PASS | STANZTECHNIK AG

TRUMPF

THICK TURRET

SALVAGNINI

PRODUCT PORTFOLIO 08/2026

SYSTEM TRUMPF, THICK TURRET & SALVAGNINI

FOR MACHINE TYPES TRUMPF, THICK TURRET & SALVAGNINI

THANK YOU VERY MUCH,

for your interest in a tool produced by PASS Stanztechnik AG.

With this brochure we would like to introduce you to our product portfolio. Therefore, we have prepared this document for your including the most important tools from the TRUMPF, THICK TURRET and SALVAGNINI systems.

Please feel free to contact us in any case of questions.

Yours

PASS Stanztechnik AG

FOR MACHINE TYPES TRUMPF, THICK TURRET & SALVAGNINI

ALL SYSTEMS

Countersinks: ps:®countersink ..... page 4
Embossings and markings ..... page 5
Connections: ps:®macro-joint ..... page 6
Hinges ..... page 7
Ball deburring: ps:®ball-deburr ..... page 8
Knock-outs: ps:®knock-out ..... page 9
Design: ps:®texture ..... page 10
Wheel tools: ps:®wheel ..... page 11

SYSTEM TRUMPF

ps:®MT5 for punching ..... page 12
ps:®easy-type ..... page 13
ps:®MT10 for punching ..... page 14
ps:®MT10 for embossing ..... page 15
ps:®flange90° + ps:®flange180° ..... page 16
ps:®single-thread ..... page 17
ps:®emboss5 ..... page 18
ps:®slitting5 ..... page 19
ps:®T8-shear ..... page 20
ps:®T8-trim ..... page 21
ps:®engraving-up ..... page 22
ps:®low-scratch-stripper ..... page 23
ps:®position ..... page 24
ps:®pivot ..... page 25
ps:®passfit ..... page 26
ps:®3D-RTC ..... page 27

SYSTEM THICK TURRET

ps:®hook ..... page 28
ps:®marking-all-in-one ..... page 29
ps:®basic ..... page 30
ps:®assembly-element ..... page 31
ps:®multi-thread® ..... page 32
ps:®MTP3RiB(PIN)-31,75 ..... page 33
ps:®MTP8RiA(PIN)-12,7 ..... page 34
ps:®MTP3RiB(I-RAM)-31,75 ..... page 35
ps:®MTP8RiA(I-RAM)-12,7 ..... page 36
ps:®beta-V2® ..... page 37

SYSTEM SALVAGNINI

Shear blades ..... page 38
Tool cassettes type standard ..... page 39
Tool cassettes type P21 up to P24 ..... page 40
Tool cassettes type P23 and P24 ..... page 41
Tool cassettes type single P2R ..... page 42

COUNTERSINKS: ps:®countersink

FOR MACHINE TYPES TRUMPF, THICK TURRET & SALVAGNINI

- countersinks in steel, aluminum and stainless steel possible
- available in two versions: rigid and spring-loaded

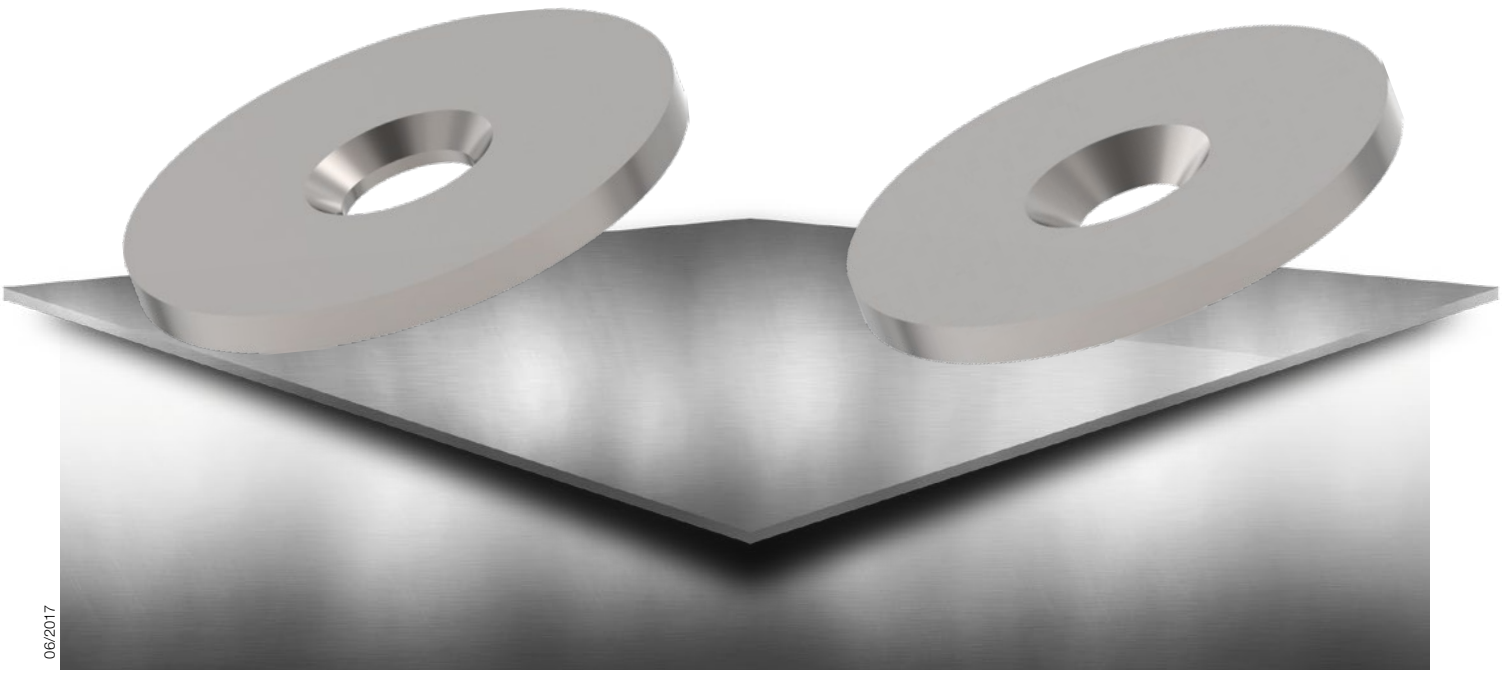
rigid version:

- countersink depth
  - aluminium: approx. 90 % of sheet thickness
  - steel: approx. 80 % of sheet thickness
  - stainless steel: approx. 66 % of sheet thickness

spring-loaded version:

- countersink depth: almost 100% of the sheet thickness
- countersink die in reinforced version
- reinforced spring in the upper part to keep the sheet flat and improve the flow behavior

rigid version **spring-loaded version**



06/2017

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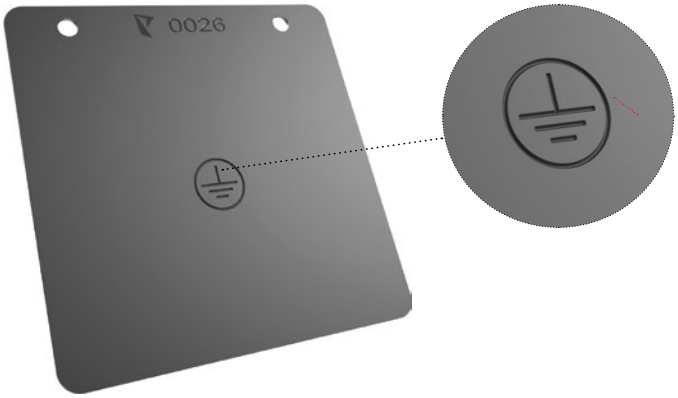
EMBOSSINGS AND MARKINGS

FOR MACHINE TYPES TRUMPF, THICK TURRET & SALVAGNINI

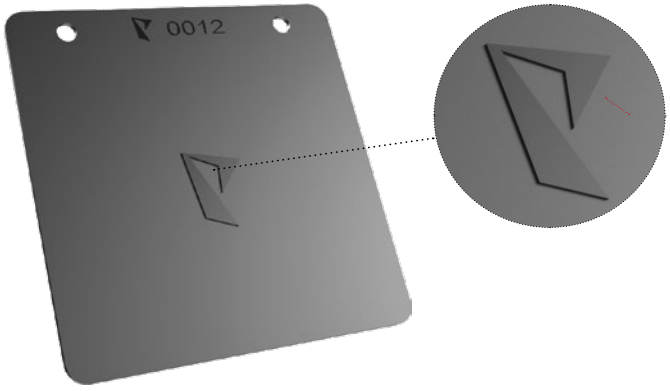
Marking tool:

- markings possible from below and above with a depth of up to approx. 0,5 mm
- fine, recessed lines possible
- markings in one hit
- effective and fast production
- application area: attachment of logos to finished products, ground symbols, protective conductor signs



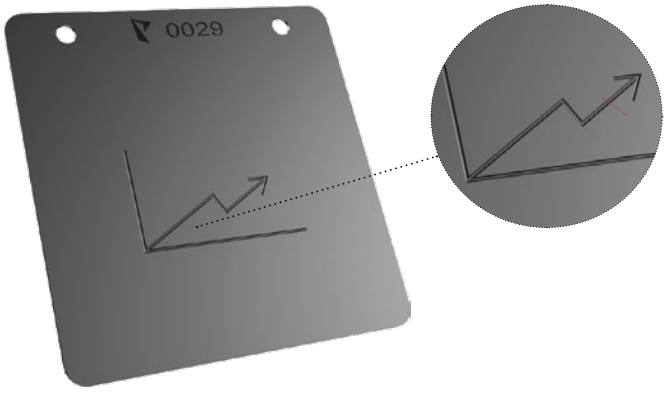
Embossing tool:

- raised embossing in one hit
- optically high quality
- application area: optical and visible sheets with logos, symbols, shapes or characters



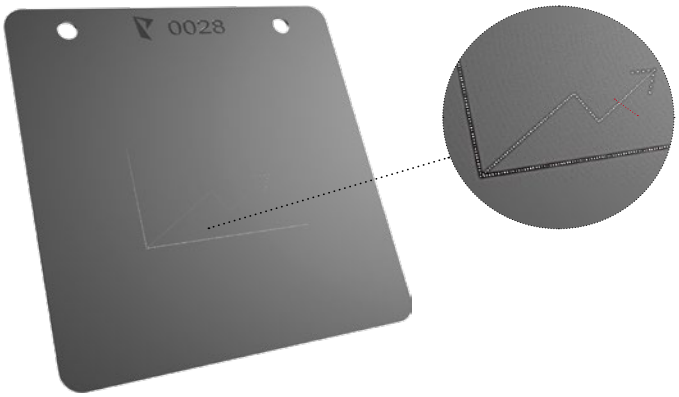
Engraving tool:

- engravings with a depth of approx. 0,15 mm
- numbers, letters, special characters, free shapes
- flexible usable



Signing tool:

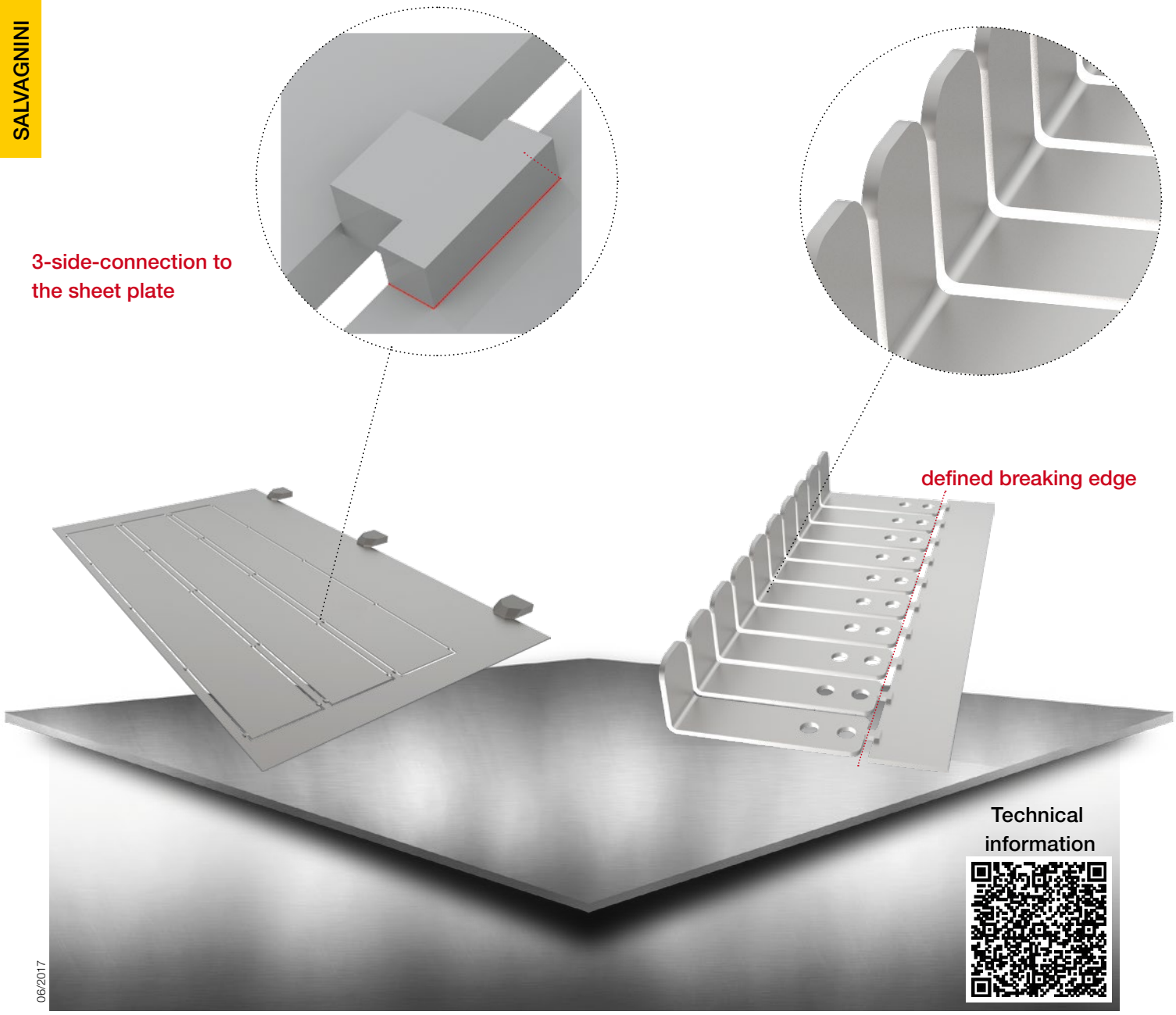
- signing of parts from individual, composite grain points
- application area: numbers, letters, special characters, free shapes



