



Multi Tools

FOR PRIMA POWER TURRET PUNCH PRESSES



MATE AND PRIMA POWER PARTNERSHIP

Mate is the leader in Multi Tool technology — producing complex, high-precision, drop-in and dedicated multi tools since 1987.

Prima Power and Mate have been working together to provide the best multi tools in the industry. Mate produces over 10 different multi tools for Prima Power's state-of-the-art, versatile, servo-electric punch press solutions.

PRIMA POWER CUSTOMER ADVANTAGES

Replaceable holders in Prima Power machines.

Prima Power machines can far exceed an Amada 52 station turret by simply adding multi-tools.

Multi Tools offer quick-change die carriers for different die clearance sets which reduce set up times dramatically.

Multi Tools save money — Customers only need to change out punches and strippers rather than having to buy additional canisters and guides.

Increases the number of indexable tools in a machine turret.

MULTI TOOLS ADVANTAGES

Multi Tools add more available stations to a punch press reducing set-up and changeover time.

Multi Tools provide a convenient way to quickly exchange/stage multiple punches, dies, strippers

Multi Tools can either be dedicated or a drop-in style for an auto-index station

Drop-in multi tools add more indexing stations to a punch press and allow a standard D Station to be used if needed

Multi Tools can offer constant die penetration through programming adjustments:

- For dedicated station multi tools, punches should be ground to the same length
- Mate recommends 3mm die penetration on slug-free dies

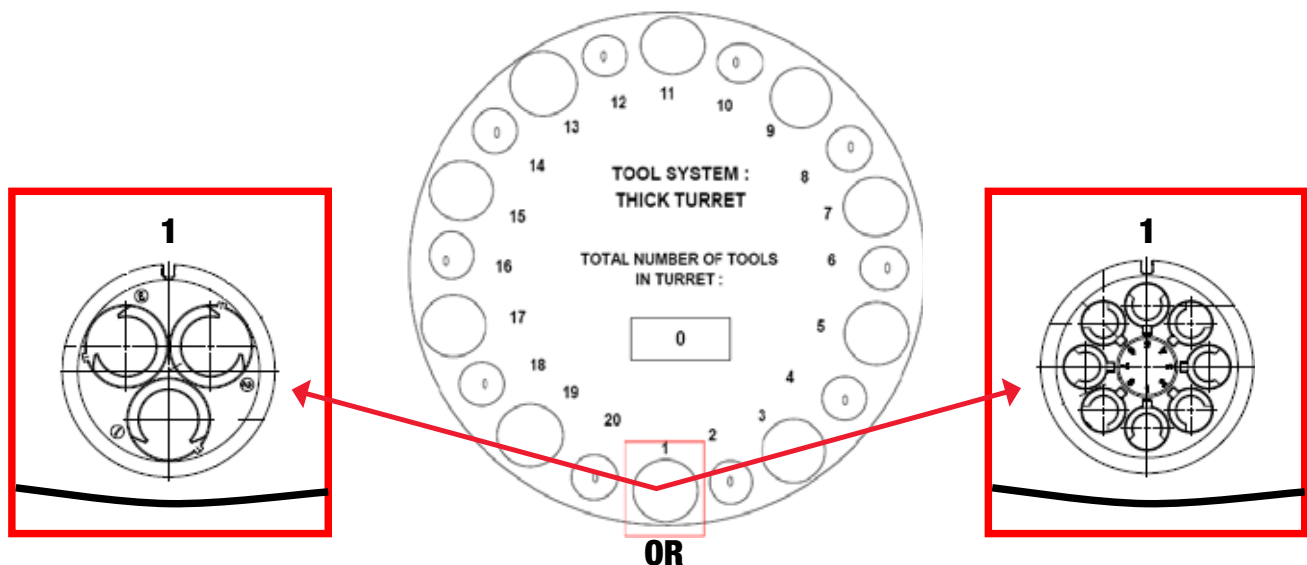
DEDICATED VS DROP-IN STYLE MULTI TOOLS:**Dedicated Style:**

