



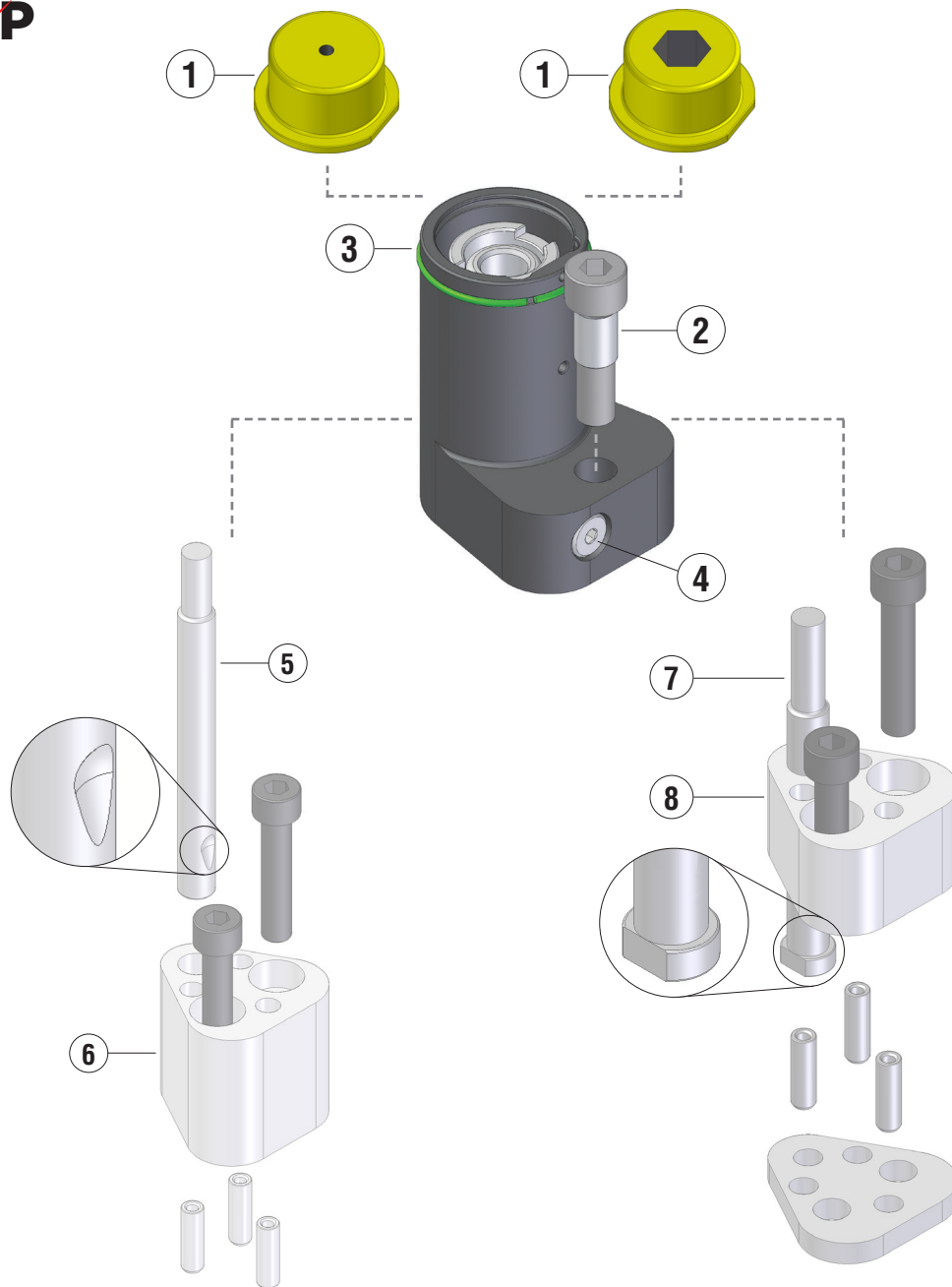
Heavy duty - adjustable force nitrogen gas stripper

