

Dayton

BAILEIGH

WOODWARD FAB

## Shrinker Stretchers

Compress sheet metal to form inside curves or expand it to form outside curves. Their jaws clamp onto material and either pull it together to shrink it or push it apart to stretch it. Stretchers are typically used to curve workpieces that already have a right-angle bend, especially when forming panel panels for door frames, windshield channels, trunk gutters, and other automotive and framing applications.

**Foot Pedal Shrinker Stretchers**—Pedal is pressed down to engage the jaws and add a curve to workpieces while both hands are free to position and hold the material. They can shape heavier-gauge sheet metal than hand-operated models but lighter gauges than hydraulic units.

**Hand-Operated Shrinker Stretchers**—Hand lever manually engages the jaws and adds a curve to workpieces. They shape lighter-gauge materials than foot pedal and hydraulic models.

**Hydraulic Shrinker Stretchers**—Deliver a powerful downstroke for greater forming force than manual machines. Tools shape heavier-gauge sheet metal than manual models and reset more quickly between strokes to speed production.

**Foot  
Pedal  
18F322**



**Hand-  
Operated  
45J328**



**Hydraulic  
31XV24**



Sheet Metal Capacity Mild Steel	Sheet Metal Capacity Stainless Steel	Sheet Capacity Aluminum	Throat Depth	Jaw Width	Brand	Item No.
<b>Foot Pedal Shrinker Stretchers</b>						
16 ga	22 ga	12 ga	8 in	2 in	Dayton	45J331
16 ga	—	14 ga	6 in	1 3/4 in	Baileigh Industrial	18F322
18 ga	—	16 ga	1 1/2 in	2 in	Baileigh Industrial	31XV26
<b>Hand-Operated Shrinker Stretchers</b>						
18 ga	22 ga	16 ga	1 in	1 3/4 in	Woodward Fab	30NX68
18 ga	24 ga	14 ga	1 in	1 3/4 in	Dayton	45J328
16 ga	—	14 ga	8 in	2 1/2 in	Baileigh Industrial	31XV25
<b>Hydraulic Shrinker Stretchers</b>						
14 ga	—	12 ga	6 in	2 in	Baileigh Industrial	31XV24

## Sheet Metal Punches *Malco*

Used to cut clean, accurate holes in flat metal sheets and plates. They hold workpieces in the throat of the tool and drive a punch through the material and into a die to create a hole. Punches accept different punch and die sets to make holes of the desired shape and size and are commonly used to punch holes in automotive panels and manufacturing components.

**Manual Sheet Metal Punches**—Hand lever drives the punch as it cuts holes in light-gauge sheet metal and plates.

Sheet Metal Capacity Mild Steel	Throat Depth	Included Dies	Adjustable Depth Stop	Item No.
<b>Manual Sheet Metal Punches</b>				
22 ga	1 1/2 in	1/2 in Punch and Die, 3/4 in Punch and Die	Yes	5KNV3



## Sheet Metal Notchers

■ 90° notch angle except 29CK41 is 180°

Carve out rectangles, triangles, and other shapes along the edges of flat metal sheets. Their cutting blades or dies shear through workpieces to make clean cuts and are commonly used to remove the corners of sheets and leave flaps that can be folded in to form trays, pans, and boxes.

**Air-Powered Sheet Metal Notchers**—Have fewer moving parts, weigh less, run cooler, and have long life compared to electric notchers. They cut heavier-gauge sheet metal with less effort than manual notchers.

**Corded Sheet Metal Notchers**—Electric motor operates their cutting blades to cut heavier-gauge sheet metal with less effort than manual notchers.

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Sheet Metal Capacity Mild Steel	Blade Length	Notch Size	Air Pressure	Air Inlet	Air Consumption	Brand	Item No.
Air-Powered Sheet Metal Notchers							
11 ga	5 in	5 in x 5 in	115 psi	¼ in	4 cfm	Baileigh Industrial	31XV86
11 ga	5 ½ in	1 in x 5 ½ in	115 psi	¾ in	155 cfm	Jet	53ZC89
14 ga	—	¾ in x ¾ in	90 psi	¼ in	3 cfm	Viking Air Tools	29CK41 *
Sheet Metal Capacity Mild Steel	Sheet Metal Capacity Stainless Steel	Sheet Capacity Aluminum	Blade Length	Notch Size	Current	Brand	Item No.
Corded Sheet Metal Notchers							
230V AC ; Three-Phase							
3 ga	10 ga	0 ga	8 ½ in	8 ½ in x 8 ½ in	20 A	Baileigh Industrial	31XV84
9 ga	13 ga	7 ga	7 ¾ in	7 ¾ in x 7 ¾ in	20 A	Baileigh Industrial	31XV85
9 ga	—	—	7 ¾ in	—	8.6 A	Jet	53ZC90
Sheet Metal Capacity Mild Steel	Sheet Metal Capacity Stainless Steel	Sheet Capacity Aluminum	Blade Length	Brand	Item No.		
Manual Sheet Metal Notchers							
1.5 mm	0.8 mm	2 mm	3 ½ in	Dayton	12G601		
1.5 mm	0.8 mm	2 mm	6 in	Dayton	13W870		

\*180° notch angle.



**Air-Powered  
31XV86**



**Corded  
53ZC90**



**Manual  
12G601**

## English Wheels

Form curves and contours on sheet metal as the metal rolls back and forth between two anvil wheel dies. The user can adjust the wheel pressure and move workpieces along the wheels by hand as the wheel dies press against the metal to slowly stretch and round it. Tools can accept dies with different contours to get the desired curve on the workpiece. Suitable for shaping metal for tanks, fenders, and other domed parts.

Throat Depth	Sheet Metal Capacity Mild Steel	Sheet Metal Capacity Stainless Steel	Sheet Capacity Aluminum	Top Wheel Diameter	Bottom Wheel Diameter	Number of Bottom Dies	Number of Top Dies	Brand	Item No.
28 in	18 ga	23 ga	14 ga	8 in	—	6	1	Dayton	45J341
37 3/4 in	16 ga	—	14 ga	6 in	3 in	9	3	Baileigh Industrial	18F323
45 in	16 ga	22 ga	8 ga	6 in	3 in	10	4	Jet	18F205
28 in	16 ga	20 ga	14 ga	8 in	3	6	1	Woodward Fab	30NX58

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**45J341**