

# Table of Contents

Company Profile.....	3
<b>Tooling</b>	
Carbide Dies, Carbide Blows, Quills & Carbide Gripper.....	4
Die, Punch Cases & Sleeves.....	5
Feed Rolls.....	6-9
Transfer Fingers.....	10-11
<b>Replacement Parts</b>	
Adjusting Screws—Horizontal.....	12
Adjusting Screws—Vertical.....	13
Centering Blocks.....	14-15
Cutter Bars/ Holders/ Knives.....	16
Feed Roll Brake Shoes.....	17
Knock Out Levers/PKO's.....	18-19
Punch Blocks.....	20-23
Punch Block Footprints.....	24-25
Punch Holder Draw Bolts.....	26-27
Punch Rocker / Oscillators.....	28
Roll Thread Replacement Parts.....	29-30
Rack Shafts / Sector Gears.....	31
Transfer Arms.....	32-36
Transfer Finger Holders.....	37-38
Transfer Heads.....	39
Turnaround Sleeves (Roll Thread).....	40
Feeder Bowls.....	41
Machinery & Equipment List.....	42-43
Notes.....	44

## COMPANY HISTORY:

Thomason Machine Works, Inc. has been family owned and operated since 1978. Our 38 years of experience combined with our highly skilled staff allows us to offer our customers the highest quality of machine repair replacement parts. We can meet your machine down situations and your daily needs at the same time. With the support of our customers, Thomason Machine has recently moved into a 37,000 sq. foot facility to better meet our customers needs and our growing expertise.

## Your Source for Machinery replacement parts...

### Header Replacement Parts including:

Asahi Okuma, Asahi Sunac, Behr, Carlo Salvi, Chun Zu, Hartford, Itami, Jyoto, Manville, Nakashimada, National, Nedschroef, Sacma, Sakamura, Saspi, Waterbury & more.

### Roll Thread Replacement Parts Including:

EW Menns, Hartford, National, Saspi, Warren, Waterbury & more.

### Rehabilitation:

- Complete rebuilding services-all Cold Forming Fastener Equipment
- including National, Waterbury, Hartford.
- Over 125 complete machine rebuilds.
- Spare parts-manufactured from our drawings, or reverse engineered of broken/worn parts.
- Over 3,000 engineered drawings on file including cams, gears, die blocks, transfers, bolsters, punch holders, punch rockers, wedges, etc.
- Complete in house precision machining of all components.

### Engineering:

- Design of OEM replacement parts/assemblies for fastener equipment from casting to machining.
- Prototype tooling, design & manufacture.

### Machinery & Equipment:

- (6) CNC Turning Centers
- (4) CNC Vertical Knee Mills
- (10) CNC Vertical Machining Centers
- (7) Manual Vertical Mills
- (9) Manual Lathes
- (4) Surface Grinders
- (3) I.D. & O.D. Grinders
- (2) Wire EDM
- (1) Conventional EDM

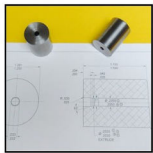


# Carbide Dies, Carbide Blows, Quills & Carbide Grippers

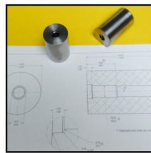
We can supply you with complete carbide inserted dies & blows or inserts only.  
We also manufacture solid carbide grips of assorted sizes and shapes.



Solid Carbide Sliding Blows



Carbide Extruding Inserts / Dies



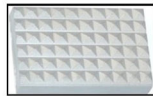
Carbide 2nd Die Top Insert



Semi Finished Carbide Nibs



Carbide Punch Insert



Solid Carbide Gripper Block



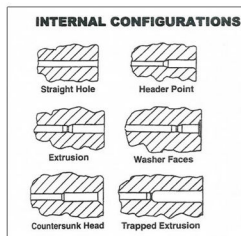
Small Carbide Heading Die



Carbide Cold Heading Die



Carbide Inserted Blows



Carbide Inserted Heading Dies

# Die, Punch Case, Nuts & Sleeves



## Punch & Die Cases:

We can make cases as small as you need and make them regularly for the ML-120 National; which are 8" Diameter and 18" Long with tapered I.D.'s and 5" diameter nuts. The majority of our Punch and Die Cases are made from H-13 Material, normally 48-50 Rockwell. On the majority of our Punch Cases with nuts, we hard turn the threaded I.D.'s after heat treat. This assures a perfect fit from case to nut.

## Punch & Die Case Sleeves:

The majority of our Punch & Die Case Sleeves are made from 52100 material and 58-60 Rockwell. We can make sleeves as small as you require. We make sleeves 10" diameter x 18" long on a regular basis.

## Die Nuts:

Our Die Nuts are typically made from S-7 material and heat treated to 57-59 Rockwell. We can make any size as needed and regularly make up to 5" threaded nuts.



# Feed Rollers



got feedrollers?  
www. .com

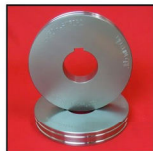
Over 100 Sets of Feed Rollers in Stock!!

Rush Orders Available!

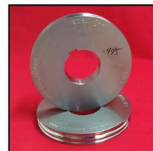
Rollers that are "In-Stock" are ready to install wire grooves & can ship in as quickly as 1-3 days!!



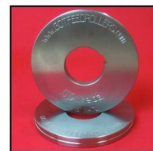
750 National



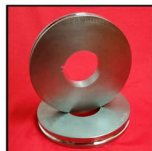
5-250 National



5/16 & 56 National



3/16 National



3/8 & 60 National



89 National



34 National



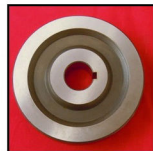
1/4-45 National



663 Carlo Salvi



3/16 Carlo Salvi



Nakashimada NS-60



DH-20 Nakashimada

# Feed Rollers

## ★ 5 Reasons of Feed Rollers are Better!

- We use 4140 alloy steel for our feed rollers. 4140's chromium content provides good hardness penetration, and the molybdenum imports uniformity of hardness and high strength
- We thru harden our feed rollers, not flame harden like in the old days. With thru hardening you can open your feed rollers to a larger size anytime it may be needed (our feed rollers are hard all the way thru). Our rollers are hardened to 48/50 Rockwell on the "C" scale.
- Our feed rollers are finished after heat treat on the I.D., O.D., thickness and grooves. This eliminates any size variations that may be present after heat treating.
- Our feed rollers have the wire size machined into them, not etched with a vibrating pencil, so you can read them after years in the shop.
- We have more feed roller blanks in stock than anyone. Our stock rollers are heat treated, ground and ready to install the grooves. Our stock rollers can be turned around in 2-3 days and possible sooner in machine down situations.



