

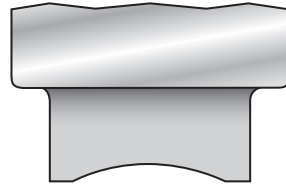
ROOFTOP



Best shear for punching at maximum tonnages.



When nibbling, bite must be 75% of punch dimension or excessive side loading will result.



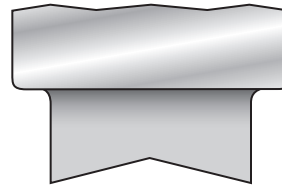
**CONCAVE OR
DOUBLE CONCAVE**



Best shear for nibbling because it inverts stresses.



Less resistant to breakage when punching at high tonnages because of inverted stresses.



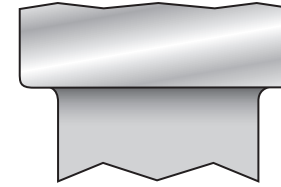
**INVERTED
ROOFTOP**



Good shear for nibbling because it inverts stresses.



More susceptible to breakage because of a sharp focal point for stresses — use great care.



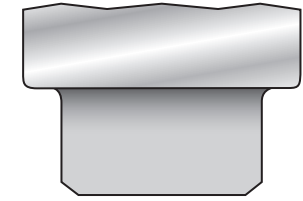
**DOUBLE
VALLEY**



Best shear for nibbling when shape is long and narrow.



Less resistant to breakage when punching at high tonnages because of inverted stresses.



JK SHEAR



A special shear that allows you to punch high strength materials with a reduced risk of breakage.



Can only be used on punches up to 1.000" (25.4mm) diameter or 'A' dimension.