

# **ROAD MILLING & RECLAIMING**

15020 INDUSTRIAL PARK ROAD | BRISTOL, VA USA | (276) 644-3520 | WWW.XCALTOOLS.COM

V3-23

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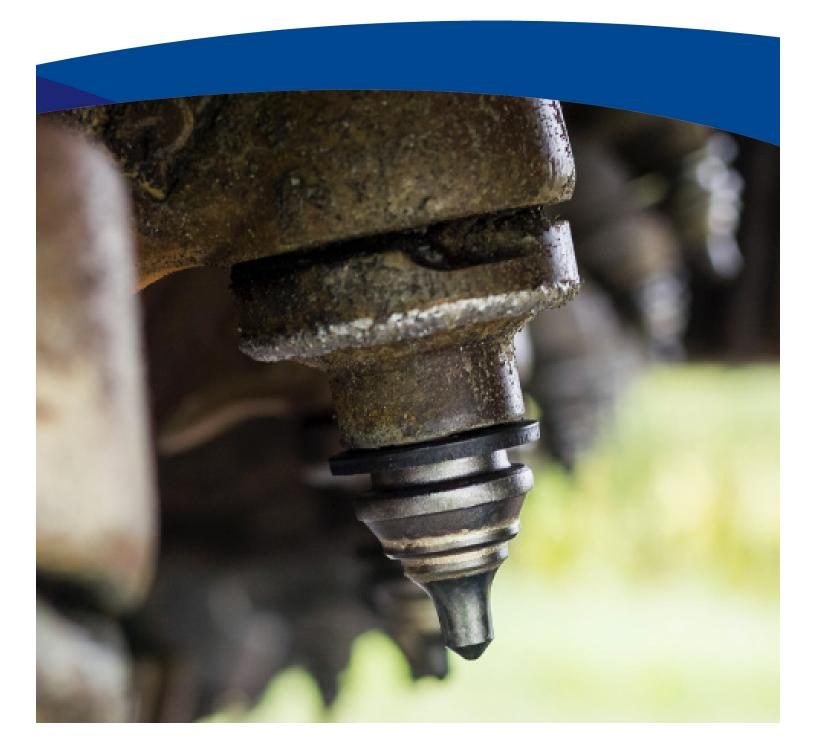
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# **SUPERIOR QUALITY**

XCAL TOOLS takes pride in manufacturing and selling a full line of road planing, soil stabilization, reclaiming, grading, trenching and foundation drilling bits and carbide tooling products that are American-made. Our inhouse operations gives us the flexibility to quickly test and adapt to changing environments and customer needs. Our cost effective production methods, allows us to provide a exceptional product of the highest quality.

# **SERVICE AND INNOVATION**

For over 20 years, our carbide producer XCAL INDUSTRIES, has been producing high quality carbide for the mining, roof drilling, snow and ice removal, road planing, wear products and metal cutting blanks, producing over fifty grades of cemented carbide and the capability to develop extra coarse, tougher grades to meet the demands of the industry.

These affiliates of JENNMAR, in collaboration with each other, can provide you with superior quality products and unmatched customer service. Our commitment to the customer is guided by three words; SAFETY, SERVICE, and INNOVATION. It's these words that form the foundation of our business. It's who we are.

# **Carbide Tips**

We are an ISO 9001 certified facility that offers a wide range of carbide tips to match the various challenges that you might face. Producing over fifty grades of cemented carbide and the ability to create new ones, we can find a carbide grade to meet your needs. Our versatility helps us to check and respond easily to evolving conditions and customer needs. All of our tips provide superb penetration and maximum productivity – regardless of whether you work in soft, medium-hard or extremely hard and demanding conditions.



INSERT

CAP



#### **Insert Carbide Tips**

Insert carbide tips are best for penetration applications where steel wash is not an issue. These tips are ideal for use in hard, high-impact conditions.



#### Cap Carbide Tips

Flat bottom carbide tips are the preferred general application tip that effectively works in 80% of cutting conditions.



#### Valve-Seat Carbide Tips

Valve-Seat carbide tips have a valve-seat braze joint for increased strength and shear resistance. The tips provide excellent penetration, and the large carbide shoulder gives excellent protection against steel wash. These tips are best suited for use in soft to medium materials or conditions.