Direct mounting to standard retainers for ball-lock and ISO headed punches



new





Ball-lock punch

ISO 8020 headed punch

①	Bronze aluminum blank holder and stripping head
②	S.H.C.S ground shoulder bolt

③	Stripping force identified with colored ring
④	M6 charging port

⑤	Ball-lock punch
⑥	Triangle precision retainer for ball-lock punch

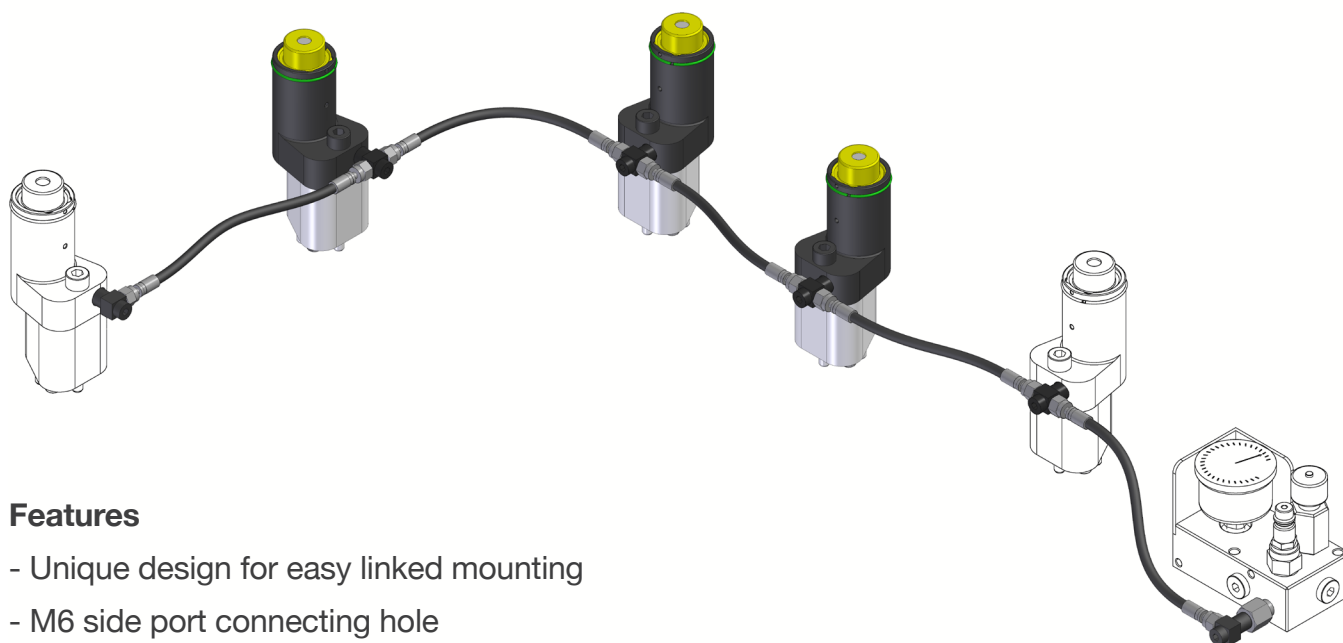
⑦	ISO 8020 punch
⑧	Triangle precision retainer for ISO 8020 punch

Features:

- Mounts directly to standard retainers
- Short and long guided bronze stripping head that is removable and machinable
- Anti - rotation head with 8 mm stroke
- 8 models from 10 mm punch diameter to 40 mm
- 4 color coded force loads as standard

- Contact force as high as 1880 daN - 4200 lbf
- Stripping force as high as 3200 daN - 7200 lbf
- Adjustable stripping force
- Linkable to other NITRO STRIP units for versatility
- OPAS (Over Pressure Active Safety) built-in as standard
- Compact design