- Dedicated station
- Cannot be converted to a D Station, but typically offers more punching stations
- MT8-24mm, MT10-16mm, and MT24-8mm cassettes are interchangeable without realignment

Drop-in Style:

- Converts an indexing D station to 8 or 3 "mini" stations
- Allows flexibility to change back to D Station easily

DEDICATED STYLE	DROP IN STYLE
MT4AU* MT6AU* MT8-24mm* MT10-16mm* MT24-8mm* MTH16*	Ultra® MT3BUI Ultra® MT8AUi Ultra® UMT3BUI Fully Indexable MT* Ultra® UMT8AUi Fully Indexable MT* Ultra® IMT3BUI Fully Indexable MT** Ultra® IMT8AUi Fully Indexable MT**
*iRAM machine compatible **iRAM machine compatible when machine equipped with shot pin	

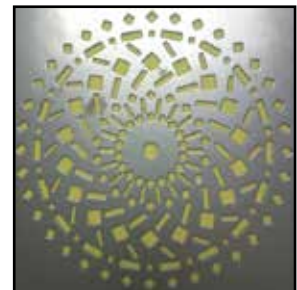
EXAMPLE OF DROP IN STYLE D STATION MULTI TOOL CONVERSION:

BENEFIT (SEE DESCRIPTIONS BELOW)	MT4AU MT6AU	MT8- 24mm	MT10- 16mm	MT24- 8mm	MTH16	UMT3BUI MT3BUI	UMT8AUI MT8AUI	IMT3BUI	IMT8AUI
STATIONS	4/6	8	10	24	16	3	8	3	8
MAX PUNCH DIAMETER OR DIAGONAL	12.7mm M4PM 15.7mm M2	24mm	16mm	8mm	4 - 16mm 12 - 8mm	31.75mm	12.7mm M4PM 15.7mm M2	31.75mm	12.7mm M4PM 15.7mm M2
INDEXABLE	MT6AU*	—	—	—	—	UMT3BUI*	UMT8AUI*	Yes	Yes
ASSEMBLY PRICE	\$\$	\$	\$	\$	\$	\$\$	\$\$	\$\$\$	\$\$\$
PUNCH, DIE, STRIPPER VALUE	••/•••	•	•	•	•	•••	•••	•••	•••
*PUNCH LIFE (MATERIAL AND GRIND LIFE)	••/•••	•	•	•	•	••/•••	••/•••	••/•••	••/•••
PUNCH 6MM MATERIAL AT MAX DIAMETER	•	••	••	••	••	•	•	•	•
FLEXIBILITY: SWAP OUT MULTI—TOOL	—	—	—	—	—	•	•	•	•
FULLY GUIDED	—	•	•	•	•	—	—	—	—
DURABILITY/LIFE	••	•	•	•	•	•••	•••	•••	•••
USES STANDARD PUNCH DIE STRIPPER	•	—	—	—	—	•	•	•	•
NIBBLING	•••	•	•	•	•	••	••	••	••
EASE OF SETUP	•••	•	•	•	•	••	••	••	••
EASE OF MAINTENANCE	•••	•	•	•	•	••	••	•	•
REDUCED SHEET MARKING	•	—	—	—	—	••	••	•••	•••

Legend: - Not Applicable • Good •• Better ••• Best ••/••• Ultra Punches available in M2 or M4PM Tool Steel
 (* For use with rotating ram.)

PRIMA POWER VS AMADA: HOW MANY TOOLS TO MAKE THIS WITHOUT IMT?

A machine such as Amada would require 80 non-indexable tools.
 An auto-indexing Prima Power machine fitted with an 8 station IMT can do it with one set of 8 tools.