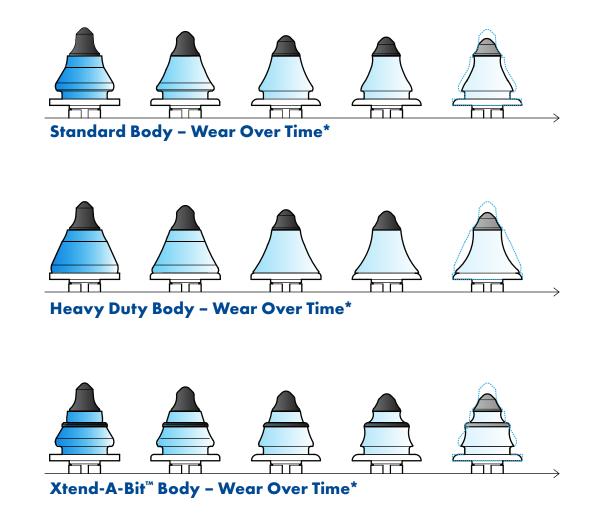
#### **Carbide Ring**

Strategically placed carbide ring prevents body wear, maximizing carbide tip use. The carbide ring also adds greater block protection.





XTEND-A-BIT<sup>™</sup> tools are equipped with a carbide ring placed slightly below the tip to prevent body wear and maximize carbide tip use. Each tool is available with either a valve seat or cap carbide tip. XTEND-A-BIT tools reign supreme in high body wash conditions.



#### **Choosing the Right Bit for Your Application**

XTEND-A-BIT<sup>™</sup> is fitted with a carbide ring that protects the steel body of the bit from erosion when the bits are exposed to extremely abrasive material.

If your heavy duty bits consistently show an hour-glass wear pattern on the body, but the carbide tips are not wearing away, consider replacing your bits with the XTEND-A-BIT.

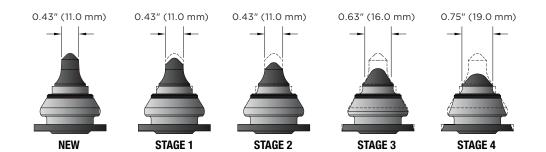
Customers who have previously experienced hourglass wear, who have replaced their bits with XTEND-A-BITs, report two to three times their bit life.

Ideal applications for XTEND Series (CARBIDE RING) tools:

- Tools are worn out and still have considerable life remaining in the tip.
- High steel/body wear.
- Any heavy wear application.



# **Tool Wear Characteristics**



#### Tools Engaged and Surface Area of the Tip in the Cut

This chart shows the change in the total surface area of tips engaged as wear occurs. Tip wear relates to the depth of cut and speed at which the machine is operating, as indicated below.

						NP68 9	SURFA	CE ARE		IPS IN	THE C	JT	
				NEW	T00L	STA	GE 1	STA	GE 2	ST/	GE 3	ST/	GE 4
	SP	EED		in²	Cm <sup>2</sup>	in²	cm²	in²	cm <sup>2</sup>	in²	Cm <sup>2</sup>	in²	cm <sup>2</sup>
DEPTH OF CUT	FPM	MPM	TOOLS ENGAGED	* 0.15	1.00	0.15	1.00	.15	1.00	.322	2.00	0.43	0.8
1.5" (3.8 cm)	30	9.1	11	1.62	10.5	1.62	10.5	1.62	10.5	3.47	22.4	4.78	30.9
1.5" (3.8 cm)	60	18.3	13	1.91	12.4	1.91	12.4	1.91	12.4	4.10	26.5	5.65	36.5
1.5" (3.8 cm)	120	36.6	17	2.50	16.2	2.50	16.2	2.50	16.2	5.37	34.6	7.39	47.7
3" (7.6 cm)	30	9.1	15	2.21	14.3	2.21	14.3	2.21	14.3	4.47	30.6	6.52	42.1
3" (7.6 cm)	60	18.3	16	2.36	15.2	2.36	15.2	2.36	15.2	5.05	32.6	6.96	44.9
3" (7.6 cm)	120	36.6	20	2.95	19.0	2.95	19.0	2.95	19.0	6.31	40.7	869	56.1
6" (15.2 cm)	30	9.1	20	2.95	19.0	2.95	19.0	2.95	19.0	6.31	40.7	8.69	56.1
6" (15.2 cm)	60	18.3	22	3.24	20.9	3.24	20.9	3.24	20.9	6.95	44.8	9.56	61.7
6" (15.2 cm)	120	36.6	26	3.83	24.7	3.83	24.7	3.83	24.7	8.21	53.0	11.30	72.9
12" (30.5 cm)	30	9.1	28	4.12	26.6	4.12	26.6	4.12	26.6	8.84	57.0	12.17	78.5
12" (30.5 cm)	60	18.3	30	4.42	28.5	4.42	28.5	4.42	28.5	9.47	61.1	13.04	84.1