Example of nitrogen stripper units linked system

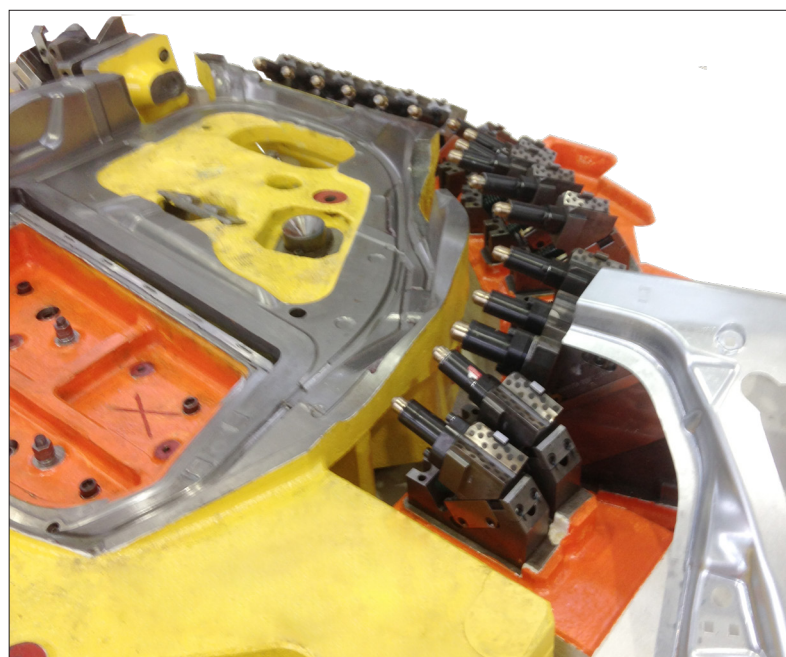


Features

- Unique design for easy linked mounting
- M6 side port connecting hole
- Ideal combination with Micro 32 hoses and connection style - see nitrogen cylinders catalog of Special Springs

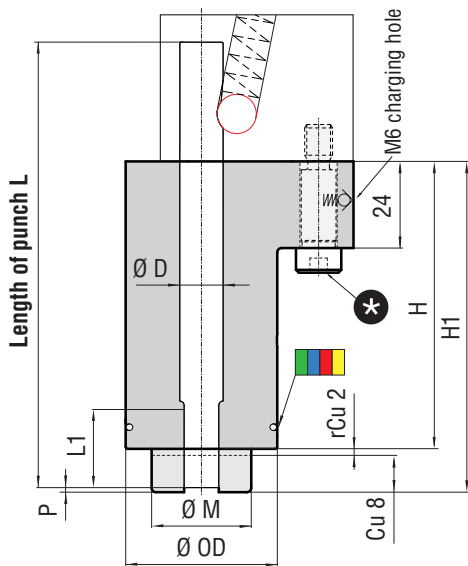
Benefits

- Same pressure in all units
- Adjustable forces
- Easy control of stripping force through control panel
- Higher safety through OPAS (Over Pressure Active Safety)
- Higher quality and less rejection of stamped parts with pressure switch on the control panel

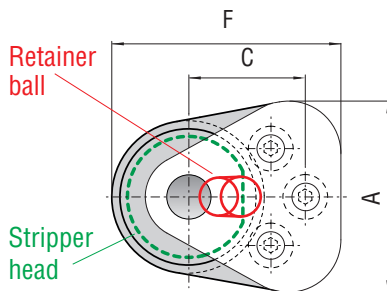
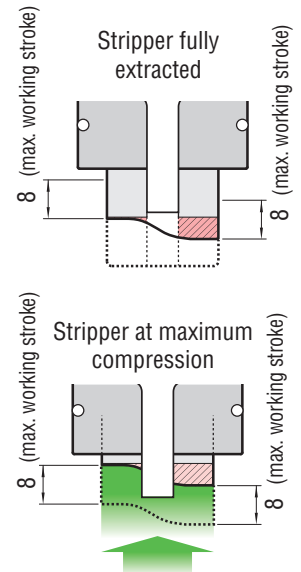
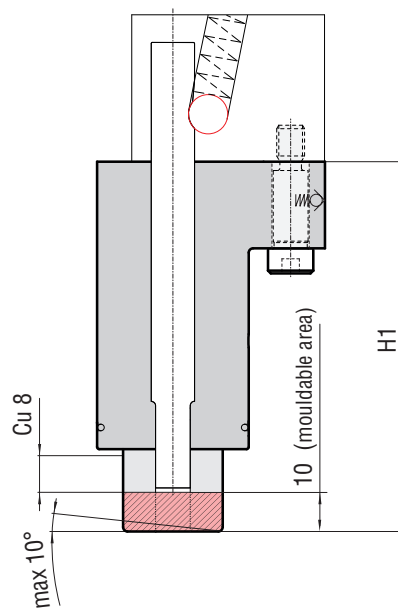