CONNECTIONS: ps:®macro-joint

FOR MACHINE TYPES TRUMPF, THICK TURRET & SALVAGNINI

- for effective production with manual part extraction
- **ps:®macro-joint** connects individual parts on a sheet plate
- connecting bridges remain on the rest fence when the parts are broken out thanks to 3-side connection
- no waste of the machine table caused by slugs
- bending of several small parts together possible
- timesaving
- optimizing the production process
- trouble-free production process



06/2017

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HINGES

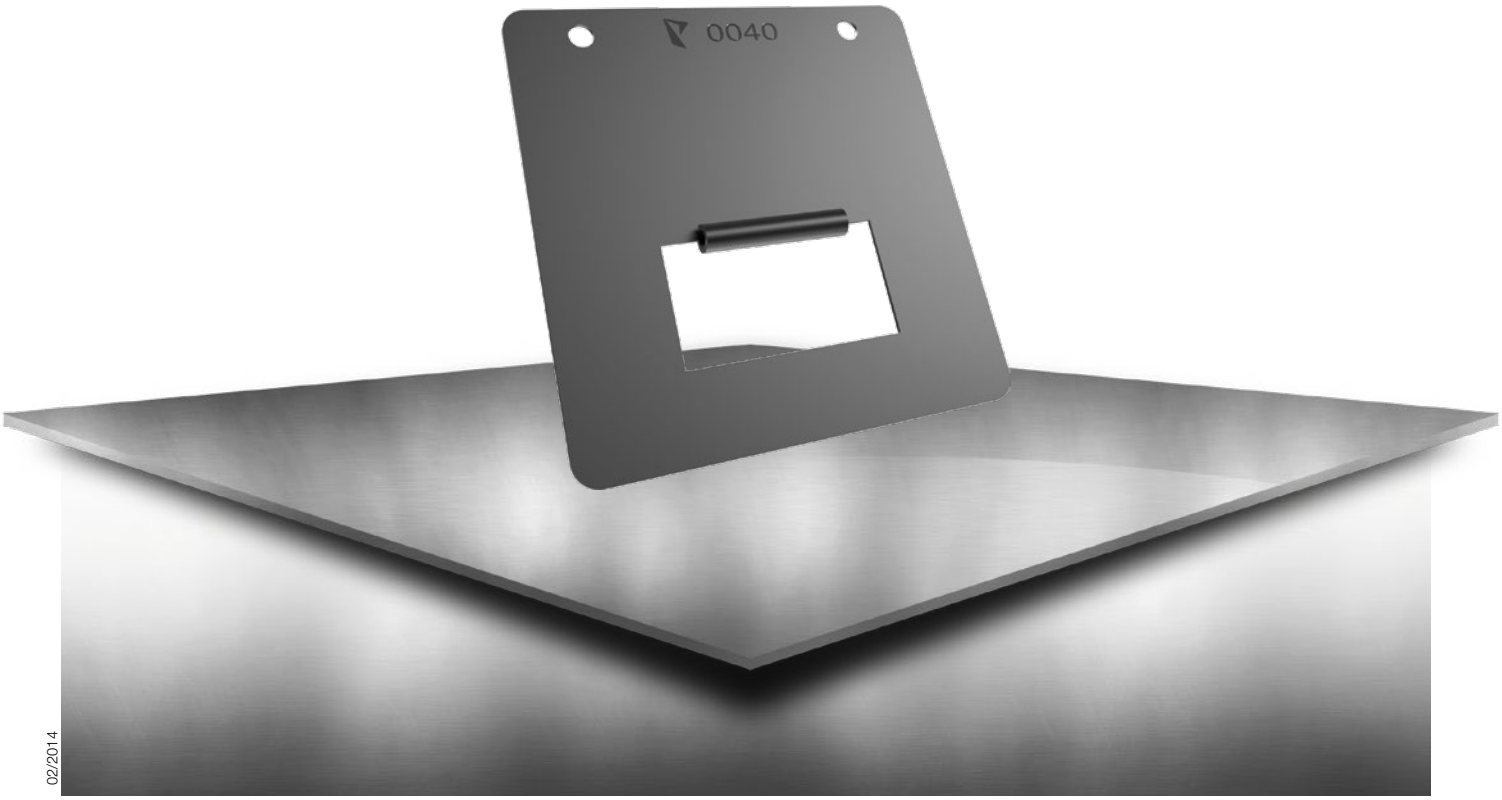
FOR MACHINE TYPES TRUMPF, THICK TURRET & SALVAGNINI

- for producing hinges with 2 tools
- bending up takes place with at least 2 hits with a pre-forming tool
- finishing of the hinge is done by a rigid finish-forming tool
- different sizes, lengths and diameters possible
- depending on Ø to sheet thickness
- for sheet materials aluminium, steel, stainless steel

step 1

step 2

step 3



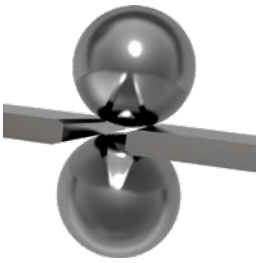
02/2014

BALL DEBURRING: ps:®ball-deburr

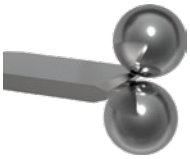
FOR MACHINE TYPES TRUMPF, THICK TURRET & SALVAGNINI

TRUMPF
THICK TURRET
SALVAGNINI

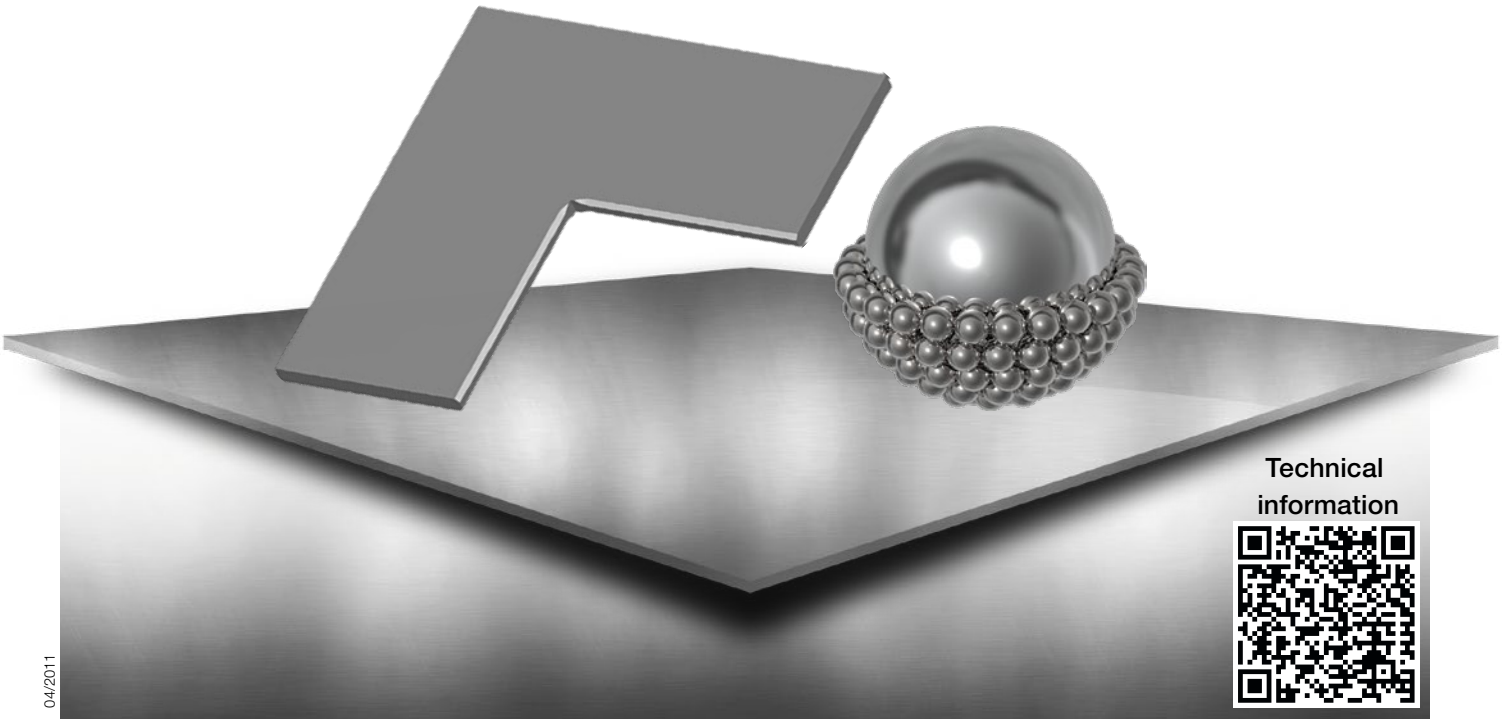
- for automated deburring of sheets
- for sheet materials aluminium, steel, stainless steel
- high operating safety by spring-loaded ball inserts (safety mechanism)
- low maintenance – long tool life
- for usage on sheet edge or 5,0 mm slitting cut
- 2 versions available:
  V3 (ball Ø 15)
  optimised deburring of combined slitting cuts
  V4 (ball Ø 8)
  deburring close to edges possible
- for sheet thickness up to s = 6,0 mm (depending on the tooling system)
- ball integrated in a solid and hardened rack
- ball works free of clearance under pressure during process
- polished ball rack providing a trouble free procedure



Version V3 Ø 15 mm



Version V4 Ø 8 mm



Technical information

04/2011

KNOCK-OUTS: ps:®knock-out

FOR MACHINE TYPES TRUMPF, THICK TURRET & SALVAGNINI

normal knock-outs:

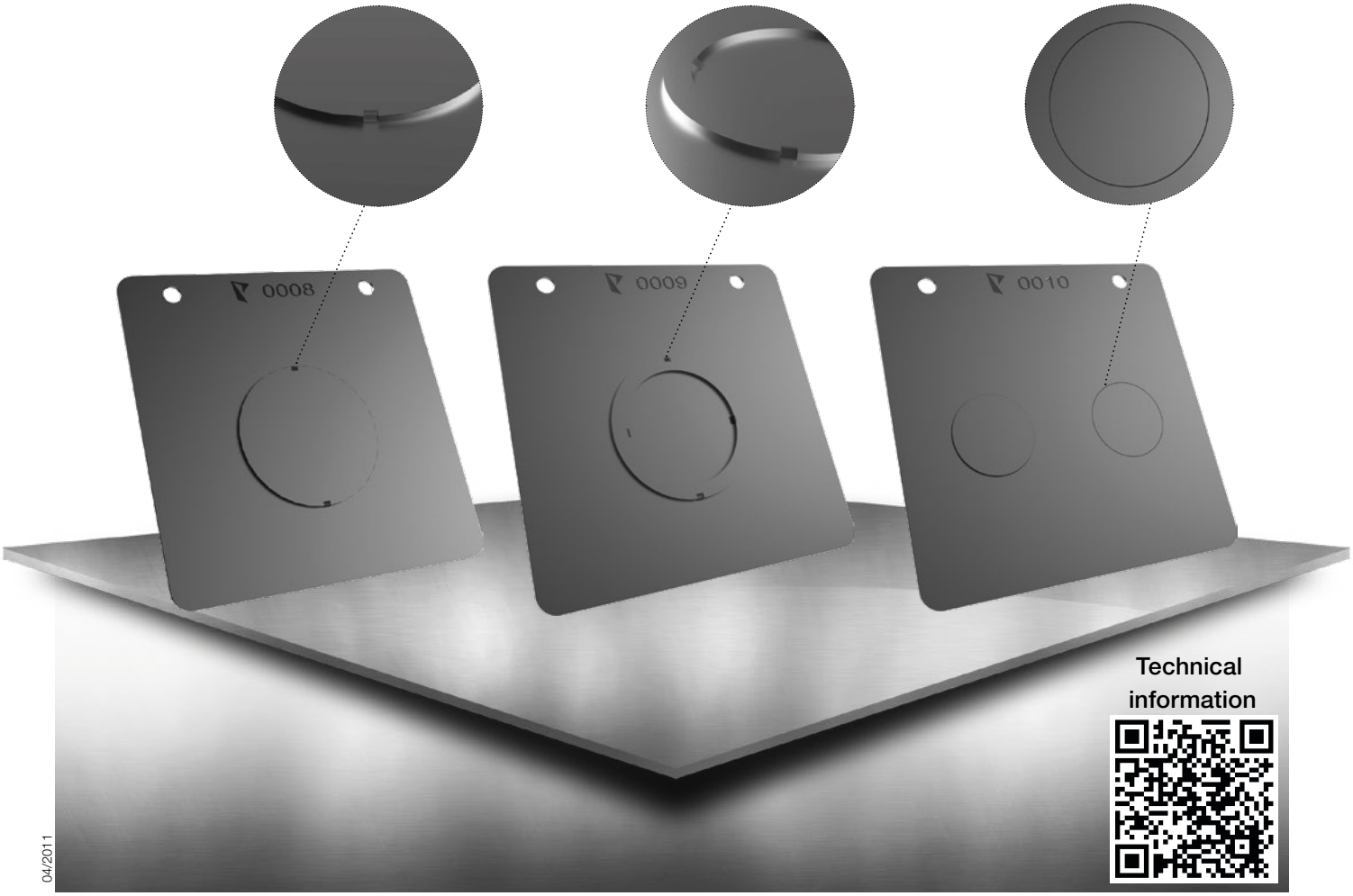
- production of knock-outs with one diameter in one hit
- suitable for all standard sheet thicknesses and sheet materials as well as surface coatings (powder, zinc, etc.)

ring knock-outs:

- production of ring knock-outs with two diameters in one hit
- suitable for all standard sheet thicknesses and sheet materials as well as surface coatings (powder, zinc, etc.)

ps:®knock-out

- production of the knock-outs in two steps:
  step 1: production of the knock-out
  step 2: flattening
- non-sharp-edged connections (risk for damaging the cable is decreased)
- slug can be removed on both sides
- suitable for all standard sheet thicknesses and sheet materials as well as surface coatings (powder, zinc, etc.)



