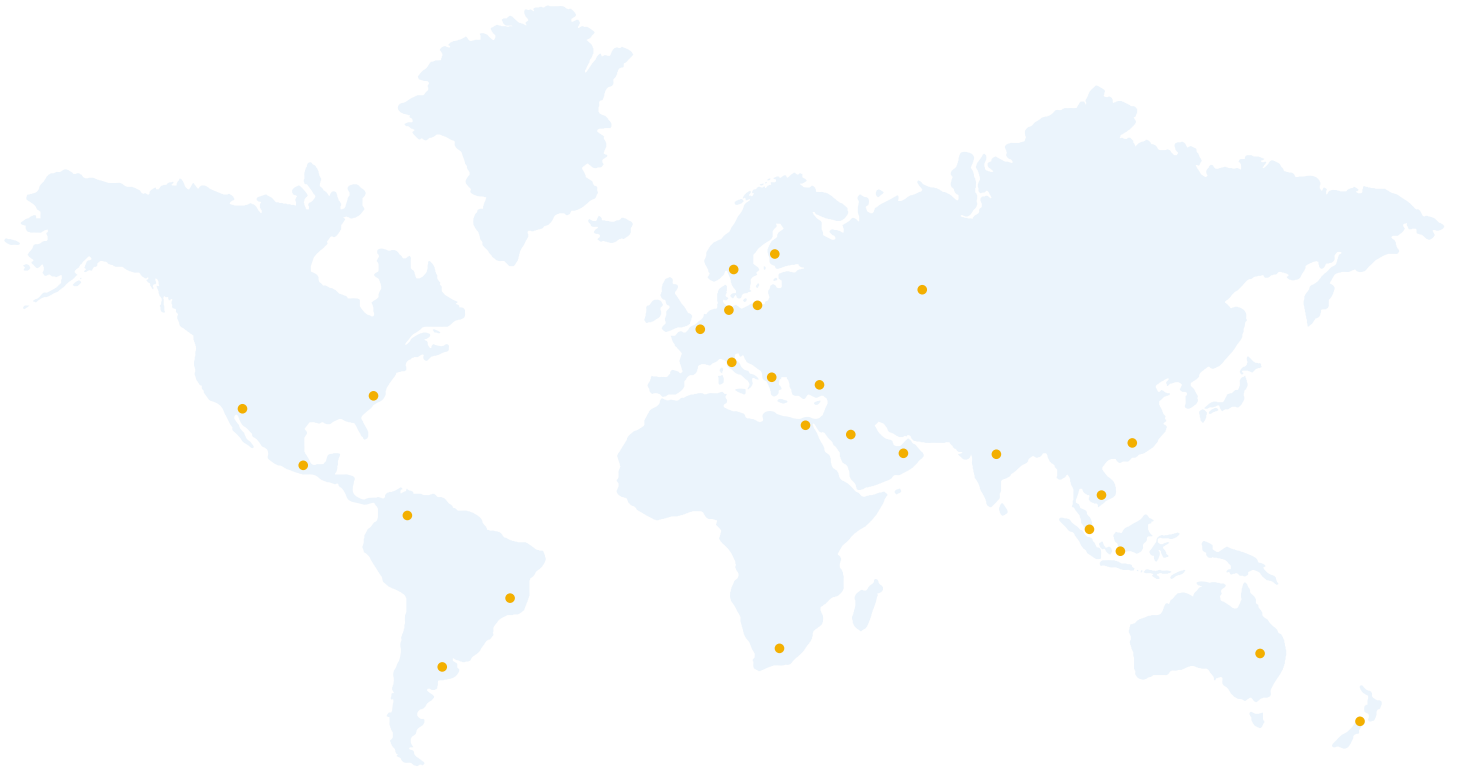
Official OEMS Partners



Customer Highlight



KETEC Agents



Our agents are established in more than 25 countries worldwide

Facilities Gallery

Ordering Workshop



Heat-Treatment Center



Standard Production Line



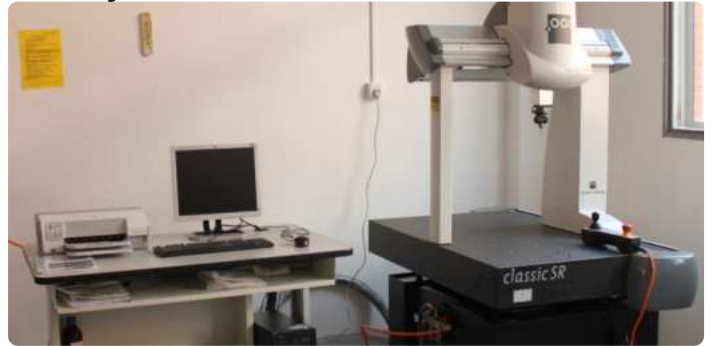
Customized Line



Tooling Test Center



Quality Control Lab



Product Offerings

We specialize in sheet metal fabrication tooling, including **Punch Press, Press Brake, Stamping tools and related machines.**

Punch Press Tooling

- Thick Turret Tooling
- Thin Turret Tooling
- TRUMPF® Style Tooling
- Salvagnini®
- Muratec-Wiedemann®



Stamping Tools

- Automotive
- Thick Plate
- Copper Plate



Press Brake Tooling

- Euro-Amada® Style
- Wila®-Trumpf® Style



Machines

- Tool Grinding Machine
- 2D Inspection Machine



Table of Contents

A STATION	
A STATION INDEX	10
A STATION INTRODUCTION	11
A STATION T85 SERIES	12-22
A STATION K85 SERIES	23-25
A STATION E85 SERIES	26-27
B STATION	
B STATION INDEX	28
B STATION INTRODUCTION	29
B STATION T85 SERIES	30-36
B STATION K85 SERIES	37-39
B STATION E85 SERIES	40-41
C STATION	
C STATION INDEX	42
C STATION INTRODUCE	43
C STATION T85 SERIES	44-47
C STATION E85 SERIES	48
C STATION OPTIONAL PARTS	49
D STATION	
D STATION INDEX	50
D STATION INTRODUCTION	51
D STATION T85 SERIES	52-57
D STATION E85 SERIES	58
D STATION OPTIONAL PARTS	59
E STATION	
E STATION INDEX	60
E STATION INTRODUCTION	61
E STATION T85 SERIES	62-66
E STATION CLOSE TO CLAMP	67
TECHNOLOGY INFORMATION	68-71

KETEC's 85 Series

About The 85 Series

Ketec's 85 series is one of our best-selling product lines, due to its reliability and popularity. Our 85 series is divided into two categories: Standard Econo 85 and Quick Adjust T85. Both categories come in station A ($\frac{1}{2}$ "), B ($1\frac{1}{4}$ ") C (2"), D ($3\frac{1}{2}$ "), E ($4\frac{1}{2}$ "), and offer full interchangeability with major OEMs such as Amada® and others.





A STATION

Thick Turret Punch Assembly Index - 85 Series

T85 STANDARD



T85 LIGHT DUTY



T85 FULLY GUIDED



T85 FULLY GUIDED SPS



T85 OPEN GUIDE



T85 STANDARD ABS



T85 OPEN GUIDE ABS



T85 FULLY GUIDED ABS



T85 FULLY GUIDED SPS ABS



T85 LIGHT DUTY FULLY GUIDED SPS



T85 CONTOURING



K85 STANDARD



K85 OPEN GUIDE



K85 OPEN GUIDE ABS



E85 STANDARD



E85 LIGHT DUTY



A STATION

INDEX

FEATURED PRODUCTS



T85 STANDARD
T85 STANDARD ABS



T85 OPEN GUIDE
T85 OPEN GUIDE ABS

T85 BASIC STRUCTURE



T85 PUNCH HEAD ASSEMBLY
GENERALLY USED IN ALL T85 SERIES.
(BUT NOT T85 LIGHT DUTY)



85 PUNCH / 85 ABS PUNCH



85 STANDARD / 85 OPEN GUIDE
85 STANDARD ABS / 85 OPEN GUIDE ABS



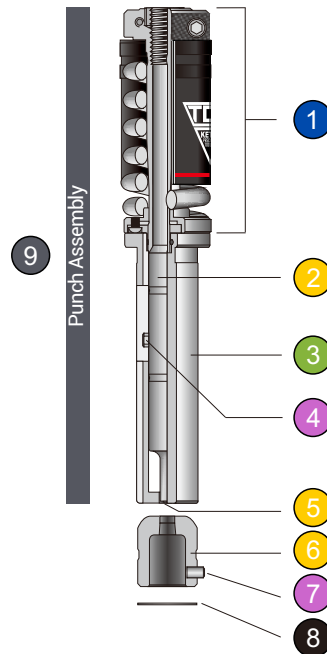
90 STRIPPER PLATE / 90 ABS STRIPPER PLATE

Product		Product Overview
	Single Groove (0°) Double Grooves (0°, 90°) Double Grooves (0°, 135°)	<ul style="list-style-type: none"> Ketec's T85 series stands out as one of our top-selling products, offering enhanced versatility and durability compared to the E85 series. Quick adjustable structure and easy handle due to one-piece punch head assembly reduces adjustment time by 50% compared to E85.
	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> Interchangeable: can be installed in other brands punch head assemblies. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.


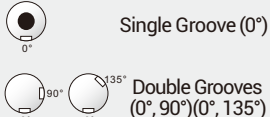

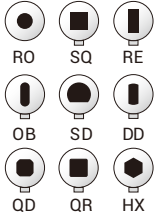

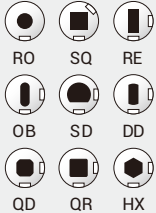


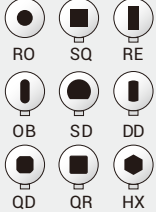
Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Dowel pin

- 6 Ejector
- 7 Dowel pin
- 8 Die shim
- 9 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- OB: Oblong.
- DD: Double D.
- SD: Single D.
- QR: Quad R.
- HX: Hexagon.
- QD: Quad D.

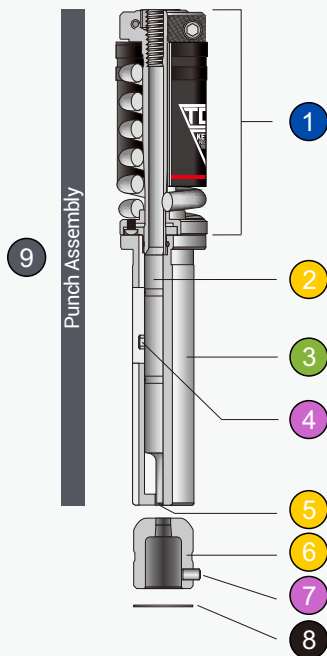
Product		Product Overview
		<ul style="list-style-type: none"> Reduce punching noise and extend the lifespan of the spring.
		<ul style="list-style-type: none"> Interchangeable: can be installed in other brands punch head assemblies. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
		<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
		<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

A STATION
T85 / LIGHT DUTY



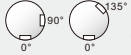

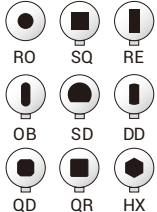

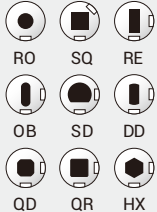


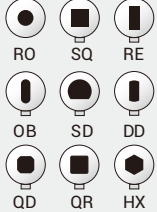
Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Dowel pin






- 6 Ejector
- 7 Dowel pin
- 8 Die shim
- 9 Punch assembly














- RO: Round.
- RE: Rectangle.
- SQ: Square.
- OB: Oblong.
- DD: Double D.
- SD: Single D.
- QR: Quad R.
- HX: Hexagon.
- QD: Quad D.






Product		Product Overview
 Punch Assembly	 Single Groove(0°)  Double Grooves (0°, 90°)(0°, 135°)	<ul style="list-style-type: none"> • Thinner blades resulting from narrower punches may compromise rigidity. • Traditional stripper plates often leave larger gaps, exposing blades to vulnerability. • Ketec's Fully Guided Solution eliminates the risk of punch breakage, bending, and die damage. • We only recommend thin material applications.
 Fully Guided Punch		<ul style="list-style-type: none"> • Enhance structure with better rigidity and less deformation on punch. • Interchangeable: can be installed in others brands punch head assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
 Fully Guided Guide		<ul style="list-style-type: none"> • Close-stripper-to-punch configurations provide robust support for narrow punch blades, extending tool life by at least threefold compared to unguided setups. • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
 Punch Head Assembly		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
 Die		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"]/ 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

	1	2	3	4	5
Tooling name	 Thick Turret/T85 Fully Guided Punch Assembly/A	 Thick Turret/85 Fully Guided Punch/A	 Thick Turret Die/A	 Thick Turret/85 Fully Guided Guide/A	 Thick Turret/T85 Punch Head Assembly/A
Size reference	RE1*10	RE1*10	RE1*10+0.2	RE1*10	

Product		Product Overview
Punch Assembly 	Only suitable for round shapes.  Single Groove (0°)	<ul style="list-style-type: none"> • Ketec's Fully Guided solution eliminates the risk of punch breakage, bending, and die damage. • We only recommend thin material applications.
Fully Guided SPS Punch  	 RO Punch inserts has two shaft sizes: RO Ø3.17 RO Ø6 	<ul style="list-style-type: none"> • Enhance structure with better rigidity and less deformation on punch. • Punch insert can be replaced individually, low cost. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
Fully Guided Guide 	 RO	<ul style="list-style-type: none"> • Close-stripper-to-punch configurations provide robust support for narrow punch blades, extending tool life by at least threefold compared to unguided setups. • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
Punch Head Assembly 		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
Die 	 RO	<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

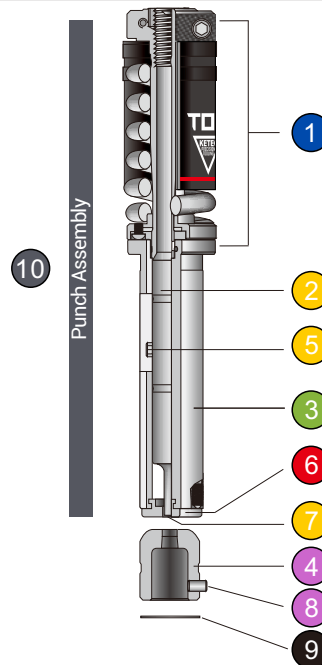
A STATION
T85 / FULLY GUIDED SPS

Description					
	1 	2 	3 	4 	5 
Tooling name	Thick Turret/T85 Fully Guided SPS Punch Assembly/A	Thick Turret/85 Fully Guided SPS Punch/A	Thick Turret Die/A	Thick Turret/85 Fully Guided SPS Guide/A	Thick Turret/T85 Punch Head Assembly/A
Size reference	RO Ø3	RO Ø3	RO Ø3+0.2	RO Ø3	

Product		Product Overview
	Single Groove (0°) Double Grooves (0°, 90°)(0°, 135°)	<ul style="list-style-type: none"> The universal open guide bushing only requires replacing the stripper plate.
		<ul style="list-style-type: none"> Interchangeable: can be installed in others brands punch head assemblies. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
Open Guide Bottom view of the guide Stripper Plate		<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
		<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Dowel pin
- 6 Stripper plate
- 7 Ejector
- 8 Dowel pin
- 9 Die shim
- 10 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▬ OB: Oblong.
- ▬ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ◆ HX: Hexagon.
- QD: Quad D.