Servo



Numacell FXT



HBP-518

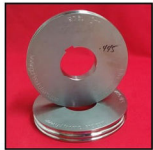
[www.thomasonmachine.com](http://www.thomasonmachine.com)



# Feed Rollers



3-300/3-350 Hartford



5/16 Hartford



5-250 Hartford



1/4 Waterbury



3/16 Waterbury Hi-Pro



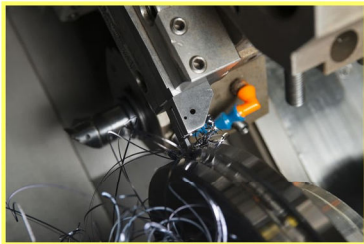
3/16 Waterbury



Sakamura BPF-660



Sakamura BP-430 SS



**Tri-Lobe Grooves...**  
**No Problem!!!**



Sacma SP-25



Sacma SP-21



Sacma SP-560



Sacma SP-160



Sacma SP-27



Sacma SP-250



Sacma SP-11

# Feed Rollers

We can make feed rollers for the following:  
Behr, Carlo Salvi, Chun Zu, Hartford, Itami, Jyoto, Manville,  
Nakashimada, National, Okuma, Sacma, Sakamura,  
Waterbury and more....



Asahi Sunac RH-80



Asahi Okuma AOT-4B



Asahi Okuma AOT-6



Asahi Okuma AOL 8/  
AOS 8



Asahi Okuma  
AQ1013



Asahi Okuma AOT-8B



Asahi Okuma  
Sax 57 RH80



**Over 100 sets  
in stock!**

[www.gotfeedrollers.com](http://www.gotfeedrollers.com)





# Transfer Fingers



# Transfer Fingers



**Material:**

Our transfer fingers are made from high quality 1018 cold rolled bars (unless otherwise specified by customer). 1018 is a low-carbon steel having a higher manganese content than mild steel and certain other low-carbon steels. Being richer in manganese, it is better steel for carburized parts, since it provides a harder and more uniform case.

**Heat Treat:**

Our transfer fingers are case hardened on the working surfaces only to a depth of .025-.035

We Don't import Transfer Fingers! At Thomason Machine Works, INC. we have been manufacturing transfer fingers for over 34 years. Our cold heading fingers have never been imported and never will be, they will always be made in the USA.



# Adjusting Screws - Vertical



3/16 National Cone / Punch  
Key #4-13 & 4-35



1/4 National  
3/8-24 x 2.625 OAL



5/16 National Cone  
1/4 National Cone / Punch  
(Short) TMW Part #1184



5/16 National  
Finish/Punch/Cone/2nd  
(Long) TMW Part #1184



34 National Punch  
5/16-24 x 1.882 OAL



45 National Cone  
3/8-24 x 1.812 OAL



45 National  
3/8-24 x 2.550 OAL



56 National Cone / Punch  
Key HS-15 26-530-016



89 National KP-53 for 2nd &  
3rd Station #4330C90331  
TMW Part #1619



89 National 1st / Cone  
TMW Part #1789



Key #KP-53



# Adjusting Screws - Horizontal



3/16 Hartford RH



3/16 Hartford LH



34 & 3/16 National  
3/8-24 x 1.437 OAL (Long)



34 & 3/16 National  
3/8-24 x 1.062 (Short)



1/4 National



5/16 National  
Key #HS-17 or 4-24



45 National Cone



45 National Cone  
1/2-20 x 1.437 OAL



56 National Cone  
S.D.S.



89 & 1/4 National  
(Short)