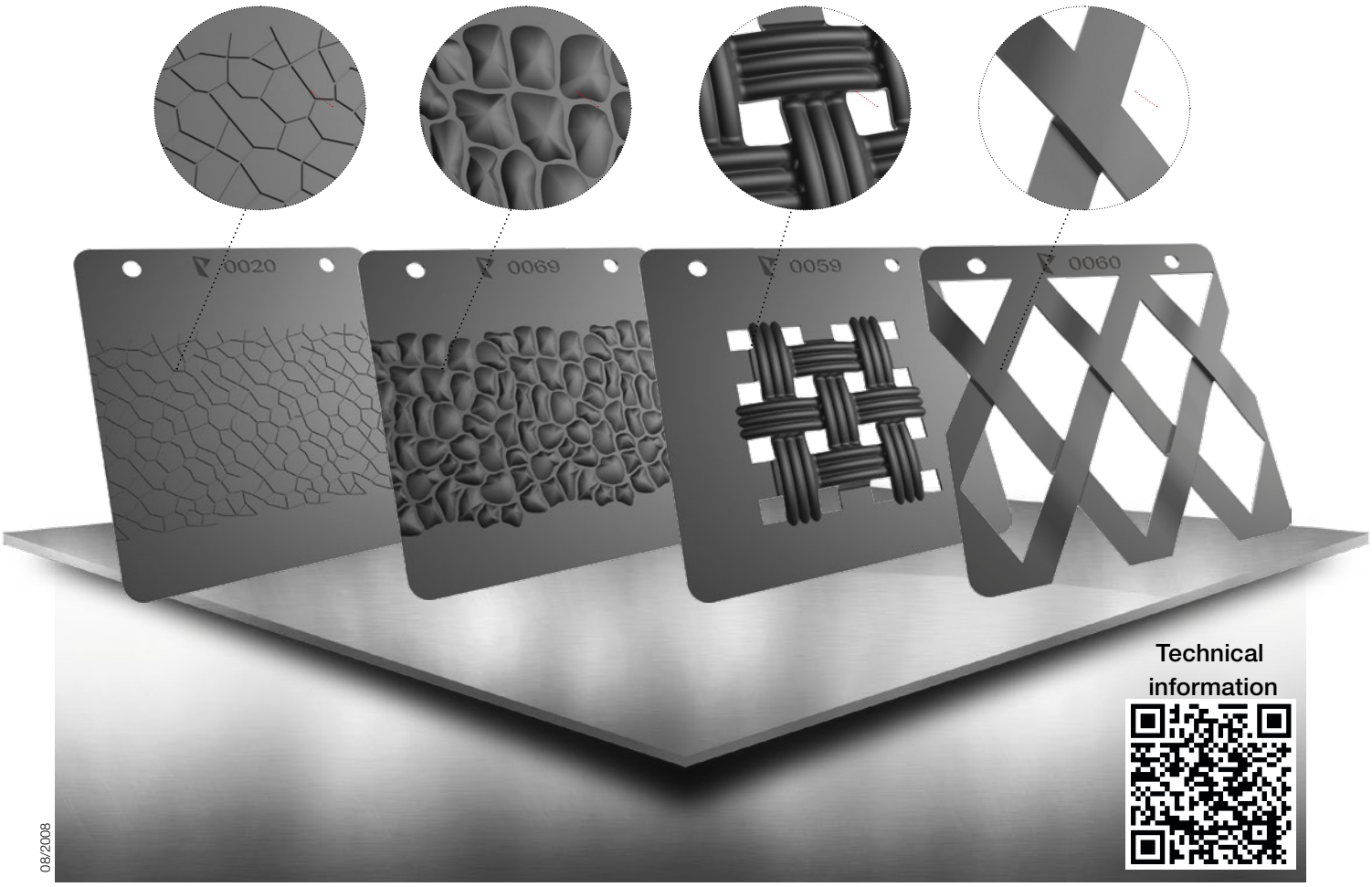
Technical information

04/2011

DESIGN: ps:®texture

FOR MACHINE TYPES TRUMPF, THICK TURRET & SALVAGNINI

- application of visible sheets in architecture: interior and exterior of private and public buildings
- specific design of sheets for car tuning area
- expanded metal, textured sheets and other optical sheets are used in many design products, garden chairs, tables and storage systems
- advantage of PASS tools: applicable in small areas of a sheet plate
- different types of pre-punching with one tool achieves unique appearances
- for sheet materials aluminium, steel
- continuous punching tool
- engineered parameters reduce warpage
- programming as embossing tool required
- for sheet thickness s = 0,3 up to approx. 2,0 mm



Technical information

08/2008

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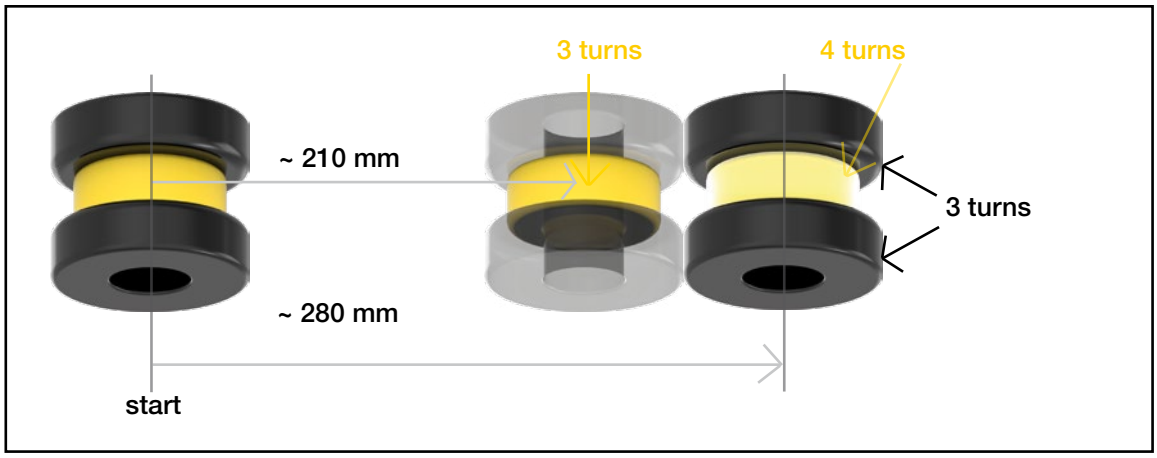
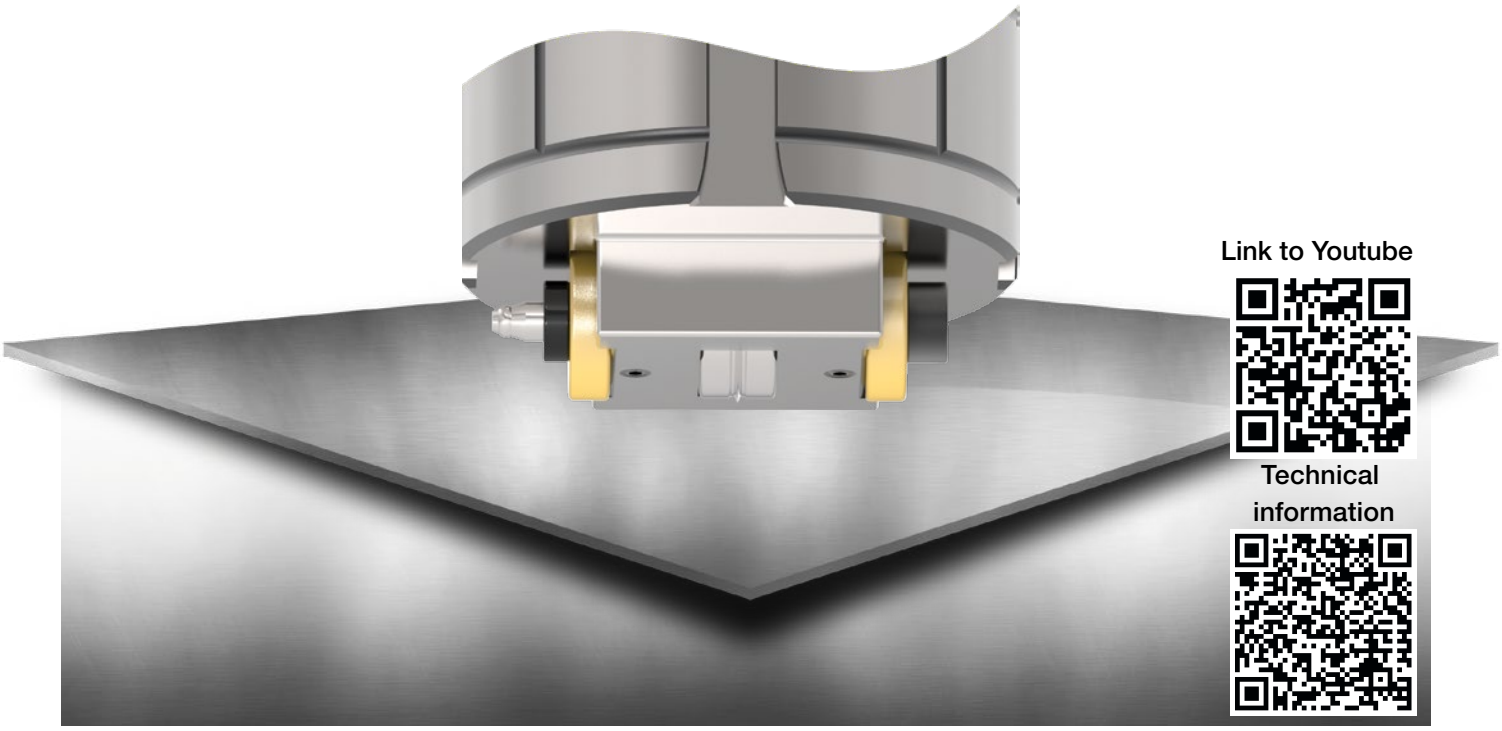
WHEEL TOOLS: ps:®wheel

FOR MACHINE TYPES TRUMPF, THICK TURRET & SALVAGNINI

- for different range of applications (e.g. beading-, flange- or offset-tool)
- reduced warpage because of differential effect (segmented wheels)
- no chatter marks
- integrated lubrication
- working with close radius possible
- perfect operating characteristics due to the shafts coated with a special lubrication
- dimensions according to customer requirements
- for different sheet materials and thicknesses





Link to Youtube

Technical information

ps:®MT5 FOR PUNCHING

FOR MACHINE TYPE TRUMPF - MACHINE GROUP I

TRUMPF

- for sheet materials aluminium, steel, stainless steel
- for sheet thickness s = up to 4,5 mm (stainless steel s = up to 3,0 mm)
- max. diameter 16,0 mm
- max. punching force 57 KN
- working with 5 different punching shapes in ONE tool
- special shapes, numbers or letters possible
- time savings in setup and tool change times