A STATION
T85 / OPEN GUIDE

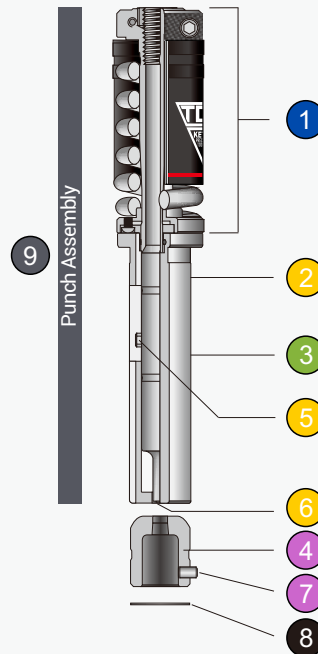
Product		Product Overview
	 Single Groove (0°) Double Grooves (0°, 90°)(0°, 135°)	<ul style="list-style-type: none"> • ABS: Air Blow System, oil mist lubrication, anti-scratch, anti-adhesion, longer punch life.
	 RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands punch head assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
	 RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
	 RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

A STATION
T85 / STANDARD ABS

Description

- 1 Punch head assembly
- 2 Punch ABS
- 3 Guide
- 4 Die
- 5 Dowel pin

- 6 Ejector
- 7 Dowel pin
- 8 Die shim
- 9 Punch assembly



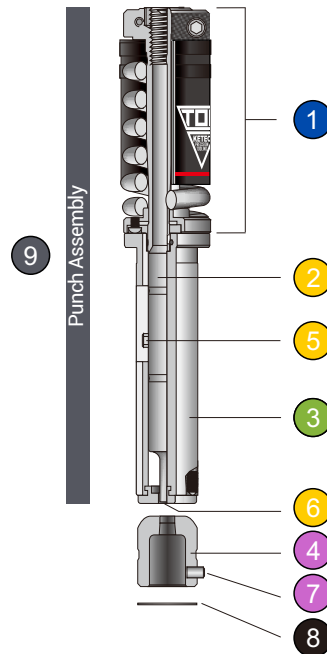
- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

Product		Product Overview
	Single Groove (0°) Double Grooves (0°, 90°) (0°, 135°)	<ul style="list-style-type: none"> • ABS: Air Blow System, oil mist lubrication, anti-scratch, anti-adhesion, longer punch life. • The universal open guide bushing only requires replacing the stripper plate.
	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> • Interchangeable: can be installed in others brands punch head assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
Open Guide ABS Bottom view of the guide Stripper Plate ABS	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description





































- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Dowel pin

- 6 Ejector
- 7 Dowel pin
- 8 Die shim
- 9 Punch assembly














- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▬ OB: Oblong.
- ▬ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

A STATION T85 / OPEN GUIDE ABS


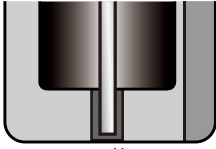
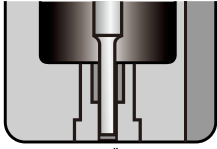
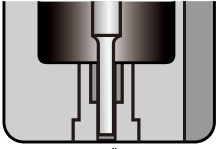


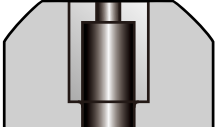
Product		Product Overview
Punch Assembly 	 Single Groove (0°)   Double Grooves (0°, 90°)(0°, 135°)	<ul style="list-style-type: none"> • Ketec's fully guided solution eliminates the risk of punch breakage, bending, and die damage. • We only recommend thin material applications. • ABS: oil mist lubrication, anti-scratch, anti-adhesion, longer punch life.
Fully Guided Punch ABS  	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> • Enhance structure with better rigidity and less deformation on punch. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
Fully Guided Guide ABS 	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
Punch Head Assembly 		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
Die 	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.












A STATION
T85 / FULLY GUIDED ABS

Description	
<ul style="list-style-type: none"> 1 Punch head assembly 2 Punch ABS 3 Guide ABS 4 Die 5 Punch assembly 	<div style="display: flex; align-items: center;"> <div style="writing-mode: vertical-rl; transform: rotate(180deg); padding-right: 5px;">Punch Assembly</div>  <div style="margin-left: 20px;"> <ul style="list-style-type: none"> ● RO: Round. ■ RE: Rectangle. ■ SQ: Square. ▬ OB: Oblong. ▬ DD: Double D. ● SD: Single D. ■ QR: Quad R. ◆ HX: Hexagon. ■ QD: Quad D. </div> </div>

Product		Product Overview
Punch Assembly 	Only suitable for round shapes.  Single Groove (0°)	<ul style="list-style-type: none"> • ABS: Air Blow System, oil mist lubrication, anti-scratch, anti-adhesion, longer punch life. • The universal open guide bushing only requires replacing the stripper plate.
Fully Guided SPS Punch ABS 	 RO Punch inserts has two shaft sizes: RO Ø3.17 RO Ø6 	<ul style="list-style-type: none"> • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
Fully Guided Guide ABS 	 RO	<ul style="list-style-type: none"> • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
Punch Head Assembly 		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
Die 	 RO	<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

Comparison of Standard, Fully Guided, Contouring Tooling

	STANDARD	FULLY GUIDED	CONTOURING
 <p>Use a 2mm diameter punch and die clearance +0.2mm contouring tool for progressive punching of a 1mm cold-rolled sheet with a 0.5mm pitch.</p>	 single clearance: 0.15mm	 single clearance: 0.025mm	 single clearance: 0.01mm
			

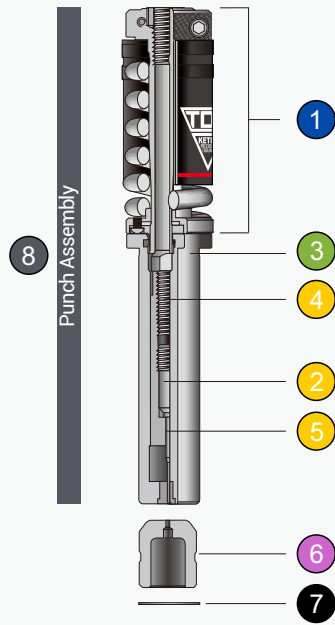
Product		Product Overview
Punch Assembly 	Only suitable for round shapes.  Single Groove (0°)	<ul style="list-style-type: none"> • Ketec's fully guided solution eliminates the risk of punch breakage, bending, and die damage. • We only recommend thin material applications. • Reduce punching noise and extend the lifespan of the spring.
Fully Guided SPS Punch  	 RO Punch inserts has two shaft sizes: RO Ø3.17 RO Ø6 	<ul style="list-style-type: none"> • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
Fully Guided Guide 	 RO	<ul style="list-style-type: none"> • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
Punch Head Assembly 		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
Die 	 RO	<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

A STATION T85 / LIGHT DUTY FULLY GUIDED SPS










Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Retaining Screw

- 5 Punch Insert
- 6 Die
- 7 Die shim
- 8 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ◆ HX: Hexagon.
- QD: Quad D.

Product		Product Overview
Punch Assembly 	Only suitable for round shapes.  Single Groove (0°)	<ul style="list-style-type: none"> It enables precision stepping punching with a 0.5mm pitch. Both the punch and the die are made of carbide material with a hardness of HRC75. This effectively prevents punch breakage caused by eccentric loading during stepping punching. The air-blow function reduces adhesion and wear on the punch edges, extending the tool's lifespan.
Contouring Punch 	 RO Punch inserts has two shaft sizes: RO Ø3.17 RO Ø6	<ul style="list-style-type: none"> Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
Contouring Guide 	 RO	<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
Punch Head Assembly 		<ul style="list-style-type: none"> Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
Die 	 RO	<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"]/ 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

1 Punch head assembly

2 Punch

3 Guide

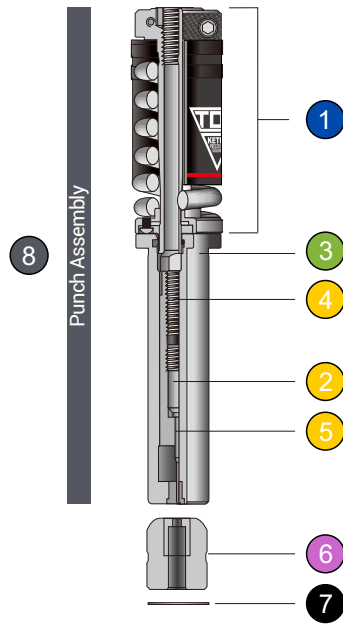
4 Retaining Screw

5 Punch Insert

6 Die

7 Die shim

8 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- OB: Oblong.
- DD: Double D.
- SD: Single D.
- QR: Quad R.
- HX: Hexagon.
- QD: Quad D.

Product		Product Overview
	Single Groove (0°) Double Grooves (0°, 90°)(0°, 135°)	<ul style="list-style-type: none"> This is Ketec's latest product, which allows for tooling length adjustment without the needs for any fixture tools. Simply grip the tooling guide with one hand, and rotate the adjustment shaft at the punch head assembly with other hand to easily lengthen or shorten the tooling. Round punches has pins, round guides has the slots for the punch pin. Highly quick adjust, save tool change time and improve production efficiency.
		<ul style="list-style-type: none"> Round shape punch with pin. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
		<ul style="list-style-type: none"> Round shape guide with pin inside for the round punch with pin. Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
		<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"]/ 1.2mm [0.0472"] die shims, 10pcs/pack.

A STATION
K85 / STANDARD

Description

1 Punch head assembly

2 Punch

3 Guide

4 Die

5 Punch assembly

Punch Assembly

- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

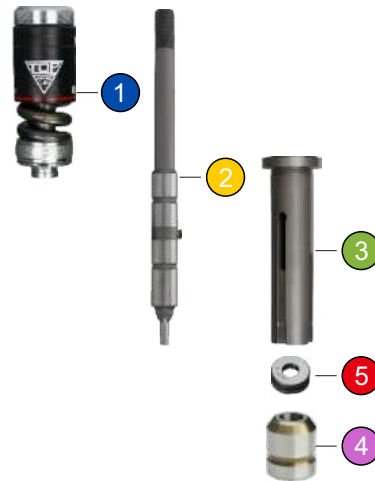
Product		Product Overview
	Single Groove (0°) Double Grooves (0°, 90°)(0°, 135°)	<ul style="list-style-type: none"> The universal open guide bushing only requires replacing the stripper plate.
		<ul style="list-style-type: none"> Round shape punch with pin. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
Open Guide Bottom view of the guide Stripper Plate		<ul style="list-style-type: none"> Round shape guide with pin inside for the round punch with pin. Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
		<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description






































- Punch head assembly
- Punch
- Guide

- Die
- Stripper plate
- Punch assembly

Punch Assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- OB: Oblong.
- DD: Double D.
- SD: Single D.
- QR: Quad R.
- HX: Hexagon.
- QD: Quad D.

Product		Product Overview
	 Single Groove (0°)  Double Grooves (0°, 90°)  Double Grooves (0°, 135°)	<ul style="list-style-type: none"> • ABS: Air Blow System, oil mist lubrication, anti-scratch, anti-adhesion, longer punch life. • The universal open guide bushing only requires replacing the stripper plate.
<p>Standard Punch ABS</p> 	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> • Round shape punch with pin. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
<p>Open Guide ABS</p>  <p>Bottom view of the guide</p>  <p>ABS Stripper Plate</p> 	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> • Round shape guide with pin inside for the round punch with pin. • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
<p>Punch Head Assembly</p> 		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

A STATION
K85 / OPEN GUIDE ABS

Description

1 Punch head assembly

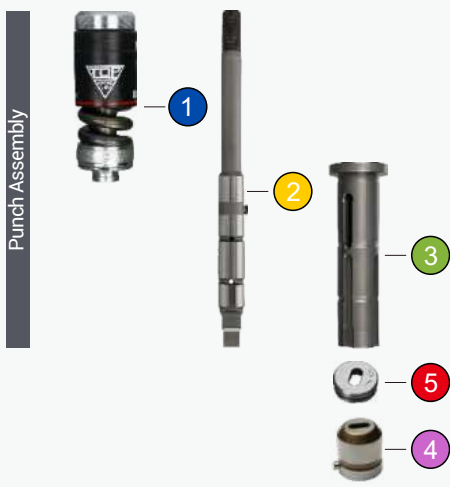
2 Punch ABS

3 Guide ABS

4 Die




































5 Stripper plate ABS

6 Punch assembly



Punch Assembly

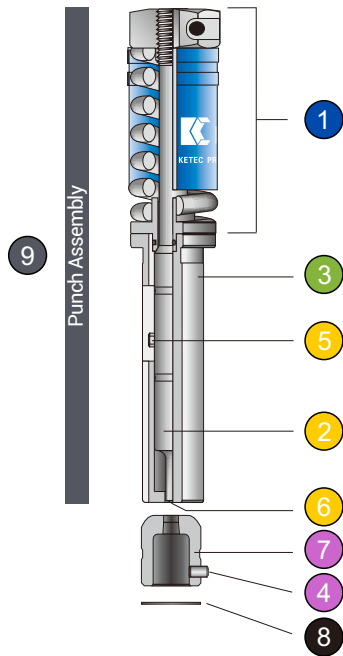
- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ◆ HX: Hexagon.
- QD: Quad D.

