VOGEL TOOL & DIE

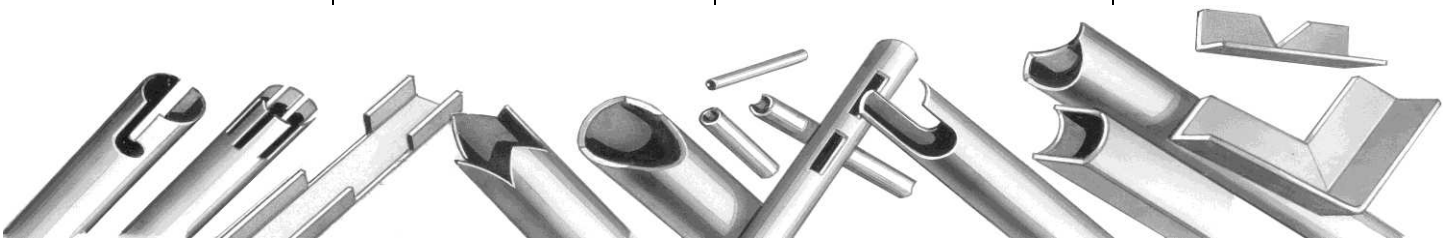
General Information

∗All prices are F.O.B. shipping point, unless noted
∗All prices are for domestic orders and shipments.
∗Different pricing applies for orders placed from, or shipping to outside the United States. Please contact factory to obtain a quotation.
∗Vogel Tool & Die, LLC standard terms, conditions of sale and warranties apply
∗Prices subject to change without notice. $25.00 minimum net billing
∗Deposits, (normally 50% of purchase price), required on all non-stock tooling
∗The abbreviation P.O.R. represents “Price on Request”. Part prints required for quoting
∗Replacement parts are available for most Vogel tooling, please call for details
∗Sharpening service is available for most Vogel tooling, please call for details
∗We specialize in custom designed dies tailored to your specialized applications

HOURS [Central Time Zone]
Monday through Friday: 6:00 am to 3:00 pm

Telephone: 630-562-1400
Fax: 630-562-1500
Website: VogelTool.com
E-Mail: Info@VogelTool.com

Remit To Address:	Factory Address:
Vogel Tool & Die, LLC 9200 Ivanhoe Street Schiller Park, IL 60176	Vogel Tool & Die, LLC 5 W. Laura Drive Addison, IL 60101



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ARC-FIT TUBE & PIPE NOTCHING TOOLING

#35 Housing, Hand Press, & Accessories

#35 Housing, to fit Vogel Hand & Hydraulic, or install in your ironworker, punch press or press brake	$275.00
#201-A Punch Press Adaptor, to assist in mounting #35 housing in your punch press	$250.00
#1400 Hand Press	$695.00

Pipe Assemblies for #35 Housing [*Pipe notched to fit the same size pipe*]

Pipe Size:	**1"**	**1-1/4"**	**1-1/2"**	**2"**	**For use with:**
Approx. OD:	1-3/8"	1-5/8"	1-7/8"	2-3/8"	
Schedule 40	$475.00	$475.00	$475.00	$475.00	Mild Steel
Schedule 40		$695.00	$695.00	$695.00	Stainless Steel
Schedule 80	$695.00	$695.00	$695.00	$695.00	Mild or Stainless Steel

Pipe assemblies for schedule 40 normally kept in stock. Other sizes typically mfg. at time of order.
For schedule 5 & 10, our schedule 40 notcher will work.
There will be increased burr, usually not an issue for a welded fit-up.
If you want a notcher made specifically for schedule 5 or 10, see custom assemblies below.

Standard Tube Assemblies for #35 Housing *[All suitable for stainless steel]*

Tube OD	1"	1-1/4"	1-3/8"	1-1/2"	1-5/8"	1-3/4"	1-7/8"	2"
16 Ga.	$695.00	$695.00	$695.00	$695.00	$695.00	$695.00	$695.00	$695.00
1/8" wall	$695.00	$695.00	$695.00	$695.00	$695.00	$695.00	$695.00	$695.00

Assemblies can be used on thinner wall tubes of the same OD. To notch 14 gauge tubing, select an 1/8" wall assembly. We can also custom make assemblies for specific gauges or OD not listed, see "Custom Assemblies" below. Stock on above assemblies varies. Mfg. time may be 4 - 5 weeks.