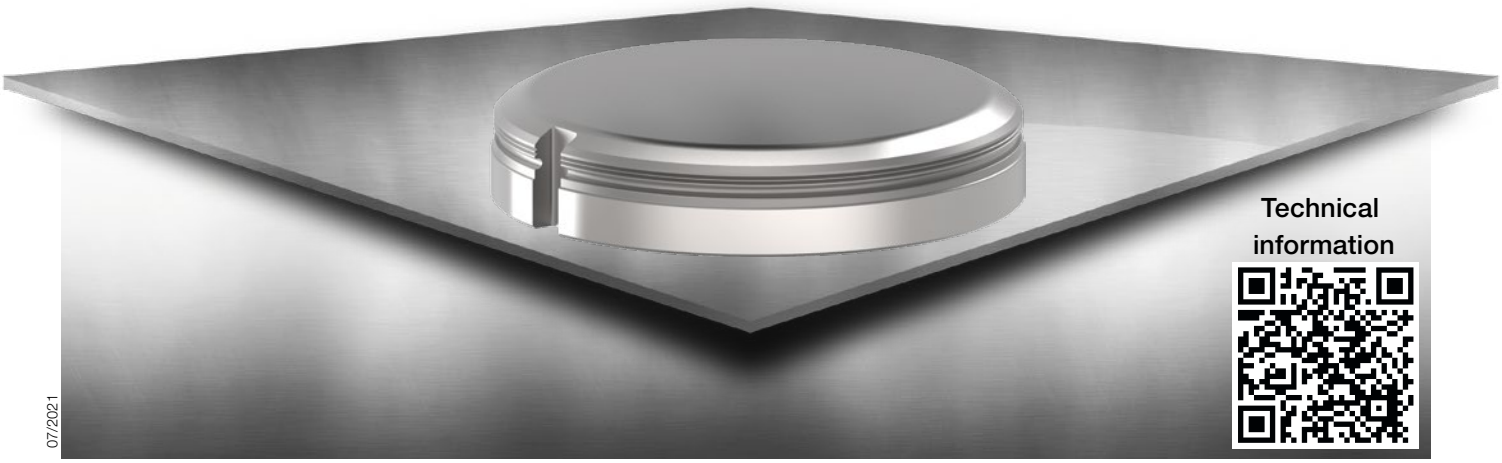
Technical information

07/2021

ps:®easy-type

FOR MACHINE TYPE TRUMPF - MACHINE GROUP I

- for sheet materials aluminium, steel, stainless steel
- for sheet thickness s = 0,5 mm up to 8,0 mm
- working with 5 different inserts for embossing in ONE tool
- for embossing numbers, letters and characters by lining up embossing segments
- font sizes 4, 5, 6, 8 or 10 mm possible
- max. embossing depth 0,5 mm
- time savings in setup and tool change times



Technical information

ps:®MT10 FOR PUNCHING

FOR MACHINE TYPE TRUMPF - MACHINE GROUP I

TRUMPF

- for sheet materials aluminium, steel, stainless steel
- for sheet thickness s = up to 4,5 mm (stainless steel s = up to 3,0 mm)
- max. diameter 10,5 mm
- max. punching force 57 KN
- working with 10 different punching shapes in ONE tool
- special shapes, numbers or letters possible
- time savings in setup and tool change times

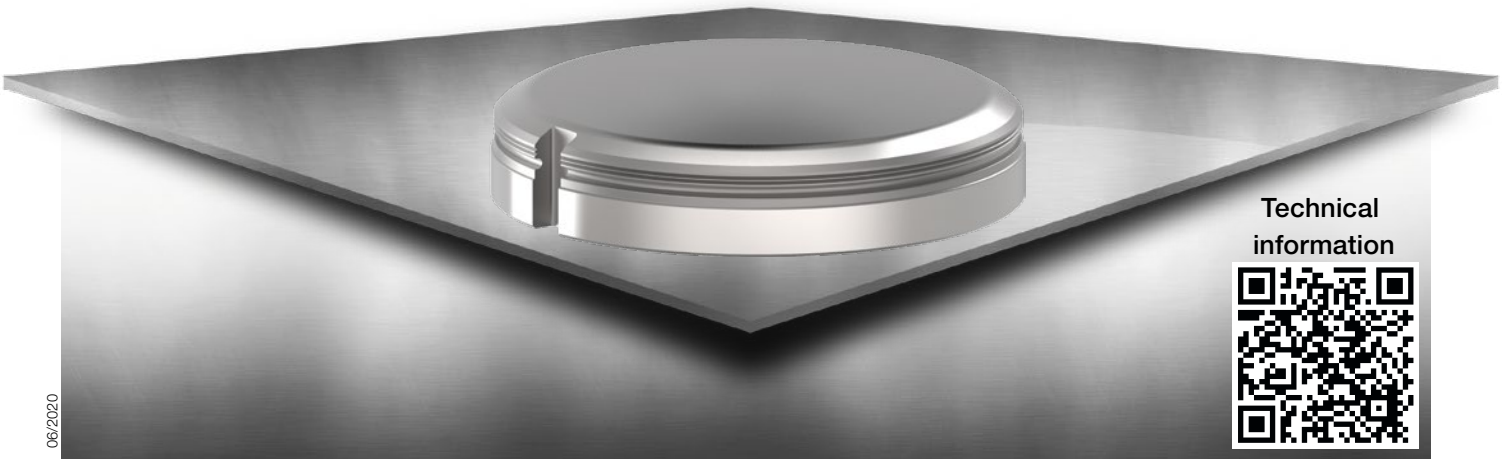
Technical information

07/2021

ps:®MT10 FOR EMBOSSING

FOR MACHINE TYPE TRUMPF - MACHINE GROUP I

- for sheet materials aluminium, steel, stainless steel
- for sheet thickness s = 0,5 mm up to 8,0 mm
- working with 10 different inserts for embossing in ONE tool
- for embossing e.g. numbers and protective conductor symbols
- max. embossing depth 0,5 mm
- time savings in setup and tool change times



Technical information

06/2020

ps:®flange90° + ps:®flange180°

FOR MACHINE TYPES TRUMPF & THICK TURRET

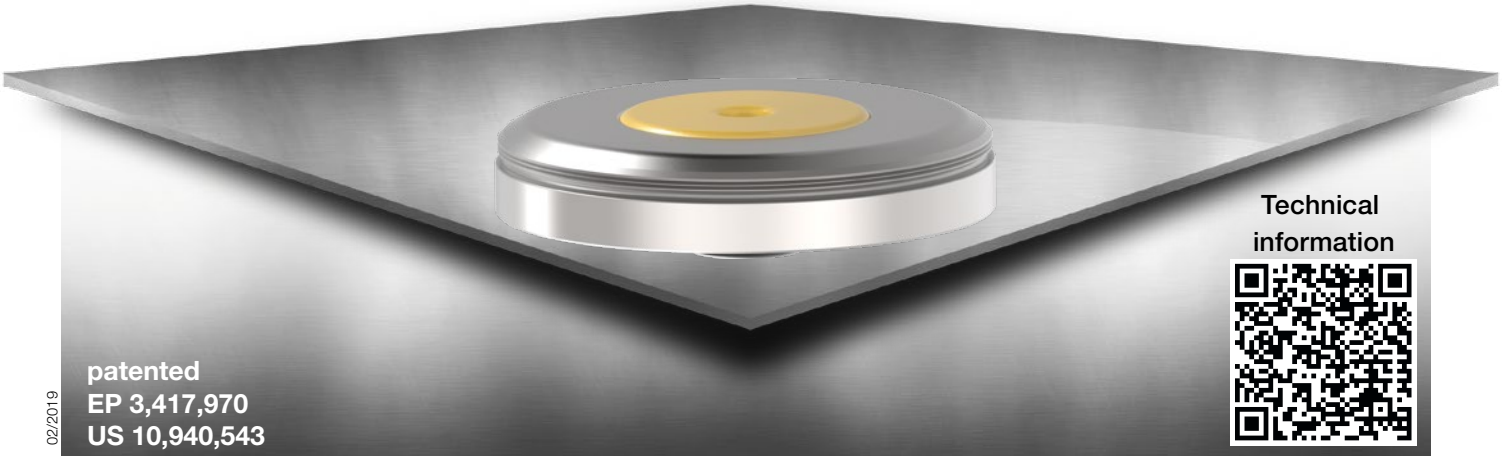
- bend, e.g. with dimension 30 x 70 mm
- flanging possible in two degrees:
  1.90° flanging with **ps:®flange90°**
  2.180° flanging with
  ps:®flange90°+ **ps:®flange180°**
- for all sheet materials
- application area:
  recessed grips of boxes or bushings

10/2019

ps:®single-thread

FOR MACHINE TYPE TRUMPF - MACHINE GROUP I

- for all sheet materials aluminium, steel, stainless steel
- for sheet thickness s = 1,0 up to 8,0 mm
- thread M2,5 up to M10
- thread forming in flat sheets and in extrusions
- easy and tool-free changing of the thread modules by slide-part system
- easy change of tap inserts by means of magnetic holder



patented
EP 3,417,970
US 10,940,543

Technical information

02/2019

ps:®emboss5

FOR MACHINE TYPE TRUMPF

- special tools with max. size as spring-loaded lower part (Ø 98,5 mm)
- special assembly for reducing sheet warpage for large embossings
- extended upper part with enlarged surface
- active die necessary

e.g. dimensions of 45 x 75 mm

10/2018

ps:®slitting5

FOR MACHINE TYPE TRUMPF

- for normal slitting cuts and process-reliable discharge of small parts
- for sheet thickness s = 0,5 up to 3,0 mm
- reduced processing times
- maximum process reliability due to monitored ejection process
- active or lowerable die necessary

09/2018

ps:®T8-shear

FOR MACHINE TYPE TRUMPF - MACHINE GROUP I

- for slitting sheets with smooth sheet edge
- for all sheet materials aluminium, steel, stainless steel
- for sheet thickness s = 0,5 up to 3,0 mm
- no nibbling marks
- die plate is available in two versions: single die plate for s = 0,5 up to 1,5 mm pair of die plates for s = 2,0 up to 3,0 mm

ps:®T8-trim

FOR MACHINE TYPE TRUMPF - MACHINE GROUP I

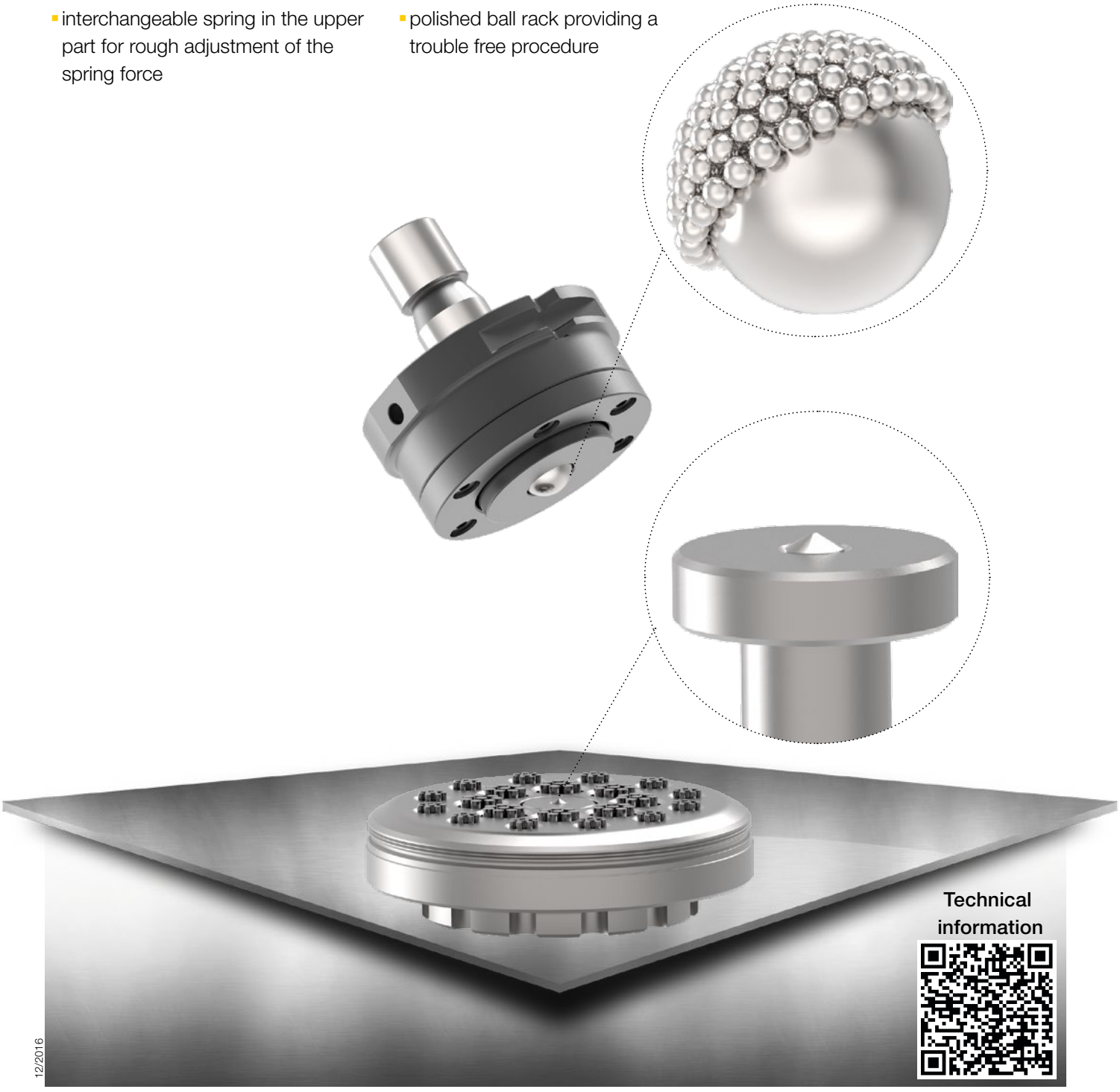
- for trimming sheets
- for all sheet materials
  aluminium, steel, stainless steel
- for sheet thickness s = 0,5 up to 3,0 mm
- no nibbling marks
- die plate is available in two versions:
  single die plate for s = 0,5 up to 1,5 mm
  pair of die plates for s = 2,0 up to 3,0 mm

ps:®engraving-up

FOR MACHINE TYPES TRUMPF & THICK TURRET

TRUMPF

- for all sheet materials and sheet thicknesses
- fully adjustable pre-loaded spring in the upper part for fine adjustment
- interchangeable spring in the upper part for rough adjustment of the spring force
- ball integrated in a solid and hardened rack
- ball works free of clearance under pressure during process
- polished ball rack providing a trouble free procedure
- low maintenance – long tool life
- diamond needle insert for supreme tool life