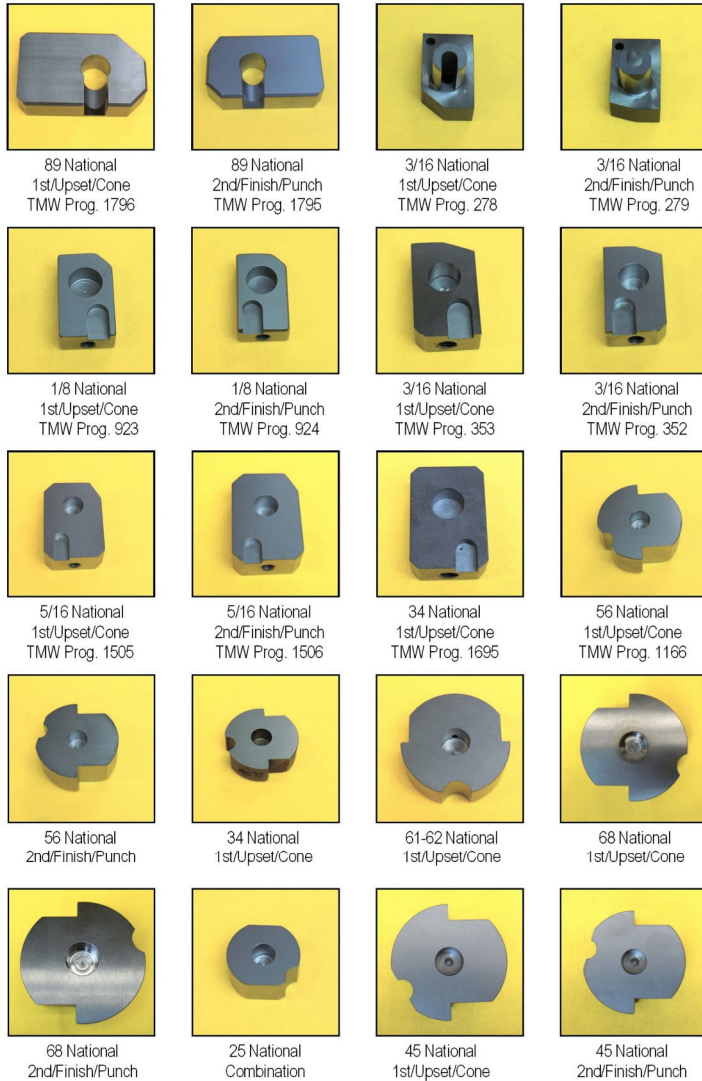


89 National





# Centering Blocks

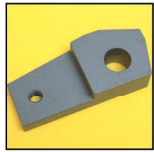


# Centering Blocks

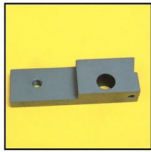




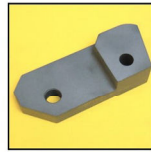
# Cutter Bars / Knives / Holders



ORH-80 Asahi Okuma  
TMW Prog. 1287



1/4 National  
TMW Prog. 1313



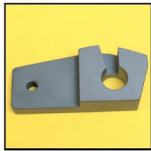
68 National  
TMW Prog. 764



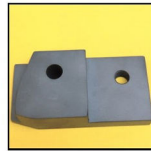
AOT-6B & 6XL  
TMW Prog. 465



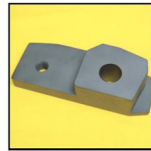
25 National  
TMW Prog. 452



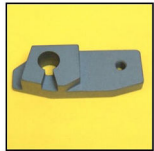
AOL-8



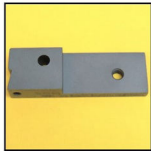
AT-1075 Asahi Okuma  
TMW Prog. 800



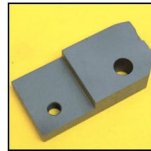
AOT-12B Asahi Okuma  
TMW Prog. 354



AOT-6 Asahi Okuma



1/4 National  
TMW Prog. 336



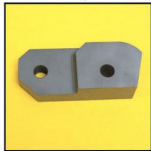
AT-635  
TMW Prog. 786



#2 Waterbury Hi-Pro  
Carbide Inserted



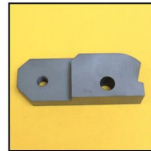
ORH-120 Asahi Okuma  
TMW Prog. 1171



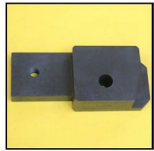
56 National  
TMW Prog. 1389



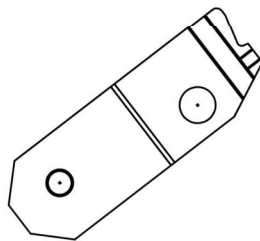
AOT-10 Asahi Okuma



45 National  
TMW Prog. 450



RH-80 Asahi Okuma  
TMW Prog. 1780



# Feed Roll Brake Shoes



National  
1/4 H.S.  
TMW Prog. 1177



National  
45 H.S.  
TMW Prog. 1053



National  
3/16 & 3/4 H.S.  
TMW Prog. 904



National  
5/16 H.S.  
TMW Prog. 1855



National  
89 H.S.  
TMW Prog. 1854



National  
56 H.S.  
TMW Prog. 1481



Waterbury  
3/16 Hi-Pro  
TMW Prog. 895



Waterbury  
3/16 Hi-Pro  
TMW Prog. 896



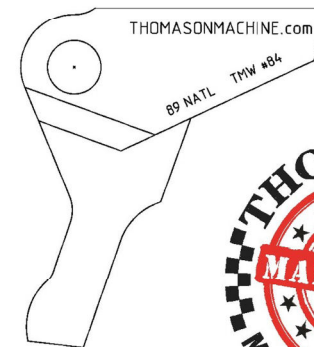
# Knock Out Levers



# Knock Out Levers



We carry many KO and PKO Levers in stock, ready to ship for National, Okuma, Waterbury and more.

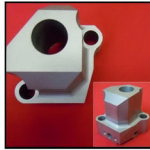


[www.thomasonmachine.com](http://www.thomasonmachine.com)



# Punch Blocks

All styles of 3/16 National High Speed. Always in stock with 1.000 bores. Including all 3 Finish styles and Cone.



3/16 National H.S.  
1st Blow/Cone



3/16 National  
Finish TMW Style #1



3/16 National  
Finish TMW Style #2



3/16 National  
Finish w/PKO TMW Style #2



3/16 Waterbury  
Hi-Pro Phillips



1/4 National H.S.  
2nd Finish w/ PKO



1/4 National  
2nd Blow Finish



5/16 National H.S.  
2nd Finish w/ PKO



1/8 or #25 National  
2nd



45 National  
1st



56 National HS SDDS  
Cone w/ PKO



AOS-8  
Combination



AOT-4B/4L/4XL  
1st



AOT-4B/4L/4XL  
2nd



AOT6B & 6XL  
1st



AOT-6B/6L/6XL  
2nd



1/8 or #25 National  
HS SDDS Cone  
TMW Prog. 535



AOT-10B/10L/10XL  
1st



AOT-10B/10L/10XL  
2nd  
TMW Prog. 1569



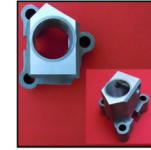
34 National  
2nd w/ PKO  
TMW Prog. 479

# Punch Blocks

We carry blocks in stock ready for finish bore sizes. Including: National, Okuma, Waterbury, Hartford and more.



34 National  
2nd Station w/ PKO  
TMW Prog. 479



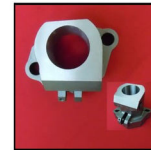
56 National  
3rd Finish w/ PKO



Nakashimada NP-81  
2nd



Asahi Sunac ST-1615  
1st Blow



68 National  
2nd Finish w/ PKO



56 National 2D3B  
2nd w/ PKO



34 National 2D3B  
1st



56 National 2D3B  
3rd



ORH-80  
2nd  
TMW Prog. 496



3/16 or 34 National  
2nd w/ PKO  
TMW Prog. 46



56 National 2D3B  
2nd  
TMW Prog. 238



5/16 National  
1st  
TMW Prog. 318



3/16 or 34 National LS  
Cone  
TMW Prog. 1401



5/16 Hartford  
1st  
TMW Prog. 191



5/16 Hartford  
2nd Finish  
TMW Prog. 1062



51 National  
Finish  
TMW Prog. 730



56 National HS-20  
1st Blow/Cone w/ PKO  
TMW Prog. 1234-Short  
TMW Prog. 1399- Tall



1/4 National H.S.  
Sliding 1st  
TMW Prog. 195



45 National H.S. SDDS  
Cone  
TMW Prog. 1735



45 National  
1st  
TMW Prog. 199



# Punch Blocks



39 National 2D3B  
TMW Prog. 533



89 National  
2nd Cone 3 Blow  
TMW Prog. 1598



31 National  
Finish  
TMW Prog. 1869



45 National  
2nd w/ PKO  
TMW Prog. 1942



89 National New Style  
3rd Station w/ PKO  
TMW Prog. 971



3-350 Hartford  
Sliding 1st  
TMW Prog. 153



Asahi Sunac RH-80  
3rd  
TMW Prog. 1792



Asahi Sunac ST1075  
1st  
TMW Prog. 1903



89 National 2D3B  
Extrusion  
TMW Prog. 939



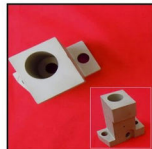
3/8 Waterbury O.S.  
Finish  
TMW Prog. 1858