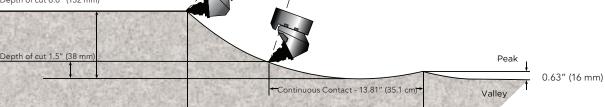
#### **Tool Path**

The longer the continuous contact on the tool, the more heat is drawn into the tool and the more wear on the tip.

10.8" (26.7 cm) \_\_\_\_ Machine Advance

> Advance Rate = 90 fpm (27.4 mpm) Drum Diameter = 46" (116.8 cm) Drum Speed = 100 rpm

Depth of cut 6.0" (152 mm)



Continuous Contact - 22.44" (57.0 cm)



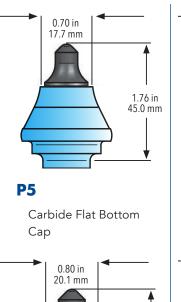




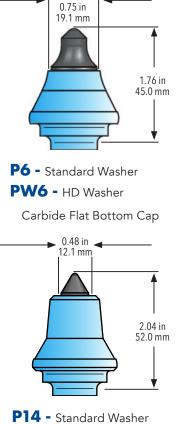
#### Features:

- Unique tool design provides superior rotation
- Full sleeve retainer and washer maintain maximum block bore and seat protection
- Puller groove for easy extraction

Part Number	<b>Shank</b> (in, mm)	<b>Tip</b> Diameter (in, mm)	Base Diameter (in, mm)	<b>Gauge</b> (in, mm)	Pieces per Box	Pieces per Pallet
P5	0.74 in 19 mm	0.36 in 9.2 mm	0.70 in 17.9 mm	1.76 in 45.0 mm	50	3000
P6 PW6	0.74 in 19 mm	0.41 in 10.5 mm	0.75 in 19.1 mm	1.76 in 45.0 mm	50	3000
P7 PW7	0.74 in 19 mm	0.43 in 11.0 mm	0.80 in 20.1 mm	1.88 in 48.0 mm	50	3000
P14 PW14	0.74 in 19 mm	0.47 in 12.1 mm	0.48 in 12.1 mm	2.04 in 52.0 mm	50	3000



 1.88 in 48.0 mm
48.0 mm
97 - Standard Washer
PW7 - HD Washer
Carbide Flat Bottom Cap



PW14 - HD Washer

Carbide Plug For concrete grinding applications.

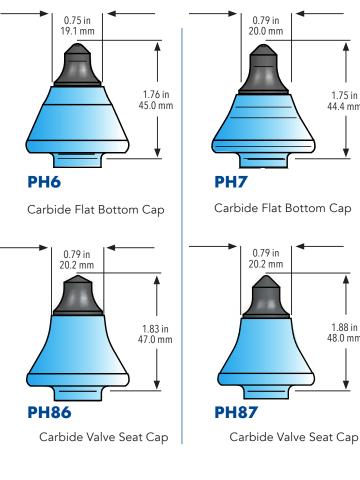
HD WASHER MAXIMUM ROTATION & BLOCK FACE DEFENSE

XCAL TOOLS's newly engineered heavy duty washer provides optimum rotation and superior block face protection allowing the bit to be used to its full life.





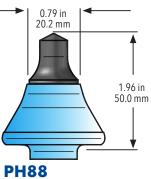




#### **Features:**

- Heavy duty body provides longer body life in ۰ steel wash conditions
- Full sleeve retainer and washer maintain maximum • block bore and seat protection

Part Number	<b>Shank</b> (in, mm)	Tip Diameter (in, mm)	Base Diameter (in, mm)	<b>Gauge</b> (in, mm)	Pieces per Box	Pieces per Pallet
PH6	0.74 in 19 mm	0.41 in 10.5 mm	0.75 in 19.1 mm	1.76 in 45.0 mm	50	3000
PH7	0.74 in 19 mm	0.41 in 10.5 mm	0.79 in 20.0 mm	1.75 in 44.4 mm	50	3000
PH86	0.74 in 19 mm	0.45 in 11.4 mm	0.79 in 20.2 mm	1.83 in 47.0 mm	50	3000
PH87	0.74 in 19 mm	0.47 in 11.9 mm	0.79 in 20.2 mm	1.88 in 48.0 mm	50	3000