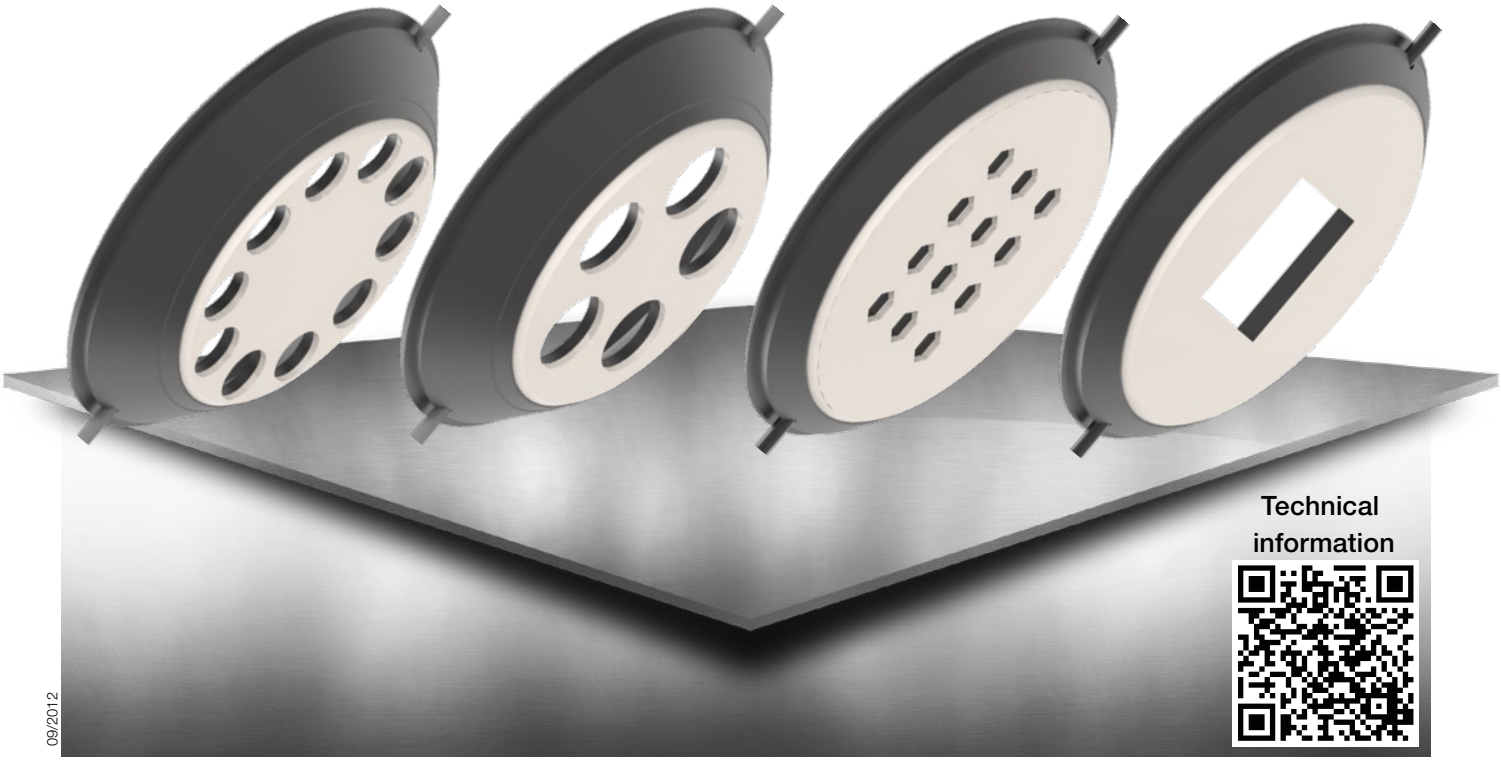
Technical information

12/2016

ps:®low-scratch-stripper

FOR MACHINE TYPE TRUMPF

- scratches on the upper side of the sheet are minimised
- reinforced base body to secure stability
- extreme high abrasive life of the PU-coating
- available for multitools ps:®MT5 and ps:®MT10 as well as normal punching tools and multitools



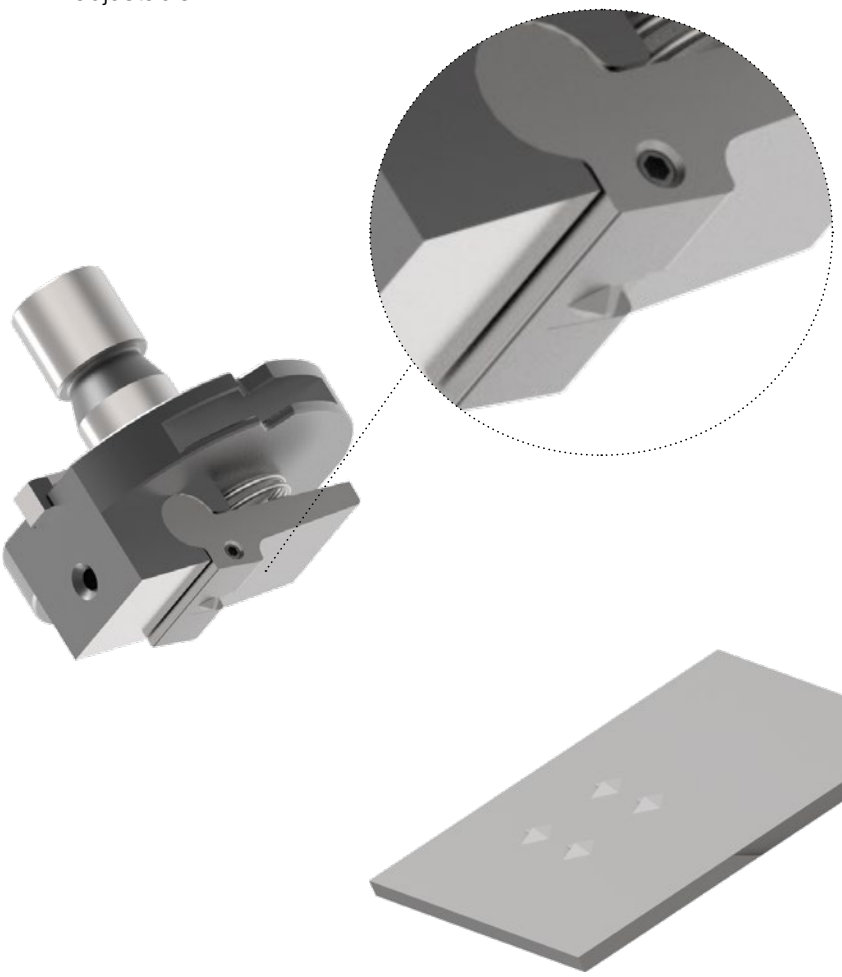
Technical information

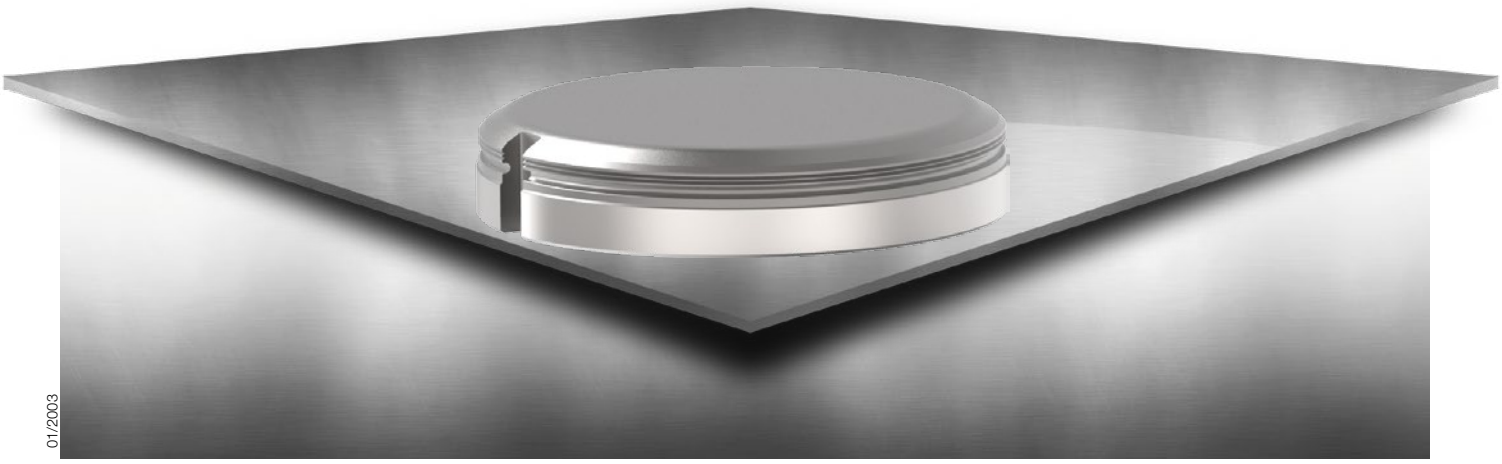
09/2012

ps:®position

FOR MACHINE TYPE TRUMPF

- for creating auxiliary stops for the accurate alignment of two sheets
- for sheet thickness s = 0,8 up to 6,0 mm
- no deformations on the bottom side of the sheet
- form height and size on the upper side of the sheet are flexibly adjustable
- programming as embossing tool required
- for sheet materials aluminium, steel





01/2003

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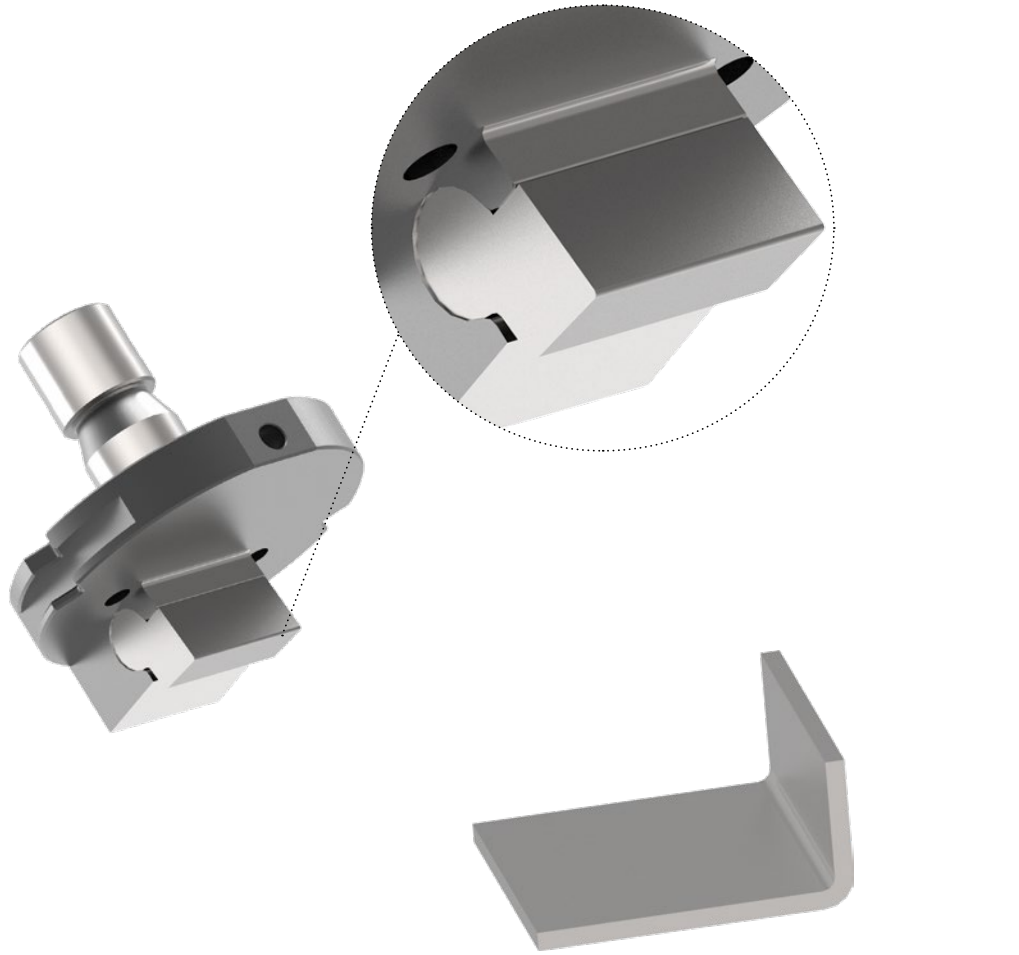
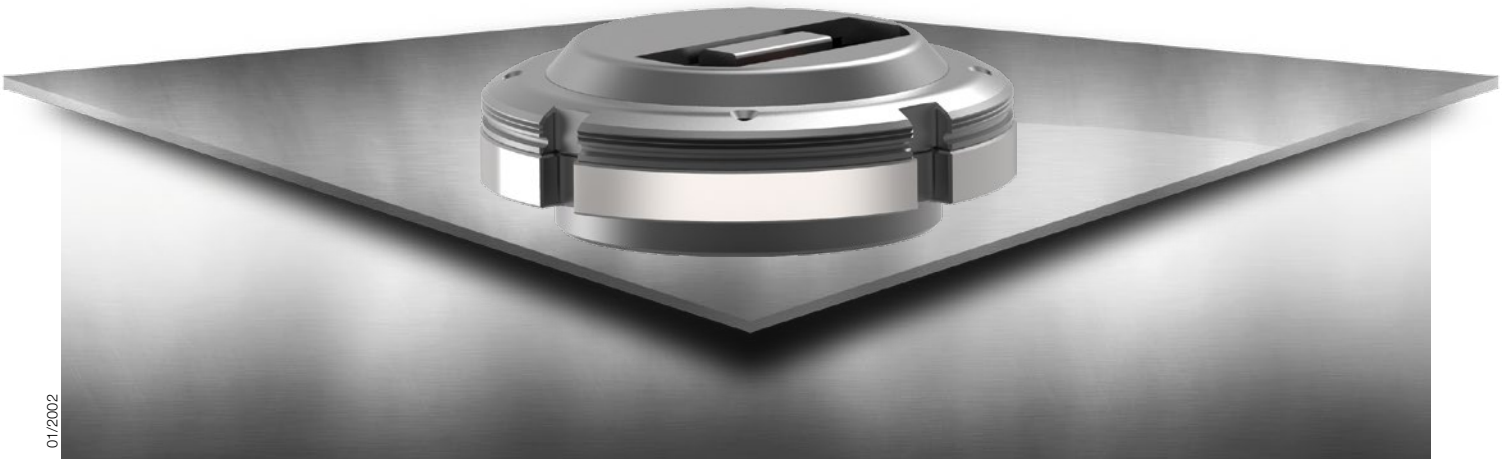
ps:®pivot