BENEFIT	DESCRIPTION OF BENEFIT
STATIONS	Number of stations of each multi-tool
MAX PUNCH DIAMETER OR DIAGONAL	This is the standard maximum size punch point diameter or diagonal that can be ordered
INDEXABLE	Identifies which multi-tools can rotate the punch shapes to any angle after selecting station number
ASSEMBLY PRICE	A dot system is used to show Good, Better or Best choice for lowest price. The more dots the lower the price
PUNCH, DIE, STRIPPER VALUE	Combining tool steel options, guiding, point length, and grind life relative to price.
*PUNCH LIFE (MATERIAL AND GRIND LIFE)	The amounts listed are based on no material so material thickness used reduces this amount
PUNCH 6MM MATERIAL AT MAX DIAMETER	This category rates the ability of the multi-tool to punch material up to 6mm thick for a maximum size punch
FLEXIBILITY: SWAP OUT MULTI—TOOL	Identifies whether or not the multi-tool is easily removed for alternate use or is a dedicated station
FULLY GUIDED	The stripper opening is a precision fit with the punch point and the stripper outside diameter is a high precision fit
DURABILITY/LIFE	This refers to the material hardness levels of the punch and die holders
USES STANDARD PUNCH DIE STRIPPER	This category refers to the use of standard single station tooling vs. dedicated multi-tool tooling
NIBBLING	Rates the best multi-tools for nibbling based on length of punch and fits
EASE OF SETUP	Speed of changing out punches, dies and strippers
EASE OF MAINTENANCE	Refers to how easy it is to remove punches, dies and strippers
REDUCED SHEET MARKING	Refers to the ability of the multi-tool to hold up the inactive stations

CHOOSING THE RIGHT MULTI TOOL: CUSTOMER FLEXIBILITY

Customer needs vary greatly and there is no "one-answer" for all customers. Mate offers a broad selection to cover all customer needs.

Mate drop-in style IMT3BUi, IMT8AUi, MT3BUi, MT8AUi, UMT3BUi or UMT8AUi Ultra® Multi Tools:

- Use Ultra® or Ultra® QCT™ Punches and Strippers and Thick Turret Dies.
- IMT3BUi allows Mate MXC™ or Wilson HP punches without removing punch hardware.
- IMT3BUi allows Mate MXC™ ABS or Wilson WLS punches.
- IMT3BUi allows Mate MXC™ or Wilson HP strippers.
- UMT3BUi & UMT8AUi are used in machines with a rotating ram in an auto-indexing station.

Mate dedicated style MT4AU and MT6AU:

- Uses A station complete assemblies Original Thick Turret Style, Ultra Style or Ultra® QCT™.
- Uses dedicated multi tool station tooling but offers additional punches to increase machine capacity.
- MT4AU is a dedicated 4-station multi tool for use in iRAM machines (110mm bore).
- MT6AU works in an auto-indexing station (135mm bore).
- MT6AU is fully indexable when used in iRAM machines.

Mate dedicated style MTH16:

- Features 4 — 16mm stations and 12 — 8mm stations.
- Center spud loosens 8 stations at one time (U.S. Patent 9,233,407). Uses dedicated multi tool tooling but offers additional punches to increase machine capacity.

Punch grind life:

- Mate IMT3BUi, IMT8AUi, Ultra (MT3BUi, MT8AUi, UMT3BUi or UMT8AUi), MT6AU and MT4AU all offer length adjustable punches for increased grind life.

SPECIFICATIONS*

	MT4AU MT6AU	MT8- 24mm	MT10- 16mm	MT24- 8mm	MTH16	UMT3BUi MT3BUi	UMT8AUi MT8AUi	IMT3BUi	IMT8AUi
MAX TONNAGE LIMIT METRIC(U.S.) TONS	6.35 (7 U.S.)	9.07 (10 U.S.)	5.44 (6 U.S.)	2.72 (3 U.S.)	2.72(3 U.S.) 5.44(6 U.S.)	10.89 (12 U.S.)	5.44 (6 U.S.)	10.89 (12 U.S.)	5.44 (6 U.S.)
MAX MATERIAL RECOMMENDED	6.4	6.4	6.4	6.4	6.4	6.0	6.0	6.0	6.0
DIE PENETRATION	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0
MAX PUNCH SIZE	15.70	24.0	16.0	8.0	8.0 and 16.0	31.75	15.70	31.75	15.70
MAX DIE OPENING	16.00	24.41	16.41	8.76	16.41	33.27	16.003	32.27	16.00
GRIND LIFE MAX (PUNCH)	9.90	2.00**	3.50**	1.00**	2.0 for 8mm* 4.50 for 16mm*	9.90	9.90	9.90	9.90
GRIND LIFE MAX (DIE)	3.00	1.50	1.50	2.00	2.00	3.00	3.00	3.00	3.00
CONSTANT DIE PENETRATION	Yes	No	No	No	No	Yes	Yes	Yes	Yes