Product		Product Overview
Punch Assembly 	 Single Groove (0°)   Double Grooves (0°, 90°)(0°, 135°)	<ul style="list-style-type: none"> Ketec's E85 series is engineered to seamlessly integrate with all leading OEMs, boasting enhancements in both material composition and design for unparalleled performance. Simple design offers a lower cost alternative compared to our flagship T85 series.
Standard Punch 	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> Interchangeable: can be installed in others brands punch head assemblies. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
Standard Guide 	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
Punch Head Assembly 		<ul style="list-style-type: none"> Traditional original punch head assembly.
Die 	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Dowel pin

- 6 Ejector
- 7 Dowel pin
- 8 Die shim
- 9 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

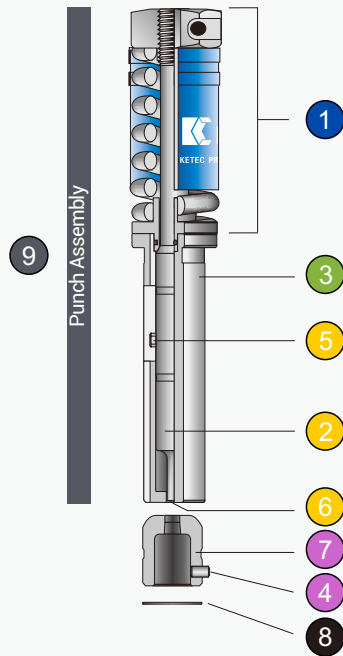
Product		Product Overview
	Single Groove (0°) Double Grooves (0°, 90°) (0°, 135°)	<ul style="list-style-type: none"> Reduce punching noise and extend the lifespan of the spring.
	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> Interchangeable: can be installed in other brands punch head assemblies. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Traditional original punch head assembly, light duty.
	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

A STATION
E85 / LIGHT DUTY

Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Dowel pin

- 6 Ejector
- 7 Dowel pin
- 8 Die shim
- 9 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.



B STATION

Thick Turret Punch Assembly Index - 85 Series

T85 STANDARD



T85 LIGHT DUTY



T85 FULLY GUIDED



T85 OPEN GUIDE



T85 STANDARD ABS



T85 STANDARD ABS



T85 OPEN GUIDE ABS



K85 STANDARD



K85 OPEN GUIDE



K85 OPEN GUIDE ABS



E85 STANDARD



E85 LIGHT DUTY



B STATION
INDEX

FEATURED PRODUCTS



T85 STANDARD
T85 STANDARD ABS

T85 OPEN GUIDE
T85 OPEN GUIDE ABS

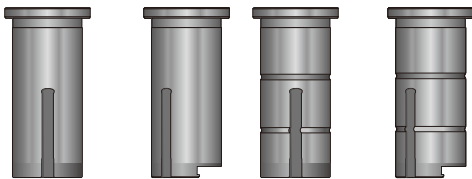
T85 BASIC STRUCTURE



T85 PUNCH HEAD ASSEMBLY
GENERALLY USED IN ALL T85 SERIES.
(BUT NOT T85 LIGHT DUTY)



85 PUNCH / 85 ABS PUNCH



85 STANDARD / 85 OPEN GUIDE
85 STANDARD ABS / 85 OPEN GUIDE ABS



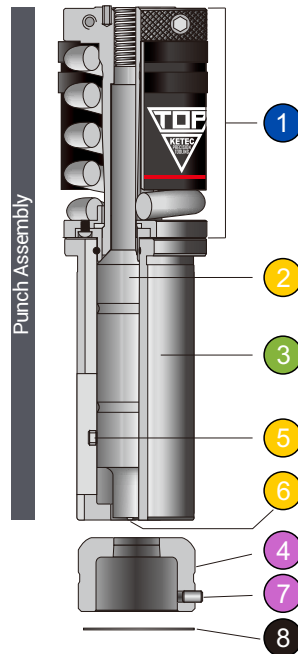
90 STRIPPER PLATE / 90 ABS STRIPPER PLATE

Product		Product Overview
	 Single Groove (0°) Double Grooves (0°, 90°) Double Grooves (0°, 135°)	<ul style="list-style-type: none"> • Ketec's T85 series stands out as one of our top-selling products, offering enhanced versatility and durability compared to the E85 series. Quick adjustable structure and easy handle due to one-piece punch head assembly reduces adjustment time by 50% compared to E85.
	 RO SQ RE OB SD DD QR HX QD	<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands punch head assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
	 RO SQ RE OB SD DD QR HX QD	<ul style="list-style-type: none"> • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
	 RO SQ RE OB SD DD QR HX QD	<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.




































Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Dowel pin

- 6 Ejector
- 7 Dowel pin
- 8 Die shim
- 9 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▬ OB: Oblong.
- ▬ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ◆ HX: Hexagon.
- QD: Quad D.

Product		Product Overview
	 Single Groove (0°)  Double Grooves (0°, 90°)  (0°, 135°)	<ul style="list-style-type: none"> • Reduce punching noise and extend the lifespan of the spring.
	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands punch head assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

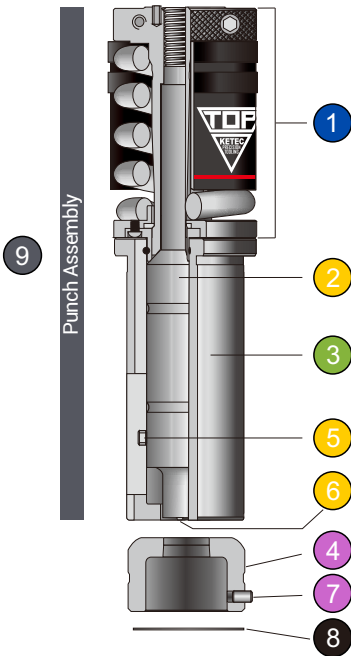
B STATION

T85 / LIGHT DUTY

Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Dowel pin

- 6 Ejector
- 7 Dowel pin
- 8 Die shim
- 9 Punch assembly

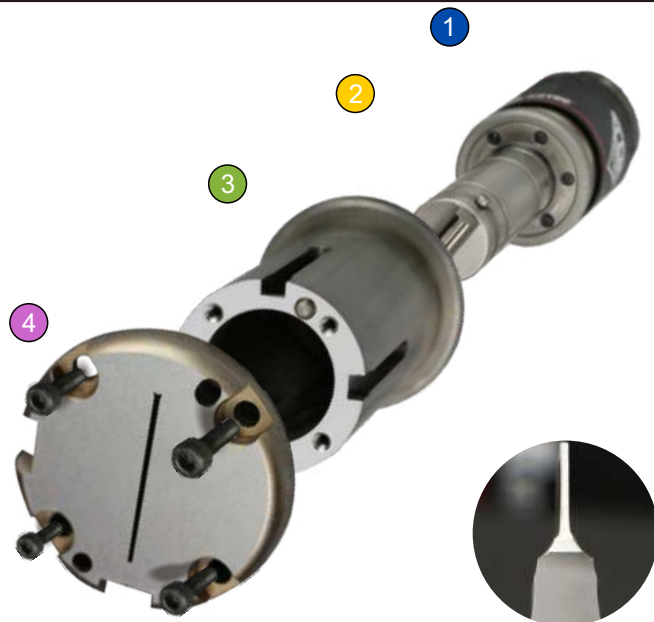


- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

Product		Product Overview
	 Single Groove (0°) Double Grooves (0°, 90°) (0°, 135°)	<ul style="list-style-type: none"> • Thinner blades resulting from narrower punches may compromise rigidity. • Traditional stripper plates often leave larger gaps, exposing blades to vulnerability. • Ketec's Fully Guided Solution eliminates the risk of punch breakage, bending, and die damage. • We only recommend thin material applications.
	 RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> • Enhance structure with better rigidity and less deformation on punch. • Interchangeable: can be installed in others brands punch head assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
 	 RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> • Close-stripper-to-punch configurations provide robust support for narrow punch blades, extending tool life by at least threefold compared to unguided setups. • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
	 RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.






































Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Stripper Plate












- RO: Round.
- RE: Rectangle.
- SQ: Square.
- OB: Oblong.
- DD: Double D.
- SD: Single D.
- QR: Quad R.
- HX: Hexagon.
- QD: Quad D.

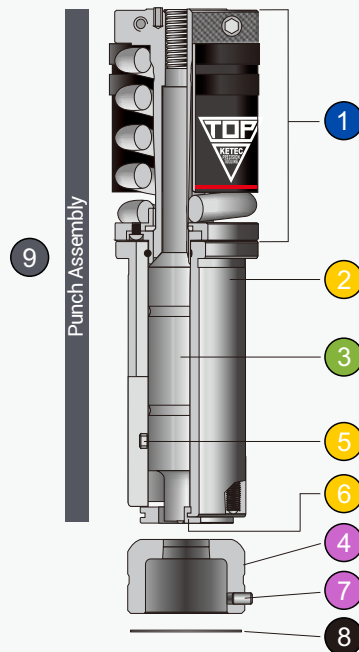
B STATION
T85 / FULLY GUIDED










Product		Product Overview
	 Single Groove (0°)  Double Grooves (0°, 90°)  Double Grooves (0°, 135°)	<ul style="list-style-type: none"> The universal open guide bushing only requires replacing the stripper plate.
	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> Interchangeable: can be installed in others brands punch head assemblies. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
  	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

Description

-  Punch head assembly
-  Punch
-  Guide
-  Die
-  Stripper

-  Ejector
-  Dowel pin
-  Die shim
-  Punch assembly



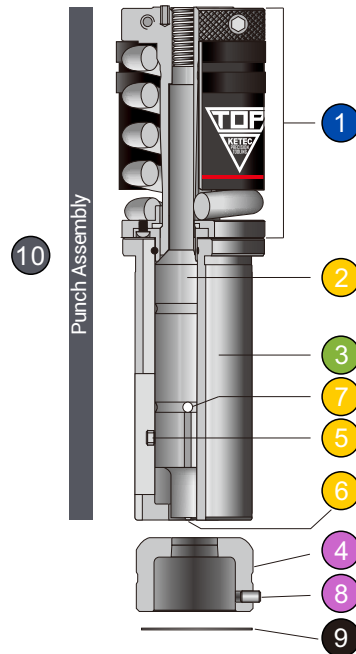
-  RO: Round.
-  RE: Rectangle.
-  SQ: Square.
-  OB: Oblong.
-  DD: Double D.
-  SD: Single D.
-  QR: Quad R.
-  HX: Hexagon.
-  QD: Quad D.

Product		Product Overview
	Single Groove (0°) Double Grooves (0°, 90°)(0°, 135°)	<ul style="list-style-type: none"> The universal open guide bushing only requires replacing the stripper plate.
	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> Interchangeable: can be installed in others brands punch head assemblies. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
	RO SQ RE OB SD DD QD QR HX	<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

Description





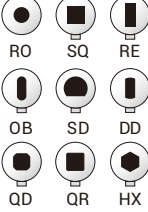


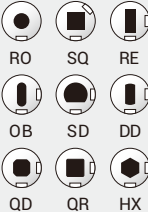

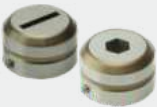
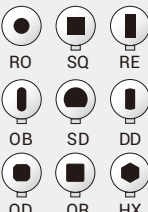
- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Dowel pin




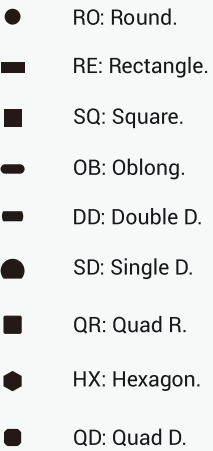
- 6 Ejector
- 7 ABS hole
- 8 Dowel pin
- 9 Die shim
- 10 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▬ OB: Oblong.
- ▬ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

B STATION T85 / STANDARD ABS

Product		Product Overview
	 Single Groove (0°)  Double Grooves (0°, 90°)(0°, 135°)	<ul style="list-style-type: none"> • Ketec's fully guided solution eliminates the risk of punch breakage, bending, and die damage. • We only recommend thin material applications. • ABS: oil mist lubrication, anti-scratch, anti-adhesion, longer punch life.
		<ul style="list-style-type: none"> • Enhance structure with better rigidity and less deformation on punch. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating available upon request for additional protection.
  Stripper Plate ABS		<ul style="list-style-type: none"> • Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> • Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