Carbide Valve Seat Cap



1.75 in

44.4 mm

Ý

1.88 in 48.0 mm



#### **Features:**

- Strategically placed carbide ring prevents body wear, maximizing carbide tip use
- Carbide ring also adds greater block protection if tip is lost
- Puller groove feature for easy enhanced rotation
- Full sleeve retainer and washer maintain maximum block bore and seat protection

Part Number	<b>Shank</b> (in, mm)	<b>Tip</b> Diameter (in, mm)	Base Diameter (in, mm)	<b>Gauge</b> (in, mm)	Pieces per Box	Pieces per Pallet
PX6 PWX6	0.74 in 19 mm	0.41 in 10.5 mm	0.75 in 19.1 mm	1.77 in 49.0 mm	50	3000
PX7 PWX7	0.74 in 19 mm	0.74 in 19 mm	0.79 in 20.0 mm	1.88 in 48.0 mm	50	3000
PX87	0.74 in 19 mm	0.47 in 12.0 mm	0.79 in 20.2 mm	1.86 in 47.0 mm	50	3000

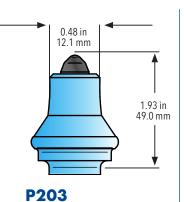
0.79 in 0.75 in 19.1 mm 20.0 mm 1.88 in 1.77 in 48.0 mm 49.0 mm **PX7** - Standard Washer **PX6 -** Standard Washer **PWX7** - HD Washer PWX6 - HD Washer Carbide Flat Bottom Cap Carbide Flat Bottom Cap 0.79 in 20.2 mm 1.86 in 47.0 mm **PX87** Carbide Valve Seat Cap MAXIMIZE YOUR TOOL **USE! XTEND-A-BIT** GO THE X-TRA MILE ALL ROAD MILLING TOOLS ARE NOT CREATED EQUAL

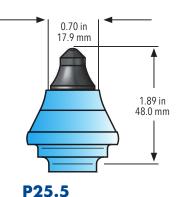
> XTEND-A-BIT's enhanced carbide tip bit is suited for cutting extremely hard or thick asphalt, or for use in applications where you may inadvertently strike rock in the road base.

> Customers who have previously experienced hourglass wear, who have replaced their bits with XTEND-A-BITs, report two to three times their bit life!









Carbide Plug -For concrete grinding

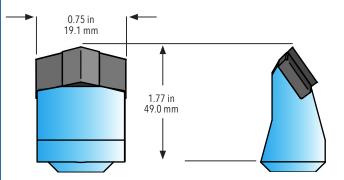
Carbide Flat Bottom Cap

#### **Features:**

applications.

- Unique tool design provides superior rotation
- Puller groove for easy extraction
- Full sleeve retainer and washer maintain maximum block bore and seat protection

Part Number	<b>Shank</b> (in, mm)	<b>Tip</b> Diameter (in, mm)	Base Diameter (in, mm)	<b>Gauge</b> (in, mm)	Pieces per Box	Pieces per Pallet
P203	0.87 in 22 mm	0.47 in 12.1 mm	0.48 in 12.1 mm	1.93 in 49.0 mm	50	3000
P25.5	0.87 in 22 mm	0.40 in 10.1 mm	0.70 in 17.9 mm	1.89 in 48.0 mm	50	3000
P2X	0.87 in 22 mm	NA	NA	2.00 in 50 mm	40	2400



#### **P2X**

Non-rotating tool with flat carbide edge for soft to medium hard conditions. Used for soil stabilization.

