PNC

NUMBER CRUNCHER®

Automated stamping for part identification

Series PNC44
with non-spherical
mounting bracket

Series PNC55
with PS(R) option

Series PNC66

ISO 9001
REGISTERED
Quality Management
System Certified

PNC06A

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MAC Distributor Network

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SOLUTIONS FOR INDUSTRIAL AUTOMATION

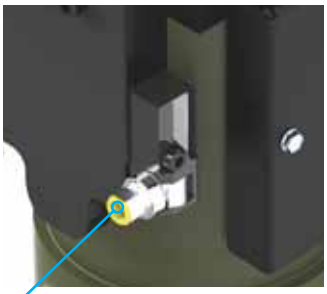
www.phdinc.com

PNC NUMBER® CRUNCHER

Automated stamping for part identification

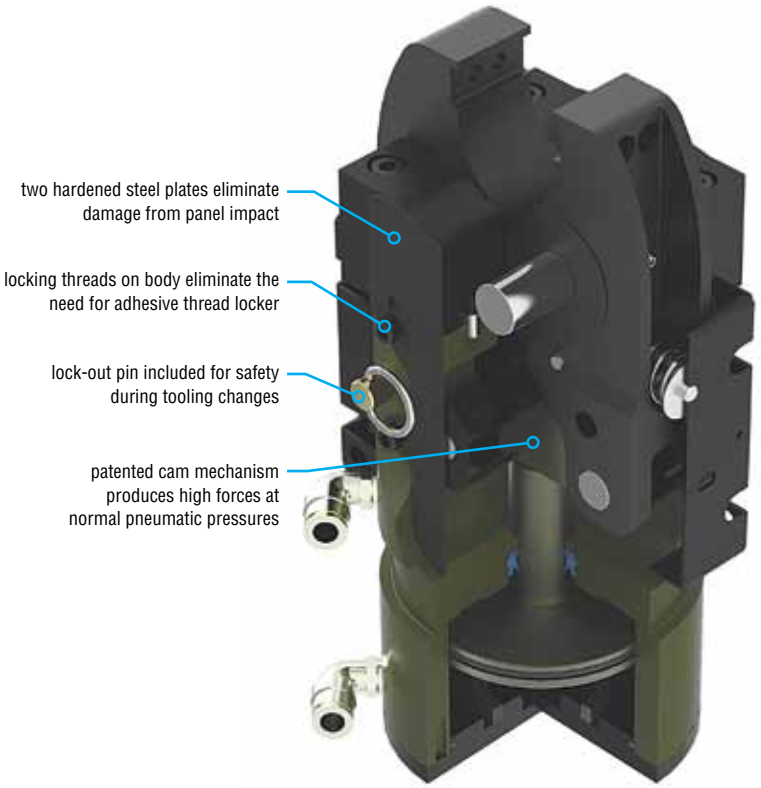
Major Benefits

- Provides cost-effective solution for identification stamping, staking, crimping, and forming.
- High clamp force produces characters in draw quality steel at only 70 psi [4.8 bar]
- Eliminates downtime associated with changing or replacing characters
- Three sizes available to fit your application requirements
- Quiet operation



optional switches allow for open and close sensing

welding slag shield option protects internal mechanisms from flying sparks and debris



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BOLT-ON TOOLING SOLUTIONS FOR PNC APPLICATIONS

Series PNC Clamps are more than part stamping/identification equipment for the automotive market. With custom tooling, they are cost-effective solutions to your stamping, staking, and crimping applications. Contact your PHD distributor for more information.

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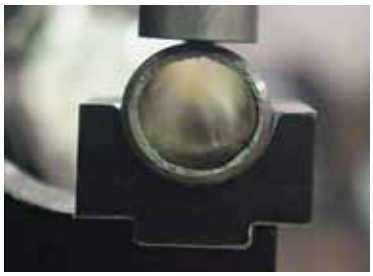
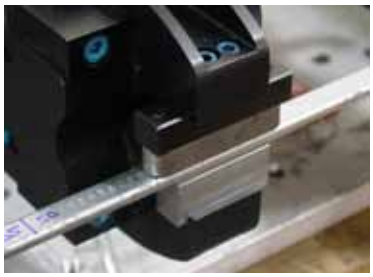
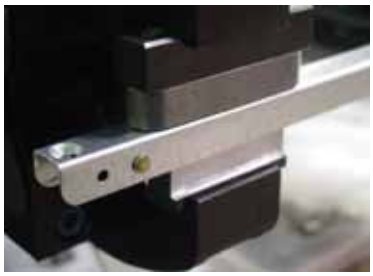
Stamping

Customer designed tooling allows for brand and size stamping in hex wrenches.



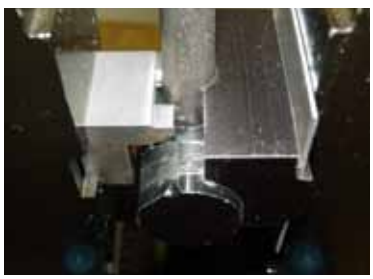
Tooling created or adapted to accept many shapes of parts in many different sizes.





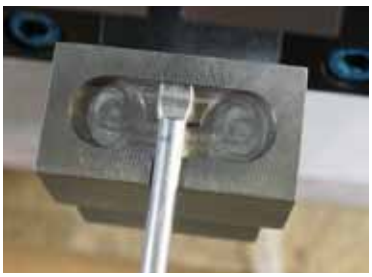
Stamping U-channels with modified anvils and standard character tooling.

Staking



Specially designed tooling used to stake handles

Crimping



Pairs of custom anvils used to crimp end of solid steel wire

Crimping a copper ferrule onto nylon wire via specialized jaw tooling

ORDERING DATA: SERIES PNC CLAMPS

TO ORDER SPECIFY:
Model, Unit Size, Mounting, Design No.,
Jaw Option, Jaw Opening, and Options.

MODEL

UNIT SIZE (with Total Clamp Force)
- 44 - ≤ 9000 lb [40 kN]
- 55 - ≤ 15000 lb [66.7 kN]
- 55 (w/B01) - ≤ 25400 lb [113 kN]
- 66 - ≤ 48330 lb [215 kN]

JAW OPTIONS - JAW A

JAW STYLE OPTION	JAW OPENING
S - Standard Jaw (to accept Tip Kits) A - Jaw to accept automatic numbering head (PNC66 only)	16 - 16° Opening

JAW OPTIONS - JAW B

JAW STYLE OPTION	JAW OPENING
S - Standard Jaw (to accept Tip Kits) A - Jaw to accept automatic numbering head (PNC66 only)	16 - 16° Opening

QUICK CHANGE TOOLING JAW (Jaw Option S only)
- BLANK - None
- JA01 - Quick change slot on jaw A
- JB01 - Quick change slot on jaw B

PNC 55 P - 1 - S16 - S16 - B01 - LAA - G01 - Jx01 - Pxxxx

MOUNTING
- N - No Mounting
- P - Rear Mounting Plate
- R - 1 inch [25.4 mm] Non-Spherical Mounting Bracket (PNC44/55 only)
- V - 1-1/4 inch [31.8 mm] Non-Spherical Mounting Bracket (PNC44/55 only)
- M - Side Mounting Plate

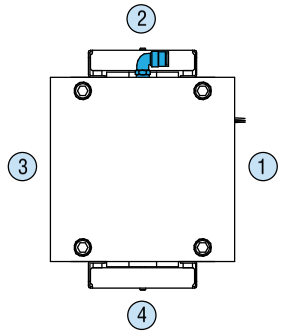
DESIGN NO.
- 1 - Imperial
- 5 - Metric (See note 1)

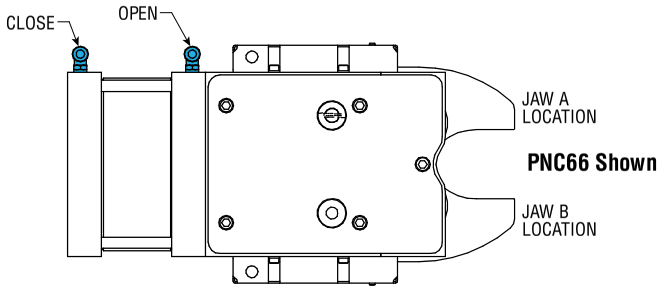
BODY OPTIONS
- B01 - Tandem Cylinder (PNC55 only)

PORT FITTINGS (BOTH PORTS)
- BLANK - None
- LAA - 90° Swivel Fitting

PROTECTIVE COVER
- BLANK - None
- G01 - Welding Slag Shields (PNC55/66 only)

NOTE:
1) Metric units have metric ports.





PNC66 Shown

POSITION SENSOR OPTION CODE

P S 1 D 2

HOUSING OPTION
- P - Positional Sensing

SENSING OPTION
- S - Standard
- R - Reversed

SWITCH HOUSING POSITION
- 1 - Position 1
- 3 - Position 3

AMPLIFIER POSITION
- 2 - Position 2
- 4 - Position 4

SWITCH OPTION
- N - No Switch
- A - 5-Pin AC/DC Switch (Turck)
- D - 4-Pin PNP DC Switch (P + F)
- E - 4-Pin PNP DC Switch (Turck)
- F - 4-Pin PNP DC Switch (Efector)
- H - 4-Pin NPN DC Switch (P + F)
- J - 4-Pin NPN DC Switch (Turck)

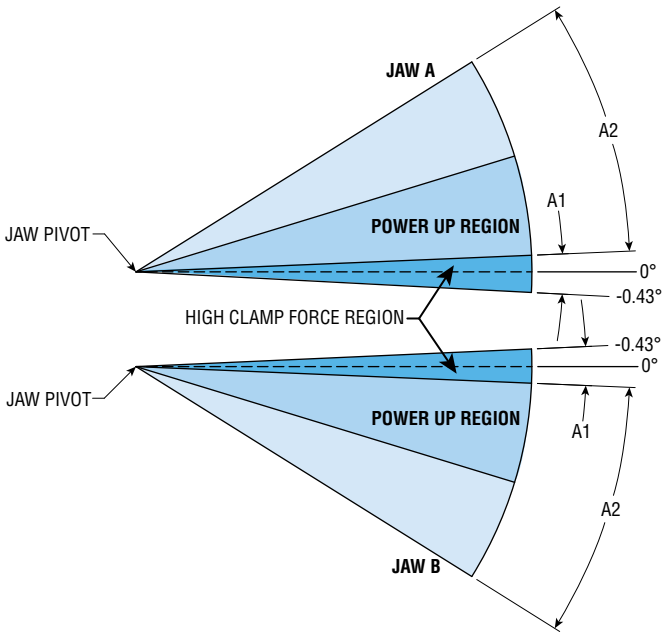
SPECIFICATIONS	PNC44/55	PNC66
WORKING PRESSURE	30 psi min - 100 psi max* [2 bar min - 7 bar max]	30 psi min - 87 psi max [2 bar min - 6 bar max]
BODY	Hardcoat Aluminum	
JAWS	Steel	
SEALS	Bidirectional Piston Seal Lip Type Rod Seal with Integral Rod Wiper	Lip Seal & Wear Ring on Piston Lip Type Rod Seal Rod Wiper
LUBRICATION	Permanent for Non-Lube Air	
OPERATING TEMPERATURE	-20° to 180°F [-30° to 82°C]	

*90 psi max [6.2 bar max] for B01 option

MODEL	UNIT WEIGHT		TOTAL CLAMP FORCE AT 87 psi [6 bar]		CLOSE OR OPEN TIME 87 psi [6 bar]	DISPLACEMENT				EFFECTIVE STAMPING RANGE				
										HIGH FORCE REGION			JAW OPENING REGION	
						OPEN		CLOSE		ANGULAR DISPLACEMENT (A1)	CLAMP FORCE FACTOR (Cf)		ANGULAR DISPLACEMENT (A2)	CLAMP FORCE FACTOR (Cf)	
	lb	kg	lb	kN	sec	in³	cm³	in³	cm³		IMPERIAL	METRIC		IMPERIAL	METRIC
PNC44	19.0	8.62	9000	40.0	0.12	19.60	321	20.87	342	1.2°	103.4	6667	14.8°	5.0	322
PNC55	22.2	10.1	15000	66.7		19.60	321	20.87	342		172.4	11117		5.0	322
PNC55-B01	27.6	12.5	25400	113.0		19.60	321	41.74	684		292.0	18833		9.0	580
PNC66N-x-S16-S16	112	50.8	48330	215.0	1.5	86.10	1411	89.55	1468	0.7°	555.52	35833	15.3°	12.80	824
PNC66N-x-A16-S16	116	52.6													

MOUNTING CODE	MOUNTING BRACKET DESCRIPTION	WEIGHT			
		PNC44/55		PNC66	
		lb	kg	lb	kg
M	Side Mounting Plate	3.0	1.4	14.4	6.53
P	Rear Mounting Plate	3.4	1.5	2.0	0.91
R	1" [25.4] Non-Spherical Mounting Bracket	2.1	1.0	—	—
V	1-1/4" [31.8] Non-Spherical Mounting Bracket	2.1	1.0	—	—

CALCULATING TOTAL CLAMP FORCE



TCF = Cf x P
TCF = Total Clamp Force, lb [N]
Cf = Clamp Force Factor
P = Working Pressure, psi [bar]

Example:
Your airline pressure: 72 psi [5 bar]

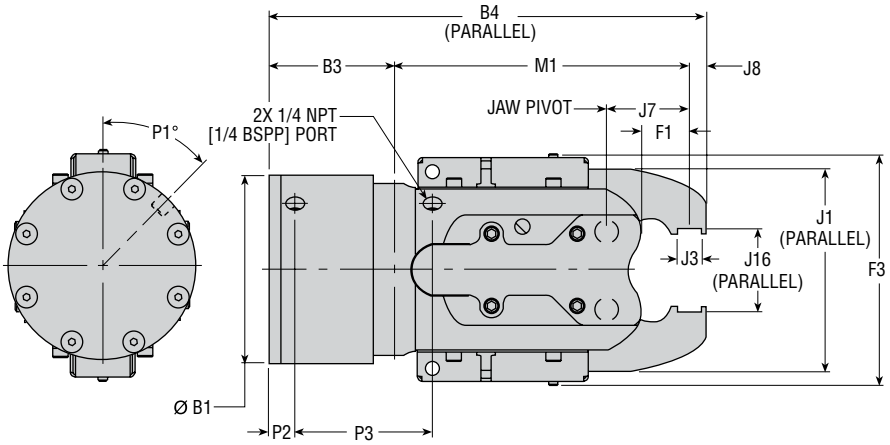
PNC55, High Force Region
TCF = 172.4 x 72 = 12,413 lb [11117 x 5 = 55,585 N]

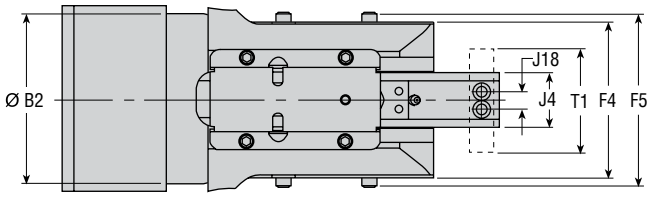
PNC66, High Force Region
TCF = 555.52 x 72 = 39,997 lb [35833 x 5 = 179,165 N]

NOTES:

1) The Series PNC Number Cruncher® is designed for external clamping only. **Do not use the PNC for internal clamping.** Consult PHD for special applications.
2) Angular measurements are in degrees.
3) To achieve maximum clamp force, custom tooling must close on the part in the high force region of jaw travel. Refer to the diagram and table for effective stamping range.