Custom Assemblies for #35 Housing

Equal & Unequal Fit-Ups, Tube or Pipe sizes not shown above. Notched tube of 2-3/8" OD or less	$1,295.00
Special Notches, Drainholes, Slots, up to 2-3/8" O.D	$1,425.00

Larger Housings & Arc-Fit Tooling

#75 Housing	$1,395.00
Schedule 40 pipe: 2-1/2" or 3", I.D. equal fit-up assemblies. Suitable for mild steel or stainless.	$2,375.00
All other tube and pipe sizes, equal and unequal fit-up assemblies up to 3-1/2" O.D. or square	$2,975.00

#125 Housing	$2,275.00
Schedule 40 pipe: 3-1/2" or 4", I.D. equal fit-up assemblies. Suitable for mild steel or stainless.	$3,250.00
All other tube and pipe sizes, equal and unequal fit-up assemblies up to 4-1/2" O.D. or square	$4,350.00

#175 Housing	$2,750.00
Schedule 40 pipe: 4-1/2" or 5", I.D. equal fit-up assemblies	$4,500.00
All other tube and pipe sizes, equal and unequal fit-up assemblies up to 5-9/16" O.D. or square	$5,450.00

#185 Housing	$3,850.00
Schedule 40 pipe: 6", I.D. equal fit-up assemblies	$7,925.00
All other tube and pipe sizes, equal and unequal fit-up assemblies up to 6-5/8" O.D. or square	$7,925.00

Sharpening services and replacement parts are available for your existing Arc-Fit Assemblies.
Please contact the factory at 630-562-1400 for more information.

ARC-TWIN TUBE & PIPE NOTCHING TOOLING

Arc-Twin Units For Use In Your Press *[tooling sold separately]*

Arc-Twin 101-DS Unit, (accepts tooling for up to 2-3/8" OD or square)	$16,500.00
Arc-Twin 103-DS Tandem Unit, (accepts two sets of tooling for up to 2-3/8" OD or square)	$21,500.00
Arc-Twin 300-DS Unit, (accepts tooling for up to 3" OD or square)	$34,500.00
Arc-Twin 500-DS Unit, (accepts tooling for up to 5" OD or square)	P.O.R.
Arc-Twin 324-DS Unit, (accepts tooling for up to 2" x 4" rectangle)	P.O.R.

Arc-Twin Self-Contained Hydraulic Machines *[tooling sold separately]*

Arc-Twin 101-HPP Hydraulic Unit, (accepts tooling for up to 2-3/8" OD or square)	$33,500.00
Arc-Twin 103-HPP Tandem Unit, (accepts two sets of tooling for up to 2-3/8" OD or square)	$37,375.00
Arc-Twin 301-HPP Hydraulic Unit, (accepts tooling for up to 3" OD or square)	P.O.R.
Arc-Twin 501-HPP Hydraulic Unit, (accepts tooling for up to 5" OD or square)	P.O.R.

Arc-Twin Accessories

Arc-Twin 110A Locator, (to maintain orientation when notching both tube ends. Ships in 24" length)	$1,825.00

101 Series Assemblies

Equal or Unequal fit ups, Round sizes not shown above, up to 2-3/8" O.D. x .154" max wall	$2,350.00
Square tubing, up to 2" square, notched with slots, or to fit round tubing	$2,650.00
Special slots in rounds, up to 2-3/8" O.D. x .154" max. wall	$2,650.00
Drain Holes, both walls	$2,875.00
Drain holes, one wall only, special assembly pricing (Sectional inserts)	$3,750.00

300 Series Assemblies

Schedule 40, equal fit-ups, choose from 1-1/2", 2", or 2-1/2" I.D., equal fit-ups	$2,550.00
Arc-Twin 300 Adaptor, (to run 100 series assemblies in your 300 series Arc-Twin Unit)	$4,875.00
All other applications	$3,650.00

324 & 500 Series Assemblies

All applications for 324 & 500 series Arc-Twin equipment	P.O.R.