3/8 Waterbury Farrel OS  
1st  
TMW Prog. 1728



89 National New Style  
2nd Finish w/ PKO  
TMW Prog. 824



3/16 Hartford  
2nd  
TMW Prog. 873



Asahi Sunac RH-80  
3rd  
TMW Prog. 1792



89 National  
Finish  
TMW Prog. 971



1/4 National H.S.  
Finish w/ PKO  
TMW Prog. 110

### 3/16 National High Speed Always in Stock:

- 1st Blows waiting for tangent pin locations & heat treat.
- Finish punch with no pko TMW Style #1 with 1.000 Bore Dia.
- Finish punch with no pko TMW Style #2 with 1.000 Bore Dia.
- Finish punch with pko TMW Style #3 with 1.000 Bore Dia.

**We carry many completed and partially completed blocks in stock!**



5459 11th Street  
Rockford, IL 61109  
815-874-8217 Fax 815-874-5044  
www.thomasonmachine.com

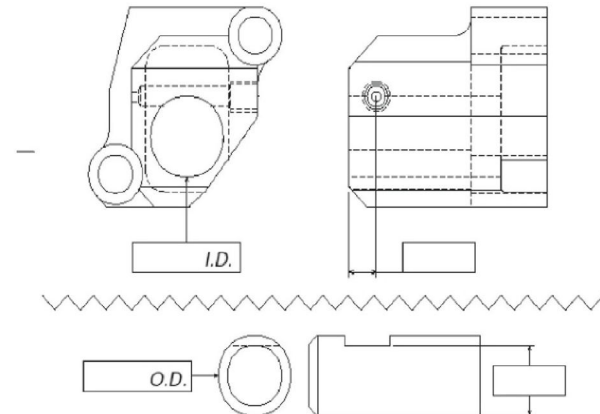
**Keeper Pin  
Critical Data**

Keeper pin location usually varies from customer to customer. Please fill in the information below, so we know where to locate your keeper pin hole.

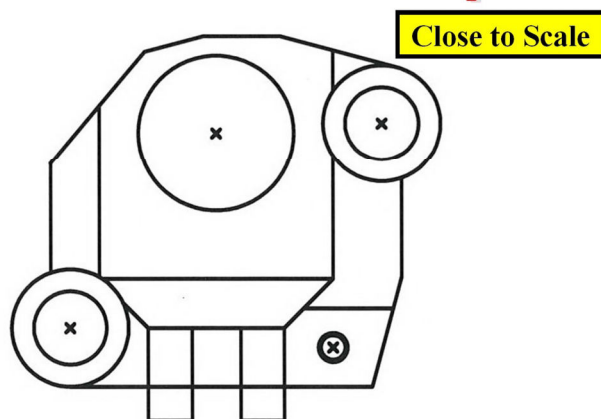
### HERE ARE THE 5 ITEMS WE MUST HAVE!!!

- 1st : Keeper Pin Diameter
- 2nd : Punch Diameter
- 3rd : Dimension From Bottom Notch on Punch to Outside Diameter of Punch
- 4th : Dimension From Top of Block to Centerline of Keeper Pin
- 5th : Overall Length of Block

THREAD SIZE	
KEEPER PIN DIA.	
PIN REMOVAL DIA.	

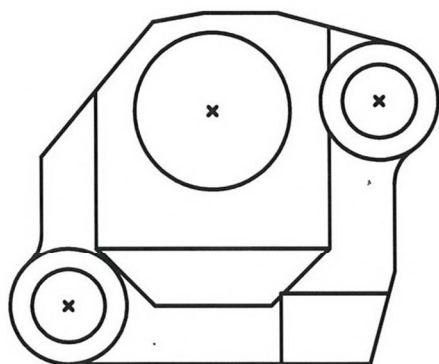


## 3/16 National H.S. Block Footprints



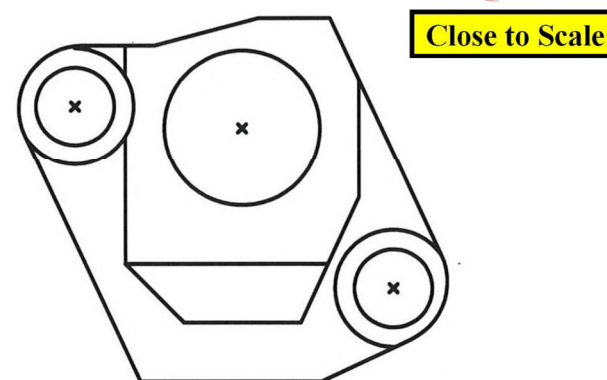
**Finish / 2nd Punch With PKO**  
TMW P/N 759-1 = .875 Bore Dia.  
TMW P/N 759-2 = 1.000 Bore Dia.

Blocks Pictured Are Typically In Stock...



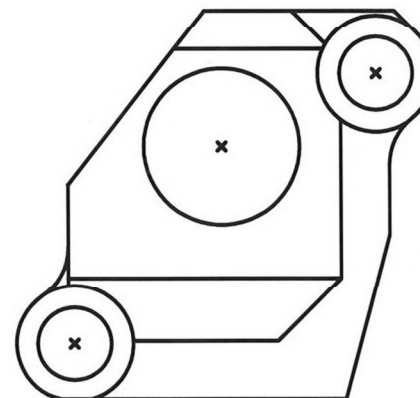
**Finish / 2nd Punch No PKO**  
TMW P/N 274-1 = .875 Bore Dia.  
TMW P/N 274-2 = 1.000 Bore Dia.

## 3/16 National H.S. Block Footprints



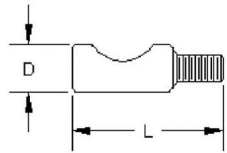
**Finish / 2nd Punch No PKO**  
TMW P/N 56-1 = .875 Bore Dia.  
TMW P/N 56-2 = 1.000 Bore Dia.