DIMENSIONS: SERIES PNC44/55 CLAMPS

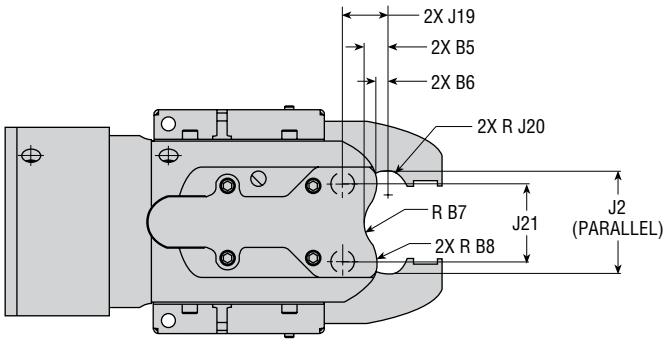




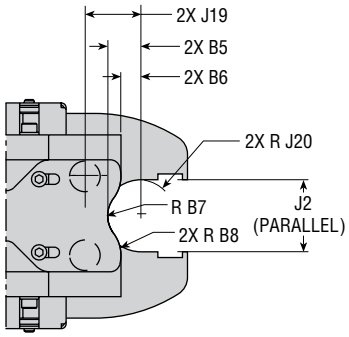
LETTER DIMENSION	MODEL NUMBER			
	PNC44		PNC55	
	in	mm	in	mm
B1	4.902	124.5	4.902	124.5
B2	4.500	114.3	4.500	114.3
B3	3.300	83.8	3.300	83.8
B4 (PARALLEL)	11.540	293.1	11.540	293.1
B5	0.590	15.0	1.078	27.4
B6	0.247	6.3	0.735	18.7
B7	0.750	19.1	0.750	19.1
B8	0.932	23.7	0.932	23.7
F1	1.269	32.2	1.269	32.2
F3	5.990	152.1	5.990	152.1
F4	4.085	103.8	4.085	103.8
F5	4.557	115.7	4.557	115.7
J1 (PARALLEL)	5.284	134.2	5.284	134.2
J2 (PARALLEL)	2.698	68.5	1.862	47.3
J3*	0.635	16.1	0.635	16.1
J4	1.440	36.6	1.440	36.6
J7	2.201	55.9	2.201	55.9
J8	0.448	11.4	0.448	11.4
J16 (PARALLEL)	2.162	54.9	2.162	54.9
J18	0.472	12.0	0.472	12.0
J19	1.179	29.9	1.667	42.3
J20	0.580	14.7	1.000	25.4
J21	2.036	51.7	2.036	51.7
P1	45°	45°	45°	45°
P2	0.682	17.3	0.682	17.3
P3	3.602	91.5	3.602	91.5
M1	7.792	197.9	7.792	197.9
T1	2.760	70.1	2.760	70.1

* TOLERANCE FOR J3 = ± 0.003 [0.076]

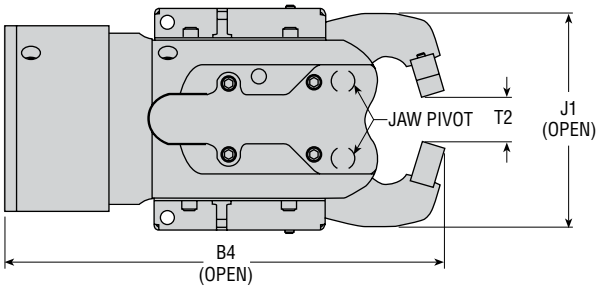
NOTE:
1) FOR MOUNTING BRACKET INFORMATION SEE PAGES 8 TO 10.



PNC44 UNITS ONLY



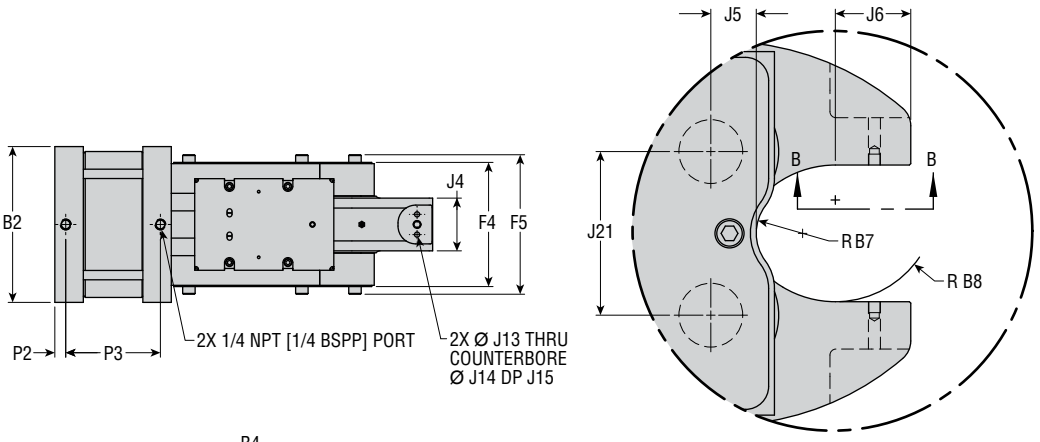
PNC55 UNITS ONLY



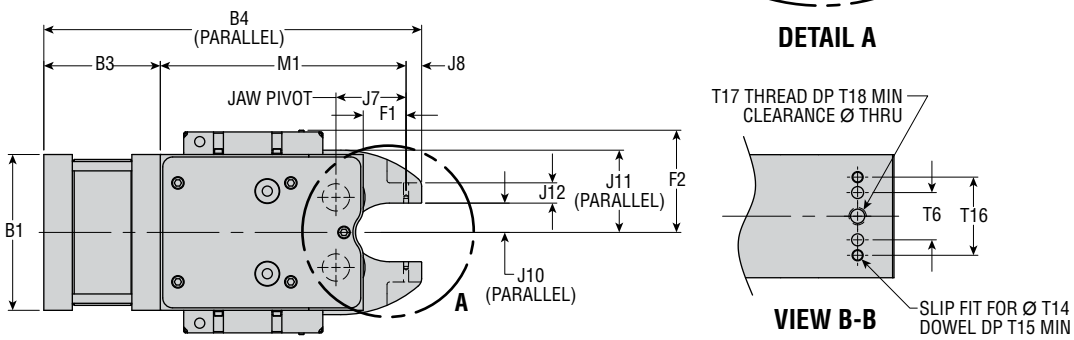
LETTER DIMENSION	MODEL NUMBER			
	PNC44		PNC55	
	in	mm	in	mm
J1 (OPEN)	5.614	142.6	5.614	142.6
T2	1.149	29.2	1.149	29.2
B4 (OPEN)	11.590	294.4	11.590	294.4

All dimensions are reference only unless specifically toleranced.

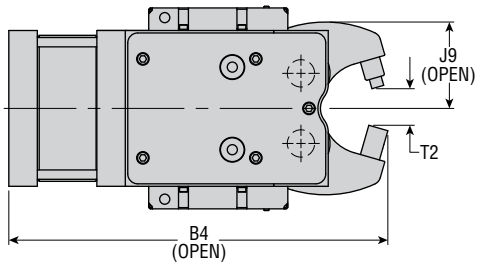
DIMENSIONS: SERIES PNC66 CLAMPS



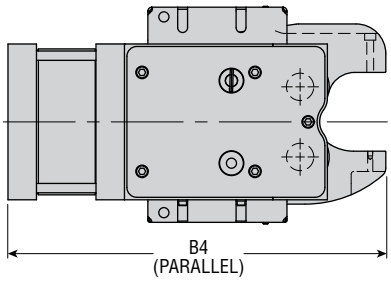
DETAIL A



VIEW B-B



PNC66-x-S16-S16



PNC66-x-A16-S16

LETTER DIM	MODEL NUMBER			
	PNC66			
	"S" STYLE JAW		"A" STYLE JAW	
	in	mm	in	mm
B1	7.874	200.0	7.874	200.0
B2	7.874	200.0	7.874	200.0
B3	5.886	149.5	5.886	149.5
B4 (PARALLEL)	19.094	485.0	19.094	485.0
B4 (OPEN)	19.155	486.5	—	—
B7	1.004	25.5	1.004	25.5
B8	2.203	56.0	1.356	34.4
F1	2.165	55.0	2.165	55.0
F2	5.164	131.2	5.842	148.4
F4	6.276	159.4	6.276	159.4
F5	7.063	179.4	7.063	179.4
J4	2.665	67.7	2.665	67.7
J5	0.984	25.0	0.984	25.0
J6	1.634	41.5	1.575	40.0
J7	3.543	90.0	3.543	90.0
J8	0.787	20.0	0.787	20.0
J9 (OPEN)	4.364	110.9	5.665	143.9
J10 (PARALLEL)	1.480	37.6	2.500	63.5
J11 (PARALLEL)	4.155	105.5	4.950	125.7
J12	1.025	26.0	1.632	41.4
J13	0.260	6.6	0.346	8.8
J14	—	—	0.561	14.2
J15	—	—	0.340	8.6
J21	3.543	90.0	3.543	90.0
M1	12.421	315.5	12.421	315.5
P2	0.551	14.0	0.551	14.0
P3	4.783	121.5	4.783	121.5
T2	1.847	46.9	—	—
T6	1.024	26.0	1.024	26.0
T14	0.236	6.0	0.236	6.0
T15	0.236	6.0	0.236	6.0
T16	1.693	43.0	1.811	46.0
T17	3/8-16 UNC		—	
T18	0.643	16.3	—	—

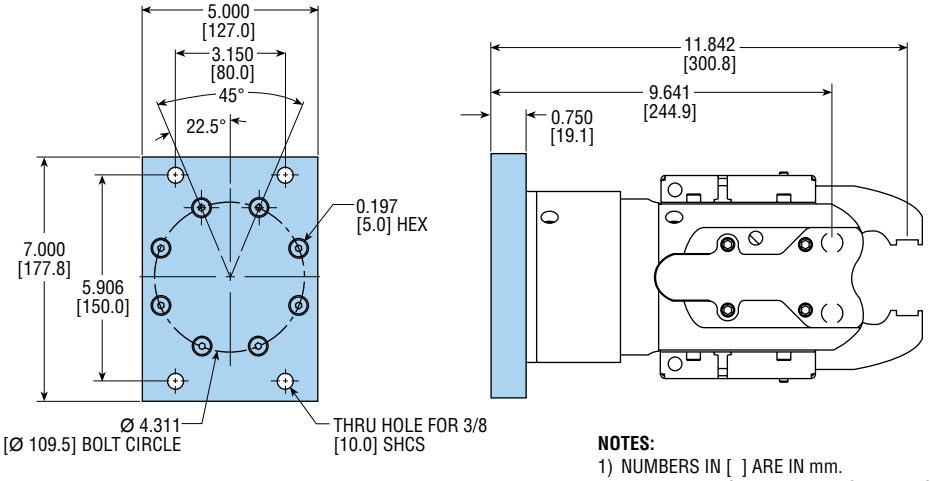
NOTE:
1) FOR MOUNTING BRACKET INFORMATION SEE PAGES 8 TO 10.

All dimensions are reference only unless specifically toleranced.

REAR MOUNTING BRACKET

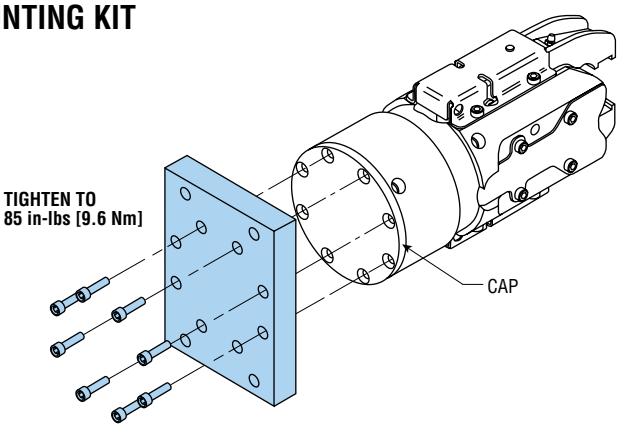
PNC44 P

PNC55 P



NOTES:
1) NUMBERS IN [ ] ARE IN mm.
2) PLATE MAY ROTATE IN 45° INCREMENTS ABOUT UNIT CENTERLINE.

REAR MOUNTING KIT

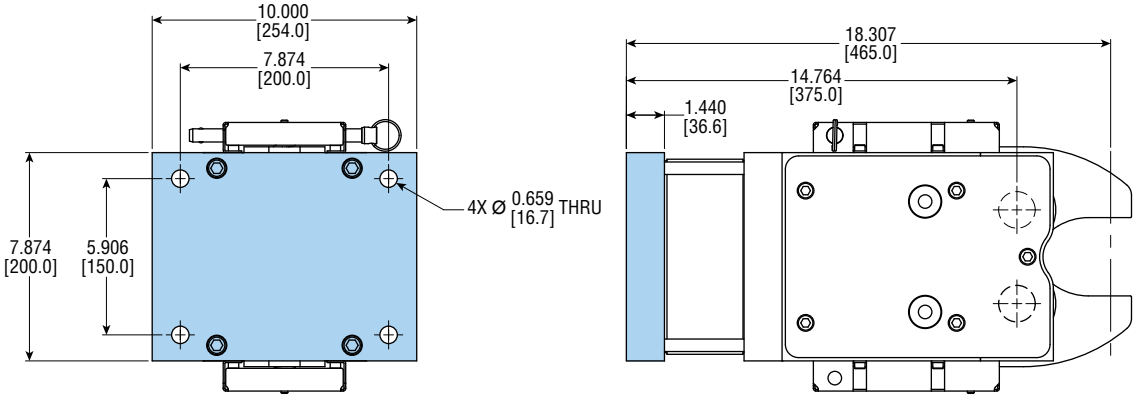


TO ORDER KIT SEPARATELY:

DESCRIPTION	KIT NUMBER
	PNC44/55P
REAR MOUNTING PLATE KIT	63099-02

NOTE: REMOVAL OF 8 CAP SFHCS IS REQUIRED BEFORE REAR MOUNTING PLATE ASSEMBLY.