Most Arc-Twin items are made at time of order, a 50% deposit is required.
Replacement parts are available on Vogel tooling, please call for pricing.
Sharpening available for your Vogel tooling, please call for details.

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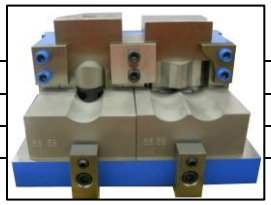
ARC-FIT ANGULAR TOOLING

Arc-Fit Angular Housing and Accessories



#75-A Arc-Fit Angular Two-Station Housing – Fits CSP-25-SA power unit	$1,545.00
#75-AAS Spanker Bar, required with Vogel CSP-25-SA Hydraulic Power Unit	$250.00
#85-A Arc-Fit Angular Two-Station Housing	$2,475.00

Arc-Fit Angular Assemblies

9214A Two-Station Assembly for 1" I.D.[1-3/8" approx. OD], schedule 40 pipe x 35°	$2,645.00
9215A Two-Station Assembly for 1-1/4" I.D.[1-5/8" approx. OD] schedule 40 pipe x 35°	$2,645.00
9566A Two-Station Assembly for 1-1/4" I.D. [1-5/8" approx. OD] schedule 40 pipe x 45°	$2,645.00
9216A Two-Station Assembly for 1-1/2" I.D. [1-7/8" approx. OD] schedule 40 pipe x 35°	$2,645.00
9567A Two-Station Assembly for 1-1/2" I.D. [1-7/8" approx. OD] schedule 40 pipe x 45°	$2,645.00
14111A Two-Station Assembly for 1-1/2" OD x 1/8" wall tubing x 35°	$2,645.00

Arc-Fit Angular Custom Assemblies to fit #75-A Housings

Equal or unequal fit-ups, up to 1-1/2" I.D. Pipe, 2" O.D. or for tube sizes or angles not listed above	$3,875.00

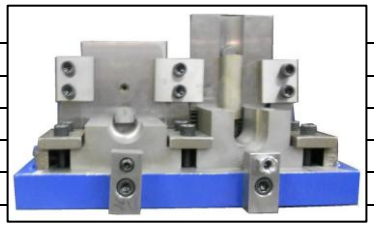
Arc-Fit Angular Custom Assemblies to fit #85-A Housings

All #85-A Assemblies, equal & unequal fit-ups	$5,275.00

For larger sizes, please consult factory

ARC-SNUG & MITRE-SNUG TOOLING

Arc-Snug Housings



#400 Housing – Fits CSP-25-SA Power Unit	$1,995.00
#400 Ram Pad for using in CSP-25-SA Power Unit	$250.00
#450 Housing	$2,295.00
#455 Housing	$2,595.00
#500 Housing	$3,650.00

Arc-Snug Assemblies

#400 Assemblies, tube or pipe sizes up to 1-1/4" O.D. or 1-1/4" square	$4,260.00
#450 Assemblies, tube or pipe sizes up to 2" O.D. or 2" square	$4,975.00
#455 Assemblies, tube or pipe sizes	$5,895.00
#500 Assemblies, tube or pipe sizes up to 3" O.D. or 3" square	$6,675.00

Arc-Snug Assembly Upgrades (add to above prices):

Assemblies with Drain Hole, 1st Station	+ $695.00
Assemblies with Drain Hole, 2nd Station	+ $695.00
Material upgrade (for stainless steel notching applications)	+ $695.00

Made-to-order tools require a 50% deposit.
Replacement parts are available on Vogel tooling, please call for pricing.
Sharpening available for your Vogel tooling, please call for details.

