

Stake No.	Description	End Diameter (OD, mm)	Hole Diameter (ID, mm)	Notes	Modern Hole Diameter (ID,mm)	Stake No.	Description	End Diameter (OD, mm)	Hole Diameter (ID, mm)	Notes	Modern Hole Diameter (ID,mm)	Stake No.	Description	End Diameter (OD, mm)	Hole Diameter (ID, mm)	Notes	Modern Hole Diameter (ID,mm)
1	"Set punch" for aligning punch and die plate					50	Flat face hollow		1.48	(4)	1.45	80	Round face hollow		1.48	(4)	1.45
7	Cross hole		0.13	(3)	0.16	51	Flat face hollow		1.4		1.4	81	Round face hollow		1.4		1.4
8	Cross hole		0.15	(3)	0.18	52	Flat face hollow		1.28	(4)	1.25	82	Round face hollow		1.28	(4)	1.25
9	Cross hole		0.21		0.21	53	Flat face hollow		1.15	(4)	1.09	83	Round face hollow		1.15	(4)	1.09
10	Cross hole		0.26	(4)	0.25	54	Flat face hollow		1.05	(4)	1.04	84	Round face hollow		1.05	(4)	1.04
12	Triangular					55	Flat face hollow		0.99	(4)	0.97	85	Round face hollow		0.99	(4)	0.97
13	Prick					56	Flat face hollow		0.97	(4)	0.95	86	Round face hollow		0.97	(4)	0.95
14	Peening											87	Round face hollow		0.94	(2)	
15	Stretching and peening					58	Flat face hollow		0.92		0.92	88	Round face hollow		0.92		0.92
16	Center wheel		1.92	(3)	1.94	59	Flat face hollow		0.89	(3)	0.9	89	Round face hollow		0.89	(3)	0.9
17	Center wheel		1.48	(3)	1.51	59A	Flat face hollow		0.84	(4)	0.81	89A	Round face hollow		0.84	(4)	0.81
18	Center wheel		1.15	(3)	1.18	60	Flat face hollow		0.81	(4)	0.79	90	Round face hollow		0.81	(4)	0.79
25	Staking rollers		0.76	(3)	0.79	61	Flat face hollow		0.79	(4)	0.75	91	Round face hollow		0.79	(4)	0.75
26	Staking rollers		0.61	(3)	0.63	62	Flat face hollow		0.76	(4)	0.74	92	Round face hollow		0.76	(4)	0.74
26B	Staking rollers		0.46	(3)	0.51	63	Flat face hollow		0.74	(4)	0.71	93	Round face hollow		0.74	(4)	0.71
26C	Staking rollers		0.38	(3)	0.41	63A	Flat face hollow		0.69	(4)	0.66	93A	Round face hollow		0.69	(4)	0.66
27	Staking rollers		1.48	(4)	1.4	64	Flat face hollow		0.66	(4)	0.63	94	Round face hollow		0.66	(4)	0.63
28	Staking rollers		1.28	(4)	1.18	65	Flat face hollow		0.61	(4)	0.6	95	Round face hollow		0.61	(4)	0.6
31	Taper mouth closing	3.53	1.08	(3)	1.09	66	Flat face hollow		0.59	(4)	0.56	96	Round face hollow		0.59	(4)	0.56
32	Taper mouth closing	2.9	0.88	(3)	0.91	67	Flat face hollow		0.56	(4)	0.53	97	Round face hollow		0.56	(4)	0.53
33	Taper mouth closing	2.68	0.84		0.84	68	Flat face hollow		0.51	(4)	0.5	98	Round face hollow		0.51	(4)	0.5
34	Taper mouth closing	2.15	0.76	(3)	0.79	69	Flat face hollow		0.46	(4)	0.45	99	Round face hollow		0.46	(4)	0.45
35	Taper mouth closing	2.01	0.69	(4)	0.56	70	Flat face hollow		0.41	(4)	0.4	100	Round face hollow		0.41	(4)	0.4
36	Taper mouth closing	1.61	0.59	(3)	0.61	71	Flat face hollow		0.38	(4)	0.37	101	Round face hollow		0.38	(4)	0.37
37	Taper mouth closing	1.4	0.51	(3)	0.53	71A	Flat face hollow		0.26	(4)	0.25	101A	Round face hollow		0.26	(4)	0.25
38	Taper mouth closing	1.15	0.41	(3)	0.46	72	Flat face hollow		0.36	(4)	0.34	102	Round face hollow		0.36	(4)	0.34
38A	Taper mouth closing	0.99	0.26	(3)	0.31	72A	Flat face hollow		0.21		0.21	102A	Round face hollow		0.21		0.21
39	For Waltham detachable staffs (driving out)	0.71	0.21		0.21	73	Flat face hollow		0.31		0.31	103	Round face hollow		0.31		0.31
40	For Waltham detachable staffs (driving in)	1.15	0.61	(3)	0.63	73A	Flat face hollow		0.13	(3)	0.16	103A	Round face hollow		0.13	(3)	0.16
41	For Waltham detachable staffs (driving in)	0.94	0.59	(3)	0.61												
42	For Waltham detachable staffs (driving in)	0.76	0.46	(4)	0.45												
106	Flat face soild	3.23				115	Round face solid	2.73				121	Screw knocking	0.76			
108	Flat face soild	2.23				116	Round face solid	2.23				122	Screw knocking	0.5		(5)	0.25
110	Flat face soild	1.48				117	Round face solid	1.76									
111	Flat face soild	0.99				118	Round face solid	1.48									
111A	Flat face soild	0.89				119	Round face solid	0.99									
						119A	Round face solid	0.84									

- Notes: 1) No. 120 included but not counted as one of the 100 stakes. Counted as part of the No. 316 Sub-punch set.  
2) Inclusion of No 87 on list is likely a typo. With it, the total stake count would be 101, and the corresponding No. 57 is not included.  
3) Smaller hole diameter than the modern punch  
4) Larger hole diameter than the modern punch  
5) Larger end diameter than the modern punch

Source: Inverto 18B & 18R Brochure, undated