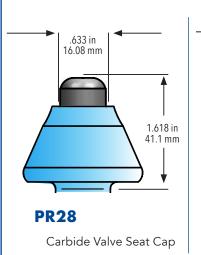


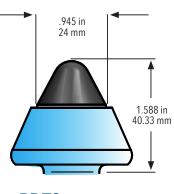


# Reclaiming









**PR70** Carbide Valve Seat Cap

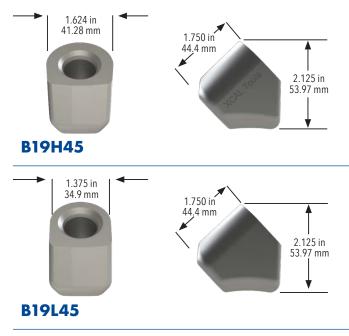
#### Features:

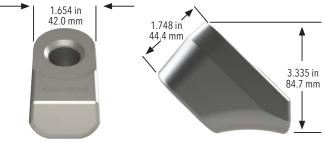
- Heavy Duty body and extra large carbide tips, provide maximum strength and tool life
- Unique carbide design provides better material gradation
- Full sleeve retainer and washer maintain maximum block bore and seat protection

Part Number	<b>Shank</b> (in, mm)	Tip Diameter (in, mm)	Base Diameter (in, mm)	<b>Gauge</b> (in, mm)	Pieces per Box	Pieces per Pallet
PR28	0.74 in 19 mm	0.633 in 16.08 mm	0.633 in 16.08 mm	1.618 in 41.1 mm	50	3000
PR70	0.74 in 19 mm	0.25 in 6.35 mm	0.945 in 24 mm	1.588 in 40.33 mm	50	3000



# **Blocks**





#### B19H45 - Heavy Duty

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	<b>Angle</b> (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
1.050 in 26.67 mm	1.624 in 41.28 mm	45°	Yes	35	2100

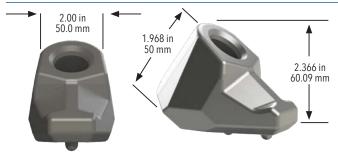
#### B19L45 - Standard Duty

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	<b>Angle</b> (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
1.020 in 25.9 mm	1.375 in 34.9 mm	45°	Yes	35	2100

#### B19HT45 - Heavy Duty Tall

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	<b>Angle</b> (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
1.050 in 26.67 mm	1.654 in 42.0 mm	45°	Yes	20	900

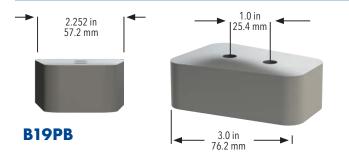
#### **B19HT45**



#### B19P50 - V design with locator pins

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	<b>Angle</b> (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
.783 in 19.89 mm	2.00 in 50.8 mm	50°	NA	15	900

**B19P50** 



#### **B19PB** - Base for B19P50

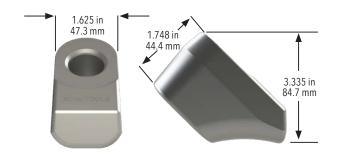
Bore Hole Diameter (in, mm)	Width (in, mm)	Angle (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
NA	2.252 in 57.2 mm	NA	NA	15	900



# **Blocks**



B22H45



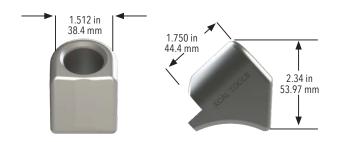
#### B22H45 - Heavy Duty

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	Angle (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
0.885 in 22.48 mm	1.625 in 47.3 mm	45°	Yes	35	2100

#### B22HT45 - Heavy Duty Tall

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	<b>Angle</b> (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
0.885 in 22.48 mm	1.625 in 47.3 mm	45°	Yes	35	2100

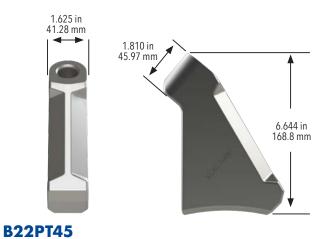
### B22HT45



#### B22NR45 - Standard, Non-Rotating

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	<b>Angle</b> (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
0.885 in 22.48 mm	1.512 in 38.4 mm	45°	Yes	35	2100