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Single Dimple Unit

PERF-ARC TOOLING

Double Dimple Unit

Perf-Arc Model #627 - For dimpled hole on tubes up to 1-1/4" round or square with up to 1/2" hole diameter

627-D Perf-Arc Unit, Dimpled hole, one wall only, incl. mounting holes for die set mounting	$950.00
627-DK Perf Arc Unit, Dimpled hole, one wall only, keyed for press brake	$1,050.00
627-DD Perf-Arc Unit, Dimpled hole, top & bottom wall, incl. mounting holes for die set mounting	$1,250.00
627-DDK Perf-Arc Unit, Dimpled hole, top & bottom wall, keyed for press brake mounting	$1,350.00
627 Perf-Arc, Replacement Punches (2-1/2" overall length)	$105.00

Perf-Arc Model #637 - For dimpled hole on tubes up to 2" round or square with up to 3/4" hole diameter

637-D Perf-Arc Unit, one wall only, incl. mounting holes for die set mounting	$1,450.00
637-DK Perf Arc Unit, Dimpled hole, one wall only, keyed for press brake	$1,550.00
637-DD Perf-Arc Unit, Dimples hole, top & bottom wall, incl. mounting holes for die set mounting	$1,650.00
637-DDK Perf-Arc Unit, Dimpled hole, top & bottom wall, keyed for press brake mounting	$1,750.00
637 Perf-Arc, Replacement Punches (Specify 3-1/8" or 3-3/8" overall length)	$135.00

Perf-Arc Model #647 - For dimpled hole on tubes up to 3" round or square with up to 1" hole diameter

647-D Perf-Arc Unit, one wall only, incl. mounting holes for die set mounting	$1,625.00
647-DK Perf Arc Unit, Dimpled hole, one wall only, keyed for press brake	$1,725.00
647-DD Perf-Arc Unit, Dimpled hole, top & bottom wall, incl. mounting holes for die set mounting	$1,850.00
647-DDK Perf-Arc Unit, Dimpled hole, top & bottom wall, keyed for press brake mounting	$1,975.00
647 Perf-Arc, Replacement Punches (Specify 4-1/4" or 4-5/8" overall length)	$165.00

Per-Arc Self-Contained Units – For dimpled hole top, clean hole bottom

629 Perf-Arc Unit (up to 1" Round or Square, up to ½" hole diameter)	$3,875.00
629 Replacement Punches (Specify 2-7/16" or 3-1/16" overall length)	$135.00
639, Perf-Arc Unit (up to 1-1/2" Round or Square, up to 3/4" hole diameter)	$4,250.00.
639 Replacement Punches (Specify 2-7/8" or 3-13/16")	$175.00
649, Perf-Arc Unit (up to 2" Round or Square, up to 1" hole diameter)	$4,650.00
649 Replacement Punches (Specify 3-3/4" or 5" overall length)	$195.00

Notes About Piercing:

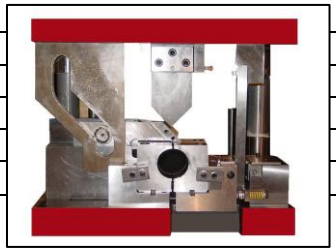
Capacity: Each Perf-Arc Tool is made for a specific tube size and hole size. 627 / 637 / 647 models can be easily changed to a new hole size by ordering replacement perforators. A new unit is needed to change tube size. 629 / 639 / 649 units require changing both the punch and lower die to change hole size. Unit replacement is recommended to change tube size.

Dimpled hole piercing is "as material flows". Factors that affect the amount of dimple include tube size & gauge, hole diameter, weld seam orientation, press speed, tooling sharpness and lubrication used. For this reason, we regret that we are unable to estimate or guarantee the amount of dimple that you may experience with the above tools.

Clean hole piercing requires a custom built mandrel-type piercing die, normally built in a two or four post die set.. In order to price this type of custom tool, please fax us a print of your part to: 630-562-1500, or email a PDF file to info@vogeltool.com, so we may review your application details and quote appropriate tooling.