Part numbers beginning with "MT" indicate number of stations and size. Example: MT24-8mm has 8mm stations.

Max Material: Must adhere to thickness to point size ratio (1.5:1 for Alum, 1.0:1 for Mild, 0.75:1 for Stainless).

*Punch Grind Life is increased by 1mm in the MTH16 because the distance between the punch and stripper is less than the MT10-16mm and MT24-8mm.

**These values are based on punch tip engagement with stripper thickness and MT fit tolerances. For MT24-8mm, this value is considered a safe amount but depending on the particular MT24-8mm, up to 1.50mm may be achieved. To be safe, tip MT upside down and check that the punches are engaged with the stripper.

MULTI TOOL CHOICES FOR NIBBLING

BEST:

MT6AU and MT4AU offer keyed long guided punches when using Thick Turret Original Style Guide and can be fully guided with tight clearance on stripper opening on closed-end guides.

BETTER:

IMT (MT3IRMATE or MT8IRMATE in NExpress) offer hardened guides, keyed long guided punches, full indexability and has optional fully guided strippers (IMT ONLY).

UMT3BUi and UMT8AUi offer hardened guides, keyed long guided punches and full indexability.

MT3BUi and MT8AUi offer hardened guides and keyed long guided punches.

GOOD:

MT8-24mm, MT10-16mm, MT24-8mm, MTH16 guides made of softer material and has non-keyed short punches which will induce wear on strippers and pockets. It can be used for nibbling, but life is reduced. A plus is that the strippers are precision fit.

Budget an additional ~€/\$1000 per year for additional multi-tool wear and tear if nibbling with multi-tools.

DEDICATED STYLE FOR iRAM MACHINES ONLY

MATE MT4AU™

110MM BORE – FIXED STATION

FEATURES

Uses size A (12.7 mm) Original Style, UltraTEC® or Ultra® QCT™ tooling

of stations: 4

Max Punch Size:

- Original Style: 13.08mm
- Ultra: 12.70mm in M4PM and 15.70mm in M2
- Ultra® QCT™: 15.44mm

Punch Tool Steel: M2 for Original Style, M2 or M4PM for UltraTEC® and M4PM for Ultra® QCT™

Die: Max station opening — 16.0mm

Guides: Surface hardened

Upper Holder: Semi-hard

Uses drop-in Thick Turret or Ultra A station assemblies



ADVANTAGES

No disassembly of single station tooling
Adjustable length = more grind life
Punch retention for reduced sheet marking
Standard A Punches, Dies and Strippers

Easy change die carrier
Quick change punch assembly
Variable stripping force (Light, Standard, HD)

SPECIFICATIONS

- Punch point range: .80mm (0.020") to 15.70mm (0.618")
- Tooling: Original Style, UltraTEC® or Ultra® QCT™ 1/2" A station punches, strippers, and Slug Free® dies
- Maximum tonnage: U.S. 7 Tons - 70 kN - 6.35 Metric Tons
- Max material thickness: 6.4mm (.292")

DEDICATED STYLE

MATE MT6AU™

135MM BORE – AUTO INDEX STATION

FEATURES

Fully indexable in iRAM machines

Uses size A (12.7 mm) Original Style, UltraTEC® or Ultra® QCT™ tooling

of stations: 6

Max Punch Size:

- Original Style: 13.08mm
- Ultra: 12.70mm in M4PM and 15.70mm in M2
- Ultra® QCT™: 15.44mm

Punch Tool Steel: M2 for Original Style, M2 or M4PM for UltraTEC® and M4PM for Ultra® QCT™

Die: Max station opening — 16.0mm

Guides: Surface hardened

Upper Holder: Semi-hard

Uses drop-in Thick Turret or Ultra A station assemblies



ADVANTAGES

No disassembly of single station tooling
Adjustable length = more grind life
Punch retention for reduced sheet marking

Standard A Punches, Dies and Strippers
Quick change punch assembly
Variable stripping force (Light, Standard, HD)

SPECIFICATIONS

- Punch point range: .80mm (0.020") to 15.70mm (0.618")
- Tooling: Original Style, UltraTEC® or Ultra® QCT™ 1/2" A station punches, strippers, and Slug Free® dies
- Maximum tonnage: U.S. 7 Tons - 70 kN - 6.35 Metric Tons
- Max material thickness: 6.4mm (.292")

DEDICATED STYLE

8 STATION DEDICATED MULTI-TOOL (MT8-24mm)

135MM BORE – AUTO INDEX STATION

FEATURES

of stations: 8 Stations
 Max Punch Size: 24mm
 Guides: Semi-Hard
 MT™ punch, die, and stripper
 Auto-tool lubrication
 Interchangeable with MT10-16mm and MT24-8mm cassettes without station realignment

ADVANTAGES

Large point size
 Low assembly price
 Fully guided

SPECIFICATIONS

Punch point range: .80mm (0.020") to 24.00mm (0.945")
 Tooling: MT™ 24mm punches, strippers, and Slug Free® dies
 Maximum tonnage: U.S. 10 Tons - 99.64 kN - 9.07 Metric Tons
 Max material thickness: 6.4mm (.292")



DEDICATED STYLE

10 STATION DEDICATED MULTI-TOOL (MT10-16mm)

135MM BORE – AUTO INDEX STATION

FEATURES

of stations: 10 Stations
 Max Punch Size: 16mm
 Guides: Semi-Hard
 MT™ punch, die, and stripper
 Auto-tool lubrication
 Interchangeable with MT8-24mm and MT24-8mm cassettes without station realignment

ADVANTAGES

Large diagonal for 10 stations
 Low assembly price
 Fully guided

SPECIFICATIONS

Punch point range: .80mm (0.020") to 16.00mm (0.630")
 Tooling: MT™ 16mm punches, strippers, and Slug Free® dies
 Maximum tonnage: U.S. 6 Tons - 54 kN - 5.44 Metric Tons
 Max material thickness: 6.4mm (.292")



DEDICATED STYLE

24 STATION DEDICATED MULTI TOOL (MT24-8mm) 135MM BORE – AUTO INDEX STATION

FEATURES

- # of stations: 24 stations
- Max Punch Size: 8mm
- Guides: Semi-Hard
- MT™ punch, die, and stripper
- Auto-tool lubrication
- Interchangeable with MT10-16mm and MT8-24mm cassettes without station realignment

ADVANTAGES

- Lots of stations
- Good for many rounds but shapes available
- Low assembly price
- Fully guided

SPECIFICATIONS

- Punch point range: .80mm (0.020") to 8.00mm (0.315")
- Tooling: MT™ 8mm punches, strippers, and Slug Free® dies
- Maximum tonnage: U.S. 3 Tons - 29.89 kN - 2.72 Metric Tons
- Max material thickness: 6.4mm (.292")



DEDICATED HYBRID STYLE

16 STATION HYBRID MULTI TOOL (MTH16) 135MM BORE – AUTO INDEX STATION

FEATURES

- # of stations: 16 (12 – 8mm and 4 – 16mm)
- Max Punch Size: 8mm and 16mm
- Guides: Semi-Hard
- MT™ punch, die and stripper
- Auto-tool lubrication
- Not interchangeable with other dedicated multi tools without realignment