Blocks Pictured Are Typically In Stock...

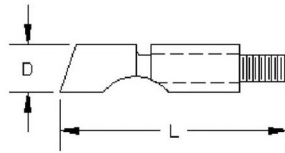


**Cone / 1st Blow No PKO**  
TMW P/N 332-1 = .875 Bore Dia.  
TMW P/N 332-2 = 1.000 Bore Dia.

# Punch Holder Draw Bolts



TYPE A (ONE PIECE)



TYPE B (TWO PIECE)



3/16 Hartford  
3-300/3-350  
1-5/16 Bore 2nd/Finish



3/16 National  
High Speed 1.000 Dia.  
TMW Prog #1070



3/16 National  
High Speed 7/8 Dia.  
TMW Prog #1070



3/16 Waterbury  
Hi-Pro Header  
7041-T-14



5/16 National Blank  
w/ Sleeve



34 National Blank  
w/ Sleeve



56 & 89 National  
2nd & 3rd Stations



68 National Blank  
w/ Sleeve



89 National Blank  
w/ Sleeve



Asahi Okuma  
AOT 4



Asahi Okuma  
AOT 6B



Asahi Sunac  
ORH 120  
1st Station

MACHINE	TMW PART #	PUNCH DIA.	D O.D.	THREAD	L LENGTH	TYPE
1/8 Hartford	DRB001	1 3/8	0.562	5/16-24	2	B
1/8 Hartford	DRB002	7/8	0.562	5/16-24	2	B
1/8 National	DRB003	7/8	0.498	5/16-24	2.25	B
3/16 Hartford	DRB004	1 1/2	0.562	5/16-24	2.625	B
3/16 Hartford	DRB005	1 1/8	0.562	5/16-24	2.625	B
5/16 Hartford	DRB006	1 5/8	0.75	1/2-20	3.5	B
00 Marville	DRB007	7/8	0.499	7/16-20	1.987	A
1 Marville	DRB008	1 1/4	0.624	7/16-20	2.75	A
250C Marville	DRB009	1 13/50	0.624	7/16-20	2.875	A
1/2 National 1st	DRB010	2	1.248	3/4-10	5.75	B
1/4 National	DRB011	1 1/4	0.873	1/2-13	3.25	B
3/16 H.S. National	DRB012	1	0.56	5/16-24	2	B
3/16 National	DRB013	7/8	0.748	1/2-13	2.287	B
3/8 National	DRB014	1 1/2	0.998	5/8-11	4.375	B
3/8 National	DRB015	1 13/16	0.998	5/8-11	4.375	B
3/8 National	DRB016	1 3/4	0.998	5/8-11	4.375	B
5/16 National	DRB017	1 1/2	0.998	5/8-11	4.125	B
5/16 National	DRB018	1 3/4	0.998	5/8-11	4.125	B
5/16 National	DRB019	1 5/8	0.998	5/8-11	4.125	B
51 National	DRB020	7/8	0.55	M-8	1.855	B
56 National LS SDDS	DRB021	2 11/16	0.998	5/8-11	4.56	B
89 National	DRB022	2 16/23	0.997	5/8-11	4.562	B
Formax FX-45	DRB023	1 1/8	0.472	M12 X 1.75	2.25	A
Formax FX-54	DRB024	1 1/2	0.629	M16 X 2	2.687	A
AOT-6B	DRB025	1 1/4	0.624	3/8-16	2.312	B
AT-635 1st Punch	DRB026	1 1/4	0.624	M10	2.64	A
AT-635 2nd Punch	DRB027	1 3/8	0.624	M10	2.64	A
AT-650 1st Punch	DRB028	1 1/4	0.624	M10	2.64	A
AT-650 2nd Punch	DRB029	1 3/8	0.624	M10	2.64	A
AT-675 1st Punch	DRB030	1 1/4	0.624	M10	2.64	A
AT-675 2nd Punch	DRB031	1 3/8	0.624	M10	2.64	A
SP350 Sacma	DRB032	1 1/2	0.862	M16	3.848	A
0 Marville	DRB033	7/8	0.499	7/16-20	2.375	A
0 Toggle (Phillips)	DRB034	7/8	0.624	7/16-20	2.125	A
0 Toggle (Plain)	DRB035	7/8	0.624	3/8-16	2.187	A
0 Toggle (Plain)	DRB036	7/8	0.624	3/8-16	2.562	A
1 Toggle (Phillips)	DRB037	7/8	0.624	7/16-20	2.125	A
1 Toggle (Plain)	DRB038	1	0.748	1/2-13	3.062	A
1 Toggle (Plain)	DRB039	7/8	0.748	1/2-13	2.562	A
1/8 Headmaster	DRB040	7/8	0.374	1/4-28	1.562	A
100 Ton Raycarl Die	DRB041	4	1.624	1-1/4-7	13.375	A
2 Toggle (Phillips)	DRB042	1 1/4	0.622	7/16-20	2.812	A
2 Toggle (Plain)	DRB043	1 1/16	0.873	5/8-11	3.125	A
2 Toggle (Plain)	DRB044	1 5/16	0.873	5/8-11	3.75	A
3/16 Headmaster	DRB045	7/8	0.56	3/8-24	1.937	A
3/16 Hi-pro (Phillips)	DRB046	7/8	0.624	7/16-20	2.562	A
3/16 Hi-pro (Phillips)	DRB047	1	0.624	7/16-20	2.562	A
3/16 Hi-pro (Phillips)	DRB048	1 1/4	0.624	7/16-20	2.562	A
3/16 Hi-pro (Plain)	DRB049	1 1/8	0.624	7/16-20	2.562	A
3/16 Hi-pro (Plain)	DRB050	1	0.624	7/16-20	2.562	A
5/16 Hi-pro	DRB051	1 5/8	0.748	1/2-13	3.5	A



# Punch Rockers / Oscillators



### Punch Rockers / Oscillators:

We continually stock Punch Rockers / Oscillators for the 3/16 National high speed header. We also usually stock Punch Rockers / Oscillators for the 1/4 and 45 National high speed header.