PNC66 P



NOTE:
1) NUMBERS IN [ ] ARE IN mm.

All dimensions are reference only unless specifically toleranced.

MOUNTING BRACKET DIMENSIONS: SERIES PNC CLAMPS

SIDE MOUNTING BRACKET

PNC44 M

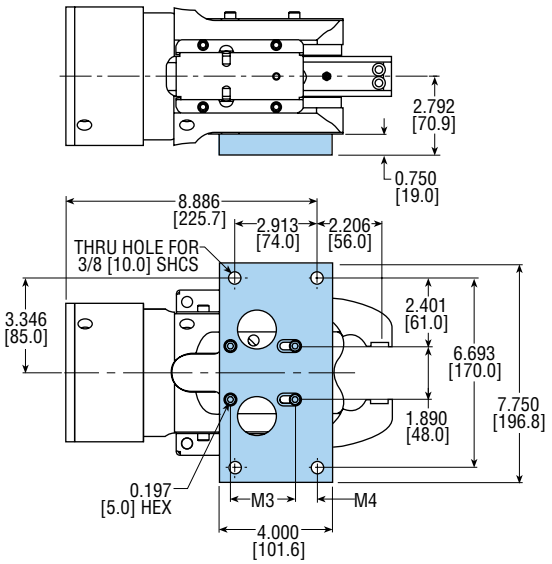
PNC55 M

When a position sensor option is ordered with PNC44/55M option, the switch housing position takes precedence over the mount position.

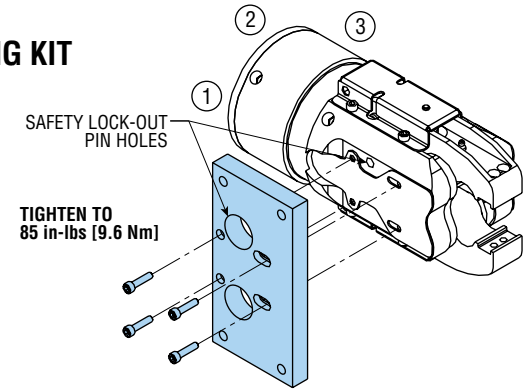
Examples:
PNC55M-1-S16-S16-LAA = Mount in Position 1
PNC55M-1-S16-S16-LAA-PS1D2 = Mount in Position 3

LETTER DIMENSION	MODEL NUMBER			
	PNC44		PNC55	
	in	mm	in	mm
M3	2.283	58.0	1.890	48.0
M4	0.783	19.9	1.176	29.9

NOTE: NUMBERS IN [ ] ARE IN mm.



SIDE MOUNTING KIT



TO ORDER KIT SEPARATELY:

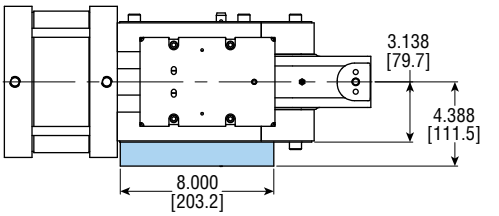
DESCRIPTION	KIT NUMBER
	PNC44/55M
SIDE MOUNTING PLATE KIT	63099-03

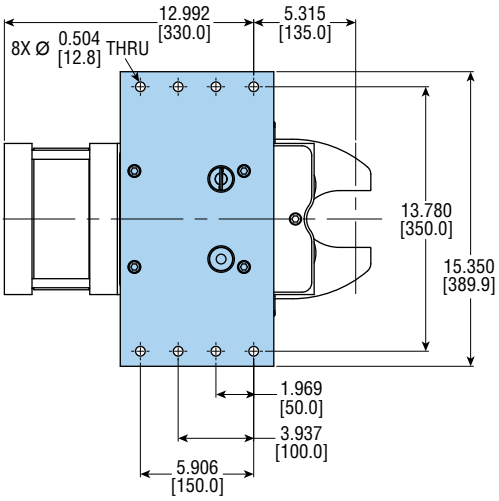
NOTE: REMOVAL OF 4 IMPACT SHCS IS REQUIRED BEFORE SIDE MOUNTING PLATE ASSEMBLY.

PNC66 M

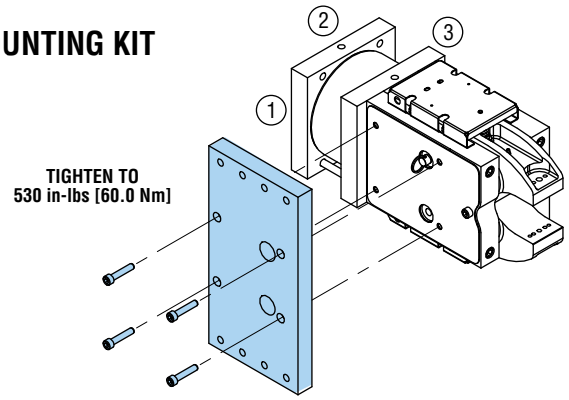
When a position sensor option is ordered with PNC66M option, the switch housing position takes precedence over the mount position.

Examples:
PNC66M-1-S16-S16-LAA = Mount in Position 1
PNC66M-1-S16-S16-LAA-PS1D2 = Mount in Position 3





SIDE MOUNTING KIT



TO ORDER KIT SEPARATELY:

DESCRIPTION	KIT NUMBER
	PNC66M
SIDE MOUNTING PLATE KIT	89022

NOTE: REMOVAL OF 4 IMPACT SHCS IS REQUIRED BEFORE SIDE MOUNTING PLATE ASSEMBLY.

All dimensions are reference only unless specifically toleranced.

MOUNTING BRACKET DIMENSIONS: SERIES PNC44/55 CLAMPS

NON-SPHERICAL MOUNTING BRACKET

PNC44 R

PNC55 R

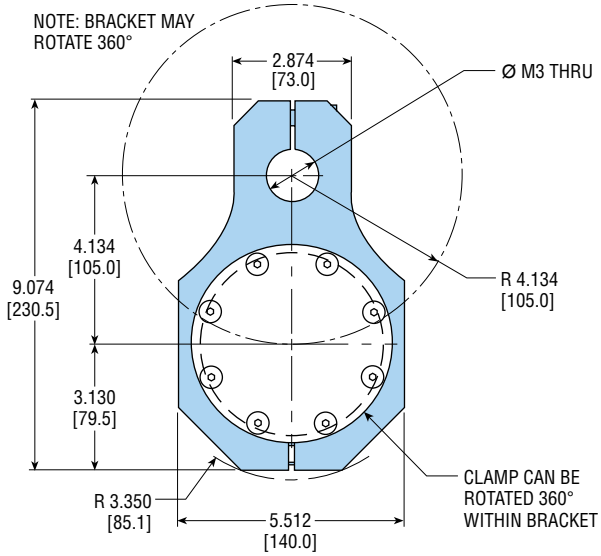
PNC44 V

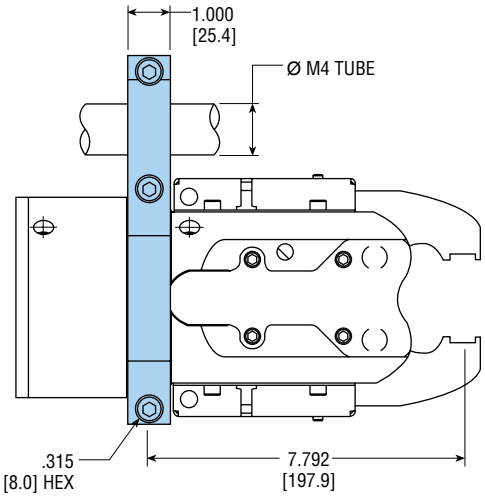
PNC55 V

LETTER DIMENSION	MODEL NUMBER			
	PNC44/55R		PNC44/55V	
	in	mm	in	mm
M3*	1.005	25.5	1.255	31.9
M4	1.000	25.4	1.250	31.8

*TOLERANCE FOR M3 = ± 0.002 [0.051]

NOTES:
1) NUMBERS IN [ ] ARE IN mm.
2) BRACKET MAY ROTATE 360° ABOUT M4 TUBE.



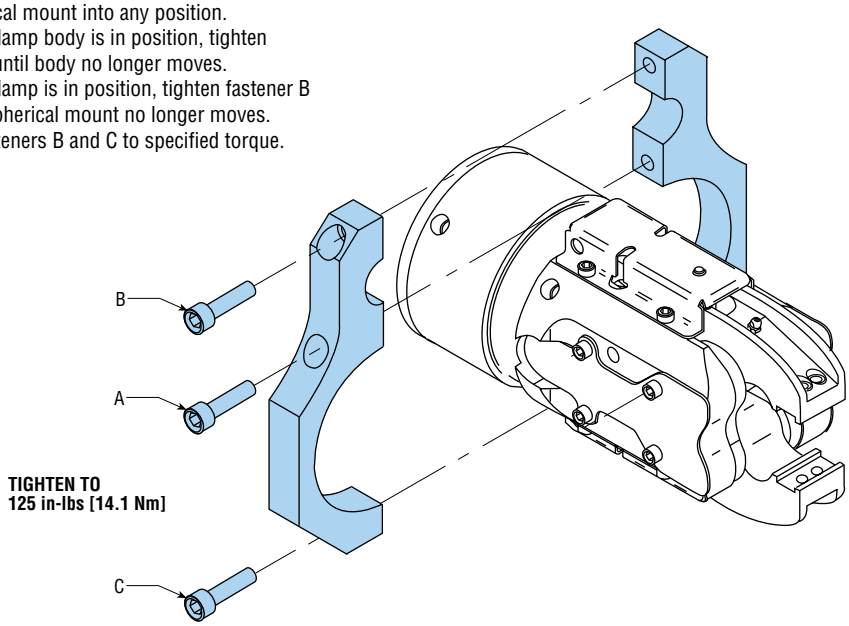


NON-SPHERICAL MOUNTING KIT

Installation Procedure:
1) Insert body between non-spherical bracket halves.
2) Insert fasteners
   A) Tighten fastener A to specified torque. This will allow for free adjustment of the clamp body and non-spherical mount into any position.
   B) When the clamp body is in position, tighten fastener C until body no longer moves.
   C) When the clamp is in position, tighten fastener B until non-spherical mount no longer moves.
   D) Tighten fasteners B and C to specified torque.

TO ORDER KIT SEPARATELY:

DESCRIPTION	KIT NUMBER	
	PNC44/55R	PNC44/55V
NON-SPHERICAL MOUNTING KIT	63099-01	63099-04



All dimensions are reference only unless specifically toleranced.

B01 TANDEM CYLINDER (PNC55 only)

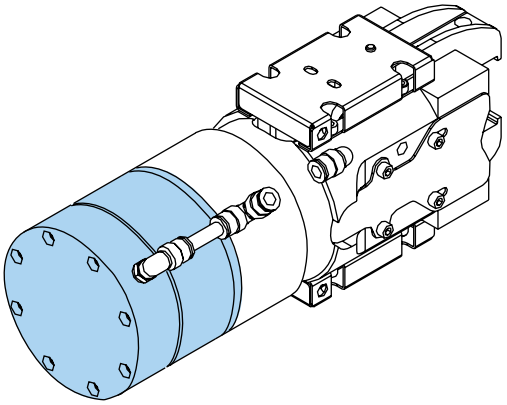
This option provides up to a 70% increase in clamp force by adding a second cylinder (tandem) on a standard PNC55 clamp. The cylinder mounts directly to the back of a PNC55 clamp body. Overall length is increased by 3.59 in [91.2 mm]. Weight is increased by 5.4 lb [2.45 kg].

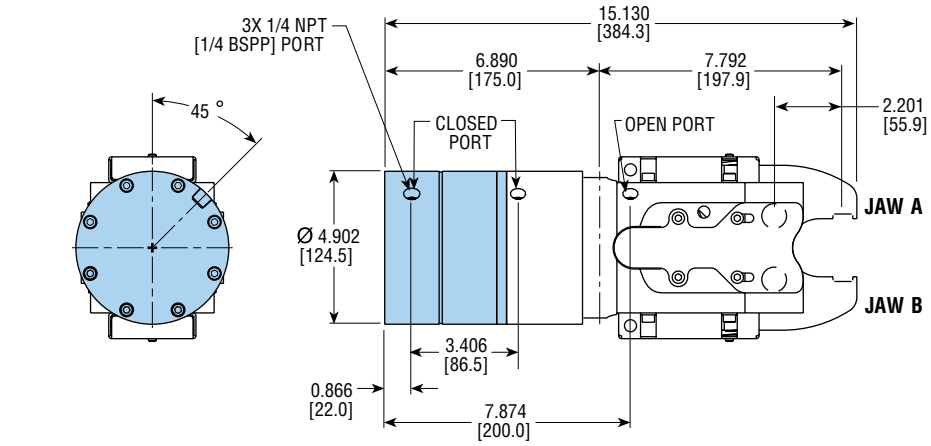
This option is compatible with P, R, V, and M mounts. Length adder affects P mounting option. See page 8 for P mounting option dimensions. This option will accommodate standard characters, retainers, and anvils.

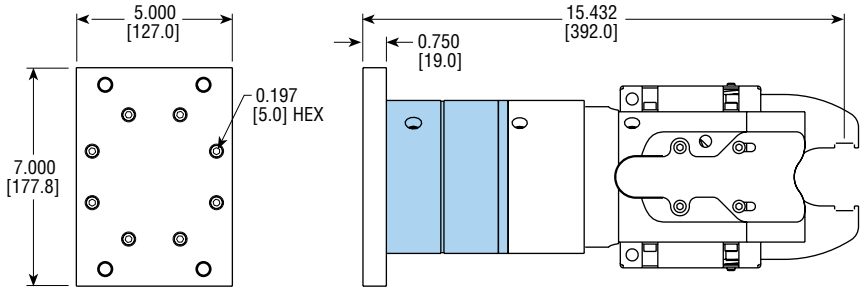
The -LAA option provides the plumbing shown on the following page. If the -LAA option is not ordered, the customer should plumb the clamp in a similar fashion as depicted on the following page.

Fittings are ordered separately.

NOTE: 90 psi [6.2 bar] max. working pressure







P MOUNTING OPTION

NOTE:
1) NUMBERS IN [ ] ARE IN mm.