ADVANTAGES

- Lots of stations
- Good for many rounds but shapes available
- Low assembly price
- Fully guided
- Quick-change dies and die carrier
- Multiple tooling sizes in one unit

SPECIFICATIONS

- Punch point range: .80mm (0.020") to 16.00mm (0.630")
- Tooling: MT™ 8mm & 16mm punches, strippers, and Slug Free® dies
- Maximum tonnage: 8mm stations — U.S. 3 Tons - 29.89 kN - 2.72 Metric Tons
16mm stations — U.S. 6 Tons - 54 kN - 5.44 Metric Tons
- Max material thickness: 6.4mm (.292")



*For patent information see page 11.

DROP IN STYLE **FOR NON-IRAM MACHINES**

8 STATION ULTRA® MULTI TOOL (MT8AUi)

135MM BORE – AUTO INDEX STATION

FEATURES:

of stations: 8 — A stations

Max Punch Size:

Ultra® A: 12.70mm in M4PM or 15.70mm in M2

Ultra® QCT™ A: 15.44mm

Works on machines with or without side shot pin design

Auto-tool lubrication

ADVANTAGES

Allows easy access to each punch by simply rotating lock collar

Offers multiple angle settings on some stations

Uses existing Ultra punches and strippers and Thick Turret dies

Punch retention to reduce sheet marking

Fully hardened guides with grease-grooves

Fits in D station

SPECIFICATIONS:

Punch point range: .80mm (0.020") to 15.70mm (0.618")

Tooling: Ultra TEC® & Ultra® QCT™ 1-1/4" A station punches, strippers, and Slug Free® dies

Maximum tonnage: U.S. 6 Tons - 54 kN - 5.44 Metric Tons

Max material thickness: 6mm (.236")

Achieved angles: Station 1, 3, 5, 7: Rounds Only

Station 2, 4, 6, 8: 0°, 90°, 225°



3 STATION ULTRA® MULTI TOOL (MT3BUi)

135MM BORE – AUTO INDEX STATION

FEATURES:

of stations: 3 — B stations

Max Punch Size:

Ultra® B: 31.75mm in M4PM or M2

Ultra® QCT™ B: 31.75mm

Works on machines with or without side shot pin design

Auto-tool lubrication

ADVANTAGES

Allows easy access to each punch by simply rotating lock collar

Offers multiple angle settings on some stations

Uses existing Ultra punches and strippers and Thick Turret dies

Punch retention to reduce sheet marking

Fully hardened guides with grease-grooves

Fits in D station

SPECIFICATIONS:

Punch point range: .80mm (0.020") to 31.75mm (1.250")

Tooling: Ultra TEC® & Ultra® QCT™ 1-1/4" B station punches, strippers, and Slug Free® dies

Maximum tonnage: U.S. 12 Tons - 107 kN - 10.89 Metric Tons

Max material thickness: 6mm (.236")

Achieved angles: Each station: 0°, 45°, 90°



*For patent information see page 11.

DROP IN STYLE

FOR iRAM MACHINES ONLY

8 STATION FULLY INDEXABLE ULTRA® UMT™ MULTI TOOL (UMT8AUi)

135MM BORE – AUTO INDEX STATION

FEATURES

- # of stations: 8 — A stations
- Max Punch Size:
 - Ultra® A: 12.70mm in M4PM or 15.70mm in M2
 - Ultra® QCT™ A: 15.44mm

Works on machines with or without side shot pin design
Auto-tool lubrication

ADVANTAGES

- Allows easy access to each punch by simply rotating lock collar
- Fully indexable
- Uses existing Ultra punches and strippers and Thick Turret dies
- Punch retention to reduce sheet marking
- Fully hardened guides with grease-grooves
- Fits in D station