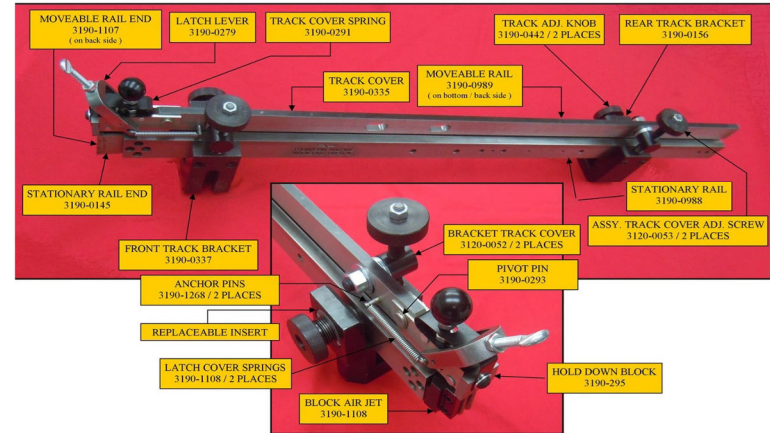
### Material:

Our Punch Rockers / Oscillators are made from a solid block of material not a casting.



# 0-400 Hartford Roll Thread

## Top Rail Complete Assembly



[www.thomasonmachine.com](http://www.thomasonmachine.com)

# Roll Thread Replacement Parts

Hartford Fits 0-400, 0-500, 10-300, 10-400 & 20-225



Block Air Jet  
3190-1108



Stationary Rail End  
3190-0145  
TMW Prog. 784



Moveable Rail End  
3190-1107



Pivot Pin  
3190-0293



Replaceable Insert for  
Front Track Bracket



Front Track Bracket  
3190-0037



Latch Cover Springs  
3190-1108



Adjustment Knob  
1/4-20 x 2" L Under Head



Latch Cover  
3190-0065



Latch Lever  
3190-0279  
TMW Prog. 857



Ball  
1/4-20 Thread x 1" Dia.



Track Cover Spring  
3190-0291



Hold Down Block  
3190-0295



Rear Track Bracket  
3190-0156



Bracket Track Cover  
3120-0052



Adjustment Knob  
3190-0442



Assy. Track Cover  
Adjusting Screw  
3120-0053



Main Rails—Stationary 3190-0988 TMW Prog. 851  
Moveable 3190-0989 TMW Prog. 850



Track Cover 3190-0335 TMW Prog. 845

# Rack Shafts



Asahi Okuma  
AOT 6B Old Style  
TMW Prog. 2048



Asahi Okuma  
AOT 6XL



Asahi Okuma  
AOT 8B  
TMW Prog. 1963



Asahi Okuma  
AOT 12B, 12L, 12XL  
TMW Prog. 1975



Asahi Sunac  
AT 815 New Style  
TMW Prog. 1985



TD 11430 A



# Sector Gears



Asahi Okuma  
AOT 4



Asahi Okuma  
AOT 8



Asahi Okuma  
AOT 12  
TMW Prog. 1975



Asahi Okuma  
AOT 8B  
TMW Prog. 1042



Asahi Sunac  
AT 635, AT 675, AT  
810, AT 850, AT 875  
TMW Prog. 1305

**Call us  
for a quote today!  
815-874-8217**



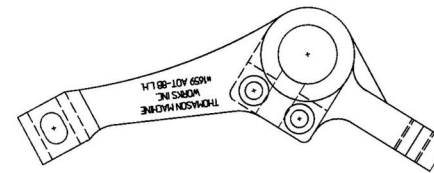
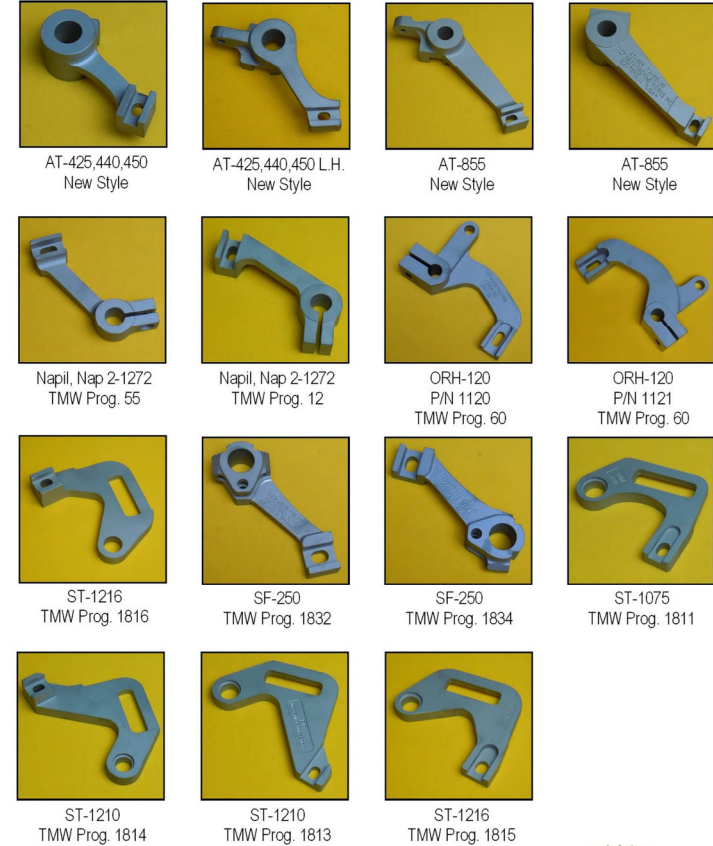
# Transfer Arms

## Asahi Okuma & Asahi Sunac



# Transfer Arms

## Asahi Okuma & Asahi Sunac





# Transfer Arms

Carlo Salvi, Nakashimada, Nedschroef,  
Sacma, Saspi, Matsumoto & More



Nakashimada  
NP-20  
TMW Prog. 1863



Nakashimada  
NP-20  
TMW Prog. 1864



Nakashimada  
NP-120 2nd  
TMW Prog. 1214



Nakashimada  
NP-120 2nd  
TMW Prog. 1279



Nedschroef  
BP-430 L.H.  
TMW Prog. 1893



Nedschroef  
BP-440L  
TMW Prog. 1891



Sacma  
SP-25  
TMW Prog. 1679



Sacma  
SP-25  
TMW Prog. 1681



Sacma SP-48  
#53F783B  
TMW Prog. 1967



Sacma  
SP-37, 330, 340, 350, 360  
TMW Prog. 1623



Sacma  
ST-1075  
TMW Prog. 1812



Sakamura  
BPF-660SSM



Matsumoto  
L.H.  
TMW Prog.