SPECIFICATIONS

CLAMP SIZE	WEIGHT ADDER		LENGTH ADDER		TOTAL CLAMP FORCE AT 87 psi [6 bar]		DISPLACEMENT			
							OPEN		CLOSE	
	lb	kg	in	mm	lb	kN	in^3	cm^3	in^3	cm^3
55	5.4	2.45	3.59	91.2	25400	113	19.60	321	41.74	684

REPLACEMENT KIT NUMBERS IF ORDERED SEPARATELY

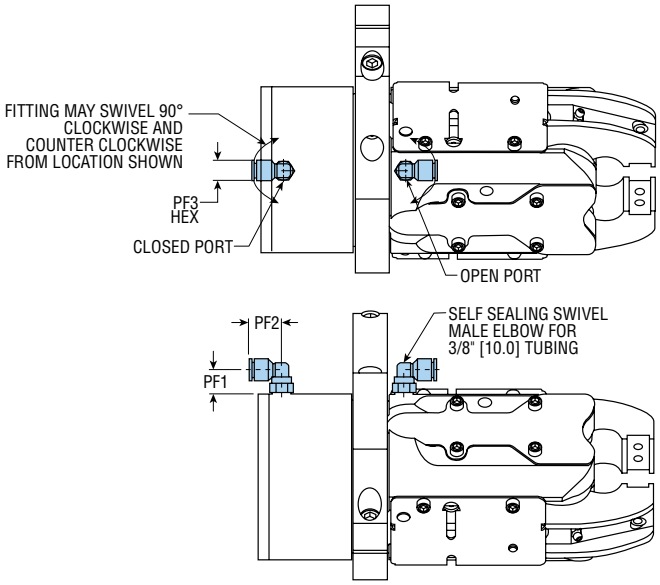
CLAMP SIZE & MODEL	CYLINDER ASSEMBLY NO.	
	IMPERIAL	METRIC
55x	72204-03	72204-04
55P	72204-05	72204-06

CLAMP SIZE & MODEL	MOUNTING KIT NO.
55P	72204-07

All dimensions are reference only unless specifically toleranced.

LAA OPTION (FITTINGS IN BOTH PORTS)

PNC44/55

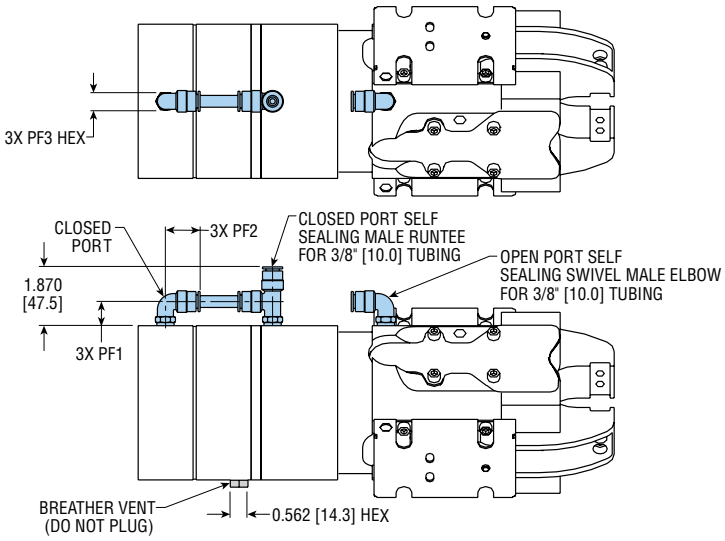


PNC55-B01

REPLACEMENT KIT NUMBERS IF ORDERED SEPARATELY

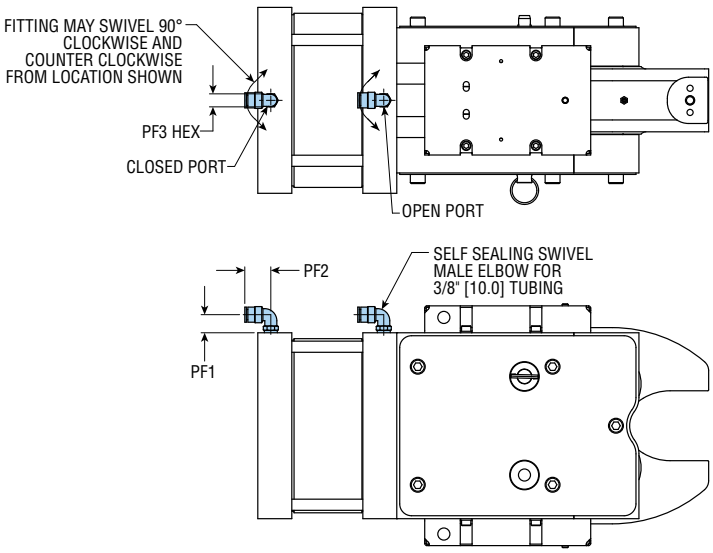
CLAMP SIZE	KIT NUMBER	
	IMPERIAL	METRIC
55	72204-11	72204-12

Kit includes: 2 swivel male elbows, 1 male runtee, 1 tube, and 1 breather vent



LETTER DIMENSION	MODEL NUMBER PNCxx	
	in	mm
PF1	0.767	18.5
PF2	1.102	28.5
PF3	0.551	14.0

PNC66

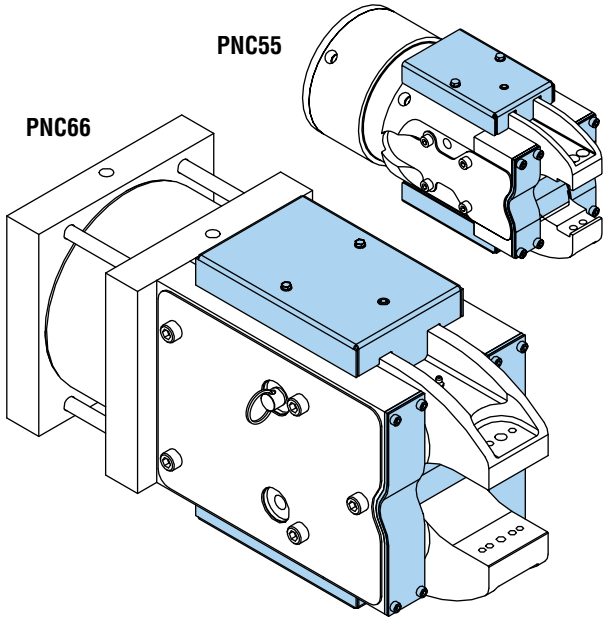


NOTE:
1) NUMBERS IN [ ] ARE IN mm.

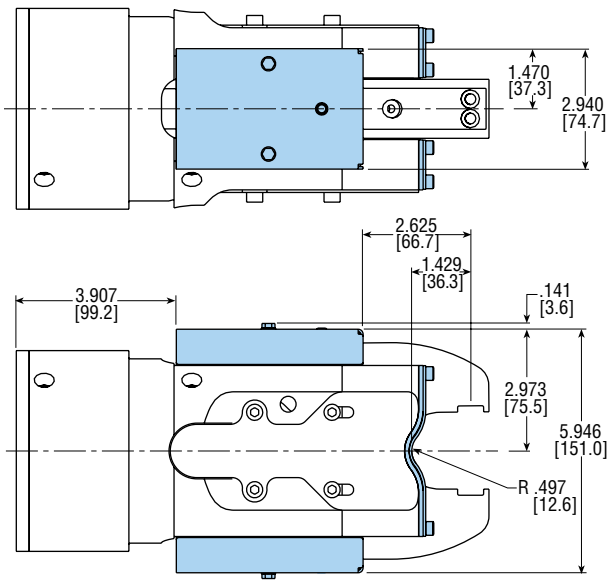
All dimensions are reference only unless specifically toleranced.

G01 WELDING SLAG SHIELDS (PNC55 and PNC66 only)

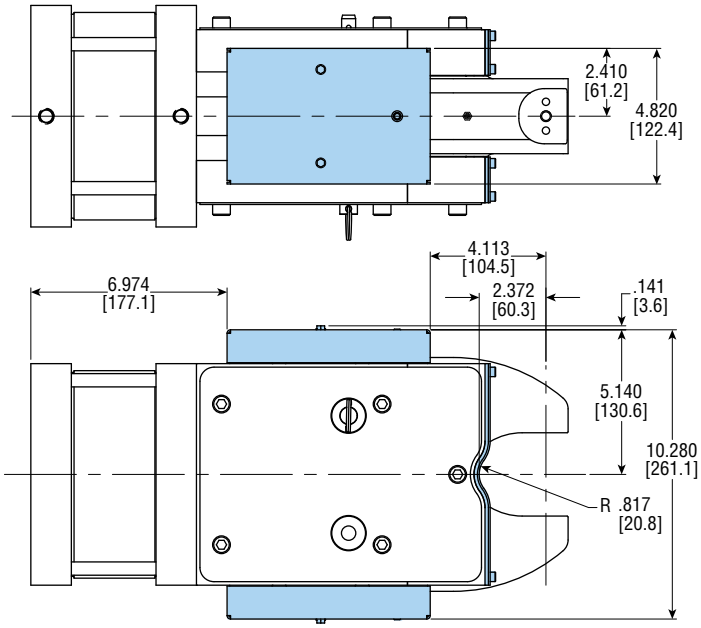
This option provides shields that protect the PNC55 and PNC66 mechanism from flying sparks and weld slag. Metal shields are assembled over the spring covers, blocking all spring cover openings. Additionally, a urethane shield is mounted on the bushing blocks covering the opening between the jaws.



PNC55



PNC66



NOTE:
1) NUMBERS IN [ ] ARE IN mm.

All dimensions are reference only unless specifically toleranced.

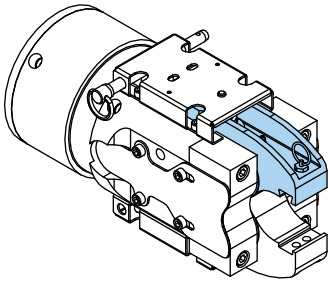
Jx01 QUICK CHANGE TOOLING JAW (A on Jaw A, B on Jaw B)

This option provides quick change character tooling. A dovetail slot in the jaw accepts matching dovetail backing plates. A hand retractable plunger holds the character tooling in place. No fasteners or wrenches are required to mount character tooling to the jaw, thus minimizing downtime for part number/date/shift code change out.

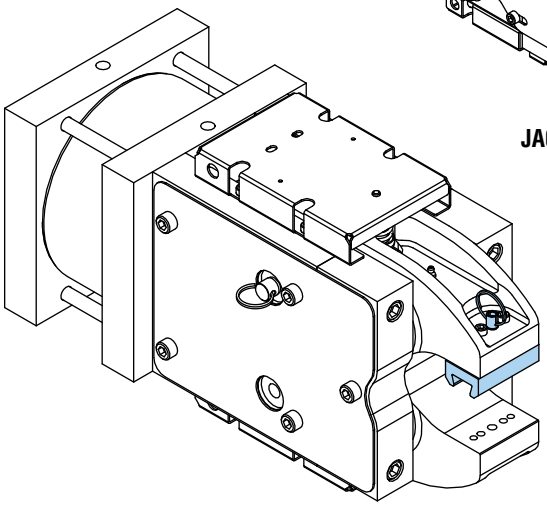
This option is not available for anvil tooling.

See page 19 for character part numbers.

Available on standard jaw configurations only.

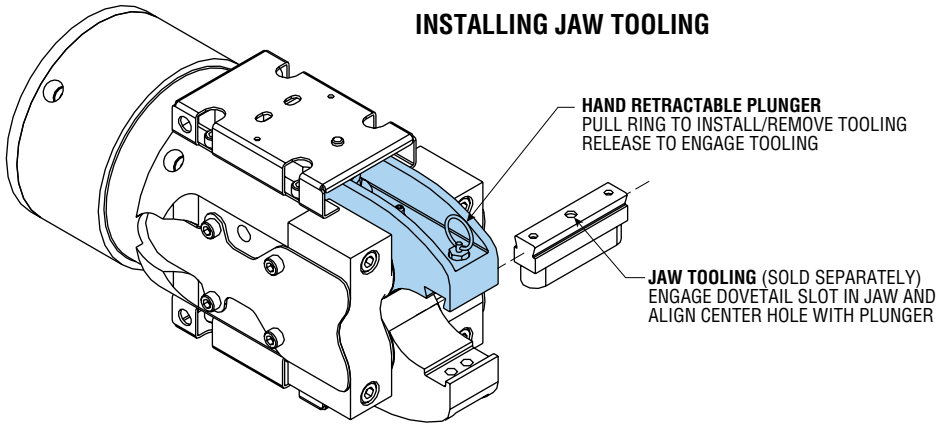


PNC55
JA01 shown



PNC66
JA01 shown

INSTALLING JAW TOOLING



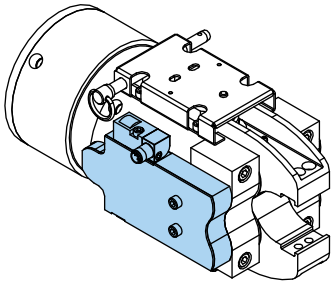
REPLACEMENT HAND RETRACTABLE PLUNGER KIT NUMBER IF ORDERED SEPARATELY

CLAMP SIZE	KIT NUMBER
44 or 55	78038-21
66	89028

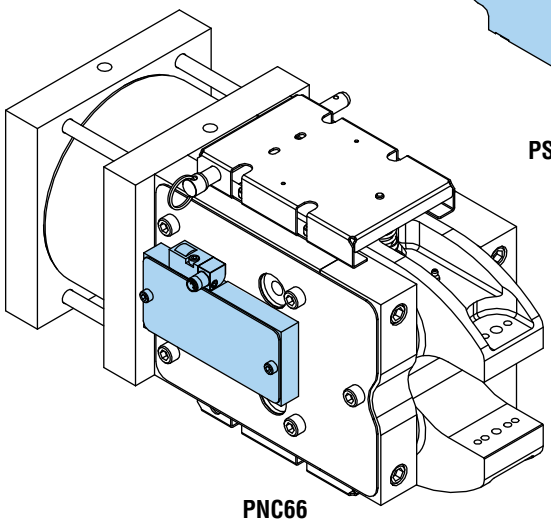
PS(R)xxx POSITIONAL SENSING DETECTION

This option provides jaw open and jaw closed sensing by affixing an aluminum housing to the side of the clamp body. The included switches sense the position of a target on the drive pin as the clamp opens and closes (open range = 14° to full open, close range = 3° to full close).

PS positions satellite switch S02 to sense open and S01 to sense close. PR positions satellite switch S01 to sense open and S02 to sense close. See tables on switch option page for satellite switch to quick disconnect pin number relationships.



