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March 2011

Punching holes in tubing can be broken down into two main categories; the **punching (clean hole) process** and the **piercing (dimpled hole) process**. Both have their pros and cons, and both are suitable to different applications.

At Multicyl we offer systems that do both. We break down the two categories into 5 sub categories based on hole details, H1-H5. Click here to learn more.

In this newsletter we are focusing on the punching method, which is broken down to the **H4** and **H5** sub categories. Click here for a comprehensive discussion of tube piercing/punching article written by Multicyl.

**Hole Punching - H4 Style**

Punching, rather than piercing a hole in tubing, means that like traditional punching in flat stock the underside of the tube is supported with a die so that the result is a clean or dimple-free hole. Punching in one side of the tubing, what we call the H4 category of punching, is one of our most popular applications.

Multicyl offers a range of semi-standard mandrel punching systems for this application. There are no external guides like there are in piercing, instead an internal mandrel is used to support the inner wall of the tube. The mandrel contains a die button which is used to produce the clean hole. The critical factor in this application is the 3 way relationship between the hole diameter, the tube ID, and the mandrel size. Tolerances are very important to the condition of the hole and to tooling life.

In the application shown in figure 2, two H4 style holes were punched using a single cylinder and a 2 punch tooling set. This system was for a 1" OD tube with two 3/8" dia. holes, but there is almost no upper limit to the tube size for H4 systems. The lower limit depends on the critical relationship mentioned above. The limitation of the system is that the mandrel must be able to reach the hole punching area, which means that hole position must not be after any bends or adjustments.

If you would like a quote on an H4 system please email Multicyl at [punch@multicyl.com](mailto:punch@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.



Figure 2. Tube station produces two H4 style holes per one second cycle. Typical H4 stations start at around \$4,000.00 but may vary with the application.

**Hole Punching - H5 Style**

H5 style tube punching is another very common Multicyl application. This process refers to punching a hole that goes through both walls of the tubing. There are 2 major methods of punching an H5 style hole. The first is very similar to the H4 style but includes the addition of a location pin. The tube is punched and then indexed with the pin picking up on the first hole, and punched again. The second is our unique "Double Horizontal" tube punching station. This system (see figure 3) uses two horizontally positioned Multicyls which fire together punching both walls of the tube with a single machine cycle. This is the best

combination of efficiency and safety to be found producing a punched clean through hole.

There is also a 3rd less common style of punching an H5 hole, the straight through method. This type of system uses a long stroke cylinder which powers a punch through the mandrel and into a second die below the tube producing the H5 hole. However, this method involves some maintenance and tube size limitations due to the nature of the application; the long punch tip and the first punched slug make for faster wear on the punch and increase risk for breakage.

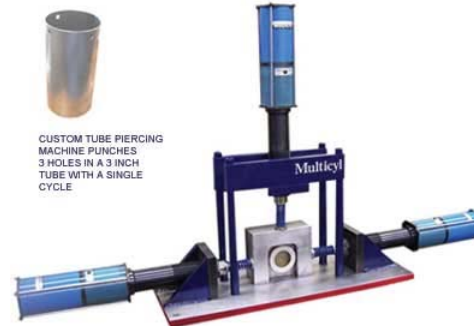


Figure 3. Three 7.5 ton Multicyls with a custom mandrel tool produce both an H5 hole and an H4 hole. Both holes are produced in a single 1 second cycle. Typical H5 Multicyl stations start at \$8,500.00, although price may vary depending on the application.

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would like a quote on an H5 system please e-mail Multicyl at [punch@multicyl.com](mailto:punch@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.**

#### 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

#### Tradehows

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

**FREE**  
**Tonnage**  
**Calculator**

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**  
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