CUT OFF DIES

1P Cut Off Die, 3” stroke (incl. micro-switch stop ass’y, less inserts & blades)	$18,950.00
1P Round Inserts (up to 1” O.D.)	$1,975.00
1P Square / Rectangle Inserts, (under 3/4” in largest dimension)	$2,450.00
1P Blades	From $40.00 /ea.
Incutting of Die Inserts for parts less than 1-1/2" long (to above prices)	+ $450.00



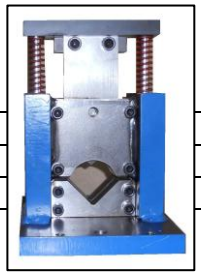
2P Cut Off Die, (incl. micro-switch stop ass’y, less inserts & blades)	$25,950.00
2LHP Cut Off Die, (incl. micro-switch stop ass’y, less inserts & blades)	$21,950.00
2P Round Inserts, (up to 2” O. D.)	$2,395.00
2P Square / Rectangle Inserts, (up to 1-1/2” in largest dimension)	$2,850.00
2P Blades	From $45.00 /ea.
Incutting of Die Inserts for parts less than 2-1/2" long, (add to above prices)	+ $550.00

3P Cut Off Die, (incl. micro-switch stop ass’y, less inserts & blades)	Request a Quote
3LHP Cut Off Die, (incl. micro-switch stop ass’y, less inserts & blades)	
3P Round Inserts, (up to 3” O. D.)	
3P Square / Rectangle Inserts, (up to 2-1/8” in largest dimension)	
3P Blades	
Incutting of Die Inserts for parts less than 3" long, (add to above prices)	

4P Cut Off Die, (incl. micro-switch stop ass’y, less inserts & blades)	Request a Quote
4LHP Cut Off Die, (incl. micro-switch stop ass’y, less inserts & blades)	
4P Round Inserts, (up to 4” O. D.)	
4P Square / Rectangle Inserts, (up to 2-13/16” in largest dimension)	
4P Blades	
Incutting of Die Inserts for parts less than 4" long, (add to above prices)	

6P Cut Off Die, (incl. micro-switch stop ass’y, less inserts & blades)	Request a Quote
6LHP Cut Off Die, (incl. micro-switch stop ass’y, less inserts & blades)	
6P Round Inserts, (up to 6” OD)	
6P Square / Rectangle Inserts, (up to 3-7/16” in largest dimension)	
6P Blades	
Incutting of Die Inserts for parts less than 4" long, (add to above prices)	

5827 Cut Off Die, (incl. micro-switch stop ass’y, less inserts & blades):	$12,225.00
5827 Round Inserts, (up to 1-1/8” O. D – tube will deform):	$2,250.00
5827 Square Inserts, (up to 1-1/8” square):	$3,150.00
5827 Standard Square Tubing Blades:	From $55.00



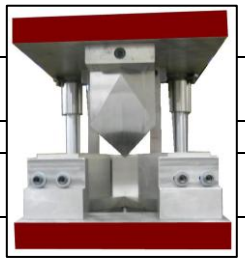
4162 Econo Cut Off Die	$3,575.00
Outboard Tube Supports (2 pcs. Set)	$725.00
Vertical Cut Off Blades	$75.00 /ea.

Titanium Nitrite (TiN) Coating of blades available & die inserts, please consult factory

TUBING V-NOTCH TOOLING & PARTING TOOLS FOR SOLID SHAPES

V-Notch Tooling for Square Tube

206-AA 90 degree V-Notch Unit, (90 degree angle between)	$12,875.00
206-AA 60 degree V-Notch Unit, (120 degree angle between)	$12,875.00
206-AA 45 degree V-Notch Unit, (135 degree angle between)	$12,875.00



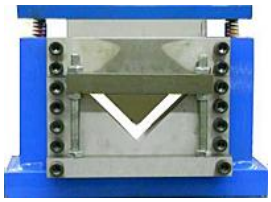
207 90 degree V-Notch Unit, (90 degree angle between)	$16,750.00
207 60 degree V-Notch Unit, (120 degree angle between)	$16,750.00
207 45 degree V-Notch Unit, (135 degree angle between)	$16,750.00

Tools to Part Solid Shapes

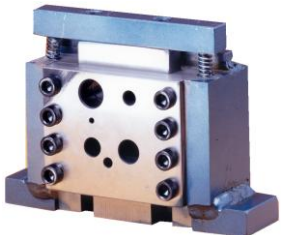
221 Housing	$1,500.00
221-RS Rod Shear Insert	$2,375.00
221-FS Flat Shear Insert	$2,375.00
221-AS Angle Shear Insert	$2,375.00
221-CS Channel & Special Shapes Insert	P.O.R.