Matsumoto  
R.H.  
TMW Prog. 1971



Nedschroef  
NB-420 L.H.  
TMW Prog. 2022

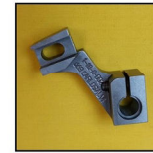


Nedschroef  
NB-420 R.H.  
TMW Prog. 2023

# Transfer Arms



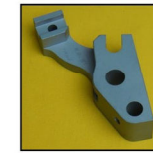
Carlo Salvi 663  
TMW Prog. 2029



Carlo Salvi 663  
TMW Prog. 2030



Nakashimada  
TH28A L.H. 2nd  
TMW Prog. 1230



Nakashimada  
NP-81 2nd  
TMW Prog. 1223



Nakashimada  
NP-81 1st Lower  
TMW Prog. 1375



Nakashimada  
NP-81 2nd  
TMW Prog. 1224



Nakashimada  
MST-308A #6035-2  
TMW Prog. 1665



Nakashimada  
MST-308A #6036-2  
TMW Prog. 1664

## National



56 2D3B L.H.  
Key # SS-30  
TMW Prog. 57



56 2D3B R.H.  
Key # SS-35  
TMW Prog. 33



89 R.H. 2nd Station  
Key # SS-35  
TMW Prog. 100



89 L.H. 2nd Station  
Key # SS-30  
TMW Prog. 88



500 Cold Former  
Key # UT-35  
TMW Prog. 1644



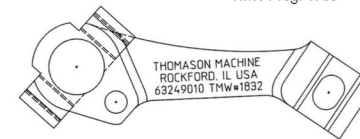
625-5/8 Cold Former  
TMW Prog. 1759



750 Cold Former  
Key # UT-35  
TMW Prog. 1709



1000 Cold Former  
TMW Prog. 1563





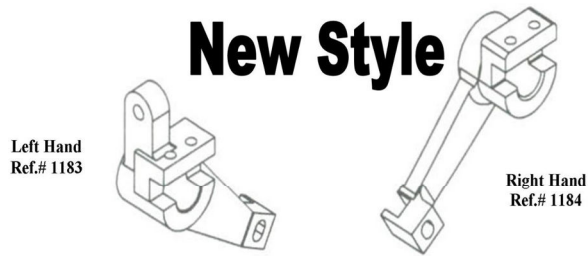
5459 11th Street  
 Rockford, IL 61109  
 Phone 815-874-8217  
 Fax 815-874-5044

## Okuma Arm Styles

### Old Style



### New Style



[www.thomasonmachine.com](http://www.thomasonmachine.com)

## Transfer Finger Holders



AT-810  
1st Upper  
TMW Prog. 1012



AT-810  
1st Lower  
TMW Prog. 1013



National 1/4 or 45  
Upper  
TMW Prog. 476



National 1/4 or 45  
Lower  
TMW Prog. 477



National 1/8 or 25  
Upper  
TMW Prog. 112



National 1/8 or 25  
Lower  
TMW Prog. 112



National 5/16  
Upper  
TMW Prog. 243



National 5/16  
Lower  
TMW Prog. 242



National 56  
Upper  
TMW Prog. 1427



National 56  
Lower  
TMW Prog. 1428



National 3/8 or 68  
Upper  
TMW Prog. 161



National 3/8 or 68  
Lower  
TMW Prog. 163



National 89 2D3B  
Upper  
TMW Prog. 1594



National 89 2D3B  
Lower  
TMW Prog. 1593



89 National 3Blow  
Lower  
TMW Prog. 429



National 810  
Upper  
TMW Prog. 1715

Call us today for a quote! 815-874-8217

# Transfer Finger Holders



National 810  
Upper  
TMW Prog. 1764



National 3/16  
Lower  
TMW Prog. 306



89 National 3Blow  
Lower  
TMW Prog. 429



Sacma SP-37, 330, 340,  
350 TMW Prog. 1623



Sacma SP-22  
Right Hand  
TMW Prog. 1661



ORH-80  
Lower  
TMW Prog. 109



ORH-120  
Upper  
TMW Prog. 418



ORH-120  
Lower  
TMW Prog. 417



AOT-8, 8B, 8L, 8XL  
Lower  
TMW Prog. 1021



AOT-8, 8B, 8L, 8XL  
Upper  
TMW Prog. 1021



AOT-4B  
Lower  
TMW Prog. 1574

### Material:

Our transfer finger holders are made from high quality 4140 steel.

### Heat Treat:

Our transfer finger holders are hardened to 48-50 Rockwell\*

\*Unless otherwise specified by customer or customer supplied prints

At Thomason Machine Works, INC. we have been manufacturing transfer finger holders for over 34 years. They will always be made in the USA. Our print inventory is growing, however most of our finger holders are made by customer supplied prints or samples.

Let Thomason Machine and [www.transferfinger.com](http://www.transferfinger.com) supply all of your cold forming transfer finger holders and fingers.

# Transfer Heads

## Transfer Heads



**Transfer Head Complete**  
(Can usually ship same or next day!)

All components can be purchased separately.

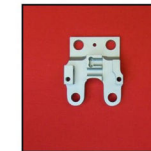
**Complete Includes: Head, Cover Plate, Upper Finger Holder, Lower Finger Holder, Dowel Pins, Springs and Hardware.**



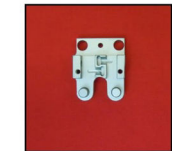
45 National H.S.  
TMW Prog. 807



3/16 National H.S.  
TMW Prog. 241



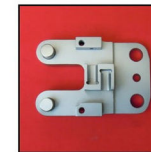
34 National / 3/16 L.S.  
TMW Prog. 97



1/8 National H.S.  
TMW Prog. 1



1/4 National H.S.  
TMW Prog. 1779



68 National H.S.  
TMW Prog. 1638



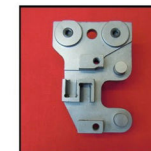
AT-810/855/875 1st  
TMW Prog. 1015



ORH-120 Asahi Okuma  
TMW Prog. 1128



1012 National



5/16 National



810 L.S.S.D.D.S.  
TMW Prog. 42 & 43



3/16 National  
Cover Plate  
TMW Prog. 241

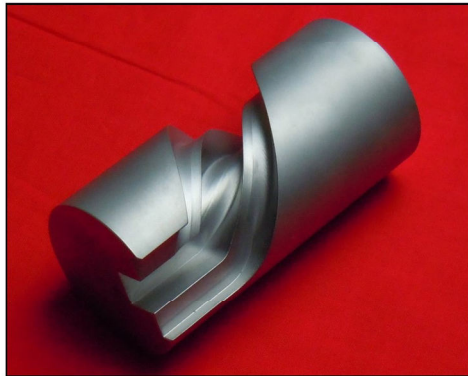


# Turnaround Sleeves - Roll Thread

In some special threading applications, you may have the need to thread a part that will not feed into a rail system from a vibratory feeder, unless you hand feed them. We have designed and made many turnaround systems that can eliminate hand feeding of these type of parts.