PNC55
PS1D2 shown



PNC66
PS1D2 shown

POSITION SENSOR OPTION CODE

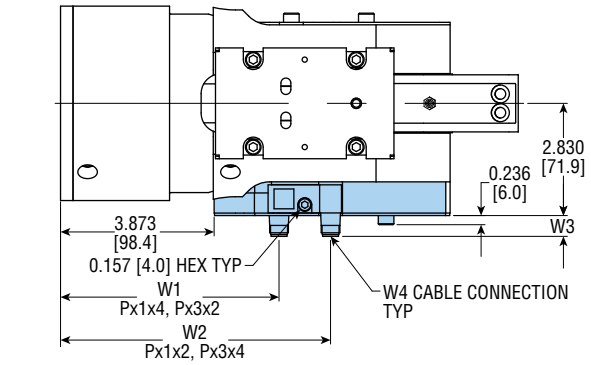
P R 1 D 2

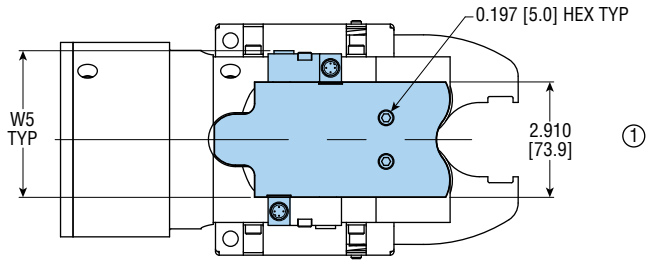
HOUSING OPTION	SENSING OPTION	SWITCH HOUSING POSITION	SWITCH OPTION	AMPLIFIER POSITION
P - Positional Sensing	S - Standard R - Reversed	1 - Position 1 3 - Position 3	N - No Switch A - 5-Pin AC/DC Switch (Turck) D - 4-Pin PNP DC Switch (P + F) E - 4-Pin PNP DC Switch (Turck) F - 4-Pin PNP DC Switch (Efector) H - 4-Pin NPN DC Switch (P + F) J - 4-Pin NPN DC Switch (Turck)	2 - Position 2 4 - Position 4

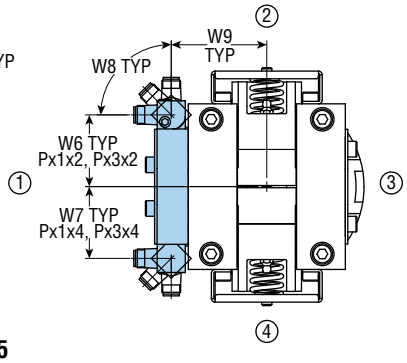
Refer to the following pages for switch option dimensions and specifications.

PS(R)xxx POSITIONAL SENSING DETECTION

(continued)

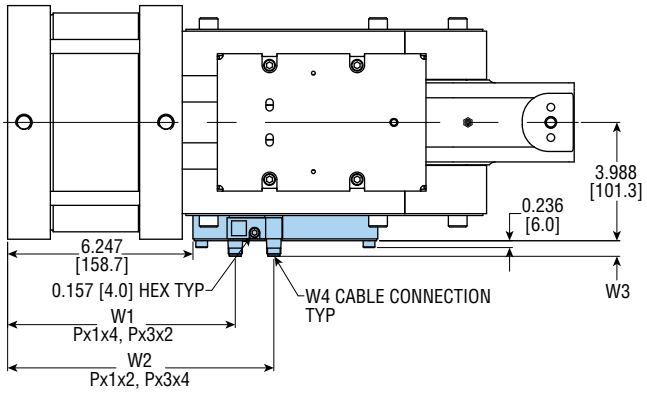


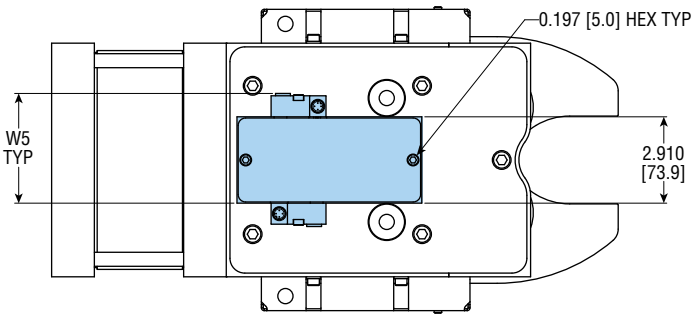


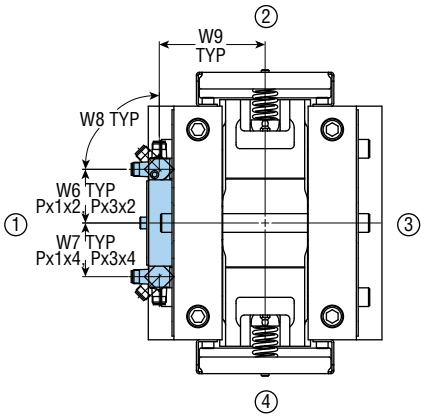


LETTER DIMENSION	MODEL NUMBER PNC44/55			
	SWITCH OPTION A		SWITCH OPTION D, E, F, H, J	
	in	mm	in	mm
W1	5.548	140.9	5.509	139.9
W2	6.769	171.9	6.808	172.9
W3	0.434	11.0	0.524	13.3
W4	1/2-20 UNF		M12 x 1	
W5	3.826	97.2	3.697	93.9
W6	2.086	53.0	1.809	46.0
W7	2.086	53.0	1.809	46.0
W8	—	—	90°	
W9	—	—	2.409	61.2

PNC44/55







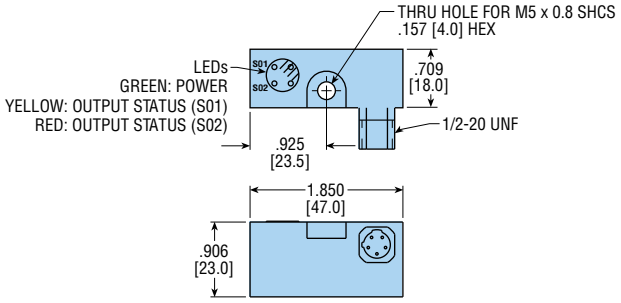
LETTER DIMENSION	MODEL NUMBER PNC66			
	SWITCH OPTION A		SWITCH OPTION D, E, F, H, J	
	in	mm	in	mm
W1	7.711	195.9	7.672	194.9
W2	8.932	226.9	8.971	227.9
W3	0.434	11.0	0.524	13.3
W4	1/2-20 UNF		M12 x 1	
W5	3.826	97.2	3.697	93.9
W6	2.086	53.0	1.809	46.0
W7	2.086	53.0	1.809	46.0
W8	—	—	90°	
W9	—	—	3.568	90.6

PNC66

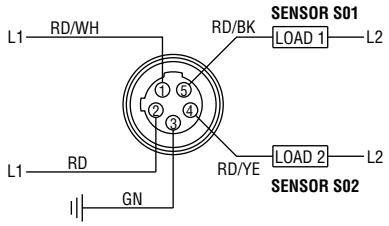
SWITCH MOUNTING OPTIONS: SERIES PNC CLAMPS

SWITCH OPTION A 71483-002-PNC Turck Part #: Ni 2-Q6.5-ADZ32-0.16-FSB 5.4X4/S304

OPTION CODE	SATELLITE UNCLAMPED	SATELLITE CLAMPED	QUICK DISCONNECT PIN NUMBER
PSxAx	S02	S01	S01 = PIN 5
PRxAx	S01	S02	S02 = PIN 4

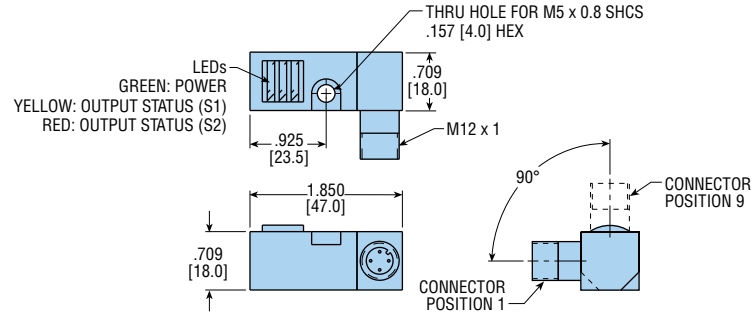


4-WIRE AC/DC

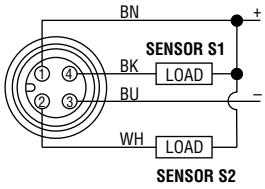


SWITCH OPTION D 71483-001-PNC P + F Part #: NBN2-F581-160S6-E8-V1 (PNP)
SWITCH OPTION H 71483-005-PNC P + F Part #: NBN2-F581-160S6-E10-V1 (NPN)

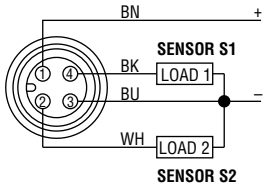
OPTION CODE	SATELLITE UNCLAMPED	SATELLITE CLAMPED	QUICK DISCONNECT PIN NUMBER
PSxD(H)x	S2	S1	S1 = PIN 4
PRxD(H)x	S1	S2	S2 = PIN 2



4-WIRE DC (V1 TYPE)
NPN DUAL NORMALLY OPEN

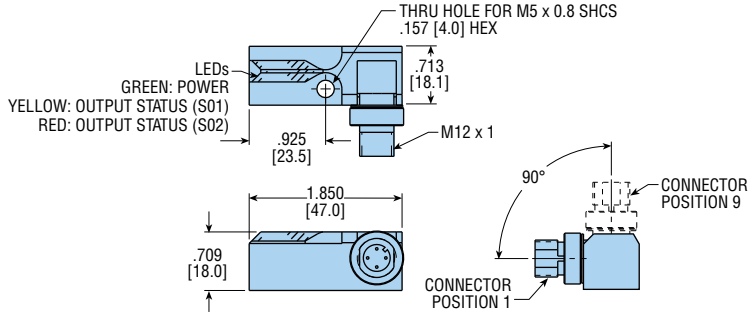


4-WIRE DC (V1 TYPE)
PNP DUAL NORMALLY OPEN

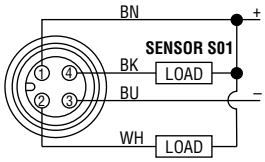


SWITCH OPTION E 71483-003-PNC Turck Part #: Ni 2-Q6.5-0.16-BDS-2AP6X3-H1141/S34 (PNP)
SWITCH OPTION J 71483-006-PNC Turck Part #: Ni 2-Q6.5-AN6-0.16-FS 4.4X3/S304 (NPN)

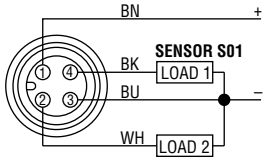
OPTION CODE	SATELLITE UNCLAMPED	SATELLITE CLAMPED	QUICK DISCONNECT PIN NUMBER
PSxE(J)x	S02	S01	S01 = PIN 4
PRxE(J)x	S01	S02	S02 = PIN 2



4-WIRE DC
NPN DUAL NORMALLY OPEN

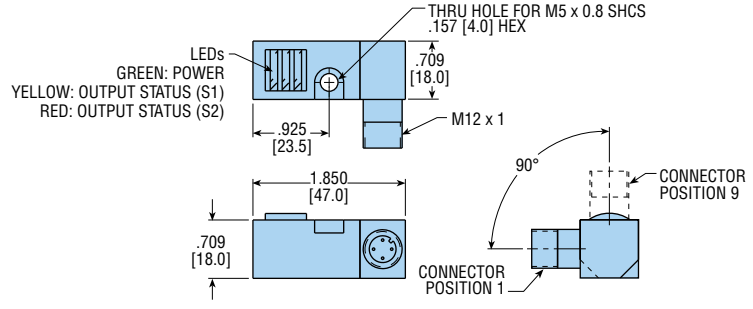


4-WIRE DC
PNP DUAL NORMALLY OPEN

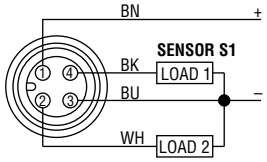


SWITCH OPTION F 71483-004-PNC Efector Part #: IN 5375 (PNP)

OPTION CODE	SATELLITE UNCLAMPED	SATELLITE CLAMPED	QUICK DISCONNECT PIN NUMBER
PSxFx	S2	S1	S1 = PIN 4
PRxFx	S1	S2	S2 = PIN 2



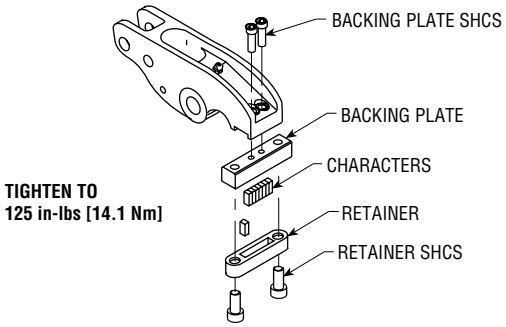
4-WIRE DC
PNP DUAL NORMALLY OPEN



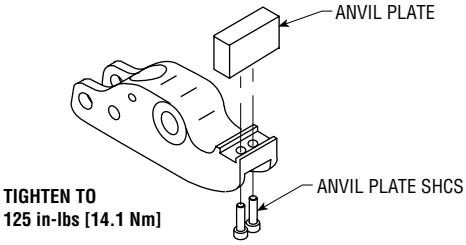
NOTE:
1) NUMBERS IN [ ] ARE IN mm.

All dimensions are reference only unless specifically toleranced.

CHARACTER MOUNTING - JAW A



ANVIL MOUNTING - JAW B



TO ORDER SPECIFY:

Based on your character **HEIGHT** and **MATERIAL THICKNESS** to be stamped, order the correct anvil, backer, and retainer kit required.
If you need all the components, order the anvil-backer-retainer kit. (Ex: **63140-01** for 1/8" tall char.) (Ex: **65340-01** for 3/16" tall char.)
If you have a retainer, order the anvil and backer kit. (Ex: **63130-01** for 1/8" tall char.) (Ex: **65330-01** for 3/16" tall char.)
Characters are ordered individually. (Ex: **63100-N6** for 1/8" tall char. number 6) (Ex: **65300-N6** for 3/16" tall char. number 6)

Retainers must be filled completely with characters to work properly.
Depending on the number to be stamped, order the characters and enough blanks or hyphens to fill the retainer.

Ex: With 1/8" tall character (63100 series) stamp the number 1999.
Matching retainer 63110-09 holds 9 characters.
Order: 1 of 63100-N1, 3 of 63100-N9, and 5 of 63100-BL.

Ex: With 3/16" tall character (65300 series) stamp the number 1999.
Matching retainer 65310-08 holds 8 characters.
Order: 1 of 65300-N1, 3 of 65300-N9, and 4 of 65300-BL.