#### **B22NR45**



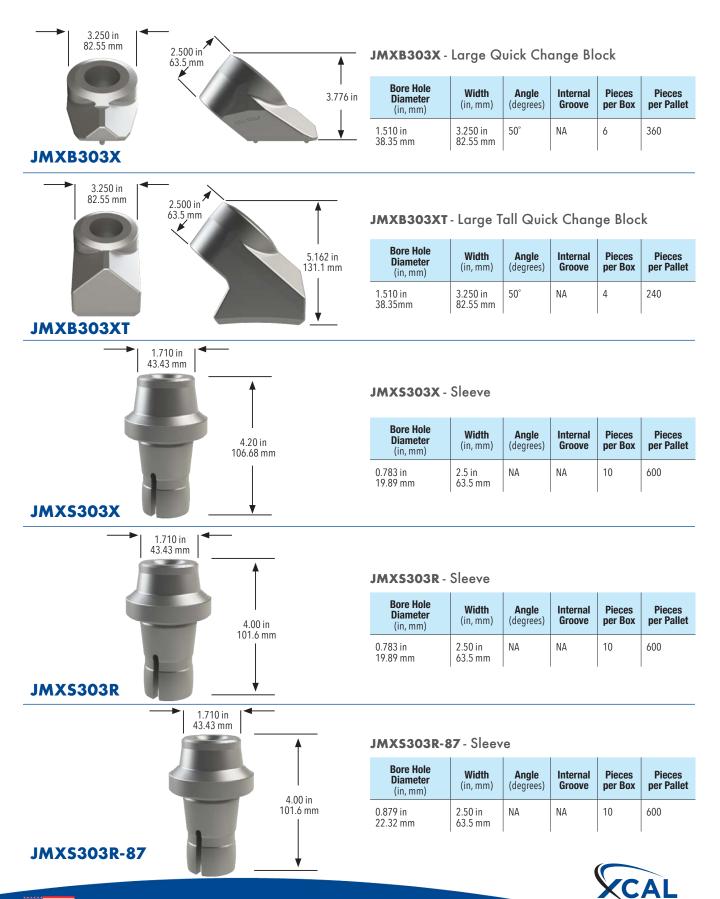
#### B22PT45 - Planer/Reclaimer Tall

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	<b>Angle</b> (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
.885 in 22.48 mm	2.00 in 50.8 mm	50°	Yes	6	360

# **CAL** TSOBLS

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# **Blocks/Sleeves**



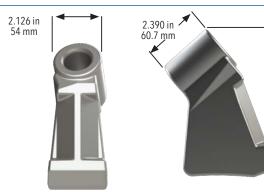


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# **Blocks/Sleeves**



#### **JMXB102P45**



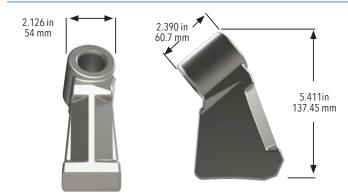
#### JMXB102P45 - Small Quick Change Block

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	Angle (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
1.181 in 30 mm	2.126 in 54 mm	45°	NA	10	600

#### JMXB102PTVR45 - Small Tall Quick Change Block, Right

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	<b>Angle</b> (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
1.181 in 30 mm	2.126 in 54 mm	45°	NA	4	240

#### JMXB102PTVR45



#### JMXB102PTVL45 - Small Tall Quick Change Block, Left

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	<b>Angle</b> (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
1.181 in 30 mm	2.126 in 54 mm	45°	NA	4	240

#### JMXB102PTVL45



#### JMXS102 - Sleeve

Bore Hole Diameter (in, mm)	<b>Width</b> (in, mm)	<b>Angle</b> (degrees)	Internal Groove	Pieces per Box	Pieces per Pallet
0.785 in 19.94 mm	1.874 in 47.59 mm	NA	NA	20	1200



5.411in 137.45 mm

### Wear Parts (For Wirtgen<sup>™</sup> Equipment - Wear Protection Skis)



**50 x 200 mm** Part Number: SK56731



**50 x 625 mm** Part Number: SK155630



**50 x 490 mm** Part Number: SK157828



**40 x 180 mm** Part Number: SK2069177



**50 x 450 mm** Part Number: SK2106074



**50 x 200 mm** Part Number: SK2111404



**40 x 170 mm** Part Number: SK2129390



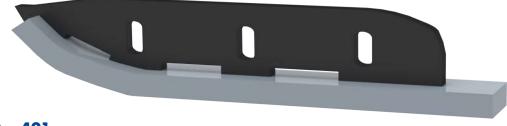
SCANNER SKI Part Number: SK2219386







**32 x 450 mm** Part Number: JMXSK2601214



**50 x 421 mm** Part Number: JMXSK2714905



### Wear Parts (For Wirtgen<sup>™</sup> Equipment - Type 1 Scrapers)

Our Type 1 scrapers are developed to guarantee the finest possible glide execution on the milled surface when scraping.