FOR TRUE 90° BENDS

- for sheet materials aluminium, steel, stainless steel
- height of tab is limited by machine type (e.g. TRUMPF machines up to 22,0 mm tab height)
- tab widths up to 55,0 mm
- even slight overbending (approx. 91-93°) is possible
- programming as embossing tool or with "Multibend" function required
- for sheet thickness s = 0,8 up to 1,5 mm (aluminium and steel up to 2,0 mm)



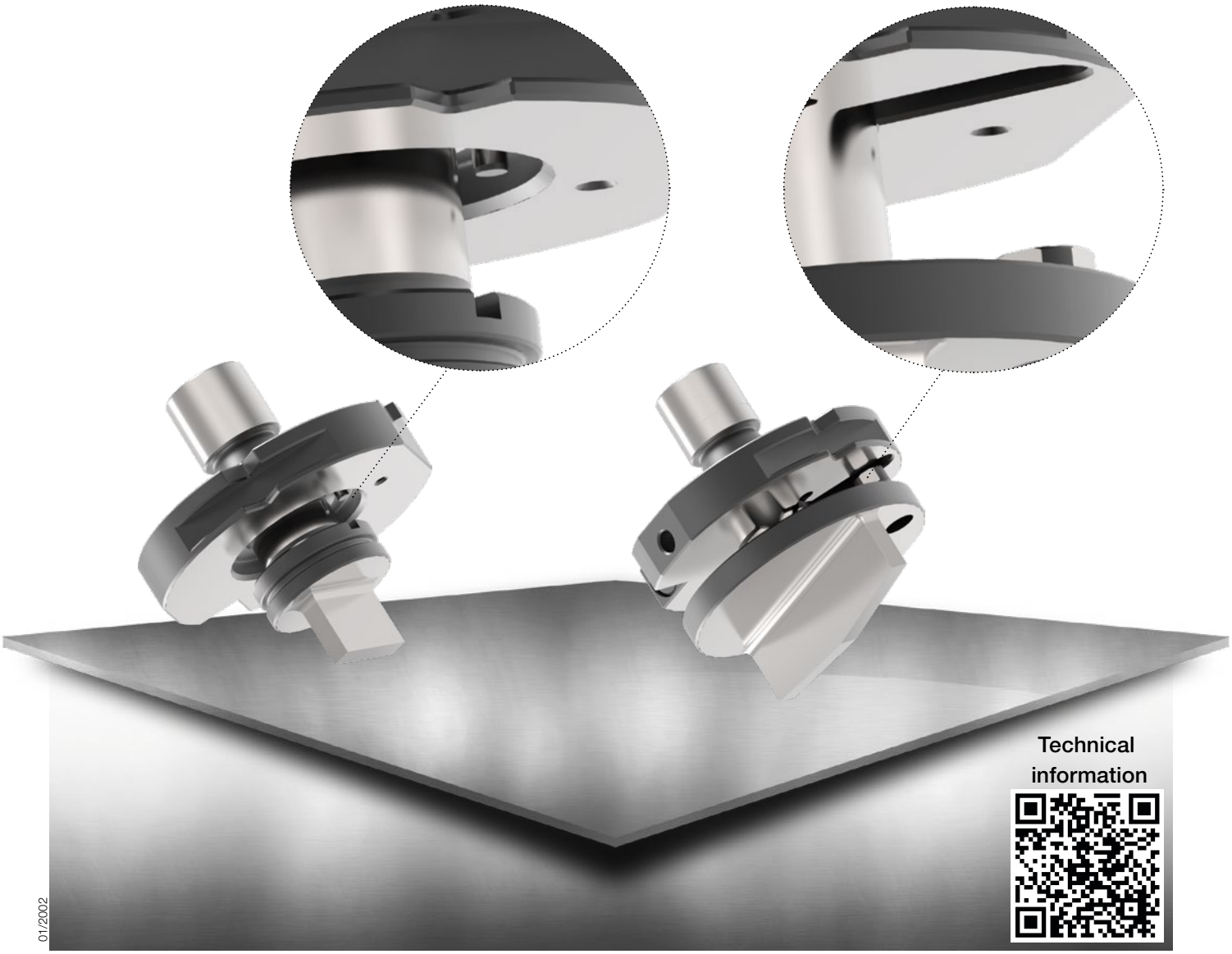


01/2002

ps:®passfit

FOR MACHINE TYPE TRUMPF

- extremely fast and easy adjustment of the tools without additional tool
- high operational security of the machine preventing expensive tool misalignments
- extremely high tool stability (sheets up to 12,0 mm – also stainless steel – can be punched)
- no expensive base bodies are necessary
- all PASS special tools, e.g. embossing tools (louver, beads, bridges, lances, etc.) are manufactured and delivered with **ps:®passfit**



Technical information

01/2002

ps:®hook

FOR MACHINE TYPES TRUMPF & THICK TURRET

- production of double bends in the smallest space
- forming station necessary
- embossing height up to 14 mm
- many different application areas e.g. case construction, steel furniture, drawers, transport boxes, etc.
- for all sheet materials aluminium, steel, stainless steel

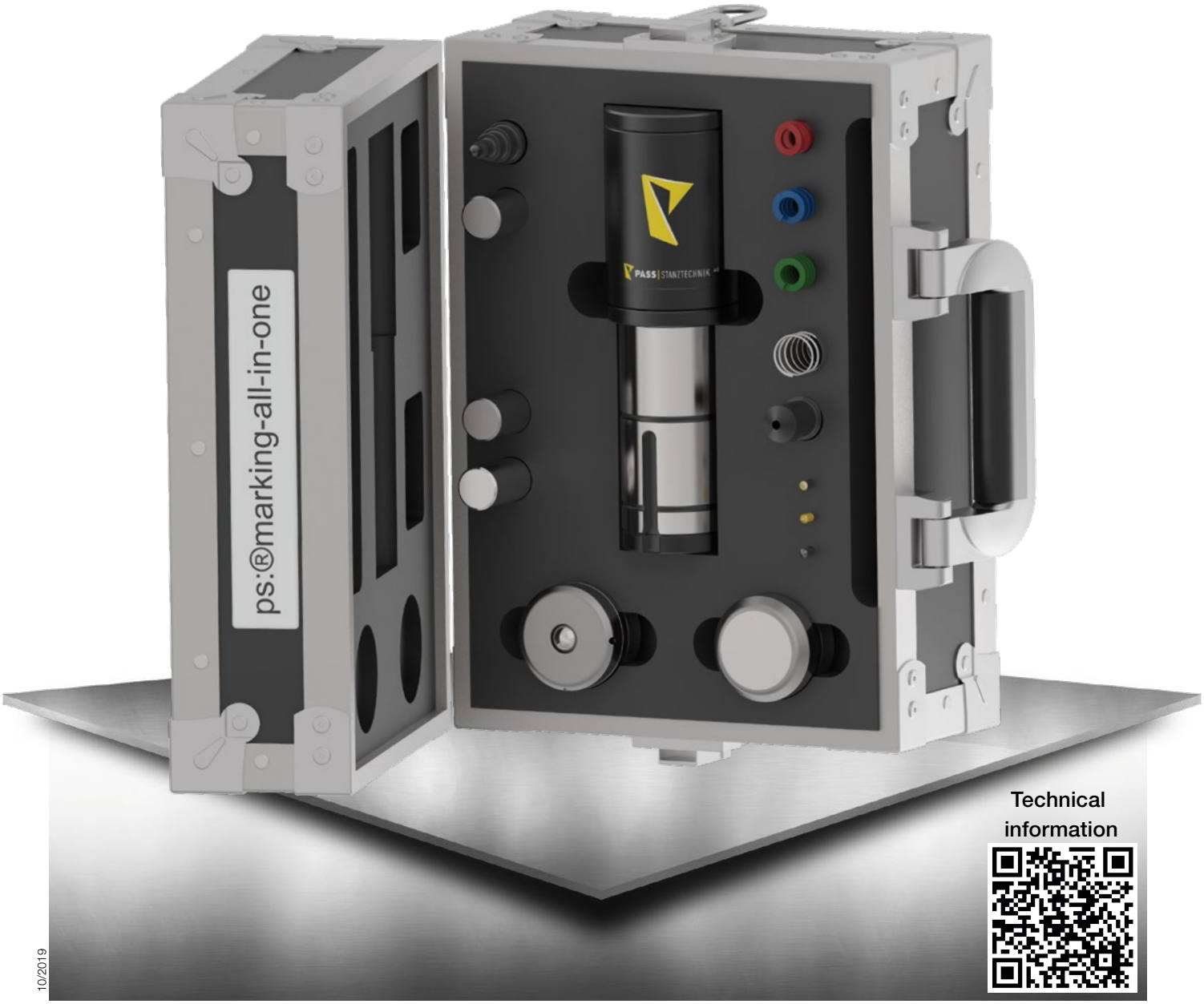
Technical information

11/2020

ps:®marking-all-in-one

FOR MACHINE TYPE THICK TURRET

- multifunctional tool for **engraving**, **signing**, **marking** and **foil cutting**
- 1 tool – 4 functions
- minimum conversion times for quick change to a new function due to head screw with bayonet lock
- incl. two dies: flat die (signing), ball roller die (engraving, marking and foil cutting)
- incl. special marking pen with Dry Safe Ink
- for all sheet materials and a sheet thickness from s = 0,8 mm



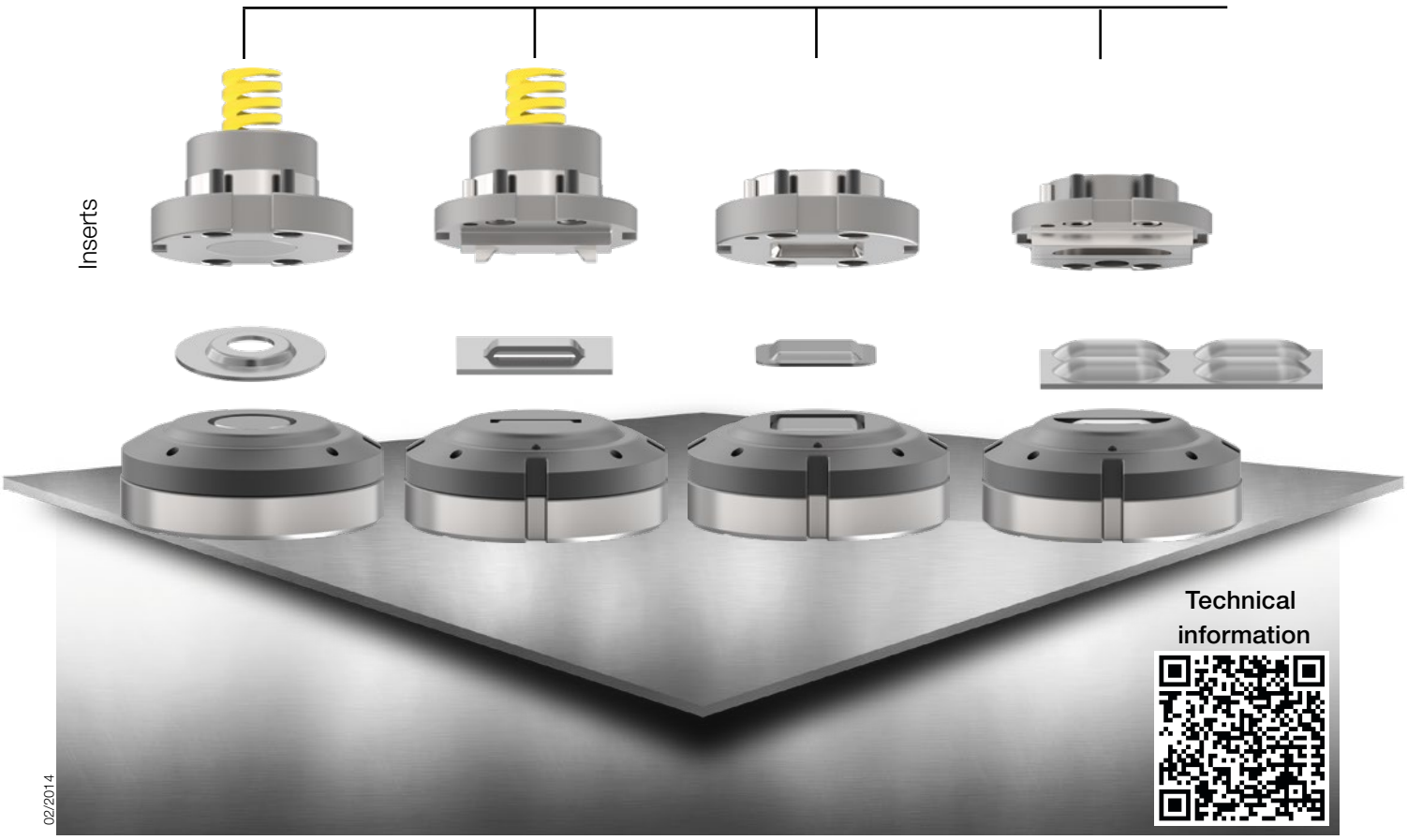
Technical information

10/2019

ps:®basic

FOR MACHINE TYPE THICK TURRET

- cost savings due to standardised guide assembly for embossings upwards
- fast and easy changing of the embossing die