CHART LEGEND
- Will not function in this range
- Ideal stamping range (high clamp force region)

PNC44x-x-S16-S16 TIP COMBINATION

DESCRIPTION	COLOR	PANEL THICKNESS in [mm]																				
		0.000	0.010	0.020	0.030	0.039	0.049	0.059	0.069	0.079	0.089	0.098	0.108	0.118	0.128	0.138	0.148	0.157	0.167	0.177	0.187	0.197
		[0]	[0.25]	[0.50]	[0.75]	[1.00]	[1.25]	[1.50]	[1.75]	[2.00]	[2.25]	[2.50]	[2.75]	[3.00]	[3.25]	[3.50]	[3.75]	[4.00]	[4.25]	[4.50]	[4.75]	[5.00]
GREEN ANVIL	GREEN																					
BLACK ANVIL	BLACK																					
SILVER ANVIL	SILVER																					
GOLD ANVIL	GOLD																					

PNC55x-x-S16-S16 TIP COMBINATION

DESCRIPTION	COLOR	PANEL THICKNESS in [mm]																				
		0.000	0.010	0.020	0.030	0.039	0.049	0.059	0.069	0.079	0.089	0.098	0.108	0.118	0.128	0.138	0.148	0.157	0.167	0.177	0.187	0.197
		[0]	[0.25]	[0.50]	[0.75]	[1.00]	[1.25]	[1.50]	[1.75]	[2.00]	[2.25]	[2.50]	[2.75]	[3.00]	[3.25]	[3.50]	[3.75]	[4.00]	[4.25]	[4.50]	[4.75]	[5.00]
GREEN ANVIL	GREEN																					
BLACK ANVIL	BLACK																					
SILVER ANVIL	SILVER																					
GOLD ANVIL	GOLD																					

PNC55x-x-S16-S16-B01 TIP COMBINATION

DESCRIPTION	COLOR	PANEL THICKNESS in [mm]																				
		0.000	0.010	0.020	0.030	0.039	0.049	0.059	0.069	0.079	0.089	0.098	0.108	0.118	0.128	0.138	0.148	0.157	0.167	0.177	0.187	0.197
		[0]	[0.25]	[0.50]	[0.75]	[1.00]	[1.25]	[1.50]	[1.75]	[2.00]	[2.25]	[2.50]	[2.75]	[3.00]	[3.25]	[3.50]	[3.75]	[4.00]	[4.25]	[4.50]	[4.75]	[5.00]
GREEN ANVIL	GREEN																					
BLACK ANVIL	BLACK																					
SILVER ANVIL	SILVER																					
GOLD ANVIL	GOLD																					

PNC66x-x-S16-S16 TIP COMBINATION

DESCRIPTION	COLOR	PANEL THICKNESS in [mm]																				
		0.000	0.010	0.020	0.030	0.039	0.049	0.059	0.069	0.079	0.089	0.098	0.108	0.118	0.128	0.138	0.148	0.157	0.167	0.177	0.187	0.197
		[0]	[0.25]	[0.50]	[0.75]	[1.00]	[1.25]	[1.50]	[1.75]	[2.00]	[2.25]	[2.50]	[2.75]	[3.00]	[3.25]	[3.50]	[3.75]	[4.00]	[4.25]	[4.50]	[4.75]	[5.00]
GREEN ANVIL	GREEN																					
BLACK ANVIL	BLACK																					
SILVER ANVIL	SILVER																					
GOLD ANVIL	GOLD																					

All dimensions are reference only unless specifically toleranced.

ANVILS, BACKERS, RETAINERS, & CHARACTERS

KITS FOR 1/8" TALL CHARACTERS

					STANDARD TOOLING MOUNTING			QUICK CHANGE (Jx01) TOOLING MOUNTING		
PNC SIZE	PANEL THICKNESS	ANVIL COLOR	KIT NUMBER ANVIL	KIT NUMBER RETAINER	KIT NUMBER BACKER	KIT NUMBER ANVIL & BACKER	KIT NUMBER ANVIL, BACKER & RETAINER	KIT NUMBER BACKER	KIT NUMBER ANVIL & BACKER	KIT NUMBER ANVIL, BACKER & RETAINER
PNC44	0.25 - 1.25 mm	GREEN	65500-00	63110-09	63120-09	63130-00	63140-00	78038-03	78038-04	78038-08
	1.25 - 2.50 mm	BLACK	65500-01			63130-01	63140-01		78038-05	78038-09
	2.50 - 3.75 mm	SILVER	65500-02			63130-02	63140-02		78038-06	78038-10
	3.75 - 4.75 mm	GOLD	65500-03			63130-03	63140-03		78038-07	78038-11
PNC55	0.25 - 1.50 mm	BLACK	65500-01			63130-01	63140-01		78038-05	78038-09
	1.50 - 3.00 mm	SILVER	65500-02			63130-02	63140-02		78038-06	78038-10
	3.00 - 4.25 mm	GOLD	65500-03			63130-03	63140-03		78038-07	78038-11
PNC55-B01	0.25 - 1.00 mm	GREEN	65500-00			63130-00	63140-00		78038-04	78038-08
	1.00 - 2.25 mm	BLACK	65500-01			63130-01	63140-01		78038-05	78038-09
	2.25 - 3.50 mm	SILVER	65500-02			63130-02	63140-02		78038-06	78038-10
	3.50 - 4.75 mm	GOLD	65500-03			63130-03	63140-03		78038-07	78038-11
PNC66	0.25 - 1.00 mm	GREEN	89021-01		88717	88719-01	88721-01	88718	88720-01	88722-01
	1.00 - 2.00 mm	BLACK	89021-02			88719-02	88721-02		88720-02	88722-02
	2.00 - 3.00 mm	SILVER	89021-03			88719-03	88721-03		88720-03	88722-03
	3.00 - 4.00 mm	GOLD	89021-04			88719-04	88721-04		88720-04	88722-04

ALL KITS INCLUDE FASTENERS REQUIRED FOR INSTALLATION

1/8" TALL CHARACTERS

PART DESCRIPTION	PART NUMBER	PART DESCRIPTION	PART NUMBER	PART DESCRIPTION	PART NUMBER	PART DESCRIPTION	PART NUMBER
NUMBER 0	63100-N0	LETTER A	63100-LA	LETTER K	63100-LK	LETTER U	63100-LU
NUMBER 1	63100-N1	LETTER B	63100-LB	LETTER L	63100-LL	LETTER V	63100-LV
NUMBER 2	63100-N2	LETTER C	63100-LC	LETTER M	63100-LM	LETTER W	63100-LW
NUMBER 3	63100-N3	LETTER D	63100-LD	LETTER N	63100-LN	LETTER X	63100-LX
NUMBER 4	63100-N4	LETTER E	63100-LE	LETTER O	63100-LO	LETTER Y	63100-LY
NUMBER 5	63100-N5	LETTER F	63100-LF	LETTER P	63100-LP	LETTER Z	63100-LZ
NUMBER 6	63100-N6	LETTER G	63100-LG	LETTER Q	63100-LQ		
NUMBER 7	63100-N7	LETTER H	63100-LH	LETTER R	63100-LR	BLANK	63100-BL
NUMBER 8	63100-N8	LETTER I	63100-LI	LETTER S	63100-LS		
NUMBER 9	63100-N9	LETTER J	63100-LJ	LETTER T	63100-LT	HYPHEN	63100-HY

9 CHARACTERS ARE REQUIRED WHEN USING PHD RETAINER NUMBER 63110-09

KITS FOR 3/16" TALL CHARACTERS

					STANDARD TOOLING MOUNTING			QUICK CHANGE (Jx01) TOOLING MOUNTING		
PNC SIZE	PANEL THICKNESS	ANVIL COLOR	KIT NUMBER ANVIL	KIT NUMBER RETAINER	KIT NUMBER BACKER	KIT NUMBER ANVIL & BACKER	KIT NUMBER ANVIL, BACKER & RETAINER	KIT NUMBER BACKER	KIT NUMBER ANVIL & BACKER	KIT NUMBER ANVIL, BACKER & RETAINER
PNC44	0.25 - 1.25 mm	GREEN	65500-00	65310-08	65320-08	65330-00	65340-00	78038-12	78038-13	78038-17
	1.25 - 2.50 mm	BLACK	65500-01			65330-01	65340-01		78038-14	78038-18
	2.50 - 3.75 mm	SILVER	65500-02			65330-02	65340-02		78038-15	78038-19
	3.75 - 4.75 mm	GOLD	65500-03			65330-03	65340-03		78038-16	78038-20
PNC55	0.25 - 1.50 mm	BLACK	65500-01			65330-01	65340-01		78038-14	78038-18
	1.50 - 3.00 mm	SILVER	65500-02			65330-02	65340-02		78038-15	78038-19
	3.00 - 4.25 mm	GOLD	65500-03			65330-03	65340-03		78038-16	78038-20
PNC55-B01	0.25 - 1.00 mm	GREEN	65500-00			65330-00	65340-00		78038-13	78038-17
	1.00 - 2.25 mm	BLACK	65500-01			65330-01	65340-01		78038-14	78038-18
	2.25 - 3.50 mm	SILVER	65500-02			65330-02	65340-02		78038-15	78038-19
	3.50 - 4.75 mm	GOLD	65500-03			65330-03	65340-03		78038-16	78038-20
PNC66	0.25 - 1.00 mm	GREEN	89021-01		88723	88725-01	88727-01	88724	88726-01	88728-01
	1.00 - 2.00 mm	BLACK	89021-02			88725-02	88727-02		88726-02	88728-02
	2.00 - 3.00 mm	SILVER	89021-03			88725-03	88727-03		88726-03	88728-03
	3.00 - 4.00 mm	GOLD	89021-04			88725-04	88727-04		88726-04	88728-04

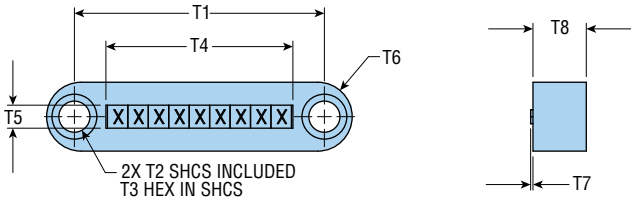
ALL KITS INCLUDE FASTENERS REQUIRED FOR INSTALLATION

3/16" TALL CHARACTERS

PART DESCRIPTION	PART NUMBER	PART DESCRIPTION	PART NUMBER	PART DESCRIPTION	PART NUMBER	PART DESCRIPTION	PART NUMBER
NUMBER 0	65300-N0	LETTER A	65300-LA	LETTER K	65300-LK	LETTER U	65300-LU
NUMBER 1	65300-N1	LETTER B	65300-LB	LETTER L	65300-LL	LETTER V	65300-LV
NUMBER 2	65300-N2	LETTER C	65300-LC	LETTER M	65300-LM	LETTER W	65300-LW
NUMBER 3	65300-N3	LETTER D	65300-LD	LETTER N	65300-LN	LETTER X	65300-LX
NUMBER 4	65300-N4	LETTER E	65300-LE	LETTER O	65300-LO	LETTER Y	65300-LY
NUMBER 5	65300-N5	LETTER F	65300-LF	LETTER P	65300-LP	LETTER Z	65300-LZ
NUMBER 6	65300-N6	LETTER G	65300-LG	LETTER Q	65300-LQ		
NUMBER 7	65300-N7	LETTER H	65300-LH	LETTER R	65300-LR	BLANK	65300-BL
NUMBER 8	65300-N8	LETTER I	65300-LI	LETTER S	65300-LS		
NUMBER 9	65300-N9	LETTER J	65300-LJ	LETTER T	65300-LT	HYPHEN	65300-HY

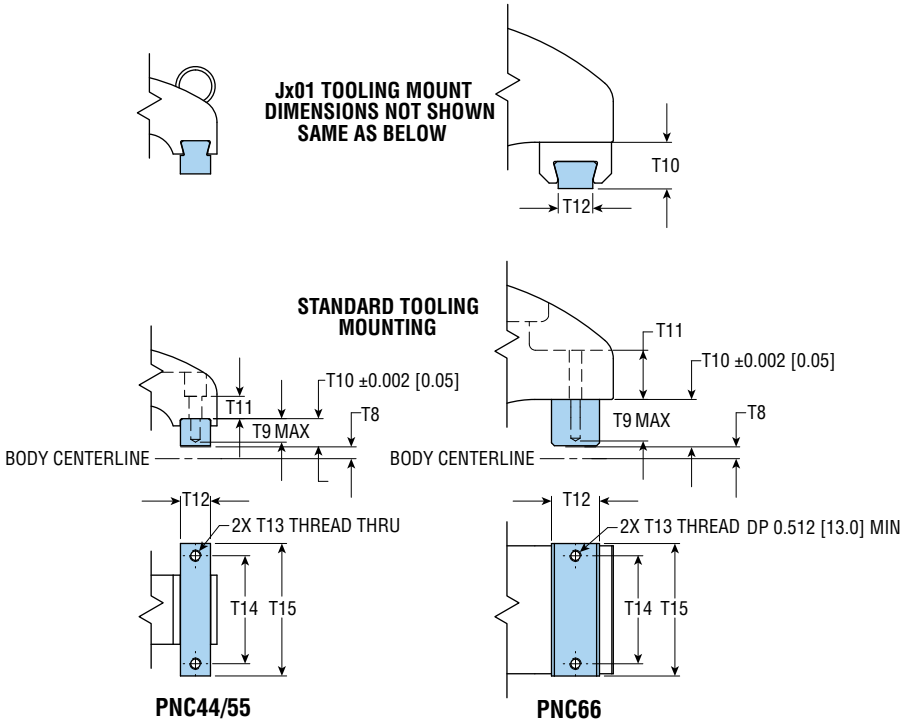
8 CHARACTERS ARE REQUIRED WHEN USING PHD RETAINER NUMBER 65310-08