222 Housing	$2,790.00
222-RS Rod Shear Insert	$3,375.00
222-FS Flat Shear Insert	$3,375.00
222-AS Angle Shear Insert	$3,375.00
222-CS Channel & Special Shapes Insert	P.O.R.

223 Housing	$3,650.00
223-RS Rod Shear Insert	$4,645.00
223-FS Flat Shear Insert	$4,645.00
223-AS Angle Shear Insert	$4,645.00
233-CS Channel & Special Shapes Insert	P.O.R



Angle Shear in Housing



Rod Shear in Housing

Replacement parts are available on all Vogel tooling. Please call for current pricing.
Most products on this page require a 50% deposit at time of order.

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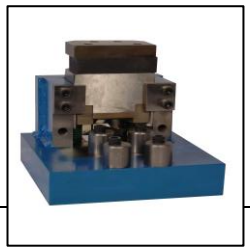
PICKET FENCE TOOLING



Form Pickets

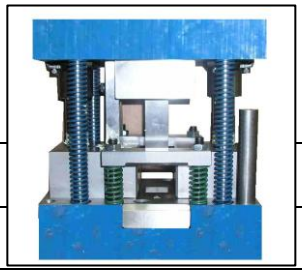
	PC75R Standard Radius Point Picket Fence Unit, (Specify ½", ¾" or 1"):	$4,395.00
	PC75R Standard Radius Tip Changeover Tooling, to convert above unit to a new size tubing	$600.00
	PC75R/HD Radius Tip Heavy Duty Unit (up to 1-1/4" square x up to 1/8" wall)	$8,795.00
	PC75R/HD Heavy Duty Radius Tip Changeover Tooling	$1,000.00
	PC75 Standard Sharp Point Picket Fence Unit, (Specify ½", ¾" or 1"):	$4,850.00
	PC75 Standard Sharp Point Changeover Tooling, to convert above unit to a new size tubing	$1,200.00

Standard Units designed for 16 gauge or thinner steel or 14 gauge or thinner aluminum. We also can offer custom tools for special angles or picket shapes. Please consult factory.

Picket Perforating Tool

	Pick-A-Picket Assembly: Christian Cross Design **[Re-pierces already formed picket with Cross]**	$3,125.00

Other designs available. Symbols, Letters, Logos. Please contact factory.



THP Tube Pierce Unit

Tube & Channel Piercing Tools

35CHP Channel Piercing Unit:	$1,950.00
75CHP Channel Piercing Unit:	$6,750.00
THP Square Tube Piercing Die, (incl. heavy-duty springs for single-acting press use):	$6,750.00
Picket Hole Stop Assembly, (fits 35CHP / 75CHP / THP units):	$775.00

Replacement parts are available on all Vogel tooling. Please call for current pricing.
Most products on this page require a 50% deposit at time of order.

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PRESSES

Hand Press (price does not include housing or assemblies, see page 2):

#1400 Hand Press, accepts #35 Housing & Assemblies only - sold separately	$695.00

CSP-25-SA

Hydraulic Press (prices do not include housing & tooling):

CSP 25-SA Hydraulic Power Tower Units, (120V, w/ foot switch) Accepts #35, #75 Housings, #75-A Angular Housing, Picket Fence Tooling Econo Cut Off Die & Triple Housing Turntable	$5,500.00

Hydraulic Press Accessories

201-A Punch Press Adaptor, (for mounting Arc-Fit #35 housing in CSP-25 units):	$250.00
75-AAS Spanker Bar, (required with Arc-Fit Angular tooling):	$250.00
CSP Triple-Housing Turntable, (incl. (3) #35 Housings, Assemblies sold separately, see page 2)	$1,125.00

Replacement parts are available on all Vogel tooling. Please call for current pricing.
End Forming machines and some other products on this page require a 50% deposit at time of order.