Example of 17 units mounted on aerial cams for a multi piercing of automotive door

Short head - type S

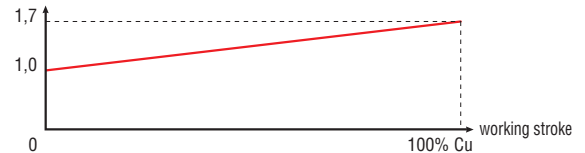


Long head - type L



Retainer type	Head type	Length of punch L	H	H1	P
Light Duty	S	100	65,5	75,5	1,2
	L			85,5	
Heavy Duty	S	110	65,5	75,5	0,2
	L			85,5	

Approx. force increase coefficient



★ Ground body shoulder screw (included)
Torque force 24 Nm + Loctite 243
Spare code: 47VM8-8,5x14A



- The machining of the short stripper head always reduces the nominal stroke
- The machining of the long stripper head, over 10 mm, always reduces the nominal stroke
- Final users are required always to machine the bronze - aluminum stripper head when needed before installation

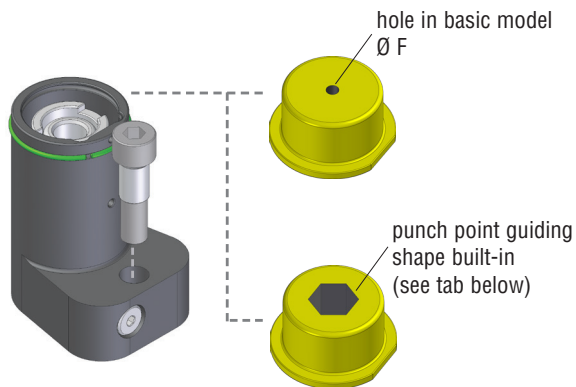
- Maximum stroke length must always be calculated from the first point of contact on the piercing area
- The NITRO STRIP unit is either available with basic stripper head (no punch point guiding shape built-in) or with punch point built-in. (See how to order)
- Always secure the NITRO STRIP on the punch retainer using thread lock (Loctite 243) and tightening torque 24 Nm

 N ₂	°F 32 176	°C 0 80	ΔP ± 0,33 %/°C	P max 100 bar 1450 psi	P min 20 bar 290 psi	SPM ~ 10 - 40 (at 20°C)	Max Speed 1,6 m/s		Maintenance by Special Springs
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CODE	D	A	C	F	OD	M	L1	V0	S	F0 (25 bar at 20° C) daN	F0 (50 bar at 20° C) daN	F0 (75 bar at 20° C) daN	F0 (100 bar at 20° C) daN	
	mm	mm	mm	mm	mm	mm	mm	cm ³	cm ²	GR	BU	RD	YW	~Kg
3L B01A (GR/BU ...)	10	43,7	26,92	52,5	35	23	≥ 19	10,3	5,06	125	255	380	505	0,48
3L B02A (GR/BU ...)	13	50	29,97	59,6	43	29		14,0	6,95	175	350	520	695	0,69
3L B03A (GR/BU ...)	16	53,2	31,75	61,2	58	40		21,2	11,59	290	580	870	1160	1,11
3L B04A (GR/BU ...)	20	59,5	33,53	71,8	67	48		25,3	13,85	345	695	1040	1390	1,14
3L B05A (GR/BU ...)	25	69,1	40,64	81,2	81	60		34,4	18,85	470	940	1410	1880	1,60
3L B06A (GR/BU ...)	32													1,55
3L B07A (GR/BU ...)	38													
3L B08A (GR/BU ...)	40													