JAW A - RETAINER



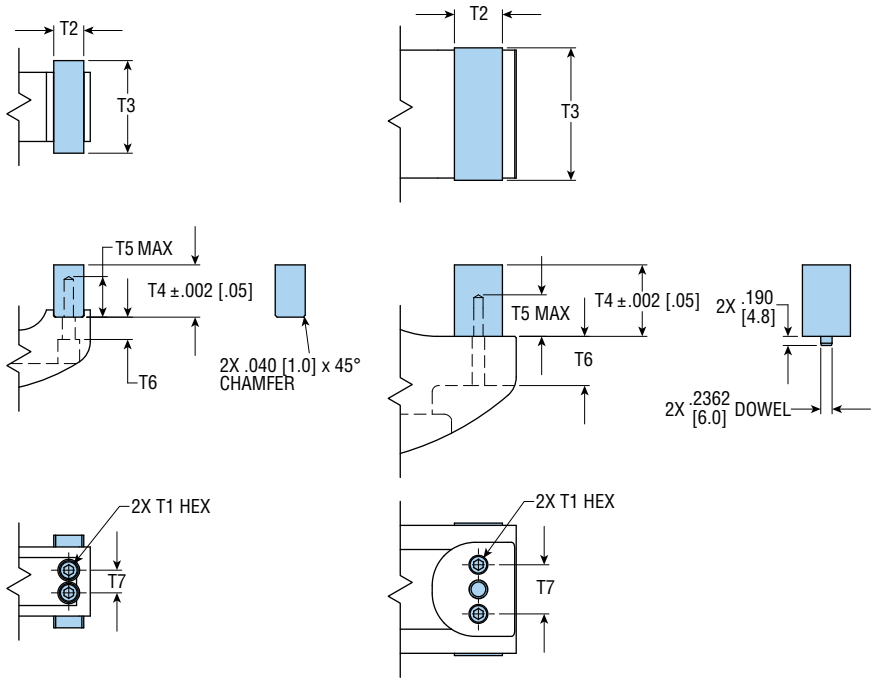
RETAINER KIT NO.	LETTER DIMENSION															
	T1		T2		T3		T4		T5		T6		T7		T8	
	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
63110-09	2.250	57.2	M6 x 1.0		0.197	5.0	1.683	42.7	0.220	5.6	0.310	7.9	0.021	0.5	0.480	12.2
65310-08	2.000	50.8	M8 x 1.25		0.236	6.0	1.310	33.3	0.250	6.4	0.310	7.9	0.032	0.8	0.469	11.9

JAW A - BACKER



CLAMP SIZE	BACKER MOUNT	BACKER KIT NO.	LETTER DIMENSION														
			T8		T9		T10		T11		T12		T13	T14		T15	
			in	mm	in	mm	in	mm	in	mm	in	mm	mm	in	mm	in	mm
PNC44/55	STANDARD	63120-09	0.517	13.1	0.490	12.4	0.564	14.3	0.465	11.8	0.625	15.9	M6 x 1.0	2.250	57.2	2.760	70.1
	STANDARD	65320-08	0.517	13.1	0.490	12.4	0.564	14.3	0.465	11.8	0.625	15.9	M8 x 1.25	2.000	50.8	2.630	66.8
	Jx01	78038-03	0.517	13.1	—	—	—	—	—	—	0.625	15.9	M6 x 1.0	2.250	57.2	2.760	70.1
	Jx01	78038-12	0.517	13.1	—	—	—	—	—	—	0.625	15.9	M8 x 1.25	2.000	50.8	2.630	66.8
PNC66	STANDARD	88717	0.516	13.1	0.807	20.5	0.964	24.49	1.025	26.0	1.000	25.4	M6 x 1.0	2.250	57.2	2.760	70.1
	STANDARD	88723	0.516	13.1	0.807	20.5	0.964	24.49	1.025	26.0	1.000	25.4	M8 x 1.25	2.000	50.8	2.760	70.1
	Jx01	88718	0.516	13.1	—	—	0.964	24.5	—	—	0.720	18.3	M6 x 1.0	2.250	57.2	2.760	70.1
	Jx01	88724	0.516	13.1	—	—	0.964	24.5	—	—	0.720	18.3	M8 x 1.25	2.000	50.8	2.760	70.1

JAW A - ANVIL

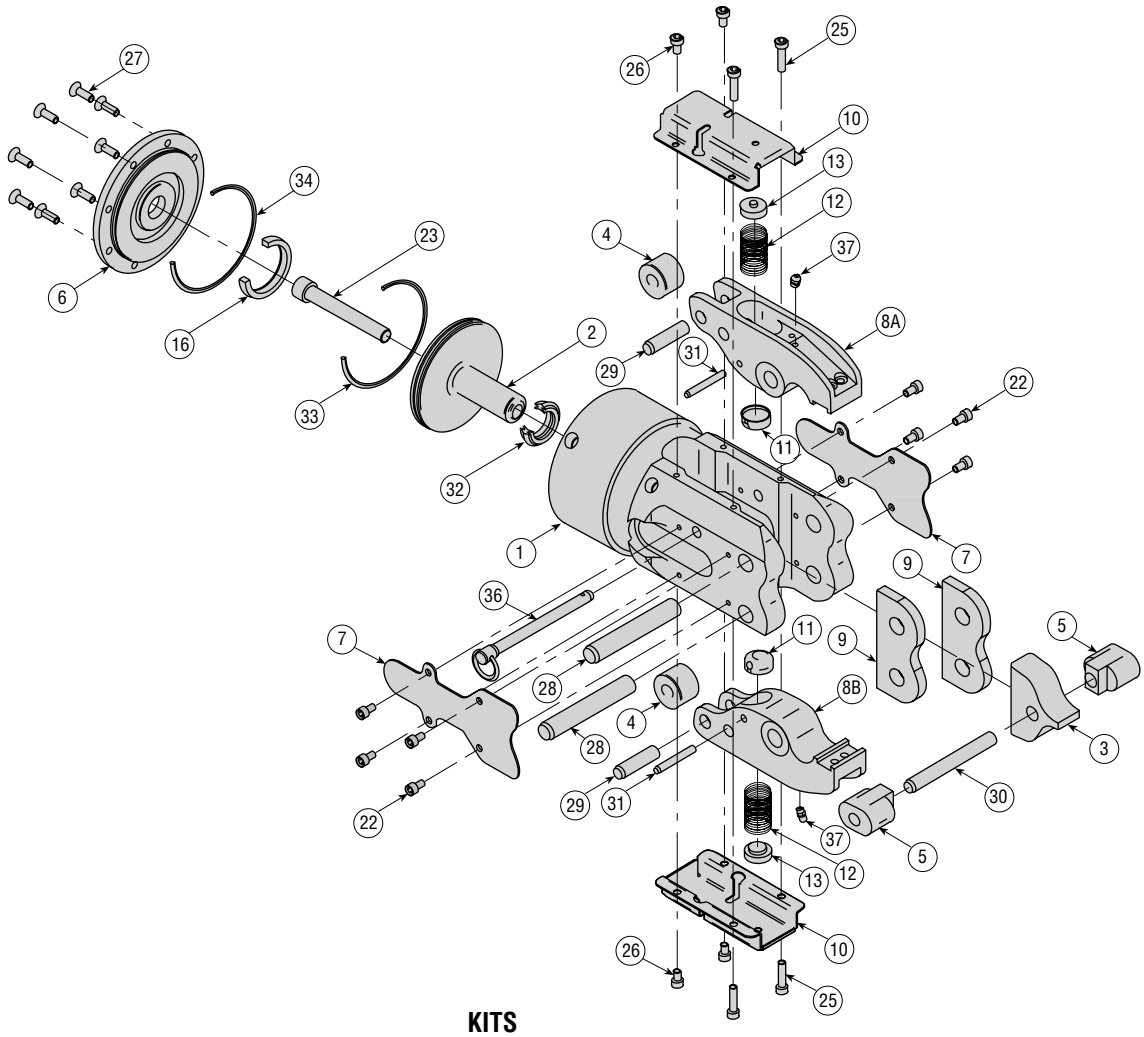


PNC44/55 **PNC66**

CLAMP SIZE	ANVIL COLOR	ANVIL KIT NO.	LETTER DIMENSION													
			T1		T2		T3		T4		T5		T6		T7	
			in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
PNC44/55	GREEN	65500-00	0.197	5.0	0.625	15.9	1.929	49.0	1.138	28.91	0.850	21.6	0.465	11.8	0.472	12.0
	BLACK	65500-01							1.089	27.66						
	SILVER	65500-02							1.040	26.42						
	GOLD	65500-03							0.990	25.15						
PNC66	GREEN	89021-01	0.197	5.0	1.000	25.4	2.760	70.1	1.552	39.42	0.807	20.5	1.025	26.0	1.024	26.0
	BLACK	89021-02							1.513	38.43						
	SILVER	89021-03							1.473	37.41						
	GOLD	89021-04							1.434	36.42						

All dimensions are reference only unless specifically toleranced.

PARTS BREAKDOWN: SERIES PNC44 CLAMPS

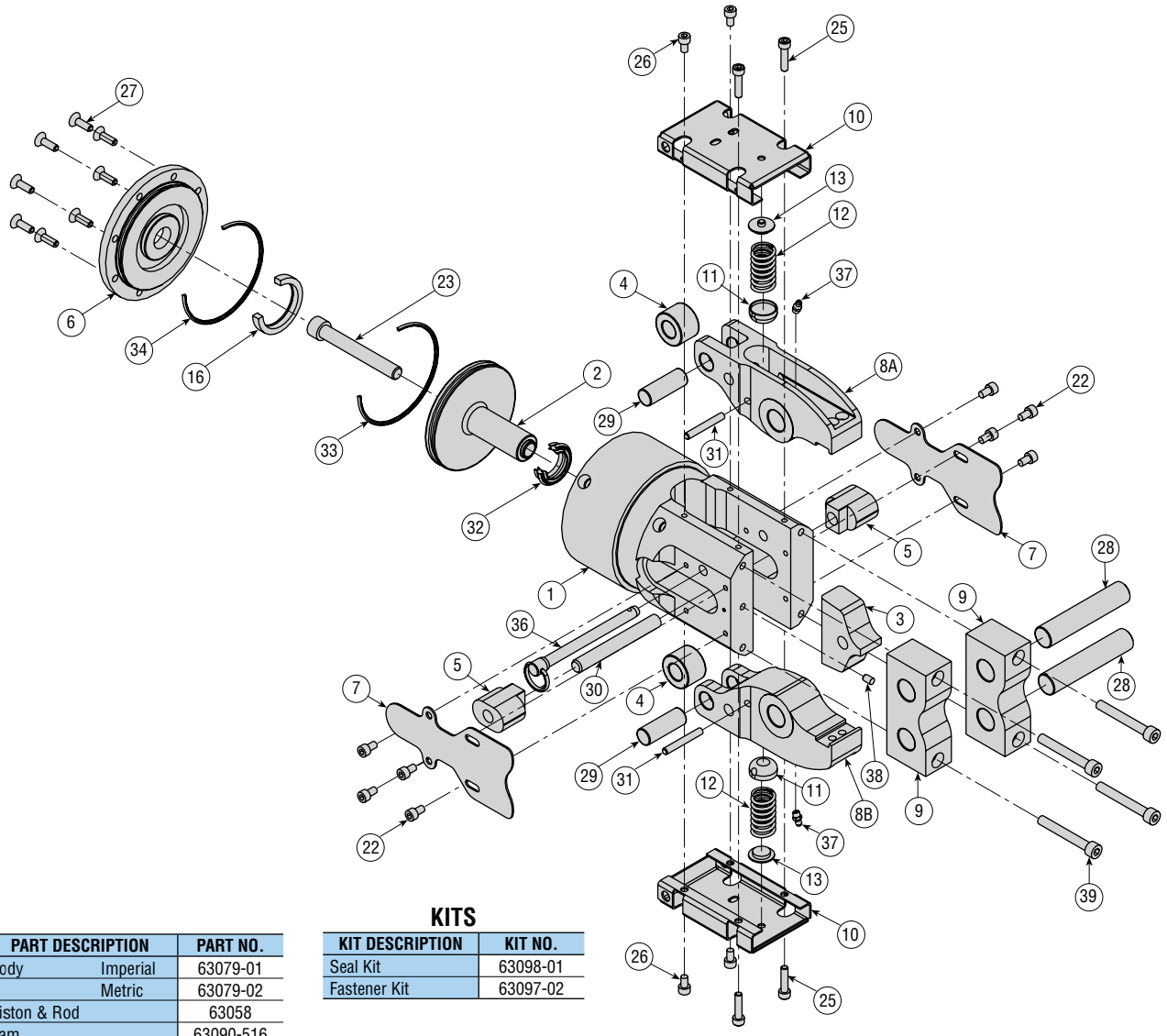


KEY	PART DESCRIPTION		PART NO.
1	Body	Imperial	63057-01
		Metric	63057-02
2	Piston & Rod		63058
3	Cam		63059
4	Roller Bearing		63060
5	Slider Bushing		63061
6	Cap		63062-01
7	Impact Plate		63093
8A	Jaw (A)		63064-01
8B	Jaw (B)		63064-01
9	Pivot Pin Link		63071-02
10	Spring Cover		63072
11	Spring Retainer Cup		63066
12	Spring		15520
13	Spring Step		63073
16	Shock Pad		62648
22	Impact Plate SHCS		59104-114
23	Piston & Rod SHCS		59104-205
25	Spring Cover SHCS		59104-120
26	Spring Cover SHCS		59104-114
27	Cap SFHCS		59104-600
28	Pivot Pin		17831-056
29	Roller Bearing Pin		17831-057
30	Cam Pin		17831-058
31	Spring Retainer Cup Pin		17831-059
32	Rod Seal		62827-009-1
33	Piston Seal		3642-051-1
34	Cap Seal		3642-051-1
36	Safety Lock-out Pin		63087
37	Grease Zerk		63086