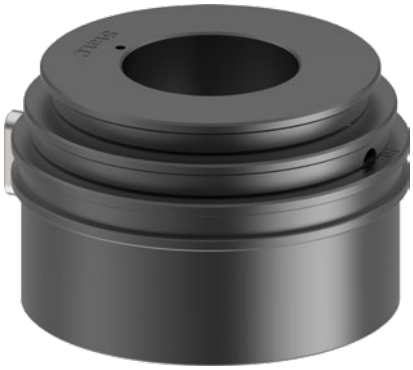
02/2014

ps:®assembly-element-pro

FOR MACHINE TYPE THICK TURRET

- as plug system
- no need to clamp in vice
- for a gentle disassembly and assembly of the tools

socket set
CDE



socket set
P110 / Pi135

base holder unit

ps:®multi-thread®

FOR MACHINE TYPE THICK TURRET – STATION Di

- fast and easy changing of tap inserts
- different sizes from M2/UNC #2-56 to M10/UNC 3/8“-16 possible
- usable for all sheets up to s = 8,0 mm
- metric and inch system tap inserts can be used in one tool
- automatic selection of the single tap inserts
- also usable for extrusions up- and downwards
- with tool and sheet lubrication
- fast thread forming (within approx. 2 sec./thread)

Link to Youtube

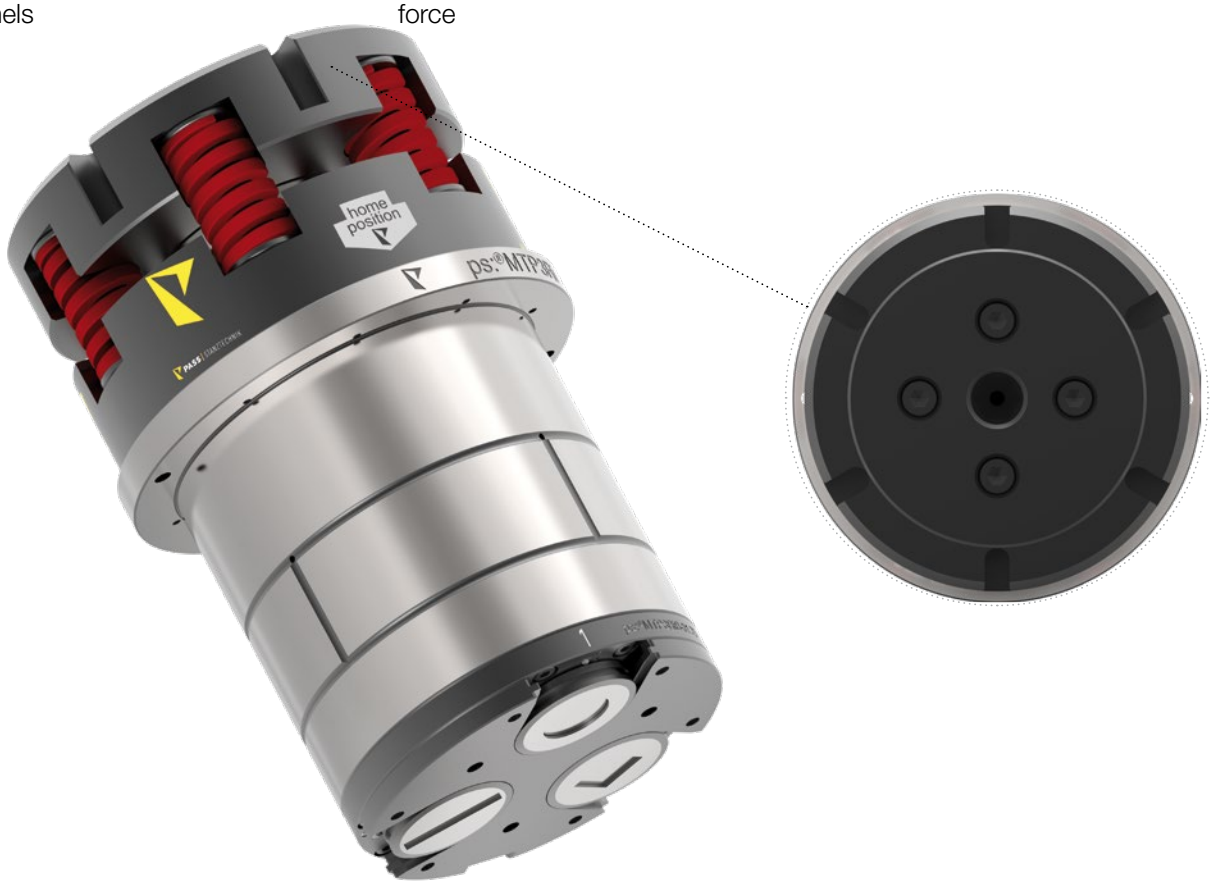
Technical information

12/2011

ps:®MTP3RiB(PIN)-31,75

FOR MACHINE TYPE THICK TURRET – STATION Di

- simple and quick change of punches with maximum process stability
- minimum tool and guide wear due to maximum guide length
- internal and external lubrication channels
- special spring to control grind life after sharpening punches
- no “witness-marks” on the sheet, due to single active punch – all unused punches stay up
- individual adjustment of stripping force
- maximum performance range due to robust design of all components for sheet thicknesses up to s = 6,0 mm (all materials)
- possibility to use standard tools from product line **ps:®beta-V2®**



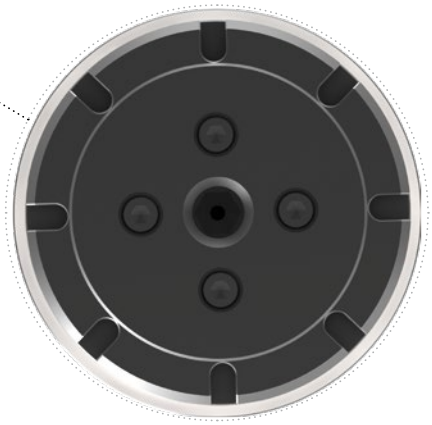
patented
EP 2,596,878
US 9,266,248

11/2011

ps:®MTP8RiA(PIN)-12,7

FOR MACHINE TYPE THICK TURRET – STATION Di

- simple and quick change of punches with maximum process stability
- minimum tool and guide wear due to maximum guide length
- internal and external lubrication channels
- special spring to control grind life after sharpening punches
- no “witness-marks” on the sheet, due to single active punch – all unused punches stay up
- individual adjustment of stripping force
- maximum performance range due to robust design of all components for sheet thicknesses up to s = 6,0 mm (all materials)
- possibility to use standard tools from product line **ps:®beta-V2®**



patented
EP 2,596,878
US 9,266,248

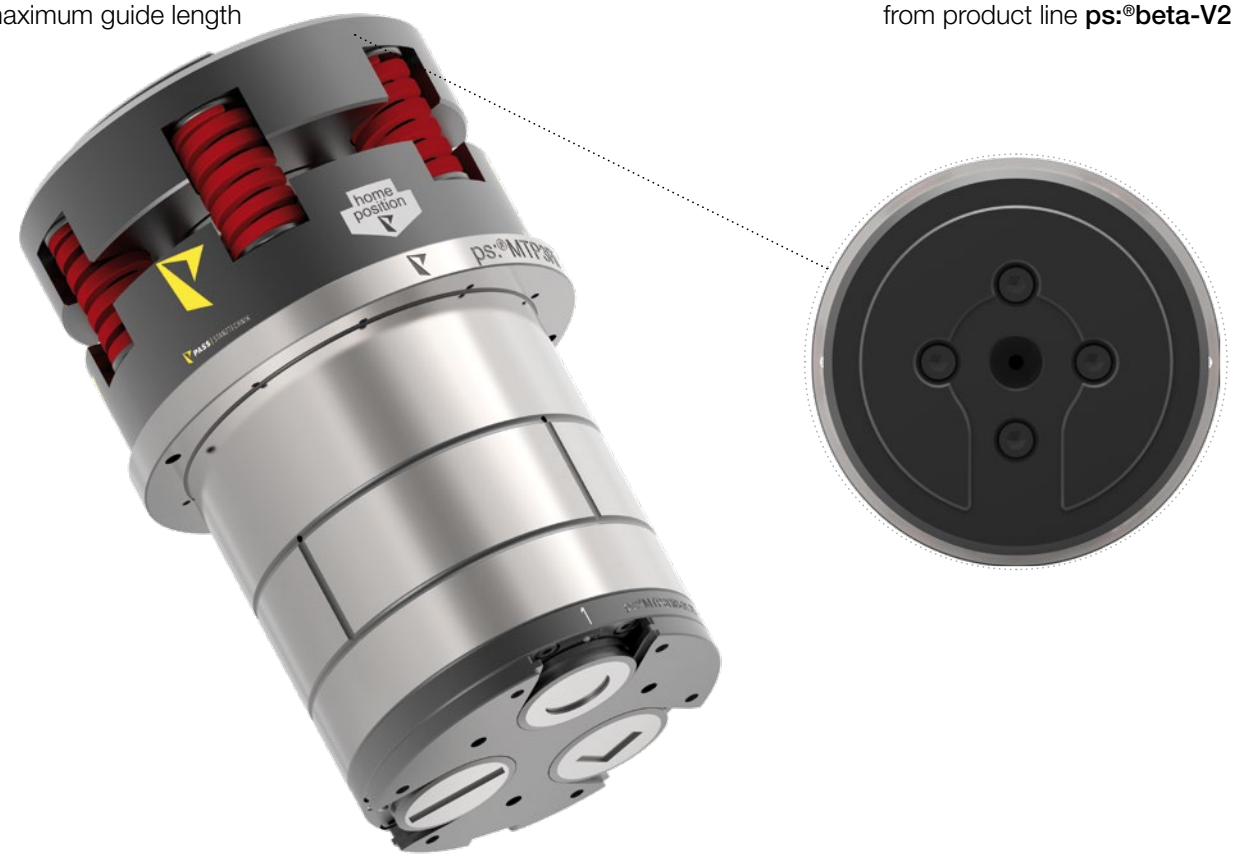
11/2011

PASS | STANZTECHNIK AG CONTACT: **+49 92 70 / 9 85 - 0**

ps:®MTP3RiB(I-RAM)-31,75

FOR MACHINE TYPE THICK TURRET – STATION Di

- effective reduction of production time due to combination of I-RAM and index station
- simple and quick change of punches with maximum process stability
- minimum tool and guide wear due to maximum guide length
- internal and external lubrication channels
- special spring to control grind life after sharpening punches
- no “witness-marks” on the sheet, due to single active punch – all unused punches stay up
- individual adjustment of stripping force
- maximum performance range due to robust design of all components for sheet thicknesses up to s = 6 mm (all materials)
- possibility to use standard tools from product line **ps:®beta-V2**



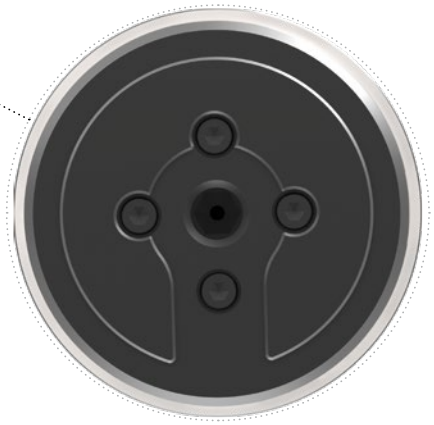
patented
EP 2,596,878
US 9,266,248

11/2011

ps:®MTP8RiA(I-RAM)-12,7

FOR MACHINE TYPE THICK TURRET – STATION Di

- effective reduction of production time due to combination of I-RAM and index station
- simple and quick change of punches with maximum process stability
- minimum tool and guide wear due to maximum guide length
- internal and external lubrication channels
- special spring to control grind life after sharpening punches
- no “witness-marks” on the sheet, due to single active punch – all unused punches stay up
- individual adjustment of stripping force
- maximum performance range due to robust design of all components for sheet thicknesses up to s = 6 mm (all materials)
- possibility to use standard tools from product line **ps:®beta-V2®**



patented
EP 2,596,878
US 9,266,248

11/2011

ps:®beta-V2®

FOR MACHINE TYPE THICK TURRET

- assembled spring unit
- tool length can be adjusted by simple, quick and safe handling
- optional available as ABS-version (for machines with lubrication system)
- regrinding length up to 10 mm (s = 1,0 mm) without using shims
- replaceable stripper plates
- closed, solid head unit secures highest obtainable reliability of operation in case of spring breakage