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Popular Arc-Fit Assemblies to fit the #35 Housing

Pipe Assemblies
To notch pipe to fit same size x 90°

Pipe Size	OD	Schedule	Wall	Assembly Number	Price
3/4"	1.050	5	.065"	11615A	$1,295.00
		10	.083"	10024A	$1,295.00
		40	.113"	9201A	$695.00
		80	.154"	9831A	$695.00
1"	1.315"	5	.065"	11576A	$1,295.00
		10	.109"	9322A	$1,295.00
		40	.133"	9202A	$475.00
		80	.179"	9357A	$695.00
1-1/4"	1.660"	5	.065"	9976A	$1,295.00
		10	.109"	9659A	$1,295.00
		40	.140"	9203 (Mild Steel)	$475.00
		40	.140"	9203A (Stainless)	$695.00
		80	.191"	9378A	$695.00
1-1/2"	1.900"	5	.065"	9526A	$1,295.00
		10	.109"	9315A	$1,295.00
		40	.145"	9204 (Mild Steel)	$475.00
		40	.145"	9204A (Stainless)	$695.00
		80	.200"	9280A	$695.00
2"	2.375"	5	.065"	10132A	$1,295.00
		10	.109"	9420A	$1,295.00
		40	.154"	9205 (Mild Steel)	$475.00
		40	.154"	9205A (Stainless)	$695.00
		80	.218"	9221A	$695.00

Note: This page lists only some of our popular Arc-Fit assemblies to fit the #35 Housing.

Note: If you work in the fence industry, please look at the left pipe assembly list above and check the “OD” column to find your material size.

Every year we also make hundreds of custom assemblies. Examples of custom assemblies include:

- One size tube or pipe notched to fit a different size
- Tube or pipe notched to fit another with a drainhole, to assist when galvanizing or powder coating
- Special shape slots or V-notches
- Non-standard sizes, such as metric tubing
- Square tubing to fit rounds

Custom assemblies typically require approx. 6 weeks manufacture time. To obtain a quote for your specialized notching application, simply email or fax a sketch of what’s required to: info@vogeltool.com

Tube Assemblies
To notch tube to fit same size x 90°

Tube Size	Gauge	Wall	Assembly Number	Price
3/4"	18	.049"	9407A	$1,295.00
	16	.065"	9305A	$695.00
	14	.083"	9708A	$1,295.00
	11	.125"	10436A	$695.00
7/8"	18	.049"	9237A	$1,295.00
	16	.065"	9264A	$695.00
	14	.083"	9263A	$1,295.00
	11	.125"	9696A	$695.00
1"	18	.049"	9272A	$1,295.00
	16	.065"	9242A	$695.00
	14	.083"	9262A	$1,295.00
	11	.125"	9905A	$695.00
1-1/8"	18	.049"	9467A	$1,295.00
	16	.065"	9359A	$695.00
	14	.083"	9222A	$1,295.00
	11	.125"	10629A	$695.00
1-1/4"	18	.049"	9574A	$1,295.00
	16	.065"	9219A	$695.00
	14	.083"	9238A	$1,295.00
	11	.125"	9380A	$695.00
1-3/8"	18	.049"	10052A	$1,295.00
	16	.065"	9611A	$695.00
	14	.083"	9274A	$1,295.00
	11	.125"	11037A	$695.00
1-1/2"	18	.049"	10802A	$1,295.00
	16	.065"	9269A	$695.00
	14	.083"	9350A	$1,295.00
	11	.125"	9351A	$695.00
1-5/8"	18	.049"	9454A	$1,295.00
	16	.065"	9233A	$695.00
	14	.083"	9517A	$1,295.00
	11	.125"	9240A	$695.00
1-3/4"	18	.049"	10794A	$1,295.00
	16	.065"	9255A	$695.00
	14	.083"	9456A	$1,295.00
	11	.125"	10113A	$695.00
1-7/8"	18	.049"	11602A	$1,295.00
	16	.065"	9513A	$695.00
	14	.083"	9553A	$1,295.00
	11	.125"	9694A	$695.00
2"	18	.049"	11496A	$1,295.00
	16	.065"	9270A	$695.00
	14	.083"	9384A	$1,295.00
	11	.125"	9229A	$695.00