KITS

KIT DESCRIPTION	KIT NO.
Seal Kit	63098-01
Fastener Kit	63097-01

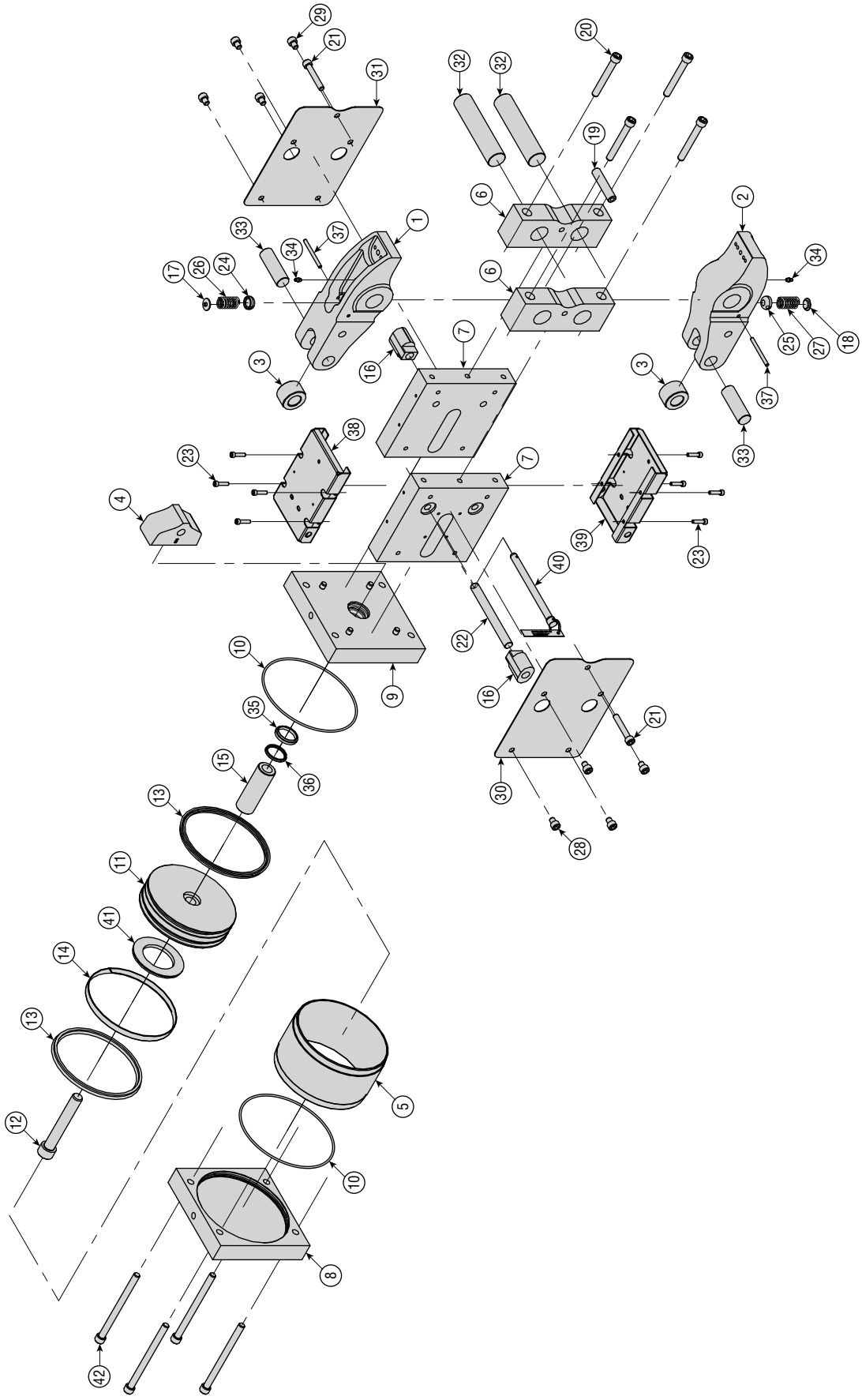
PARTS BREAKDOWN: SERIES PNC55 CLAMPS



KEY	PART DESCRIPTION		PART NO.
1	Body	Imperial	63079-01
		Metric	63079-02
2	Piston & Rod		63058
3	Cam		63090-516
4	Roller Bearing		63080
5	Slider Bushing		63061
6	Cap		63062-01
7	Impact Plate		63093
8A	Jaw (A)		63094-01
8B	Jaw (B)		63094-01
9	Bushing Block		63091
10	Spring Cover		63082
11	Spring Retainer Cup		63066
12	Spring		15520
13	Spring Step		63081
16	Shock Pad		62648
22	Impact Plate SHCS		59104-114
23	Piston & Rod SHCS		59104-205
25	Spring Cover SHCS		59104-120
26	Spring Cover SHCS		59104-114
27	Cap SFHCS		59104-600
28	Pivot Pin		63101
29	Roller Bearing Pin		63102
30	Cam Pin		17831-058
31	Spring Retainer Cup Pin		17831-059
32	Rod Seal		62827-009-1
33	Piston Seal		3642-051-1
34	Cap Seal		3642-051-1
36	Safety Lock-out Pin		63087
37	Grease Zerk		63086
38	Bushing Block Pin		17831-162
39	Bushing Block SHCS		59104-144

KITS

KIT DESCRIPTION	KIT NO.
Seal Kit	63098-01
Fastener Kit	63097-02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KEY	DESCRIPTION		PART NUMBER
1	Jaw A	"S" Style	88687
		"A" Style	88710
2	Jaw B	"S" Style	88687
		"A" Style	88710
3	Roller Bearing		88692
4	Cam		88694
5	Cylinder Tube		88714
6	Bushing Block Assembly		89026
7	Slider Bushing Rail		88713
8	Cap	Imperial	88700-01
		Metric	88700-02
9	Head Assembly	Imperial	89027-01
		Metric	89027-02
10	O-Ring		1950-263-1
11	Piston		88702
12	SHCS		59104-298
13	Piston Seal		78193-001-9
14	Wear Ring		78195
15	Piston Rod		88696
16	Slider Bushing		88697
17	Jaw A Spring Step	"S" Style	63081
		"A" Style	63081-01
18	Jaw B Spring Step	"S" Style	63081
		"A" Style	63081-01
19	Bushing Block Tierod		88693
20	SHCS		59104-205
21	SHCS		59104-172
22	Bushing Pin		88695
23	SHCS		59104-120
24	Jaw A Retainer Cup	"S" Style	63066
		"A" Style	74366-01
25	Jaw B Retainer Cup	"S" Style	63066
		"A" Style	74366-01
26	Jaw A Spring	"S" Style	15520
		"A" Style	74258
27	Jaw B Spring	"S" Style	15520
		"A" Style	74258
28	Side 1 SHCS		59104-160
29	Side 3 SHCS		59104-160
30	Side 1 Cover		88688
31	Side 3 Cover		88688
32	Bushing Pin		88689
33	Roller Pin		88690
34	Grease Zerk		63086
35	Rod Wiper		78198-01375-1
36	Rod Seal		1978-015-1
37	Dowel Pin		17831-164
38	Jaw A Spring Cover	"S" Style	88691
		"A" Style	88709
39	Jaw B Spring Cover	"S" Style	88691
		"A" Style	88709
40	Lock-Out Safety Pin Assembly		88699
41	Shock Pad		88701
42	SHCS		59104-212

KITS

KIT DESCRIPTION	KIT NUMBER
Seal Kit	89024
Fastener Kit	89023

REPLACEMENT KIT NUMBERS IF ORDERED SEPARATELY

CLAMP SIZE	ACCESSORY	KIT NUMBER	DESCRIPTION
PNC44/55	PS(R)xN0	71251-04	Switch Housing Kit without Switch
	PS(R)xAx	71251-08	Switch Housing Kit with 5 pin AC/DC, (Turck) Switch
	PS(R)xDx	71251-03	Switch Housing Kit with 4 pin DC, PNP (P + F) Switch
	PS(R)xEx	71251-06	Switch Housing Kit with 4 pin DC, PNP (Turck) Switch
	PS(R)xFx	71251-10	Switch Housing Kit with 4 pin DC, PNP (Efector) Switch
	PS(R)xHx	71251-12	Switch Housing Kit with 4 pin DC, NPN (P + F) Switch
	PS(R)xJx	71251-13	Switch Housing Kit with 4 pin DC, NPN (Turck) Switch
PNC66	PS(R)xN0	89025-01	Switch Housing Kit without Switch
	PS(R)xAx	89025-02	Switch Housing Kit with 5 pin AC/DC, (Turck) Switch
	PS(R)xDx	89025-03	Switch Housing Kit with 4 pin DC, PNP (P + F) Switch
	PS(R)xEx	89025-04	Switch Housing Kit with 4 pin DC, PNP (Turck) Switch
	PS(R)xFx	89025-05	Switch Housing Kit with 4 pin DC, PNP (Efector) Switch
	PS(R)xHx	89025-06	Switch Housing Kit with 4 pin DC, NPN (P + F) Switch
	PS(R)xJx	89025-07	Switch Housing Kit with 4 pin DC, NPN (Turck) Switch

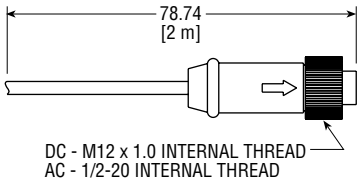
Kit includes: Housing and all pins and screws required for installation.

REPLACEMENT SWITCH KIT NUMBERS IF ORDERED SEPARATELY

SWITCH OPTION	SWITCH TYPE	PHD SWITCH KIT NUMBER	SWITCH PART NUMBER
A	5-PIN AC/DC - N.O.	71483-002-PNC	Ni 2-Q6.5-ADZ32-0.16-FSB 5.4X4/S304
D	4-PIN DC - N.O. - PNP	71483-001-PNC	NBN2-F581-160S6-E8-V1
E	4-PIN DC - N.O. - PNP	71483-003-PNC	Ni 2-Q6.5-0.16-BDS-2AP6X3-H1141/S34
F	4-PIN DC - N.O. - PNP	71483-004-PNC	IN 5375
H	4-PIN DC - N.O. - NPN	71483-005-PNC	NBN2-F581-160S6-E10-V1
J	4-PIN DC - N.O. - NPN	71483-006-PNC	Ni 2-Q6.5-AN6-0.16-FS 4.4X3/S304

MATCHING CORDSETS 2 METERS LONG

SWITCH OPTION	PHD PART NUMBER	CORDSET PART NUMBER
A	73317-00-02	KB 5T-2
D	65440-001-02	V1-G-YE2M-PVC
E	78039-00-02	RK 4.4T-2
F	65440-001-02	V1-G-YE2M-PVC
H	65440-001-02	V1-G-YE2M-PVC
J	78039-00-02	RK 4.4T-2



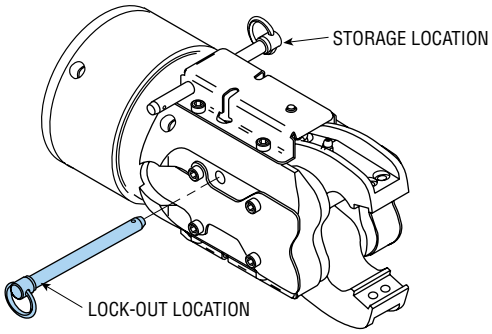
MATING CORDSET

SAFETY LOCK-OUT

The safety lock-out pin is a safety device that stops jaw motion during maintenance on the clamp.

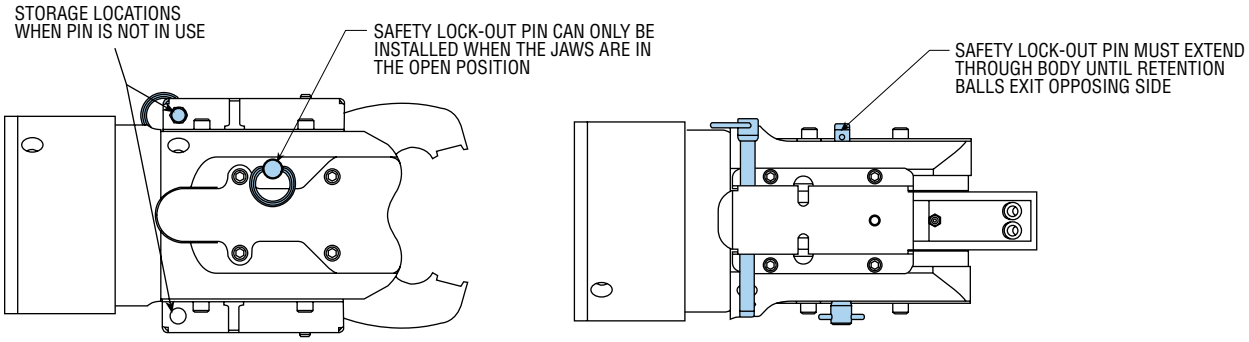
Remove the safety lock-out pin from the storage location. Re-install the safety lock-out pin in the lock-out location in the body before attempting to work on or near the stamping portion of this clamp.

No attempt should be made to service the clamp and/or remove the retainer, backing plate, or anvil before the safety lock-out pin is installed in the lock-out location.



DESCRIPTION	REPLACEMENT PART NO.	
	PNC44/55	PNC66
SAFETY LOCK-OUT PIN	63087	88699

NOTE: ONE SAFETY LOCK-OUT PIN SUPPLIED WITH UNIT



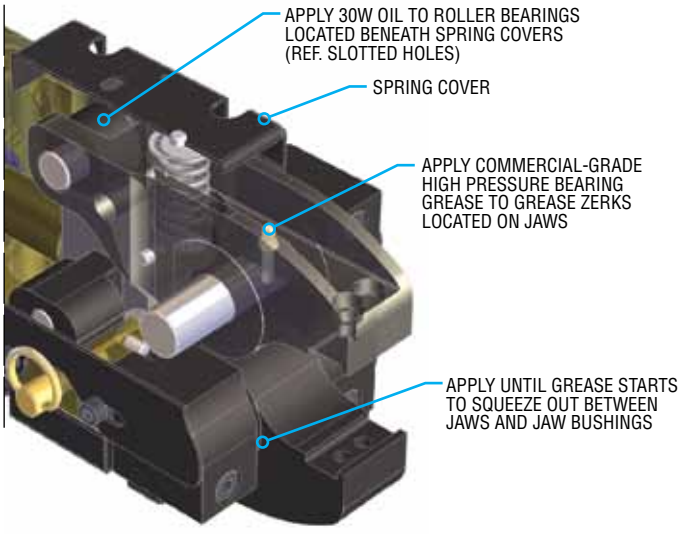
MAINTENANCE SCHEDULE

Lubrication guidelines for the Series PNC Clamp are based on continuous operation at the following cycle speeds:
PNC44 and PNC55 at 30 cycles/minute
PNC66 at 15 cycles/minute

Variations in cycle speeds from those listed herein may require more or less frequent maintenance schedules.

Apply commercial-grade high-pressure bearing grease to the grease zerks located on the jaws. Apply until the grease starts to squeeze out between the jaw and jaw bushing. Grease should be applied to the jaws every 200,000-300,000 cycles.

Apply 30W oil to the roller bearings located beneath the spring covers. Insert the nozzle of the oil can into each spring cover slot. Apply enough oil to saturate the bearings. This allows oil to wick into the mating surfaces of the bearings and jaws, and also onto the roller bearing pins. Oil should be applied to the roller bearings every 200,000-300,000 cycles.



phd Unlimited® UNIQUE SOLUTIONS

Unique PNC “Mongo” Clamp

Higher force for heavy duty crimping and forming applications

- Capable of generating 64,000 lb [284.7 kN] of total clamp force at 87 psi [6 bar].
- Provides more than twice the force of a standard PNC55-B01.
- Weighs 154 lb [69.9 kg]
- Tandem 7 in [178 mm] bore cylinders

Unique PNC Clamp with Longer Jaws & Special Sensor

PNC66P-5-A16-S16-PS1E2

- Jaws reach 16 mm further into part when stamping.
- Linear displacement sensor provides constant information on jaws’ position.
- Provides a cost-effective solution for stamping identification characters into parts or material.
- Capable of generating 40,915 lbf [182 kN] of total clamp force at 87 psi [6 bar].
- High clamp force produces characters in draw quality steel.
- Estimated weight 121.3 lb [55 kg]

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