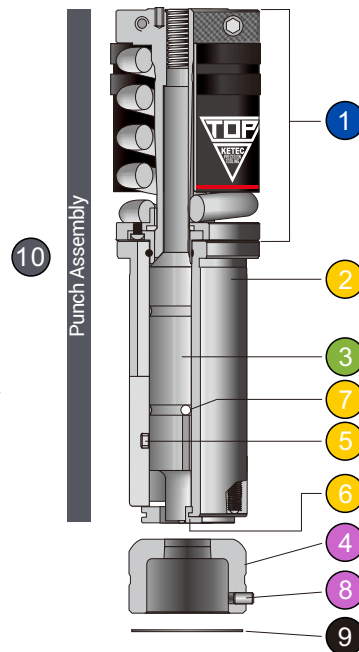
Description	
<p>1 Punch head assembly</p>	
<p>2 Punch</p>	
<p>3 Guide</p>	
<p>4 Punch assembly</p>	 

Product		Product Overview
	Single Groove (0°) Double Grooves (0°, 90°)(0°, 135°)	<ul style="list-style-type: none"> The universal open guide bushing only requires replacing the stripper plate.
		<ul style="list-style-type: none"> Interchangeable: can be installed in others brands punch head assemblies. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
		<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Ketec's patent, QuickAdjust™, allowing at least twice less amount of time to adjust punch length.
		<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

Description


























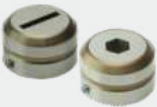









- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Stripper





- 6 Ejector
- 7 Dowel pin
- 8 Dowel pin
- 9 Die shim
- 10 Punch assembly


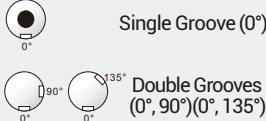

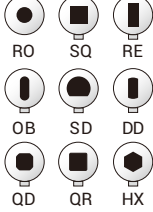

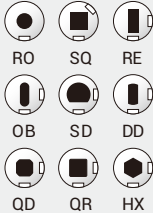


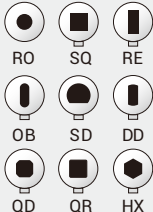


- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

B STATION T85 / OPEN GUIDE ABS

Product		Product Overview
Punch Assembly 	 Single Groove (0°)  Double Grooves (0°, 90°)  (0°, 135°)	<ul style="list-style-type: none"> This is Ketec's latest product, which allows for tooling length adjustment without the needs for any fixture tools. Simply grip the tooling guide with one hand, and rotate the adjustment shaft at the punch head assembly with other hand to easily lengthen or shorten the tooling. Round punches has pins, round guides has the slots for the punch pin. Highly quick adjust, save tool change time and improve production efficiency.
Standard Punch 	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> Round shape punch with pin. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
Standard Guide 	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> Round shape guide with pin inside for the round punch with pin. Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
Punch Head Assembly 		<ul style="list-style-type: none"> Ketec's patent, Highly QuickAdjust™.
Die 	 RO  SQ  RE  OB  SD  DD  QD  QR  HX	<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

Description	
<ol style="list-style-type: none"> Punch head assembly Punch Guide Punch assembly 	    <div style="float: right; margin-top: 20px;"> <ul style="list-style-type: none"> ● RO: Round. ■ RE: Rectangle. ■ SQ: Square. ▭ OB: Oblong. ▭ DD: Double D. ● SD: Single D. ■ QR: Quad R. ⬠ HX: Hexagon. ■ QD: Quad D. </div>


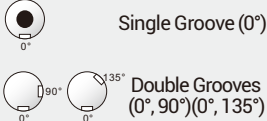

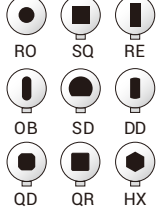

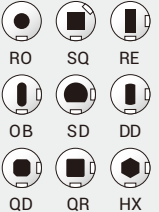


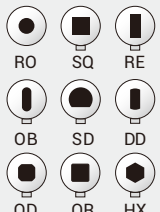
Product		Product Overview
		<ul style="list-style-type: none"> The universal open guide bushing only requires replacing the stripper plate.
		<ul style="list-style-type: none"> Round shape punch with pin. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
		<ul style="list-style-type: none"> Round shape guide with pin inside for the round punch with pin. Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Ketec's patent, Highly QuickAdjust™.
		<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.




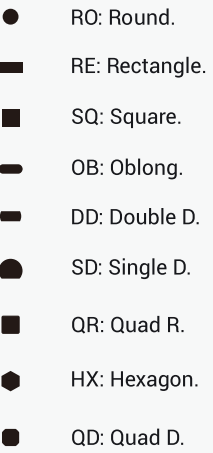
Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

Product		Product Overview
		<ul style="list-style-type: none"> The universal open guide bushing only requires replacing the stripper plate. ABS: Air Blow System, oil mist lubrication, anti-scratch, anti-adhesion, longer punch life.
		<ul style="list-style-type: none"> Round shape punch with pin. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
		<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Ketec's patent, Highly QuickAdjust™.
		<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

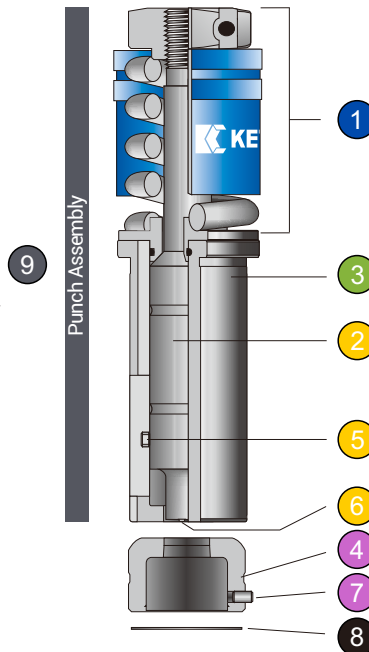
Description	
<p>1 Punch head assembly</p>	
<p>2 Punch</p>	
<p>3 Guide</p>	
<p>4 Punch assembly</p>	
	

Product		Product Overview
	 Single Groove (0°) Double Grooves (0°, 90°)(0°, 135°)	<ul style="list-style-type: none"> Ketec's E85 series is engineered to seamlessly integrate with all leading OEMs, boasting enhancements in both material composition and design for unparalleled performance. Simple design offers a lower cost alternative compared to our flagship T85 series.
		<ul style="list-style-type: none"> Interchangeable: can be installed in others brands punch head assemblies. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
		<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Traditional original punch head assembly.
		<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

Description




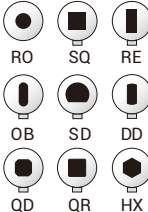

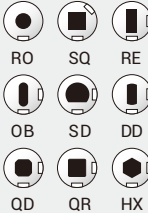

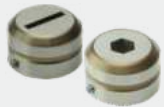
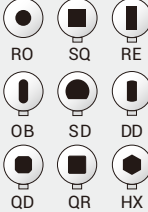
- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Dowel pin

- 6 Ejector
- 7 Dowel pin
- 8 Die shim
- 9 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

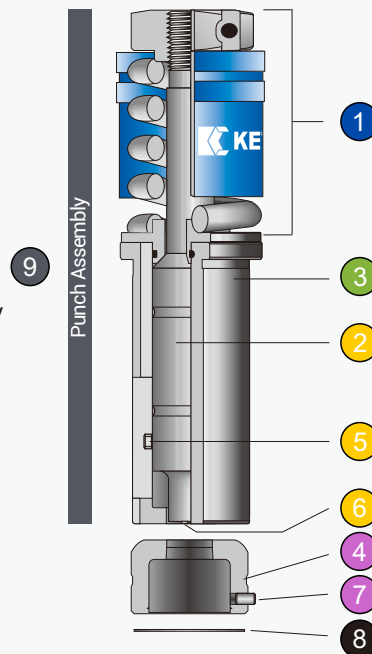
B STATION E85 / STANDARD

Product		Product Overview
		<ul style="list-style-type: none"> Reduce punching noise and extend the lifespan of the spring.
		<ul style="list-style-type: none"> Interchangeable: can be installed in other brands punch head assemblies. Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating available upon request for additional protection.
		<ul style="list-style-type: none"> Guides treated with nitriding process to enhance compressive, wear, and corrosion resistance.
		<ul style="list-style-type: none"> Traditional original punch head assembly, light duty function.
		<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 10pcs/pack.

Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Dowel pin

- 6 Ejector
- 7 Dowel pin
- 8 Die shim
- 9 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.



C STATION

Thick Turret Punch Assembly Index - 85 Series

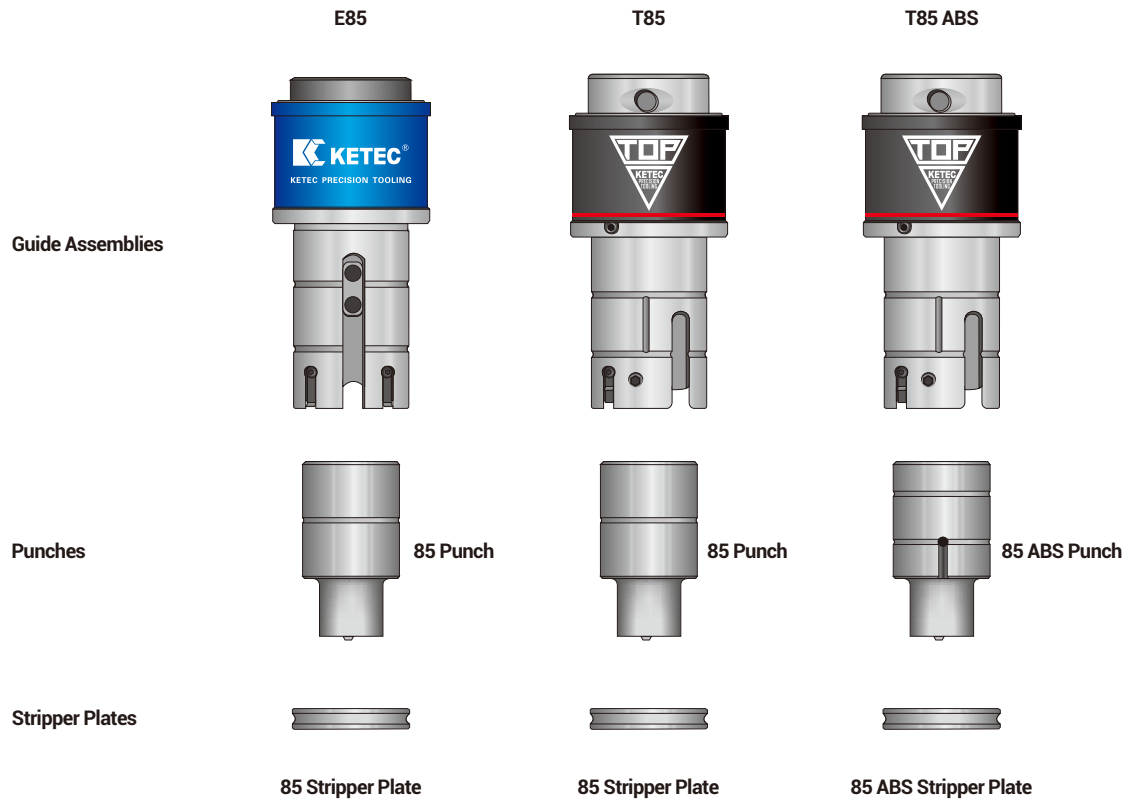
	T85	T85 LIGHT DUTY	T85 FULLY GUIDED	T85 ABS	E85
PUNCH ASSEMBLIES					
PUNCH HEAD ASSEMBLIES					
GUIDES					
GUIDE ASSEMBLIES					


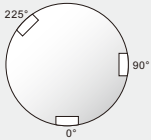

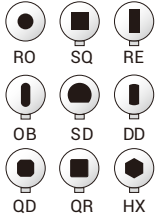

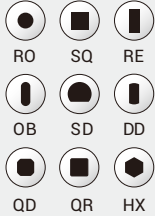

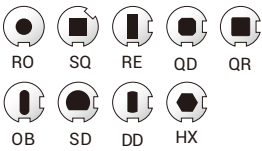
FEATURED PRODUCTS






T85 & T85 ABS





E85 / T85 / T85 ABS STRUCTURE COMPARASION

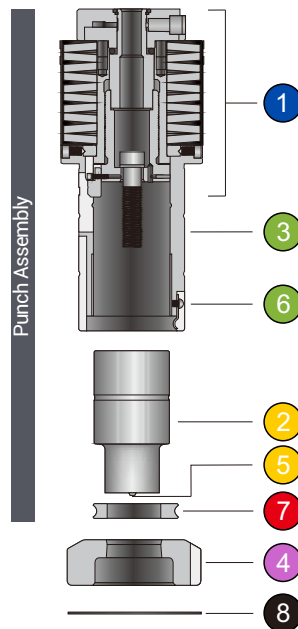











Product		Product Overview
<p>Punch Assembly</p> 	<p>Triple Grooves (0°, 90°, 225°)</p> 	<ul style="list-style-type: none"> • Ketec's T85 series stands out as one of our top-selling products, offering enhanced versatility and durability compared to the E85 series. • To adjust length, press down on the quick-adjust button, rotate the punch head clockwise or counterclockwise to adjust punch length.
<p>Punch</p> 		<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands guide assemblies. • Extended grind life of 8mm, rooftop shear available upon request. • TiCN coating available upon request for additional protection.
<p>Stripper Plate</p> 		<ul style="list-style-type: none"> • KETEC 85 Stripper
<p>Die</p> 		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

-  Punch head assembly
-  Punch
-  Guide
-  Die
-  Ejector

-  Stripper screw & clip
-  Stripper plate
-  Die shim
-  Punch assembly


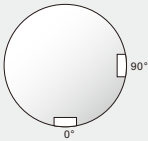


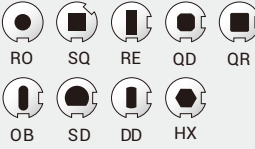

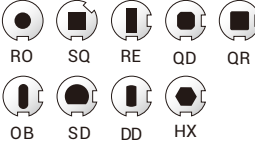


-  RO: Round.
-  RE: Rectangle.
-  SQ: Square.
-  OB: Oblong.
-  DD: Double D.
-  SD: Single D.
-  QR: Quad R.
-  HX: Hexagon.
-  QD: Quad D.