SPM = Recommended min. amount for larger size and max amount for smaller size

S = Piston seal area V0 = Initial gas volume F0 = Initial force



The stripper head can be supplied separately from NITRO STRIP unit



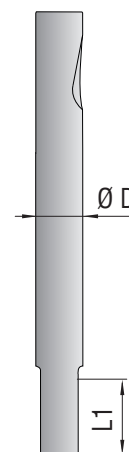
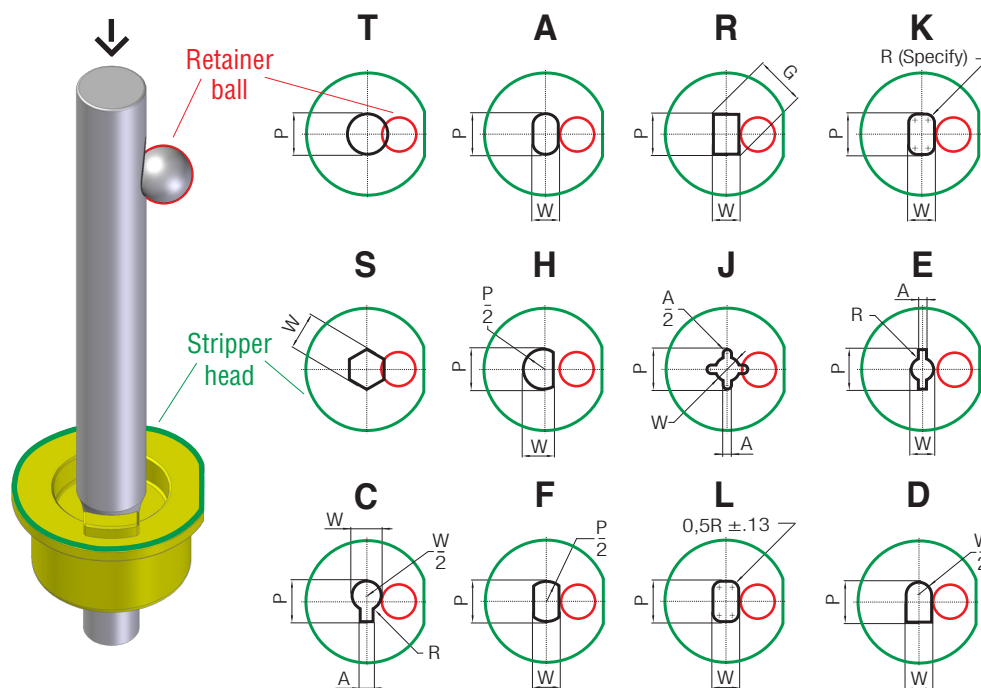
It can be supplied as basic model or with punch point guiding shape built-in

Geometry, size and tolerance of the built-in punch guiding shape is always referred to the nominal punch size

Radial clearance between punch and punch point guiding hole is max. 0,1 mm

Punch not included ! ⚠

Nitrogen stripper unit code	Punch Ø	Short head - type S for light and heavy duty retainers code	Long head - type L for light and heavy duty retainers code	Ø F
3L B01A	10	42 S 01	42 S 02	1,5
3L B02A	13	42 S 03	42 S 04	3
3L B03A	16			
3L B04A	20	42 S 07	42 S 08	
3L B05A	25			
3L B06A	32	42 S 11	42 S 12	
3L B07A	38	42 S 13	42 S 14	
3L B08A	40			

