

Stake List for Inverto 18 from ca. 1937 to before 1952 (before introduction of Inverto 18B)

Stake No.	Description	End	Hole	Modern	Stake No.	Description	End	Hole	Modern	Stake No.	Description	End	Hole	Modern
		Diameter (OD, mm)	Diameter (ID, mm)	Hole Diameter (ID,mm)			Diameter (OD, mm)	Diameter (ID, mm)	Hole Diameter (ID,mm)			Diameter (OD, mm)	Diameter (ID, mm)	Hole Diameter (ID,mm)
1	"Set punch" for aligning punch and die plate				43	Flat face hollow		2.56						
7	Cross hole		0.13 (2)	0.16	44	Flat face hollow		2.33		74	Round face hollow		2.33	
8	Cross hole		0.15 (2)	0.18	45	Flat face hollow		2.15		75	Round face hollow		2.15	
9	Cross hole		0.21	0.21	46	Flat face hollow		2.01		76	Round face hollow		2.01	
10	Cross hole		0.26 (3)	0.25	47	Flat face hollow		1.92		77	Round face hollow		1.92	
11	Cross hole		0.26 (3)		48	Flat face hollow		1.76		78	Round face hollow		1.76	
11A	Centered end				49	Flat face hollow		1.61		79	Round face hollow		1.61	
12	Triangular				50	Flat face hollow		1.48 (3)	1.45	80	Round face hollow		1.48 (3)	1.45
13	Prick				51	Flat face hollow		1.4	1.4	81	Round face hollow		1.4	1.4
14	Peening				52	Flat face hollow		1.28 (3)	1.25	82	Round face hollow		1.28 (3)	1.25
15	Stretching and peening				53	Flat face hollow		1.15 (3)	1.09	83	Round face hollow		1.15 (3)	1.09
16	Center wheel		1.92 (2)	1.94	54	Flat face hollow		1.05 (3)	1.04	84	Round face hollow		1.05 (3)	1.04
17	Center wheel		1.48 (2)	1.51	55	Flat face hollow		0.99 (3)	0.97	85	Round face hollow		0.99 (3)	0.97
18	Center wheel		1.15 (2)	1.18	56	Flat face hollow		0.97 (3)	0.95	86	Round face hollow		0.97 (3)	0.95
19	Staking double rollers		1.97		57	Flat face hollow		0.94 (3)		87	Round face hollow		0.94	
20	Staking double rollers		1.48		58	Flat face hollow		0.92	0.92	88	Round face hollow		0.92	0.92
21	Staking double rollers		1.05		59	Flat face hollow		0.89 (2)	0.9	89	Round face hollow		0.89 (2)	0.9
22	Staking double rollers		0.89		59A	Flat face hollow		0.84 (3)	0.81	89A	Round face hollow		0.84 (3)	0.81
23	Staking rollers		1.28		60	Flat face hollow		0.81 (3)	0.79	90	Round face hollow		0.81 (3)	0.79
24	Staking rollers		0.99		61	Flat face hollow		0.79 (3)	0.75	91	Round face hollow		0.79 (3)	0.75
25	Staking rollers		0.76 (2)	0.79	62	Flat face hollow		0.76 (3)	0.74	92	Round face hollow		0.76 (3)	0.74
26	Staking rollers		0.61 (2)	0.63	63	Flat face hollow		0.74 (3)	0.71	93	Round face hollow		0.74 (3)	0.71
27	Collet closing		1.48 (3)	1.4	63A	Flat face hollow		0.69 (3)	0.66	93A	Round face hollow		0.69 (3)	0.66
28	Collet closing		1.28 (3)	1.18	64	Flat face hollow		0.66 (3)	0.63	94	Round face hollow		0.66 (3)	0.63
29	Taper mouth closing	4.71	1.76		65	Flat face hollow		0.61 (3)	0.6	95	Round face hollow		0.61 (3)	0.6
30	Taper mouth closing	3.76	1.48		66	Flat face hollow		0.59 (3)	0.56	96	Round face hollow		0.59 (3)	0.56
31	Taper mouth closing	3.53	0.99 (2)	1.09	67	Flat face hollow		0.56 (3)	0.53	97	Round face hollow		0.56 (3)	0.53
32	Taper mouth closing	2.9	0.92 (3)	0.91	68	Flat face hollow		0.51 (3)	0.5	98	Round face hollow		0.51 (3)	0.5
33	Taper mouth closing	2.68	0.84	0.84	69	Flat face hollow		0.46 (3)	0.45	99	Round face hollow		0.46 (3)	0.45
34	Taper mouth closing	2.15	0.76 (2)	0.79	70	Flat face hollow		0.41 (3)	0.4	100	Round face hollow		0.41 (3)	0.4
35	Taper mouth closing	2.01	0.69 (3)	0.56	71	Flat face hollow		0.38 (3)	0.37	101	Round face hollow		0.38 (3)	0.37
36	Taper mouth closing	1.61	0.59 (2)	0.61	71A	Staking pallet arbors		0.26 (3)	0.25	101A	Round face hollow		0.26 (3)	0.25
37	Taper mouth closing	1.4	0.51 (2)	0.53	72	Flat face hollow		0.36 (3)	0.34	102	Round face hollow		0.36 (3)	0.34
38	Taper mouth closing	1.15	0.41 (2)	0.46	72A	Staking pallet arbors		0.21	0.21	102A	Round face hollow		0.21	0.21
38A	Taper mouth closing	0.99	0.26 (3)	0.31	73	Flat face hollow		0.31	0.31	103	Round face hollow		0.31	0.31
39	For Waltham detachable staffs (driving out)		0.21	0.21	73A	Staking pallet arbors		0.13 (2)	0.16	103A	Round face hollow		0.13 (2)	0.16
40	For Waltham detachable staffs (driving in)	1.15	0.61 (2)	0.63										
41	For Waltham detachable staffs (driving in)	0.94	0.59 (2)	0.61	104	Flat face solid	4.1			112	Round face solid	4.1		
42	For Waltham detachable staffs (driving in)	0.76	0.46 (3)	0.45	105	Flat face solid	3.76			113	Round face solid	3.76		
					106	Flat face solid	3.23			114	Round face solid	3.23		
					107	Flat face solid	2.73			115	Round face solid	2.73		
					108	Flat face solid	2.23			116	Round face solid	2.23		
					109	Flat face solid	1.76			117	Round face solid	1.76		
120	Sub-punch holder				110	Flat face solid	1.48			118	Round face solid	1.48		
121	Screw driving	0.76			111	Flat face solid	0.99			119	Round face solid	0.99		
122	Screw driving	0.69	(4)	0.25	111A	Flat face solid	0.89			119A	Round face solid	0.84		

Notes: 1) Sub-punch holder and set of 10 sub-punches included but not counted in the 130 total stake count.

Source: Inverto 18 brochure, 1937

- 2) Smaller hole diameter than the modern punch
- 3) Larger hole diameter than the modern punch
- 4) Larger end diameter than the modern punch