Product		Product Overview
<p>Punch Assembly</p> 	 <p>Structure inside the canister</p>  <p>Triple Grooves (0°, 90°, 225°)</p>	<ul style="list-style-type: none"> • Eliminate or reduce the sheet marks. • Reduce noise, extend spring life time. • Adjust the punch force by change different color springs.
<p>Punch</p> 		<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands guide assemblies. • Extended grind life of 8mm, rooftop shear available upon request. • TiCN coating available upon request for additional protection.
<p>Stripper Plate</p> 		<ul style="list-style-type: none"> • KETEC 85 Stripper
<p>Die</p> 		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

SPL Light Duty Family

A Station	B Station	C Station	D Station	E Station
				
Structure inside the canister				
Different strength springs				
				


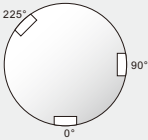

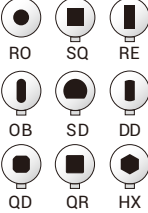

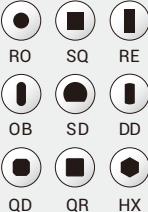

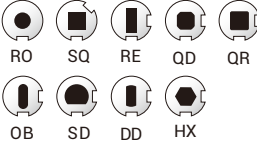
Product		Product Overview
<p>Punch Assembly</p> 	<p>Double Grooves (0°, 90°)</p> 	<ul style="list-style-type: none"> • Thinner blades resulting from narrower punches may compromise rigidity. • Traditional stripper plates often leave larger gaps, exposing blades to vulnerability. • Ketec's Fully Guided Solution eliminates the risk of punch breakage, bending, and die damage. • We only recommend thin material applications.
<p>Punch</p> 		<ul style="list-style-type: none"> • Enhance structure with better rigidity and less deformation on punch. • Interchangeable: can be installed in others brands guide assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating & rooftop shear are available upon request for additional protection.
<p>Stripper Plate</p> 		<ul style="list-style-type: none"> • Close-stripper-to-punch configurations provide robust support for narrow punch blades, extending tool life by at least threefold compared to unguided setups.
<p>Die</p> 		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description






- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Stripper Plate








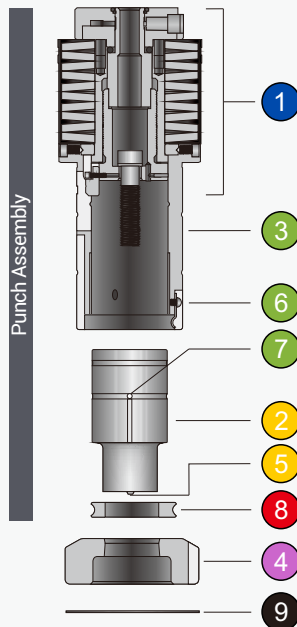
- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▬ OB: Oblong.
- ▬ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.










Product		Product Overview
	<p>Triple Grooves (0°, 90°, 225°)</p> 	<ul style="list-style-type: none"> • ABS: Air Blow System, oil mist lubrication, anti-scratch, anti-adhesion, longer punch life.
		<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands guide assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating & rooftop shear are available upon request for additional protection.
		<ul style="list-style-type: none"> • KETEC 85 ABS Stripper
		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.



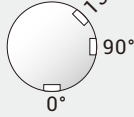
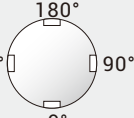

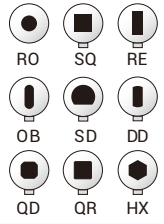

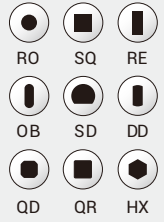

Description

-  Punch head assembly
-  Punch ABS
-  Guide
-  Die
-  Ejector





-  Stripper screw & clip
-  ABS hole
-  Stripper plate ABS
-  Die shim
-  Punch assembly








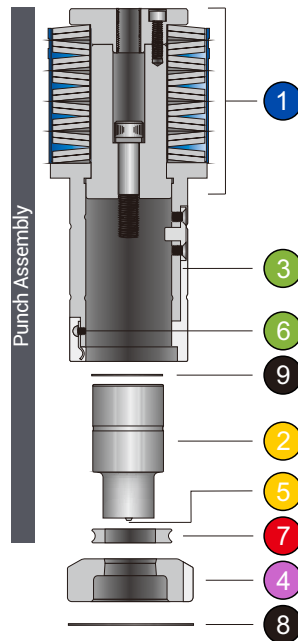
-  RO: Round.
-  RE: Rectangle.
-  SQ: Square.
-  OB: Oblong.
-  DD: Double D.
-  SD: Single D.
-  QR: Quad R.
-  HX: Hexagon.
-  QD: Quad D.










Product		Product Overview
	<p>Double Grooves (0°, 90°) </p> <p>Double Grooves (0°, 90°, 135°) </p> <p>Double Grooves (0°, 90°, 180°, 270°) </p>	<ul style="list-style-type: none"> • Ketec's E85 series is engineered to seamlessly integrate with all leading OEMs, boasting enhancements in both material composition and design for unparalleled performance. • Simple design offers a lower cost alternative compared to our flagship T85 series.
		<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands guide assemblies. • Extended grind life of 8mm, rooftop shear available upon request. • TiCN coating & rooftop are available upon request for additional protection.
		<ul style="list-style-type: none"> • KETEC 85 Stripper
		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description









-  Punch head assembly
-  Punch
-  Guide
-  Die
-  Ejector

-  Stripper screw & clip
-  Stripper plate
-  Die shim
-  Punch shim
-  Punch assembly



-  RO: Round.
-  RE: Rectangle.
-  SQ: Square.
-  OB: Oblong.
-  DD: Double D.
-  SD: Single D.
-  QR: Quad R.
-  HX: Hexagon.
-  QD: Quad D.

C STATION E85

Product		Product Overview
<p>Slitting Punch (Type 19)</p> 	<p>T85 + Slitting Punch T85 Light Duty + Slitting Punch T85 Fully Guided + Slitting Punch E85 + Slitting Punch</p>	<ul style="list-style-type: none"> Based on the 85 punch holder, interchangeable punch sizes are available It is suitable for various rectangular or oblong cutting tools.
<p>Clusters (Punch, Die, Stripper Plate)</p> 	<p>T85 Cluster T85 ABS Cluster T85 Fully Guided Cluster E85 Cluster</p>	<ul style="list-style-type: none"> Cluster is one of the commonly and widely used methods in sheet metal processing. The 85 series is equipped with a cluster slitting punch for customers to choose. Customers only need to provide the sheet metal drawing, thickness, machine model information.
<p>Blank Die</p> 	<ul style="list-style-type: none"> Mostly use in forming tools, such as lots of form down centerpoint, form down stamping logo / letter... 	
<p>Roller Ball Die</p> 	<ul style="list-style-type: none"> The function of the roller ball die is for scratch-resistant sheets. 	
<p>Brush Die</p> 	<ul style="list-style-type: none"> The function of the roller ball die is for scratch-resistant sheets. 	
<p>90 Guide</p> 	<ul style="list-style-type: none"> Use for T85 / T85ABS / T85 LIGHT DUTY. 	
<p>85 Guide</p> 	<ul style="list-style-type: none"> Only for E85. 	
<p>Fully Guided</p> 	<ul style="list-style-type: none"> Only for Fully Guided. 	



D STATION

Thick Turret Punch Assembly Index - 85 Series

T85

T85 LIGHT DUTY

T85 FULLY GUIDED

T85 ABS

T85 CLOSE TO CLAMP

PUNCH ASSEMBLIES



T85 CLOSE TO CLAMP LIGHT DUTY

E85

PUNCH ASSEMBLIES



D STATION

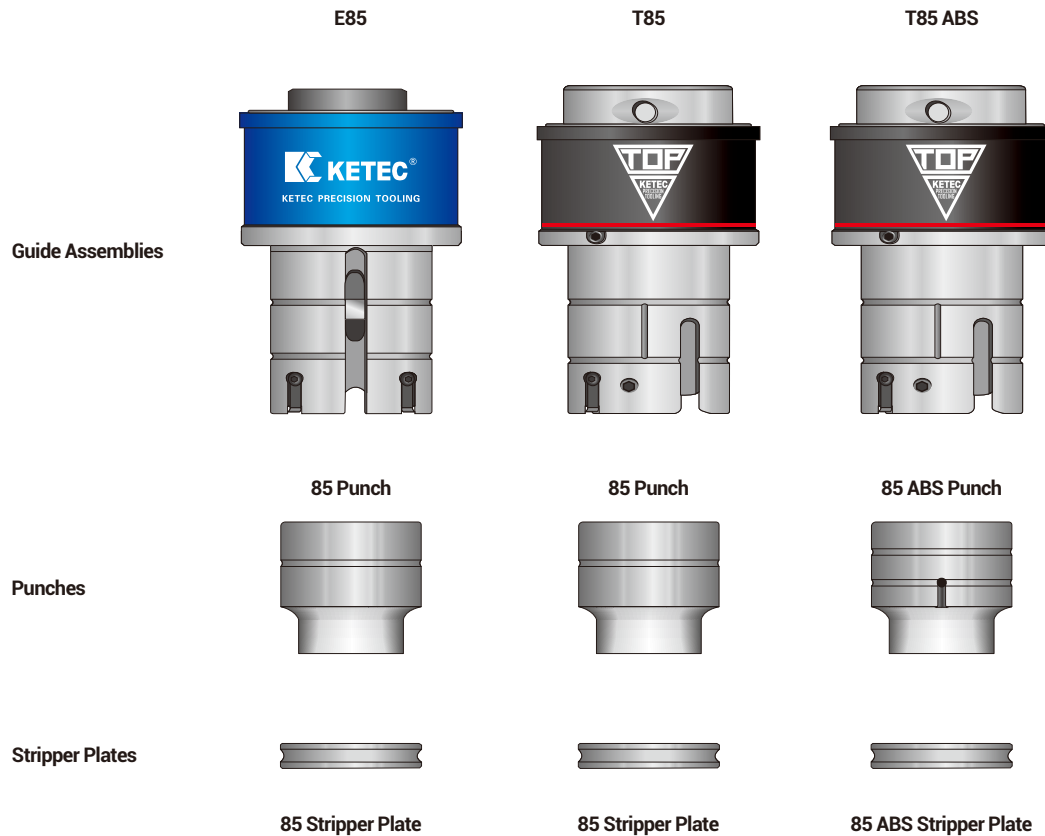
INDEX


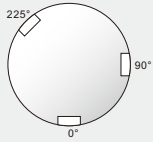

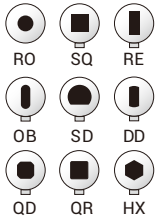

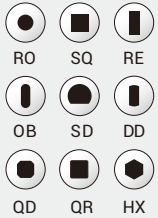

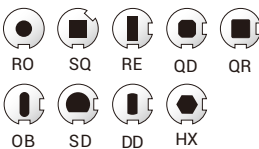
FEATURED PRODUCTS






T85 & T85 ABS





E85 / T85 / T85 ABS STRUCTURE COMPARASION

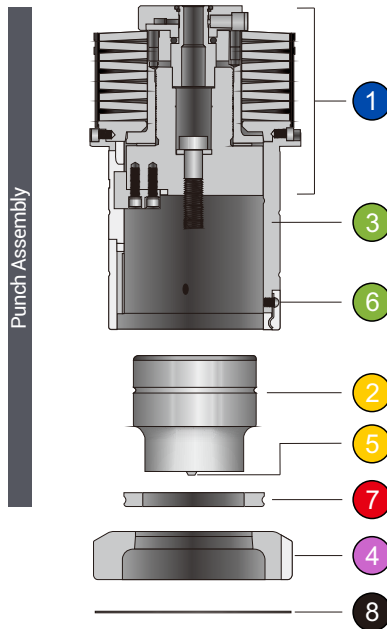











Product		Product Overview
	<p>Triple Grooves (0°, 90°, 225°)</p> 	<ul style="list-style-type: none"> • Ketec's T85 series stands out as one of our top-selling products, offering enhanced versatility and durability compared to the E85 series. • To adjust length, press down on the quick-adjust button, rotate the punch head clockwise or counterclockwise to adjust punch length.
<p>Standard Punch</p> 		<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands guide assemblies. • Extended grind life of 8mm, rooftop shear available upon request. • TiCN coating available upon request for additional protection.
<p>Stripper Plate</p> 		<ul style="list-style-type: none"> • KETEC 85 Stripper
<p>Die</p> 		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

-  Punch head assembly
-  Punch
-  Guide
-  Die
-  Ejector

-  Stripper screw & clip
-  Stripper plate
-  Die shim
-  Punch assembly

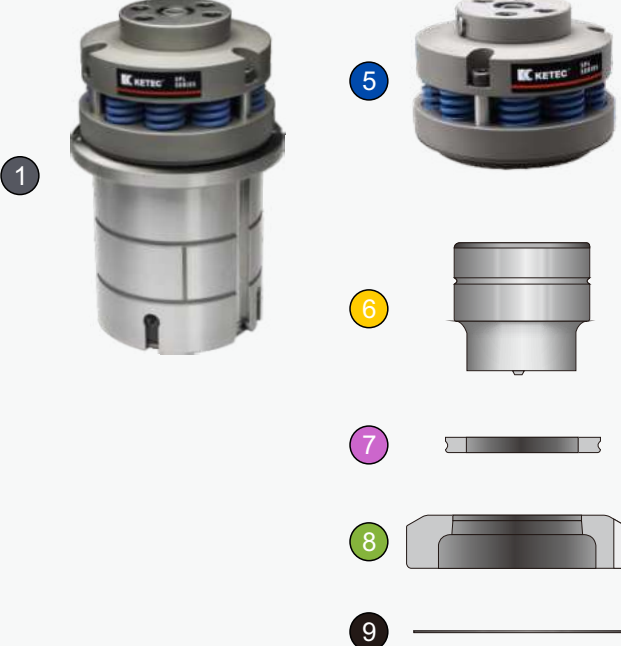


-  RO: Round.
-  RE: Rectangle.
-  SQ: Square.
-  OB: Oblong.
-  DD: Double D.
-  SD: Single D.
-  QR: Quad R.
-  HX: Hexagon.
-  QD: Quad D.