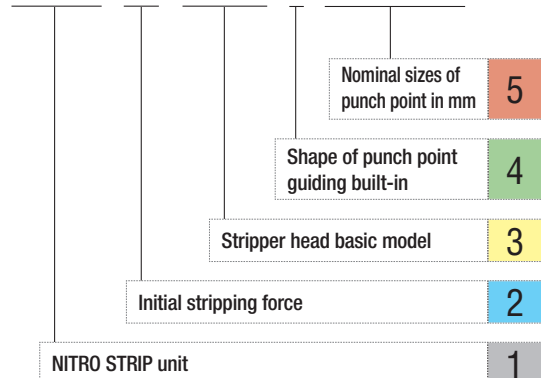


Other shapes upon request
Punch point standard tolerance

Round P $+0,01$
 $-0,00$ $\odot$ 0,01 P on D
Shape P, W $\pm 0,01$ $\odot$ 0,02 P on D

HOW TO ORDER: Nitrogen stripper unit for ball-lock retainer

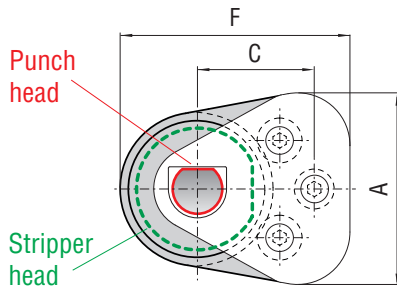
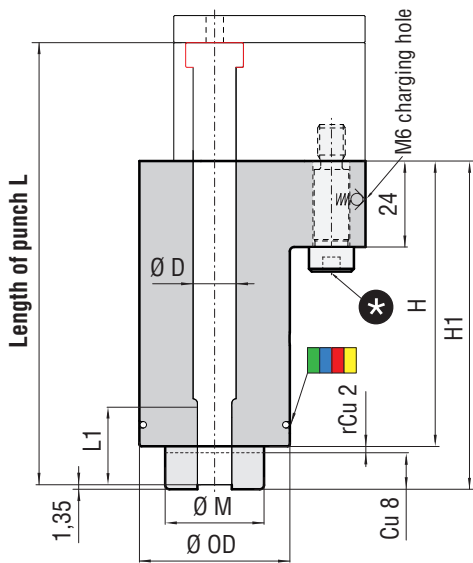
3L B07A YW 42 S 13 A P=... W=...



Ordering options

NITRO STRIP unit only	1 + 2	Code example 3L B07 YW
NITRO STRIP unit + STRIPPER HEAD basic model	1 + 2 + 3	3L B07 YW 42 S 13
NITRO STRIP unit + STRIPPER HEAD basic model + punch point guiding built-in	1 + 2 + 3 + 4 + 5	3L B07 YW 42 S 13 A P=.. W=..
STRIPPER HEAD basic model only	3	42 S 13
STRIPPER HEAD basic model + punch point guiding built-in	3 + 4 + 5	42 S 13 A P=... W=...

Short head - type S

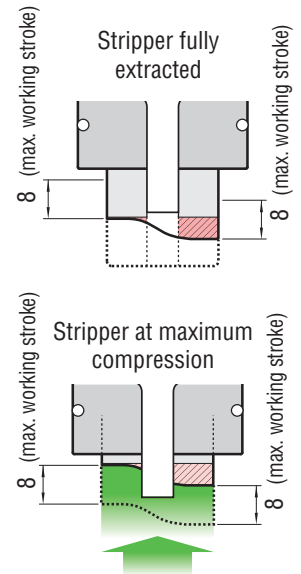
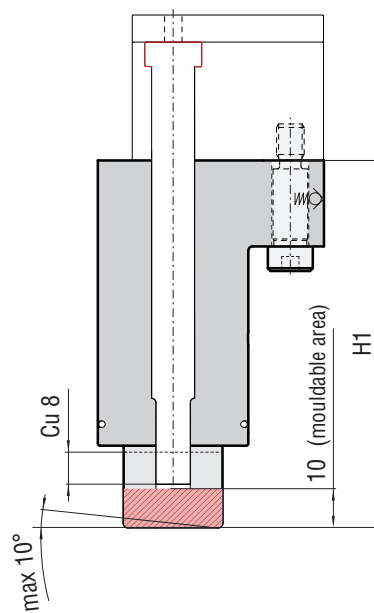


