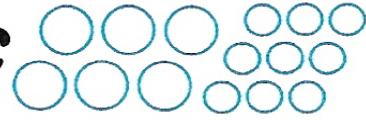




# Plumb Products, LLC



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Setting the feed for various blank sizes:

Changing blank sizes is just a matter of changing a simple stroke plate. This stroke plate insures the correct movement for each job. No adjustments are necessary.

A stroke plate is a piece of steel (3/32 x 1 x 2-1/4 L) in which you locate two .250" diameter holes the "stroke plate" width apart. (See calculation below)

## Stroke Plate Calculations:

### Single-Row Stroke Plate

**SAMPLE: 1-5/8 Blank with a web or bridge of .035**

$$\begin{aligned}\text{Stroke Plate} &= (\text{BLANK} + \text{BRIDGE})/2 + .625 \\ (1.625 + .035) &= 1.660/2 = .830 + .625 = \mathbf{1.455}\end{aligned}$$

### 2-Row Stroke Plate

$$\begin{aligned}\text{Stroke} &= (\text{BLANK} + \text{BRIDGE}) \times .866 \\ (1.625 + .035) &= 1.660 \times .866 = 1.438\end{aligned}$$

$$\begin{aligned}\text{Strip Width} &= \text{STROKE} + \text{BLANK} + 2 \text{ BRIDGES} \\ 1.438 + 1.625 + .035 + .035 &= 3.133\end{aligned}$$

$$\begin{aligned}\text{Stroke Plate} &= (\text{STROKE}/2) + .625 \text{ (this is the crank center to dowel)} \\ (1.438/2) &= .719 + .625 = \mathbf{1.344}\end{aligned}$$

### 3-Row Stroke Plate

$$\begin{aligned}\text{Stroke} &= (\text{BLANK} + \text{BRIDGE}) \times .866 \\ (1.625 + .035) &= 1.660 \times .866 = 1.438\end{aligned}$$

$$\begin{aligned}\text{Strip Width} &= (2 \times \text{STROKE}) + \text{BLANK} + 2 \text{ BRIDGES} \\ (2 \times 1.438) &= 2.876 + 1.625 + .035 + .035 = 4.571\end{aligned}$$

$$\begin{aligned}\text{Stroke Plate} &= \text{STROKE} + .625 \text{ (this is the crank center to dowel)} \\ 1.438 + .625 &= \mathbf{2.063}\end{aligned}$$