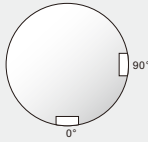

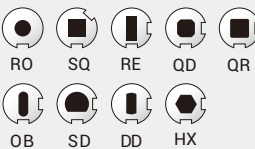

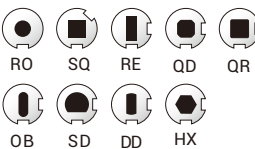
Product		Product Overview
	 <p>Structure inside the canister</p>  <p>Triple Grooves (0°, 90°, 225°)</p>	<ul style="list-style-type: none"> • Eliminate or reduce the sheet marks. • Reduce noise, extend spring life time. • Adjust the punch force by change different color springs.
		<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands guide assemblies. • Extended grind life of 8mm, rooftop shear available upon request. • TiCN coating available upon request for additional protection.
		<ul style="list-style-type: none"> • KETEC 85 Stripper
		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description





- 1 Guide assembly
- 2 Blue springs (Light)
- 3 Red springs (Medium)
- 4 Green springs (Heavy)
- 5 Punch head assembly
- 6 Punch
- 7 Stripper plate
- 8 Die
- 9 Die shim












- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- DD: Double D.
- SD: Single D.
- QR: Quad R.
- ◆ HX: Hexagon.
- QD: Quad D.

Product		Product Overview
<p>Punch Assembly</p> 	<p>Double Grooves (0°, 90°)</p> 	<ul style="list-style-type: none"> • Thinner blades resulting from narrower punches may compromise rigidity. • Traditional stripper plates often leave larger gaps, exposing blades to vulnerability. • Ketec's Fully Guided Solution eliminates the risk of punch breakage, bending, and die damage. • We only recommend thin material applications.
<p>Fully Guided Punch</p> 		<ul style="list-style-type: none"> • Enhance structure with better rigidity and less deformation on punch. • Interchangeable: can be installed in others brands guide assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating & rooftop shear are available upon request for additional protection.
<p>Stripper Plate</p> 		<ul style="list-style-type: none"> • Close-stripper-to-punch configurations provide robust support for narrow punch blades, extending tool life by at least threefold compared to unguided setups.
<p>Die</p> 		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

-  Punch head assembly
-  Punch
-  Guide
-  Stripper Plate



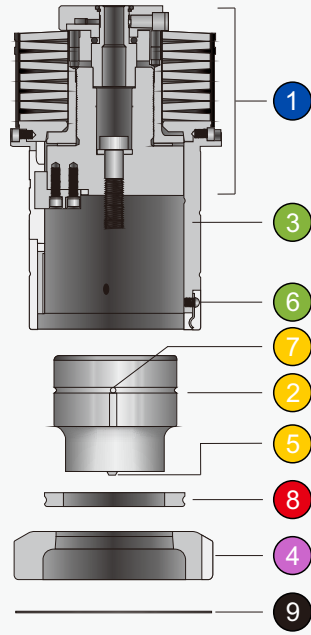
-  RO: Round.
-  RE: Rectangle.
-  SQ: Square.
-  OB: Oblong.
-  DD: Double D.
-  SD: Single D.
-  QR: Quad R.
-  HX: Hexagon.
-  QD: Quad D.

Product		Product Overview
	<p>Triple Grooves (0°, 90°, 225°)</p> 	<ul style="list-style-type: none"> • ABS: Air Blow System, oil mist lubrication, anti-scratch, anti-adhesion, longer punch life.
<p>Standard Punch ABS</p> 		<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands guide assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating & rooftop shear are available upon request for additional protection.
<p>Stripper Plate ABS</p> 		<ul style="list-style-type: none"> • KETEC 85 ABS Stripper
<p>Die</p> 		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.


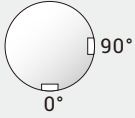

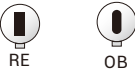




Description

- 1 Punch head assembly
- 6 Stripper screw & clip
- 2 Punch ABS
- 7 ABS hole
- 3 Guide
- 8 Stripper plate ABS
- 4 Die
- 9 Die shim
- 5 Ejector
- 10 Punch assembly

Punch Assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

Product	Product Overview	
<p>Punch Assembly</p> 	<p>Double Grooves (0°, 90°)</p> 	<ul style="list-style-type: none"> Parting and slitting are common practices in sheet metal fabrication. Whether you are parting nested parts or straightening the edge of the sheet, you need a Close-to-clamp tool specifically to maximize your productivity for those applications.
<p>Punch Blade</p> 		<ul style="list-style-type: none"> Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating and rooftop shear are available upon request for additional protection. <p>RE5*100 OBØ6*100</p> <ul style="list-style-type: none"> Common sizes: RE8*100 OBØ6*100
<p>Stripper Plate</p> 		<ul style="list-style-type: none"> Close-to-clamp stripper maximizes sheet use
<p>Die (Close to Clamp)</p> 		<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

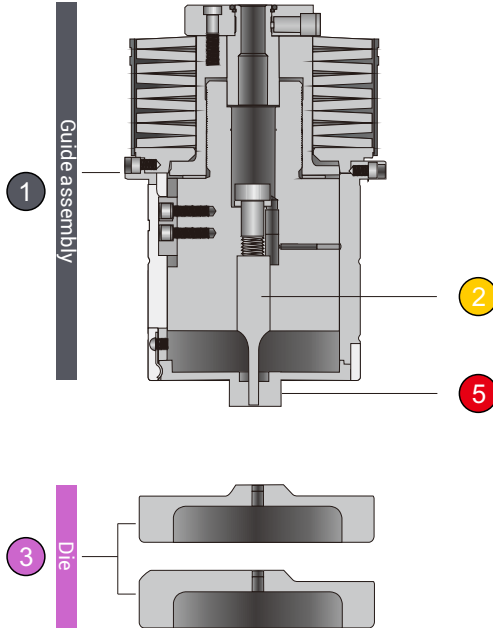
1 Guide assembly

2 Punch


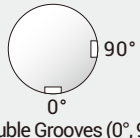




3 Die

4 Guide

5 Stripper Plate


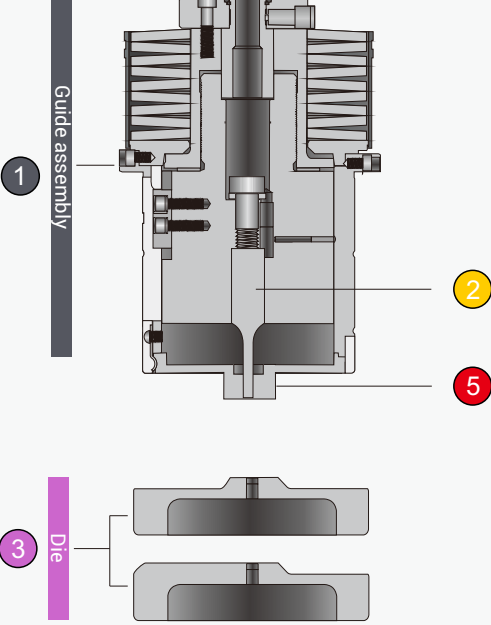


- RO: Round.
- RE: Rectangle.
- SQ: Square.
- OB: Oblong.
- DD: Double D.
- SD: Single D.
- QR: Quad R.
- HX: Hexagon.
- QD: Quad D.


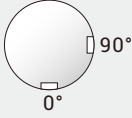

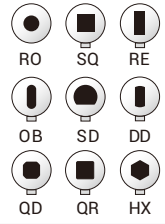

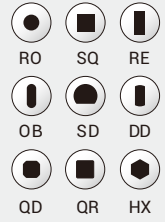
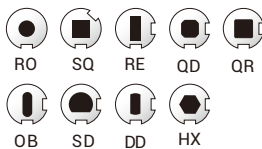
Product		Product Overview
<p>Punch Assembly</p> 	 <p>Structure inside the canister</p>  <p>Double Grooves (0°, 90°)</p>	<ul style="list-style-type: none"> Parting and slitting are common practices in sheet metal fabrication. Whether you are parting nested parts or straightening the edge of the sheet, you need a Close-to-clamp tool specifically to maximize your productivity for those applications.
<p>Punch Blade</p> 	 <p>RE OB</p>	<ul style="list-style-type: none"> Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating and rooftop shear are available upon request for additional protection. Common sizes: RE5*80 OBØ6*80
<p>Stripper Plate</p> 	 <p>RE OB</p>	<ul style="list-style-type: none"> Close-to-clamp stripper maximizes sheet use
<p>Die (Close to Clamp)</p> 	 <p>RE OB</p>	<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

- 1 Guide assembly
- 2 Punch
- 3 Die
- 4 Guide
- 5 Stripper Plate

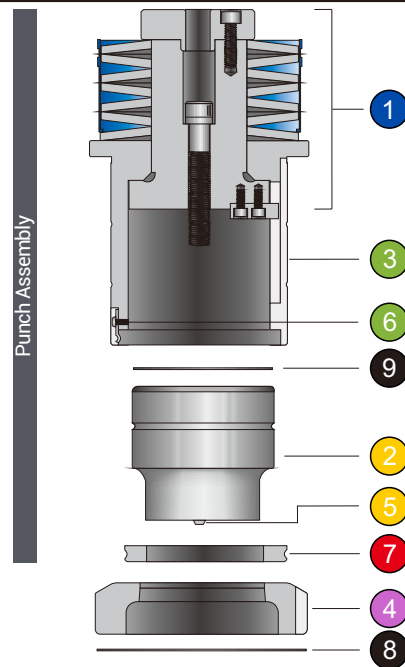
- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- DD: Double D.
- SD: Single D.
- QR: Quad R.
- ◆ HX: Hexagon.
- QD: Quad D.

Product		Product Overview
<p>Punch Assembly</p> 	<p>Double Grooves (0°, 90°)</p> 	<ul style="list-style-type: none"> • Ketec's E85 series is engineered to seamlessly integrate with all leading OEMs, boasting enhancements in both material composition and design for unparalleled performance. • Simple design offers a lower cost alternative compared to our flagship T85 series.
<p>Standard Punch</p> 		<ul style="list-style-type: none"> • Interchangeable: can be installed in others brands guide assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating and rooftop shear are available upon request for additional protection.
<p>Stripper Plate</p> 		<ul style="list-style-type: none"> • KETEC 85 Stripper Plate
<p>Die</p> 		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

- 1 Punch head assembly
- 2 Punch
- 3 Guide
- 4 Die
- 5 Ejector

- 6 Stripper screw & clip
- 7 Stripper plate
- 8 Die shim
- 9 Punch shim
- 10 Punch assembly



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

Product		Product Overview
<p>Slitting Punch (Type 16)</p> 	<p>T85 + Slitting Punch T85 Light Duty + Slitting Punch T85 Fully Guided + Slitting Punch E85 + Slitting Punch</p>	<ul style="list-style-type: none"> Based on the 85 punch holder, interchangeable punch sizes are available It is suitable for various rectangular or oblong cutting tools.
<p>Clusters (Punch, Die, Stripper Plate)</p> 	<p>T85 Cluster T85 ABS Cluster T85 Fully Guided Cluster E85 Cluster</p>	<ul style="list-style-type: none"> Cluster is one of the commonly and widely used methods in sheet metal processing. The 85 series is equipped with a cluster slitting punch for customers to choose. Customers only need to provide the sheet metal drawing, thickness, machine model information.
<p>Blank Die</p>  <p>Roller Ball Die</p>  <p>Brush Die</p> 	<ul style="list-style-type: none"> Mostly use in forming tools, such as lots of form down centerpoint, form down stamping logo / letter... The function of the roller ball die is for scratch-resistant sheets. The function of the roller ball die is for scratch-resistant sheets. 	
<p>90 Guide</p>  <ul style="list-style-type: none"> Use for T85 / T85 ABS, T85 LIGHT DUTY. 	<p>Close to Clamp</p>  <ul style="list-style-type: none"> Use for T85 CLOSE TO CLAMP, T85 CLOSE TO CLAMP LIGHT DUTY. 	
<p>85 Guide</p>  <ul style="list-style-type: none"> Only use for E85. 	<p>Fully Guided</p>  <ul style="list-style-type: none"> Only use for Fully Guided. 	

