

MULTICYL

POWER TO PUNCH WITH



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Punching Basics Guide



In March Multicyl sent out a newsletter on tube punching in which we discussed clean hole punching and gave some detail on our H4 and H5 clean hole systems (view March newsletter).

In this issue we are going to consider tube piercing in which the tube gets a dimpled hole.

At Multicyl we offer several versions of tube piercing machines which can be broken down into 3 categories; H1, H2, and H3. Below is a brief but detailed description of each.

H1 & H2 Tube Piercing

H1 and H2 tube piercing refers to applications in which the holes being punched are dimpled only. Unlike the punching method piercing does not use an internal mandrel and die sections to keep the tube from dimpling, but instead it uses external guides to encapsulate the tube. What this does is keep the OD of the tube consistent while the punch pierces into the hollow tube drawing material around it and forming a dimple.

H1 refers to a dimpled hole on one side, while H2 refers to a dimpled hole on both sides, or what is commonly referred to as a double dimple.

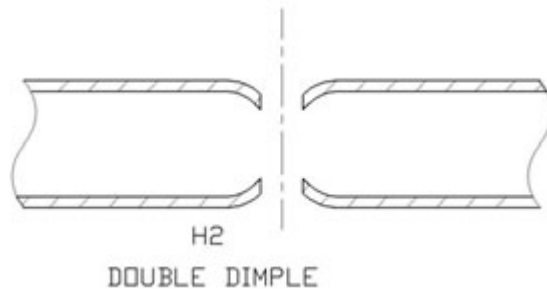
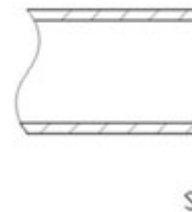
Multicyl provides a standard system for both H1 and H2 applications for tubes up to 1.5" diameter, and custom systems for larger tubes. An H1 system is easily converted to an H2 system by adding a punch assembly to the bottom guide in our standard tool set.

H1 and H2 tube pierce stations are the most cost effective method of punching holes in tubing; a simple H1 system for a 1" dia tube can be bought complete with Multicyl, tooling, and controls for about \$3,500.00.

If you would like a quote on an H1 or H2 system please email Multicyl at sales@multicyl.com and include the following information: tube diameter or profile information, material, wall thickness, hole diameter, and hole location relative to the end of the tube, and application number (H1 or H2). A drawing is always best to quote from. Go to our quote request form.



An application in which the customer used four H2 Multicyl units in a tube piercing cell.



H3 Straight Through Tube Pierce

H3 tube piercing refers to applications in which the tube is pierced straight through with one punch. Although classed as a piercing application, it is actually a bit of a hybrid between piercing and punching as the top side is pierced as described above in the H1 and H2 section, but the bottom hole is actually punched from the inside out as the punch travels through to the bottom of the tube and punches the bottom hole against an external die.

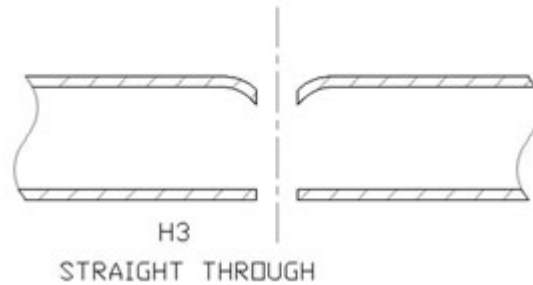
Multicyl straight through tube pierce stations produce a through hole which is dimpled on the top and clean on the bottom. Maintenance may be higher with this application as the punch tip is significantly longer and the bottom hole is actually punched with the slug from the top hole.

Because of the longer distance that the punch must travel in this application longer stroke cylinders are used and applications are limited to tubes with 1.00" maximum diameter (front feed) or 1.25" maximum diameter (side feed).

If you would like a quote on an H3 system please email Multicyl at sales@multicyl.com and include the following information: tube diameter or profile information, material, wall thickness, hole diameter, and hole location relative to the end of the tube, and application number (H3). A drawing is always best to quote from. Go to our quote request form.



A tube punching work station in which the customer combined an H3 straight through piercing Multicyl unit with a Multicyl tube notcher.



New 2011 U.S. Tax Law Gives Manufacturers a Boost

The new law enacts President Obama's proposal to **increase bonus depreciation to 100% for NEW equipment** purchased and placed in service after September 8, 2010 and through December 31, 2011.

In addition, the new law also includes important provisions that reduce business costs and incentivize innovation and R&D. Make sure to let your prospects and customers know!

Example:

\$800,000 NEW Machine 2010/2011

100% Bonus Depreciation = \$800,000

TOTAL First-year Deduction = \$800,000 - 100% write-off in 1st yr*.

* Bonus depreciation

Tradeshows

Please stop by and visit us at the following tradeshows:

CMTS 2011 Oct.17-20, 2011

Direct Energy Centre, Toronto, Booth #2539

Fabtech Nov. 14-17 2011

2011 McCormick Place, Chicago, Booth #1373



Use our [Tonnage Calculator](#) to determine your force requirements.

To use our tonnage calculator select either the hole diameter or shear length option. Then select your material or fill in the tensile strength of the material you are using (KSI). Fill in the rest of the data and hit calculate.

You will be given the tonnage requirement and a list of potential Multicyl cylinders for the application.

Contact us for a free quote on your application

www.multicyl.com punch@multicyl.com

Tel. **905.951.0670** US Toll Free. **800.388.6359** Fax. **905.951.0672**

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MULTICYL Inc. | 640 Hardwick Road, Unit 1 | Bolton | Ontario | L7E 5R1 | Canada