★ Ground body shoulder screw (included)
Torque force 24 Nm + Loctite 243
Spare code: 47VM8-8,5x14A



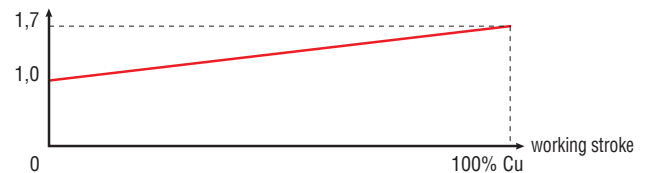
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- Final users are required always to machine the bronze - aluminum stripper head when needed before installation

Long head - type L



Retainer type	Head type	Length of punch L	H	H1
ISO 8020 Headed punch	S	100	65,5	75,5
	L			85,5

Approx. force increase coefficient



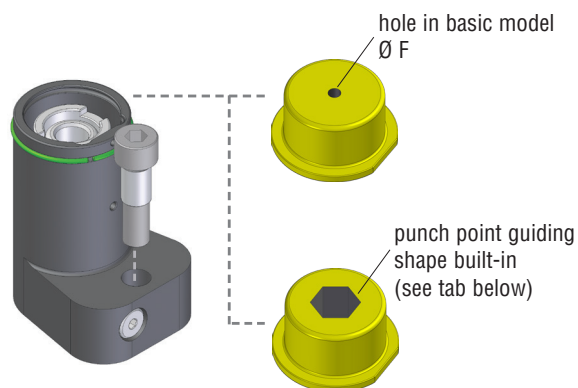
- Maximum stroke length must always be calculated from the first point of contact on the piercing area
- The NITRO STRIP unit is either available with basic stripper head (no punch point guiding shape built-in) or with punch point built-in. (See how to order)
- Always secure the NITRO STRIP on the punch retainer using thread lock (Loctite 243) and tightening torque 24 Nm

 N ₂	°F 32 176	°C 0 80	ΔP ± 0,33 %/°C	P max 100 bar 1450 psi	P min 20 bar 290 psi	SPM ~ 10 - 40 (at 20°C)	Max Speed 1,6 m/s		Maintenance by Special Springs
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CODE	D	A	C	F	OD	M	L1	V0	S	F0 (25 bar at 20° C) daN	F0 (50 bar at 20° C) daN	F0 (75 bar at 20° C) daN	F0 (100 bar at 20° C) daN	
	mm	mm	mm	mm	mm	mm	mm	cm ³	cm ²	GR	BU	RD	YW	~Kg
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3L B05A (GR/BU ...)	25	69,1	40,64	76,7	81	60		34,4	18,85	470	940	1410	1880	1,55
3L B06A (GR/BU ...)	32			81,2										
3L B08A (GR/BU ...)	40	76,6	43,99	91,9										