E STATION

Thick Turret Punch Assembly Index - 85 Series

- T85
- T85 LIGHT DUTY
- T85 FULLY GUIDED
- T85 ABS
- T85 CLOSE TO CLAMP



PUNCH ASSEMBLIES



E85



PUNCH ASSEMBLIES

E STATION

INDEX

FEATURED PRODUCTS



T85 & T85 ABS

T85 STANDARD FAMILY




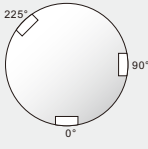

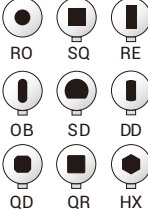

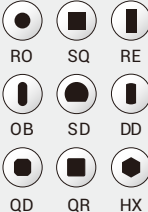

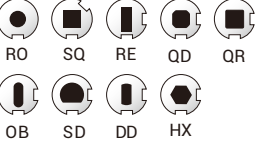
A STATION

B STATION

D STATION

D STATION

E STATION

Product		Product Overview
<p>Punch Assembly</p> 		<ul style="list-style-type: none"> • Ketec's T85 series stands out as one of our top-selling products, offering enhanced versatility and durability compared to the E85 series. • To adjust length, press down on the quick-adjust button, rotate the punch head clockwise or counterclockwise to adjust punch length.
<p>Punch</p> 		<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands guide assemblies. • Extended grind life of 8mm, rooftop shear available upon request. • TiCN coating available upon request for additional protection.
<p>Stripper Plate</p> 		<ul style="list-style-type: none"> • KETEC 85 Stripper
<p>Die</p> 		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

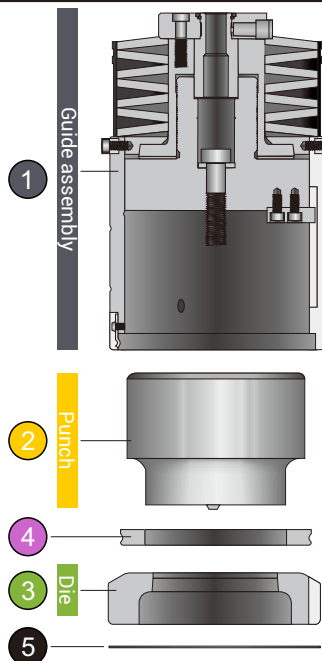
1 Guide assembly

2 Punch ABS




3 Die


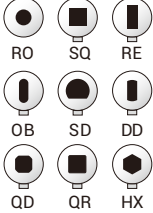
4 Stripper Plate ABS

5 Die shim


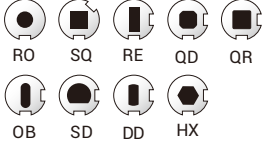


- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▬ OB: Oblong.
- ▬ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ◆ HX: Hexagon.
- QD: Quad D.

Product		Product Overview
<p>Punch Assembly</p> 	 <p>Structure inside the canister</p>  <p>Triple Grooves (0°, 90°, 225°)</p>	<ul style="list-style-type: none"> • Eliminate or reduce the sheet marks. • Reduce noise, extend spring life time. • Adjust the punch force by change different color springs.

<p>Punch</p> 		<ul style="list-style-type: none"> • Interchangeable: can be installed in other brands guide assemblies. • Extended grind life of 8mm, rooftop shear available upon request. • TiCN coating available upon request for additional protection.
--	---	--

<p>Stripper Plate</p> 		<ul style="list-style-type: none"> • KETEC 85 Stripper
--	--	---


<p>Die</p> 		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"]/ 1.2mm [0.0472"] die shims, 5pcs/pack.
--	---	---

Description






- 1 Guide assembly
- 2 Blue springs (Light)
- 3 Red springs (Medium)
- 4 Green springs (Heavy)
- 5 Punch head assembly
- 6 Punch
- 7 Stripper plate
- 8 Die
- 9 Die shim


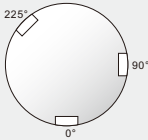

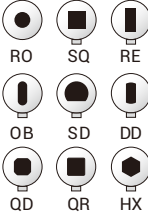

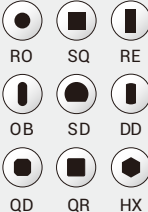

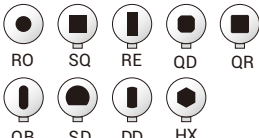


- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ◆ HX: Hexagon.
- QD: Quad D.

Product		Product Overview
<p>Punch Assembly</p> 	<p>Double Grooves (0°, 90°)</p> 	<ul style="list-style-type: none"> • Thinner blades resulting from narrower punches may compromise rigidity. • Traditional stripper plates often leave larger gaps, exposing blades to vulnerability. • Ketec's Fully Guided Solution eliminates the risk of punch breakage, bending, and die damage. • We only recommend thin material applications.
<p>Punch</p> 		<ul style="list-style-type: none"> • Enhance structure with better rigidity and less deformation on punch. • Interchangeable: can be installed in others brands guide assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating & rooftop shear are available upon request for additional protection.
<p>Stripper Plate</p> 		<ul style="list-style-type: none"> • Close-stripper-to-punch configurations provide robust support for narrow punch blades, extending tool life by at least threefold compared to unguided setups.
<p>Die</p> 		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

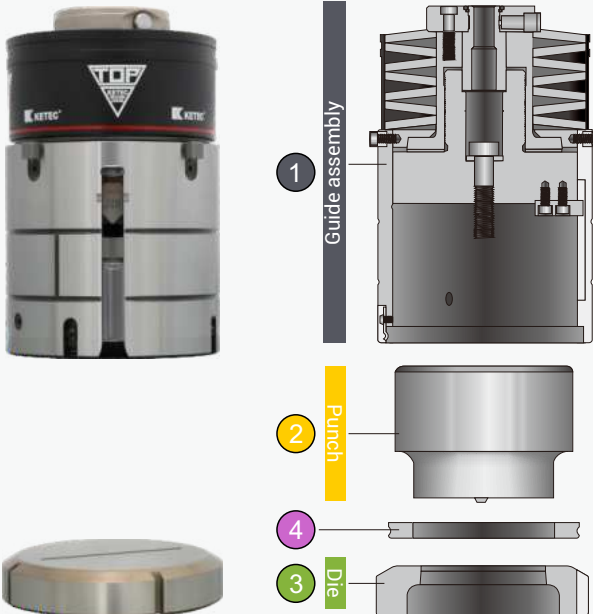
Description

	1	2	3	4	5	6
Description	 Thick Turret/T85 Fully Guided Punch Assembly/E	 Thick Turret/T85 Punch Head Assembly/E	 Thick Turret / 85 Fully Guided Guide	 Thick Turret/85 Fully Guided Punch/E	 Thick Turret/85 Fully Guided Stripper Plate/E	 Thick Turret Die/E
Size	General use	General use	General use	RE5*110	RE5*110	RE5*110+0.15


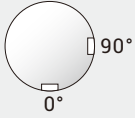









Product		Product Overview
	<p>Triple Grooves (0°, 90°, 225°)</p> 	<ul style="list-style-type: none"> • ABS: Air Blow System, oil mist lubrication, anti-scratch, anti-adhesion, longer punch life.
		<ul style="list-style-type: none"> • Interchangeable: can be installed in others brands guide assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating and rooftop shear are available upon request for additional protection.
		<ul style="list-style-type: none"> • KETEC 85 ABS Stripper Plate
		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

- 1 Guide assembly
- 2 Punch ABS
- 3 Die
- 4 Stripper Plate ABS
- 5 Die shim



- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ⬠ HX: Hexagon.
- QD: Quad D.

Product	Product Overview	
<p>Punch Assembly</p> 	<p>Double Grooves (0°, 90°)</p>  <ul style="list-style-type: none"> Parting and slitting are common practices in sheet metal fabrication. Whether you are parting nested parts or straightening the edge of the sheet, you need a Close-to-clamp tool specifically to maximize your productivity for those applications. 	
<p>Punch</p> 	 	<ul style="list-style-type: none"> Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. TiCN coating and rooftop shear are available upon request for additional protection. <p>RE5*100 OBØ6*100</p> <ul style="list-style-type: none"> Common sizes: RE8*100 OBØ6*100
<p>Stripper Plate</p> 	 	<ul style="list-style-type: none"> Close-to-clamp stripper maximizes sheet use
<p>Die</p> 	 	<ul style="list-style-type: none"> Standard: Slugfree. Options: Slughugger, Vacuum. After grinding, a die shim is required to maintain a consistent height of 30mm. Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

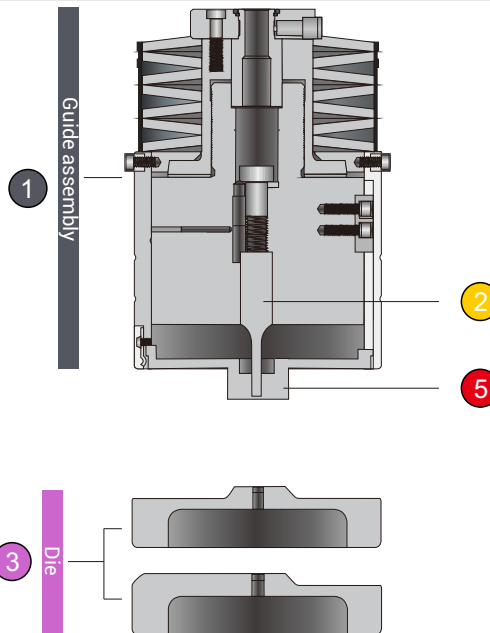
1 Guide assembly

2 Punch


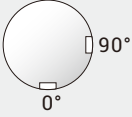

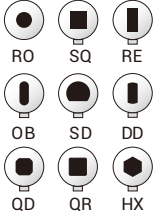

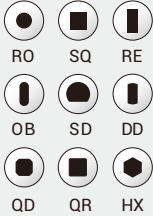

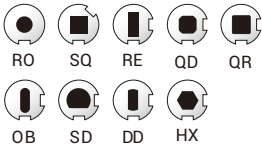
3 Die

4 Guide

5 Stripper Plate

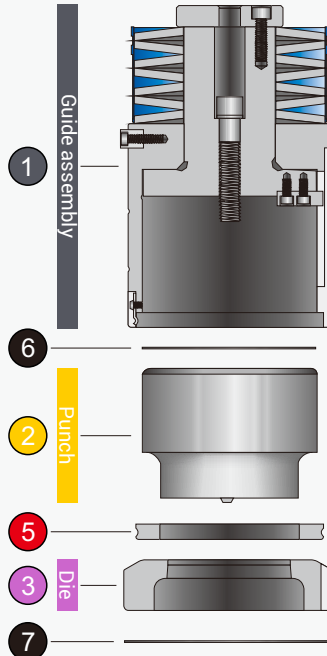


- RO: Round.
- RE: Rectangle.
- SQ: Square.
- OB: Oblong.
- DD: Double D.
- SD: Single D.
- QR: Quad R.
- HX: Hexagon.
- QD: Quad D.

Product		Product Overview
<p>Punch Assembly</p> 	<p>Double Grooves (0°, 90°)</p> 	<ul style="list-style-type: none"> • Ketec's E85 series is engineered to seamlessly integrate with all leading OEMs, boasting enhancements in both material composition and design for unparalleled performance. • Simple design offers a lower cost alternative compared to our flagship T85 series.
<p>Punch</p> 		<ul style="list-style-type: none"> • Interchangeable: can be installed in others brands guide assemblies. • Using HRC 63 High-Speed Steel for exceptional durability in high-stress environments. • TiCN coating and rooftop shear are available upon request for additional protection.
<p>Stripper Plate</p> 		<ul style="list-style-type: none"> • KETEC 85 Stripper Plate
<p>Die</p> 		<ul style="list-style-type: none"> • Standard: Slugfree. • Options: Slughugger, Vacuum. • After grinding, a die shim is required to maintain a consistent height of 30mm. • Ketec offers 0.4mm [0.0157"] / 0.8mm [0.0315"] / 1.2mm [0.0472"] die shims, 5pcs/pack.

Description

- 1 Guide assembly
- 2 Punch
- 3 Die
- 4 Guide
- 5 Stripper plate
- 6 Punch shim
- 7 Die shim

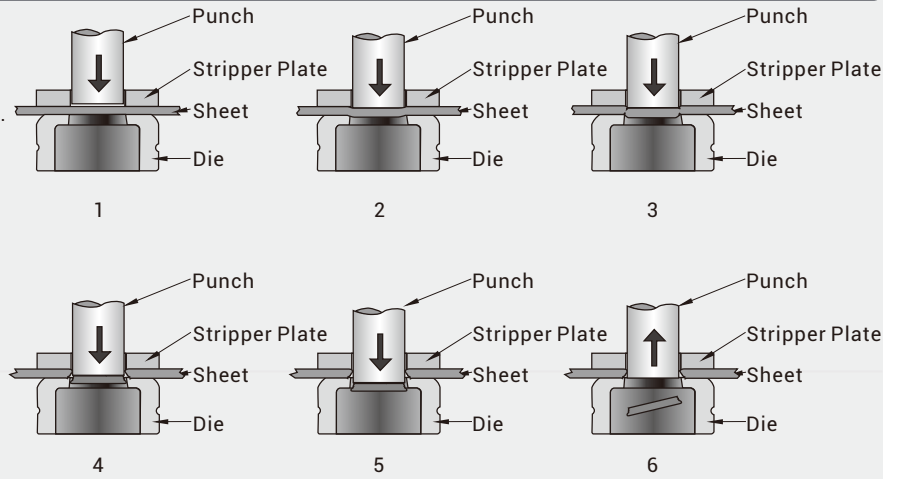


- RO: Round.
- RE: Rectangle.
- SQ: Square.
- ▭ OB: Oblong.
- ▭ DD: Double D.
- SD: Single D.
- QR: Quad R.
- ◆ HX: Hexagon.
- QD: Quad D.

Tips and Techniques

1. Punching Process

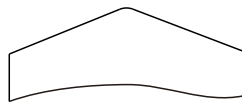
- The stripper plate presses the sheet tightly.
- The punch contacts the sheet, and the sheet begins to deform.
- The punch and die begin to shear the sheet.
- The sheet begins to tear.
- The punch reaches the bottom.
- The punch retracts, and the slug falls freely.