**248 mm** Part Number: SC43408



**248 mm** Part Number: SC44638



**248 mm** Part Number: SC44639



**145 mm** Part Number: SC56335



**145 mm** Part Number: SC56336



100 mm Part Number: SC56731



**145 mm** Part Number: SC60117





### Wear Parts (For Wirtgen<sup>™</sup> Equipment - Type 2 Scrapers)

The position, shape, and contour of our Type 2 scrapers are designed for the most dependable strength and glide execution in mind.



**248 mm** Part Number: SC146456



**248 mm** Part Number: SC146457



**248 mm** Part Number: SC146458



**145 mm** Part Number: SC146461



**145 mm** Part Number: SC146460



**100 mm** Part Number: SC146459



**145 mm** Part Number: SC146515





3793.40 mm - Whole Assembly • Multi-piece assembly allows for Part Number: JMXSC94271-03 manageable installation 6.00 in 152.40 mm • Sold in individual sections for easy replacements and cost savings 32.62 in 828.69 mm ð 828.69 mm Part Number: JMXSC94271-03 L 42.0 in 1066.80 mm ۵ ×. 1066.80 mm 149.34 in Part Number: JMXSC94271-03 LH 3793.40 mm 3 з 8 42.0 in 1066.80 mm 1066.80 mm Part Number: JMXSC94271-03 R 32.62 in 828.69 mm 828.69 mm Part Number: JMXSC94271-03 RH

- Multi-piece assembly allows for manageable installation
- Sold in individual sections for easy replacements and cost savings



**400.08 mm** Part Number: JMXSC225326-03 L

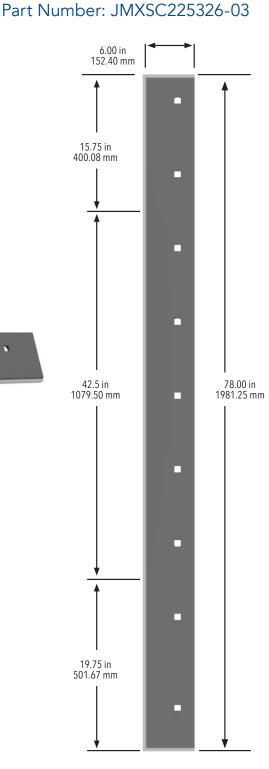


#### 1079.50 mm

Part Number: JMXSC225326-03 Center



**501.67 mm** Part Number: JMXSC225326-03 R



1981.25 mm - Whole Assembly



- Multi-piece assembly allows for manageable installation
- Sold in individual sections for easy replacements and cost savings

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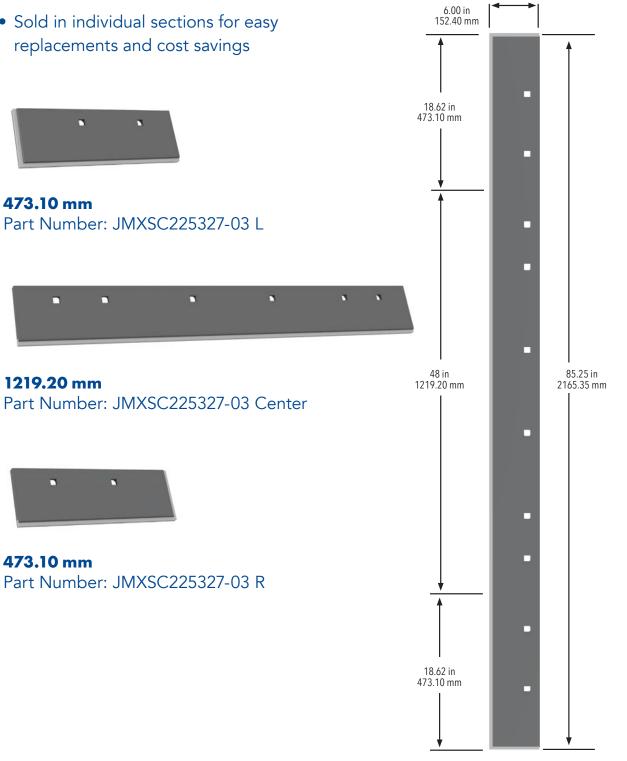
۵