SPECIFICATIONS

- Punch point range: .80mm (0.020") to 15.70mm (0.618")
- Tooling: Ultra TEC® & Ultra® QCT™ 1/2" A station punches, strippers, and Slug Free® dies
- Maximum tonnage: U.S. 6 Tons - 54 kN - 5.44 Metric Tons
- Max material thickness: 6mm (.236")
- Achieved angles:
 - Station 1: 90°
 - (if not in a rotating ram machine) Station 2: 135°
 - Station 3: 180°
 - Station 4: 225°
 - Station 5: 300°
 - Station 6: 315°
 - Station 7: 0°
 - Station 8: 45°



3 STATION FULLY INDEXABLE ULTRA® UMT™ MULTI TOOL (UMT3BUi)

135MM BORE – AUTO INDEX STATION

FEATURES

- # of stations: 3 — B stations
- Max Punch Size:
 - Ultra® B: 31.75mm in M4PM or M2
 - Ultra® QCT™ B: 31.75mm

Works on machines with or without side shot pin design
Auto-tool lubrication

ADVANTAGES

- Allows easy access to each punch by simply rotating lock collar
- Fully indexable
- Uses existing Ultra punches and strippers and Thick Turret dies
- Punch retention to reduce sheet marking
- Fully hardened guides with grease-grooves
- Fits in D station

SPECIFICATIONS

- Punch point range: .80mm (0.020") to 31.75mm (1.250")
- Tooling: Ultra TEC® & Ultra® QCT™ 1-1/4" B station punches, strippers, and Slug Free® dies
- Maximum tonnage: U.S. 12 Tons - 107 kN - 10.89 Metric Tons
- Max material thickness: 6mm (.236")
- Achieved angles:
 - Station 1: 90°
 - (if not in a rotating ram machine) Station 2: 180°
 - Station 3: 0°



*For patent information see page 11.

DROP IN STYLE

FOR ALL MACHINES WITH SHOT PIN

8 STATION FULLY INDEXABLE ULTRA® IMT™ MULTI TOOL (IMT8AUi)

135MM BORE – AUTO INDEX STATION

FEATURES

of stations: 8 — A stations

Max Punch Size:

Ultra® A: 12.70mm in M4PM or 15.70mm in M2

Ultra® QCT™ A: 15.44mm

Works on machines with side shot pin design

Auto-tool lubrication

ADVANTAGES

Each station can rotate to any angle setting

Uses existing Ultra punches and strippers and Thick Turret dies

Can be upgraded to use Fully Guided strippers

Tool-less punch removal

Punch Retention, dedicated stripper option for reduced sheet marking

Fully hardened guides with grease-grooves

Fits in D station

SPECIFICATIONS:

Punch point range: .80mm (0.020") to 15.70mm (0.618")

Tooling: Ultra TEC® & Ultra® QCT™ 1/2" A station punches, strippers, and Slug Free® dies

Maximum tonnage: U.S. 6 Tons - 54 kN - 5.44 Metric Tons

Max material thickness: 6mm (.236")



3 STATION FULLY INDEXABLE ULTRA® IMT™ MULTI TOOL (IMT3BUi)

135MM BORE – AUTO INDEX STATION

FEATURES

of stations: 3 — B stations

Max Punch Size:

Ultra® B: 31.75mm in M4PM or M2

Ultra® QCT™ B: 31.75mm

Works on machines with side shot pin design

Auto-tool lubrication

ADVANTAGES

Each station can rotate to any angle setting

B station: Allows MXC or HP Punches

Uses existing Ultra punches and strippers and Thick Turret dies

Can be upgraded to use Fully Guided strippers

Tool-less punch removal

Punch Retention, dedicated stripper option for reduced sheet marking

Fully hardened guides with grease-grooves

Fits in D station

SPECIFICATIONS

Punch point range: .80mm (0.020") to 31.75mm (1.250")

Tooling: Ultra TEC® & Ultra® QCT™ 1-1/4" B station punches, strippers, and Slug Free® dies

Maximum tonnage: U.S. 12 Tons - 107 kN - 10.89 Metric Tons

Max material thickness: 6mm (.236")



*For patent information see page 11.



MATE PRECISION TOOLING GLOBAL COVERAGE

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