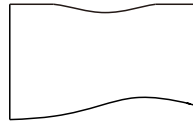
2. Punch Shear Styles



Horizontal Shear



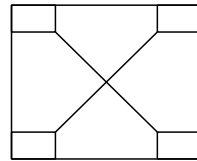
Rooftop Shear



Quad Concave Shear

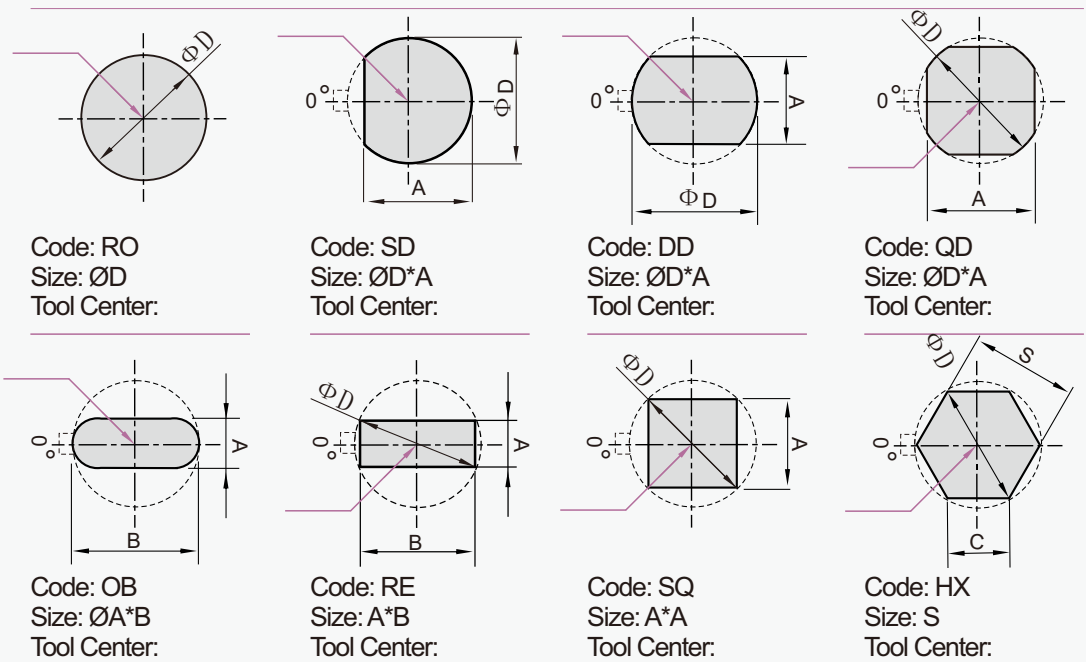


Double Concave Shear



3. Standard Shape Size Diagram

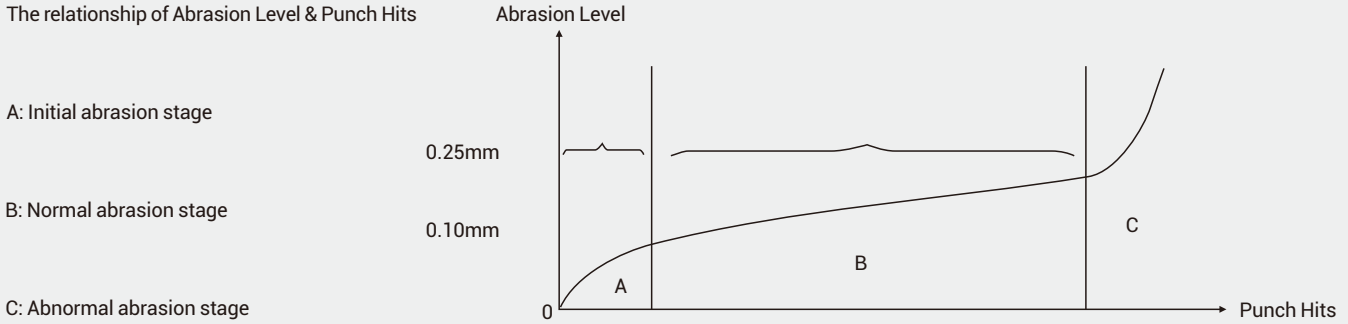
Standard Shape



Tips and Techniques

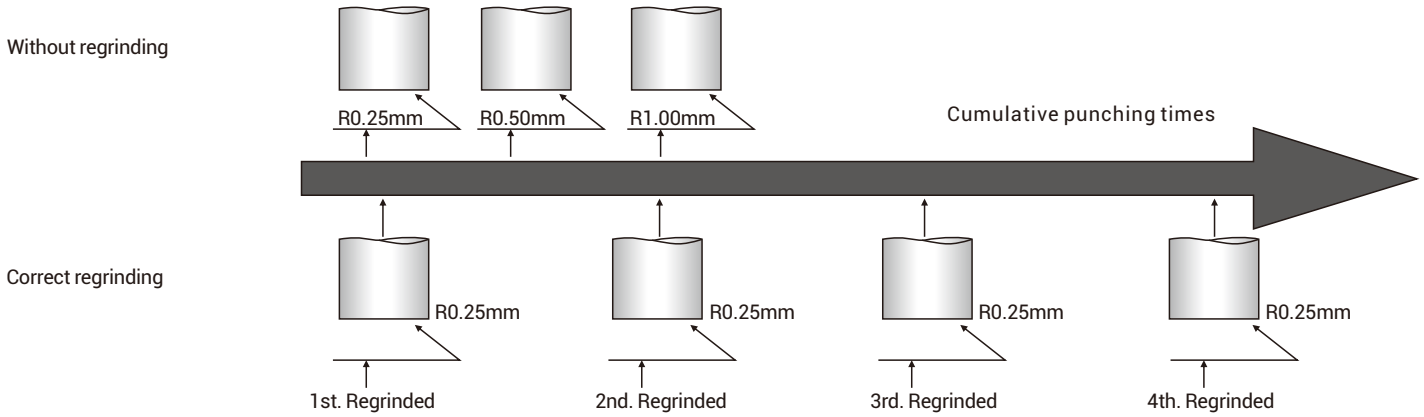
4. Abrasion Level & Punch Hits

The relationship of Abrasion Level & Punch Hits

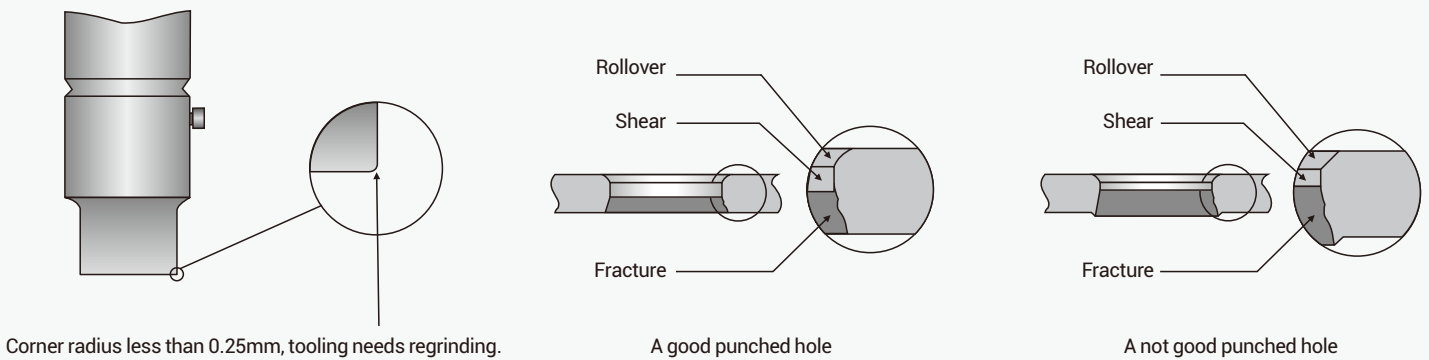


5. Tooling Regrinding Instruction

Following the correct instruction to regrind the punch, the tooling life will be extended to double.



6. Timing for Regrinding



7. Precautions of Regrinding

Precautions:

There are various methods for sharpening tooling blades. A specialized blade sharpening machine can be used, or it can be done on a surface grinder. When sharpening tooling blades, the following factors need to be considered:

- Choose an appropriate grinding wheel, it is recommended to use a loose, coarse-grained, soft grinding wheel, such as WA46KV.
- The grinding amount for each pass should not exceed 0.015mm. Excessive grinding can cause surface overheating, resulting in softening of the tooling or the formation of cracks.
- Sufficient cooling must be provided, and the grinding wheel should be kept sharp.
- The punch and lower die should be kept stable and fixed, using specialized fixtures and tooling.
- After sharpening, the edge should be treated with oil to avoid excessive sharpness. Clean thoroughly, demagnetize, apply oil, and adjust the tooling height.

Tips and Techniques

8. Adjustment after Regrinding

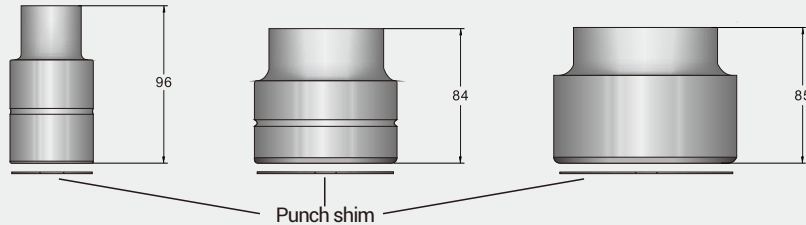
Punch Adjustment

The new punch heights for C, D, and E stations are as shown in the diagram.

In older guide assemblies like E85 series, after each sharpening of the punch, it is necessary to add shims to adjust the punch height.

The adjustment method is as follows: the thickness of the shims plus the punch height should equal the values shown in the diagram below.

In newer guide assembly like T85 or T90, punch height adjustment is made using threaded mechanism, eliminating the need for shims.



Die Adjustment

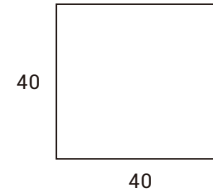


9. Calculation of Punching Force

Punching force (KN) = Shape Perimeter (L) X Thickness (T) X 0.345 X Material Factor X Shear Factor

e.g. SQ40*40, T=3.0mm, SPCC, Flat shear

Punching force = (40X4)X3.0X0.345X1.2X1.0=198.72 (KN). [19.9 tons]



If the thickness of the sheet metal plate is greater than or equal to 3mm, the punching force needs to be calculated to determine:

1. whether the required punching force exceeds the machine's rated nominal force.
2. whether the required punching force exceeds the pressure-bearing capacity of the punch's weakest part.

The punching force can be reduced by altering the punch edge structure, changing the station, or using heavy duty tooling to avoid damage to the tool or the machine.

10. Recommended Value of Die Clearance

Sheet material:

Different materials have varying hardness and ductility, which affects the required clearance. Softer materials generally require smaller clearances, while harder materials need larger clearance.

Sheet thickness:

As the thickness of the sheet increases, the required die clearance should also increase to accommodate proper cutting or forming without causing damage to the tooling or material.

Die clearance:

The clearance between the punch and die should be appropriately set based on the sheet material and thickness to ensure clean cuts, prevent excessive wear, and avoid issues like burrs or deformation.

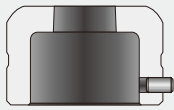
In general, as the sheet thickness increases, the clearance should also increase proportionally to maintain the quality of the process.

Thickness (T) / Material	0.8	1.0	0.8	0.8	2.5	3.0	3.2	3.5	4.0	4.5	5.0	5.5	6.0
Aluminum	0.12	0.15	0.2	0.3	0.35	0.45	0.48	0.53	0.6	0.68	0.75	0.83	0.9
SPCC, Mild Steel	0.15	0.2	0.3	0.4	0.5	0.6	0.65	0.7	0.8	0.9	1	1.1	1.2
Stainless Steel	0.15	0.2	0.35	0.45	0.5	0.6	0.65	0.7	0.8				

Tips and Techniques

11. Selection of Die Type

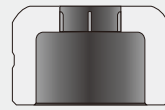
The four different die styles as offered by KETEC are illustrated in below:



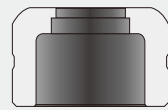
Positive taper



Negative taper



Slughugger



Stairs

Positive taper

This is the best style of die for punching holes of less than 0.236" [6mm] diameter in mild steel and stainless steel, or less than 0.472" [12mm] diameter in aluminum. Use of this style of die can result in slug pulling.

Negative taper

Although the taper is only 0.0005" [0.01mm], this is enough to help squeeze and hold the slug as its pushed down into the die land, thus helping to prevent slug pulling. Negative taper is not recommended for punching aluminum or plastic because of slug packing.

Slughugger

This is the only guaranteed method of stopping slug pulling and is especially recommended for use with modern punch presses due to the high punching speed.

12. Thick Turret Alignment Tools & Adapters



Thick Turret Alignment Tools

Item	Code			
Full Set	J.DW-HA1	J.DW-HB1	J.DW-HC1	J.DW-HD1
Punch	J.DW-HA2	J.DW-HB2	J.DW-HC2	J.DW-HD2
Die	J.DW-HA3	J.DW-HB3	J.DW-HC3	J.DW-HD3
Handle	J.DW-HA4	J.DW-HB4	J.DW-HB4	J.DW-HB4

Thick Turret Adapters

STATION	PUNCH CODE	DIE CODE
B to A	J.H-BA1	J.H-BA3
C to A	J.H-CA1	J.H-CA3
C to B	J.H-CB1	J.H-CB3
D to A	J.H-DA1	J.H-DA3
D to B	J.H-DB1	J.H-DB3
D to C	J.H-DC1	J.H-DC3

Please provide KETEC your machine models.



Precision Meets Perfection, Economical Solutions.

< Phone number

North America
+1 (339) 233-4347 (Charlie Qi)

China
+86 (20) 37965500 (Christy Wen)
+86 188-1981-5253 (Simon Tam)

< WhatsApp

+1 518-837-1464 (North America)
+86 188-1981-5253 (International)

< Address

North America
154 Wells Ave, Newton, MA, 02459, USA.

China
No.7 Lifeng Road, Mingzhu Industrial Park, Conghua
Guangzhou, China. 510931.

< Email

North America
Charlie.q@ketectooling.com

China
International@ketectool.com
Simon.t@ketectooling.com

< Fax

+86 (20) 3796 5393

< Follow us

LinkedIn

Facebook

Twitter