473.10 mm

1219.20 mm

473.10 mm

#### 2165.35 mm - Whole Assembly Part Number: JMXSC225327-03



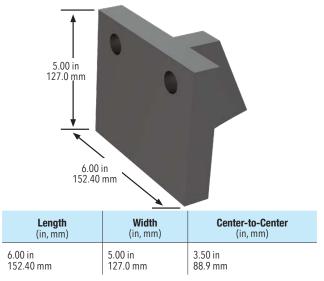


2470.15 mm - Whole Assembly • Multi-piece assembly allows for Part Number: JMXSC225328-03 manageable installation 6.00 in 152.40 mm • Sold in individual sections for easy replacements and cost savings 20.68 in 525.49 mm N 525.49 mm Part Number: JMXSC225328-03 L N N N 48 in 1219.20 mm 97.25 in 2470.15 mm 1219.20 mm Part Number: JMXSC225328-03 Center ٦ 525.49 mm Part Number: JMXSC225328-03 R 20.68 in 525.49 mm 

# **Drum Discharge Paddles**

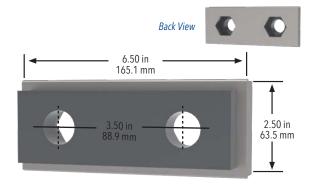
#### Base

Part Number: JMXDPB3044



### Paddle

Part Number: JMXDPWP6

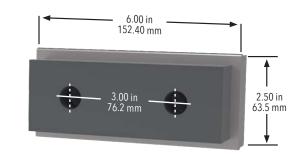


Length	Width	Center-to-Center
(in, mm)	(in, mm)	(in, mm)
6.50 in	2.50 in	3.50 in
165.1 mm	63.5 mm	88.9 mm



### Paddle

Part Number: JMXDP140214-03

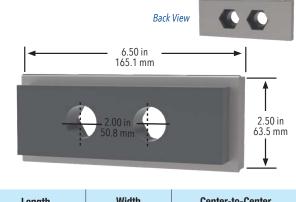


Note: Bolt holes are tapped 3/4" - 10 thread

<b>Length</b>	<b>Width</b>	Center-to-Center
(in, mm)	(in, mm)	(in, mm)
6.00 in	2.50 in	3.00 in
152.40 mm	63.5 mm	76.2 mm

### Paddle

### Part Number: JMXDP271131-03HD



Length	<b>Width</b>	Center-to-Center
(in, mm)	(in, mm)	(in, mm)
6.00 in	2.50 in	2.00 in
152.40 mm	63.5 mm	50.8 mm

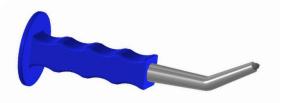
### Discharge Paddle

Part Number: JMXDP271131-03

<b>Length</b>	<b>Width</b>	Center-to-Center
(in, mm)	(in, mm)	(in, mm)
5.62 in	2.50 in	2.00 in
142.7 mm	63.5 mm	50.8 mm







CURVED KNOCK OUT PUNCH - Tool remover with carbide tip for extended life.

Part Number Product Code

JMXA-CKP



CURVED KNOCK OUT PUNCH - Long radius tool remover with hardened tip.

Part Number Product Code

JMXA-HP4



#### FORKED PULLER

#### Part Number Product Code

JMXA-FP19 - For removal of tools with 19mm shank JMXA-FP22 - For removal of tools with 22mm shank JMXA-FP25 - For removal of tools with 25mm shank





**AIR HAMMER PUNCH** - 3/8" chuck. For removal of conical tools from blocks. Hardened tip provides long life. Fits air-hammer guns with 3/8-inch chucks.

Part Number Product Code

JMXA-AH38



AIR HAMMER PUNCH - 1/2" chuck with hardened tip. For removal of conical tools from blocks. Fits light-duty and heavy-duty air-hammer guns with 1/2" chuck.

#### Part Number

Product Code JMXA-AH12



**AIR HAMMER SMALL CUP** - 3/8" Chuck for installation of conical tools into blocks. Fits air hammers with 3/8" chuck.

Part Number Product Code

JMXA-0015



AIR HAMMER PUNCH - Long radius, 3/8" chuck. For removal of conical tools from blocks. Hardened tip provides long life. Fits air-hammer guns with 3/8-inch chucks.

Part Number Product Code



**AIR HAMMER PUNCH -** Long radius, 1/2" chuck. For removal of conical tools from blocks. Fits light-duty and heavy-duty air-hammer guns with 1/2" chuck.

Part Number Product Code JMXA-AH412



**AIR HAMMER LARGE CUP** - 3/8" Chuck for Installation of conical tools into Blocks. Fits air hammers with 3/8" chuck.

Part Number Product Code

JMXA-0015L





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