**Our Solution:** First, the part will be fed normally thru the vibrator feed bowl and half way down the rail system. Then, the part will go thru a 180 degree turnaround that will invert the part, and re-install it on the rail. Lastly, it will thread the part that would normally have to be hand fed.

We can either manufacture a turnaround that you have designed or you can send us samples of the parts and we can design a turn-around to work for your specific needs. Including turnaround for Chun Zu, Hartford, Waterbury, EW Menn, National, Sanmei, Saspi, Manville, Landis & more.



VISIT US ON THE WEB  
[WWW.THOMASONMACHINE.COM](http://WWW.THOMASONMACHINE.COM)  
 TO SEE THE TURNAROUND SLEEVES IN ACTION!  
 (ROLL THREADS-REPAIR PARTS BY DESCRIPTION-  
 TURNAROUND SLEEVES)



# Feeder Bowls



We are now representing Greenfield Welding for all your feeder bowl needs!



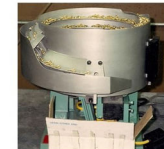
CCW Std Screw Feeder  
 15" Dia.  
 Blanks from 3/16" — 1-1/2"



CW Custom Straight Parallel  
 Screw Feeder 15" Dia. For  
 Feeding Head  
 Heavy Blanks on EW Menns



CCW Std Screw Feeder  
 18" Dia.  
 Blanks from 3/16" — 2-1/2"



CCW Custom Tooled Vibratory  
 Feeder 18"  
 Designed to Feed Brass Eyelets  
 into Assembly Machine



CCW Custom Airless Screw  
 Feeder 21" Dia.  
 #8x.625 Headed Blank at 600 +  
 PPM w/out using air



CCW Outside Tooled Screw  
 Feeder 24" Dia.  
 Blanks from 1/2" — 4"



CW Outside Tooled Vibratory  
 Screw Feeder 30" Dia.  
 Blank Size #10 to 5/8 Popular w/  
 #20 & #30 Rollers



Adjustable Stand for  
 Vibratory Hopper

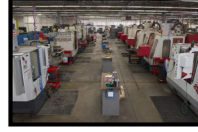


Air Jet for Feeder Bowl  
 1/8"  
 TMW Part #3029



Air Jet for Feeder Bowl  
 3/16"  
 TMW Part #3028

## Machinery and Equipment List



### CNC TURNING EQUIPMENT

- 3 - Hyundai HIT 15S CNC Turning Center with 8" Dia. Chuck
- 1 - Hyundai HIT 30S CNC Turning Center with 12" Dia. Chuck
- 1 - Hyundai HIT 8 CNC Turning Center with 6" Dia. Chuck
- 2 - Haas SL-20 CNC Turning Center with 8" Dia. Chuck
- 2 - Haas SL-30 CNC Turning Center with 12" Dia. Chuck

### CNC VERTICAL KNEE MILLS

- 1 - Dyna Myte FM3116
- 4 - ProtoTRAK M2's

### CNC VERTICAL MACHINING CENTERS

- 2 - HAAS VFOE CNC Vertical Machining Center with 18 tools
- 1 - HAAS VF-3 CNC Vertical Machining Center with 24 tools
- 1 - HAAS VF-4 CNC Vertical Machining Center with 20 tools
- 1 - HAAS Mini Mill Vertical Machining Center with 10 tools
- 2 - Dyna Myte 4800 Vertical Machining Center with 24 tools
- 5 - Dyna Myte 4500 Vertical Machining Center with 16 tools

### MANUAL MILLING EQUIPMENT

- 2 - Lagun FTV-2 Vertical Mill with digital readout, power feed, power drawbar
- 2 - Webb Vertical Mill with digital readout, power feed, power drawbar
- 2 - Bridgeport Series 1 Vertical Mills with power feed, power drawbar
- 1 - Chevalier Vertical Mills with power feed, power drawbar

### MANUAL TURNING EQUIPMENT

- 1 - Monarch Lathe with 14" swing and digital readout
- 2 - Harding TFB-H with 11" swing and 20" length
- 2 - Clausing Colchester Lather with 15" swing, and digital readout
- 1 - Turnmaster Lathe with 15" swing, and digital readout
- 2 - DoAll 13 with 13" swing, and digital readout
- 1 - Lansing G Lathe with 24" swing and 144" length capacity

## Machinery and Equipment List

### GRINDING AND HONING EQUIPMENT

- 2 - Kent RGS-410AHD Surface Grinder with 20" x 40" capacity
- 1 - Chevalier FSG-1224AD Surface Grinder with 12" x 24" capacity
- 1 - Proth Surface Grinder with 10" dia. x 19-1/2" capacity
- 1 - Tos Hostivar B4-28 I.D. and O.D. Grinder with 12" swing
- 1 - Shigiya Seiki G-27 O.D. Grinder with 12" swing
- 1 - Sunnen MBB-1660 Hone
- 1 - Sunnen MBC-1804 Stroker Hone

### EDM EQUIPMENT

- 3 - Charmilles Robofil 310 Wire EDM
- 1 - Chevalier ED-252, 30 amp Plung EDM

### MISCELLANEOUS EQUIPMENT

- 1 - Peerless C-26A Automatic Horizontal Production Band Saw
- 1 - Gage Master Series 20 Optical Comparitor
- 1 - Peerless Champ "P" Horizontal Band Saw
- 1 - Clausing Cosen Horizontal Band Saw
- 1 - Blastmaster RA-30-1 Sand Blaster
- 2 - Oxygen and Acetylene Torch Sets
- 1 - Blastmaster RA-18 Sand Blaster
- 1 - Rams Rockford Rockwell Testor
- 1 - Manley 60 Ton Hydraulic Press
- 2 - Grob Vertical Band Saw
- 1 - Miller Heliarc Welder
- 2 - 20 Ton Arbor Press
- 1 - Miller Mig Welder



[www.thomasonmachine.com](http://www.thomasonmachine.com)