08/2008

SHEAR BLADES

FOR MACHINE TYPE SALVAGNINI

- made of highest X3-PM quality which increases the lifetime

- 400 mm
- 500 mm

08/2009

TOOL CASSETTES TYPE STANDARD

FOR MACHINE TYPE SALVAGNINI S4

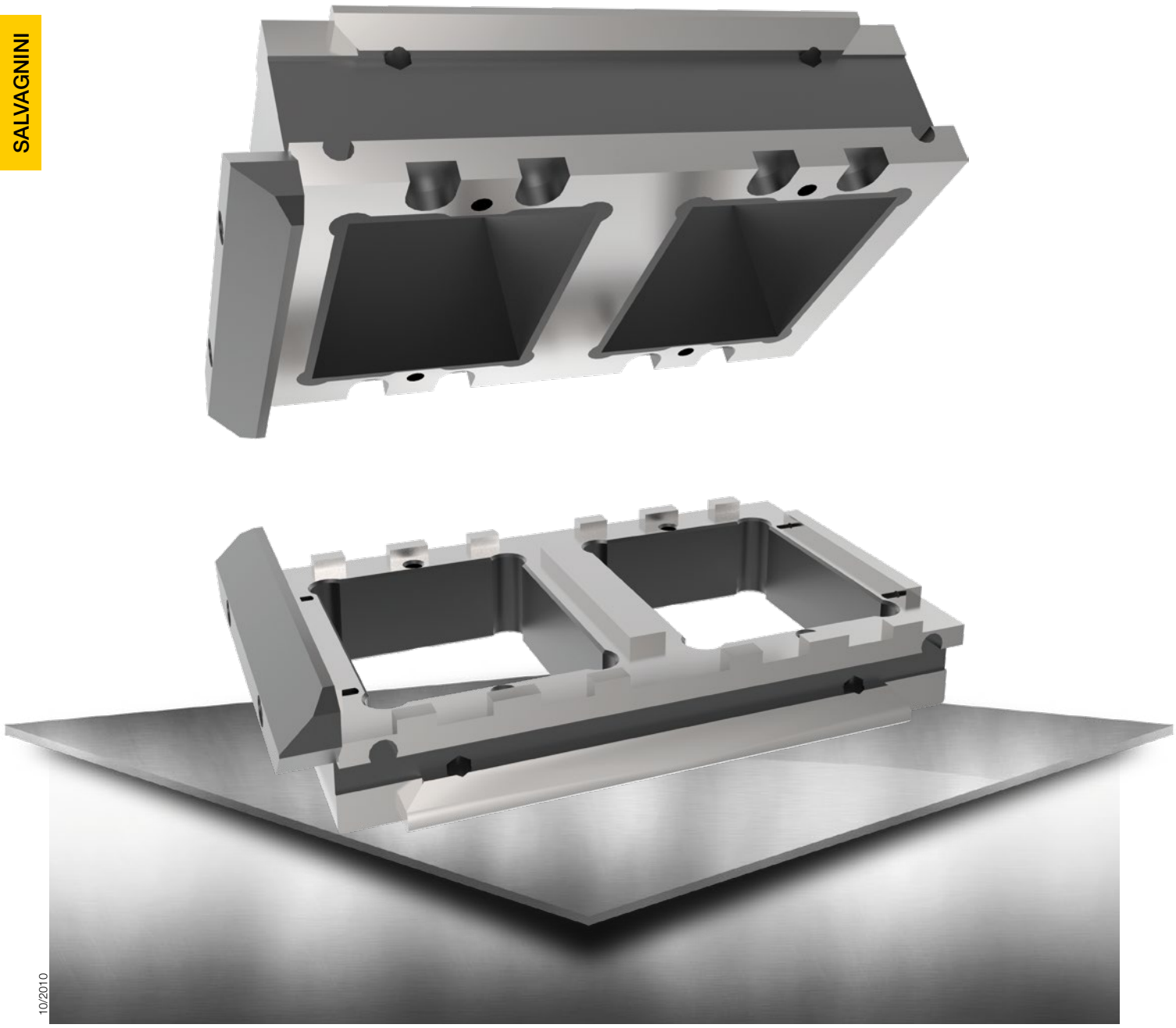
- cassette for 70 kN
- type standard
- max. diameter 33 mm

10/2010

TOOL CASSETTES TYPE P21 UP TO P24

FOR MACHINE TYPE SALVAGNINI S4

- cassette for 260 kN
- P21 up to P24 / Front & Rear
- max. diameter 70 x 90 mm



10/2010

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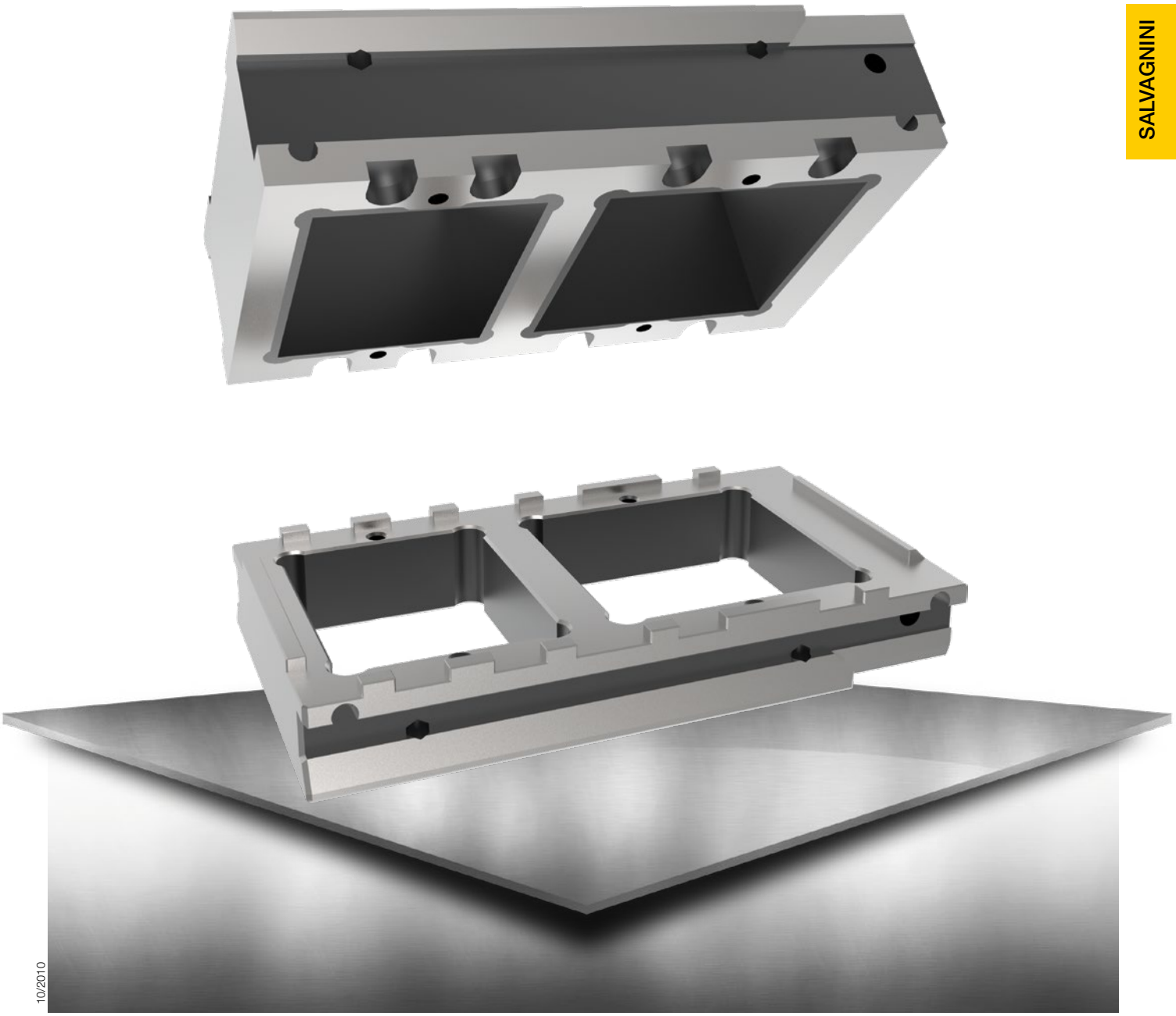
TOOL CASSETTES TYPE P23 AND P24

FOR MACHINE TYPE SALVAGNINI S4

- cassette for 260 kN
- P23 and P24 / Rear
- max. diameter
  70 x 90 mm / 90 x 90 mm



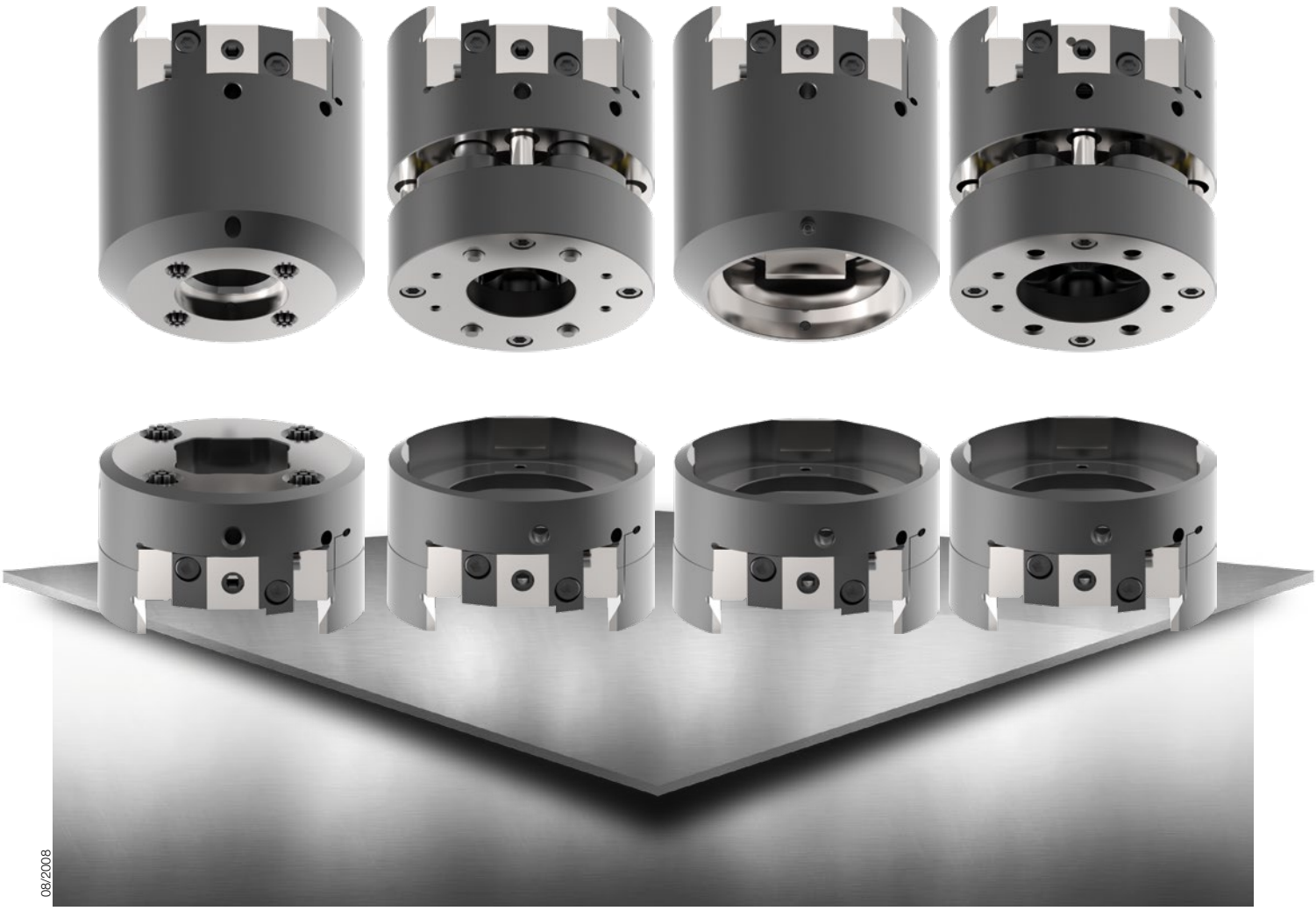
10/2010

TOOL CASSETTES TYPE SINGLE P2R

FOR MACHINE TYPE SALVAGNINI S4 (P2R-ROTATION STATION)

SALVAGNINI

- to 33 mm solid
- to 42 mm spring-loaded
- to 60 mm solid
- to 50,8 mm spring-loaded



08/2008

SALVAGNINI | THICK TURRET | TRUMPF

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Product portfolio 03/2025 Version 1.3