SPM = Recommended min. amount for larger size and max amount for smaller size

S = Piston seal area V0 = Initial gas volume F0 = Initial force



The stripper head can be supplied separately from NITRO STRIP unit



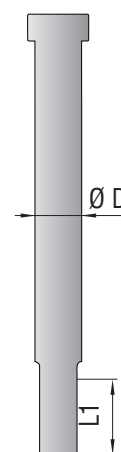
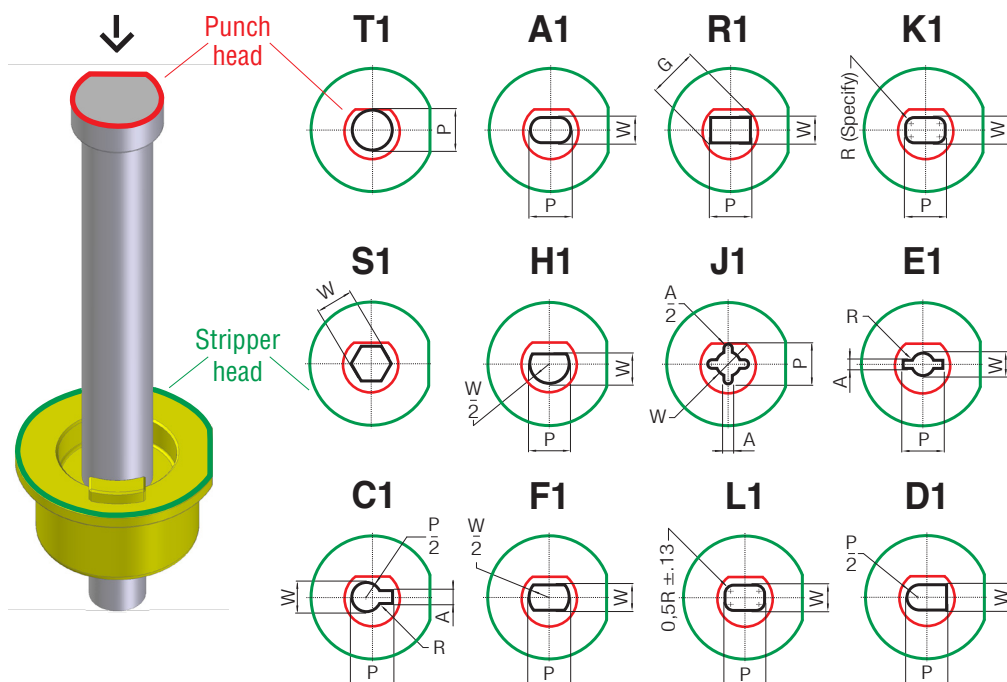
It can be supplied as basic model or with punch point guiding shape built-in

Geometry, size and tolerance of the built-in punch guiding shape is always referred to the nominal punch size

Radial clearance between punch and punch point guiding hole is max. 0,1 mm

Punch not included ! ⚠

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3L B03A	16			
3L B04A	20	42 S 07	42 S 08	
3L B05A	25			
3L B06A	32	42 S 11	42 S 12	
3L B08A	40	42 S 13	42 S 14	

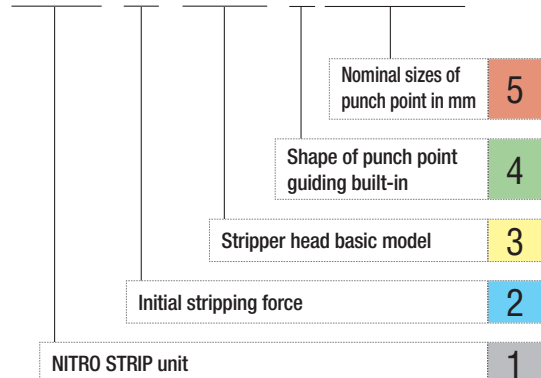


Other shapes upon request
Punch point standard tolerance

Round P $+0,01$
- 0,00 0,01 P on D
Shape P, W $\pm 0,01$ 0,02 P on D

HOW TO ORDER: Nitrogen stripper unit for ISO 8020 headed punch retainers

3L B08A YW 42 S 13 A1 P =... W =...



Ordering options		Code example
NITRO STRIP unit only	1 + 2	3L B08 YW
NITRO STRIP unit + STRIPPER HEAD basic model	1 + 2 + 3	3L B08 YW 42 S 13
NITRO STRIP unit + STRIPPER HEAD basic model + punch point guiding built-in	1 + 2 + 3 + 4 + 5	3L B08 YW 42 S 13 A1 P=.. W=..
STRIPPER HEAD basic model only	3	42 S 13
STRIPPER HEAD basic model + punch point guiding built-in	3 + 4 + 5	42 S 13 A1 P=... W=...



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